



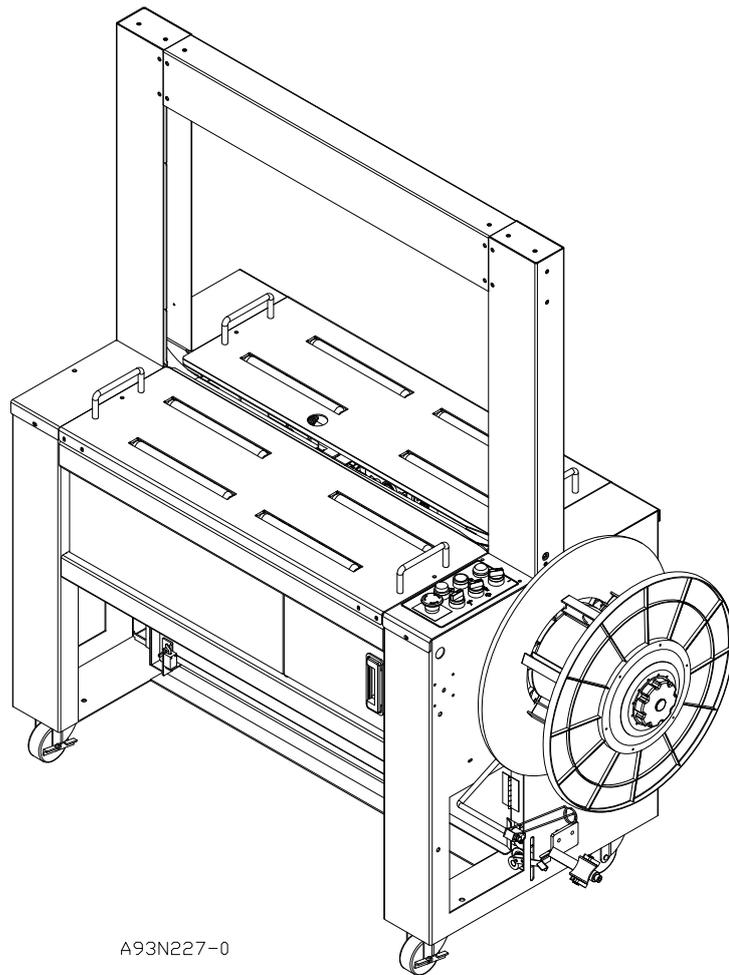
8 NET, Inc.

Installation Guide / Operating Manual

**PSM-FA235, Fully Automatic Strapping
Machine**

Automatic Strapping Machine
Operator Manual and Spare Parts List

A93N



A93N227-0

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CHAPTER 1 : General

1.1

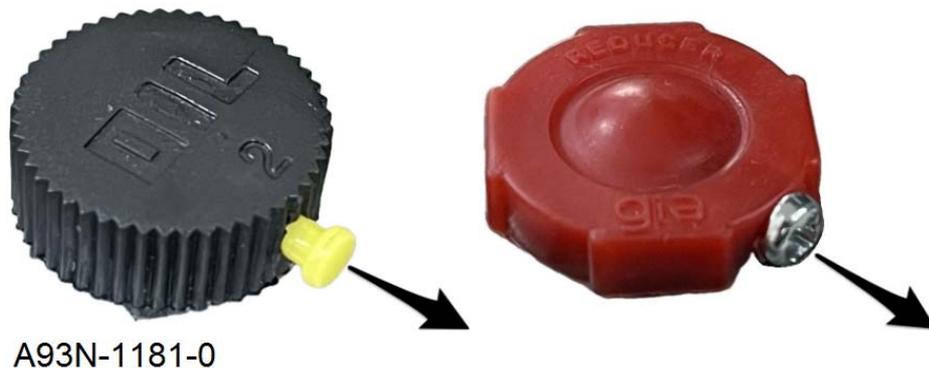
Preface

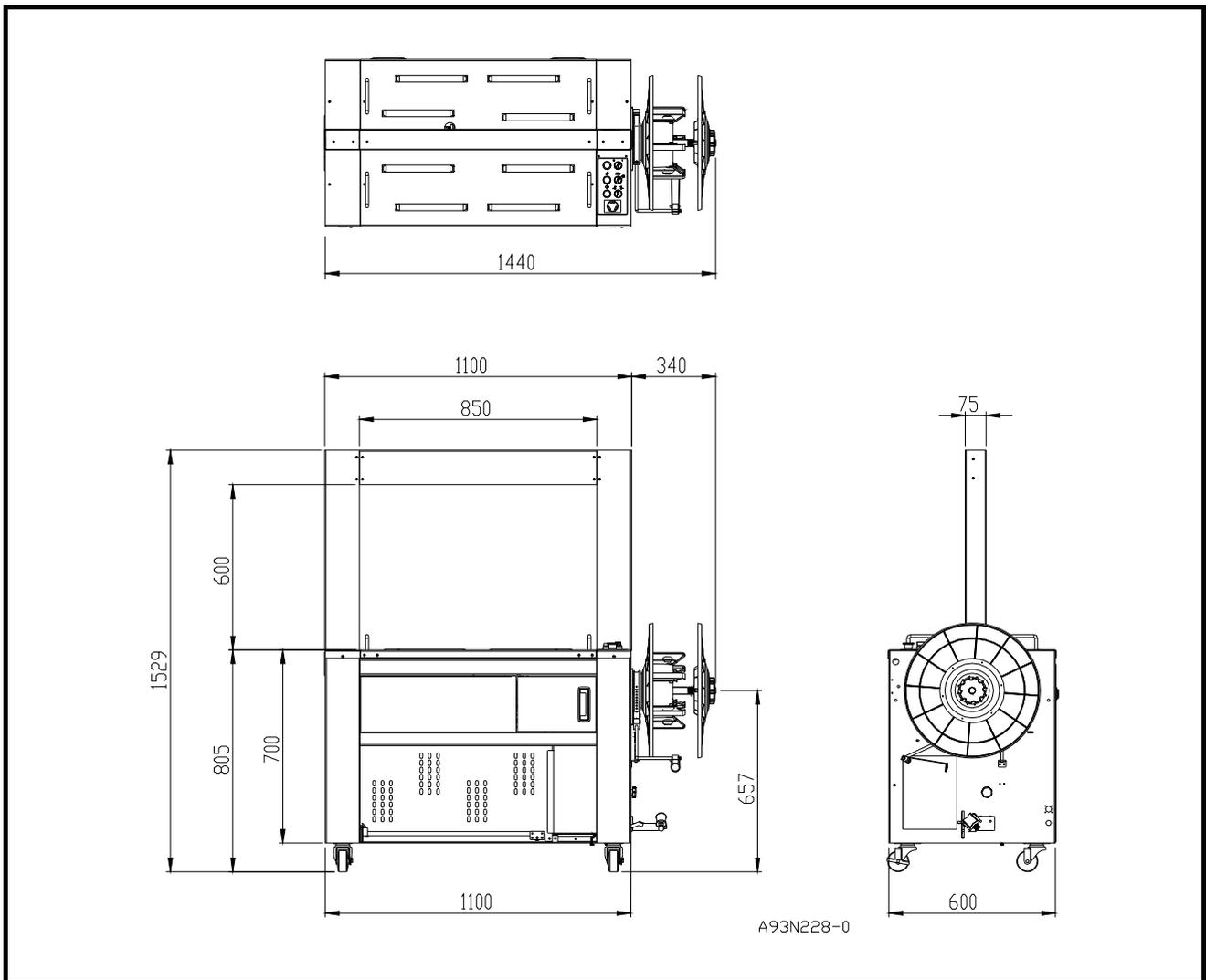
- Your patronage in the purchase of our automatic strapping machine is keenly appreciated.
- Each machine's interior and exterior structure is designed, assembled and well tested by our experienced technicians in order to attain brilliant strapping performance.
- Please read this manual thoroughly prior to your use of the machine for better efficiency in operations.

1.2

Safety Instruction

- It is prohibited for unauthorized persons to use the machine!
- Observe all safety precautions and warning signs.
- Do not clean the machine or try to execute repairs while it is under the power-on status → Turn power switch off first.
- Never put any heavy article on power cord which could cause fire or electric shock.
- Do not touch the welding element tongue if the machine has been switched on (operating temperature exceeds 280°C).
- After performing adjustment, make sure to reinstall the cover panels.
- In case of fire it is strictly prohibited to use water for the extinction.
- Follow the instructions provided in this manual.
- Prior to the first startup of the machine, ensure that the pin on the gearbox oil cap has been removed



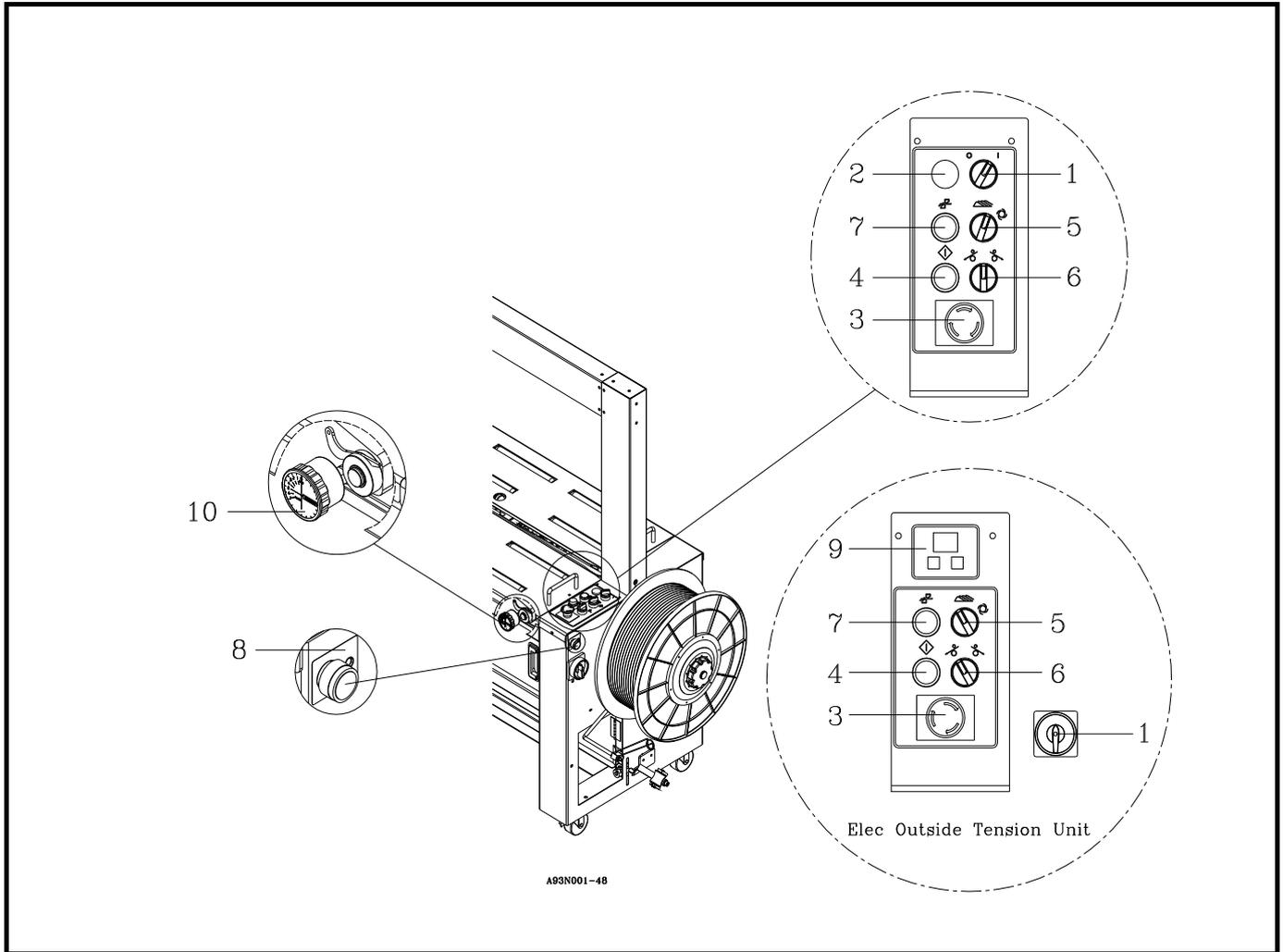


- Model no.: A-93N
- Capacity: Approx. 24 strapping/minute
- Arch size: W850 ×H600mm
- Min. package size: W 100 mm x H 30 mm
- Strap tension: 15 - 70 kg (Adjustable)
- Strap width: 12 mm(1/2")
- Strap dispenser: Inside diameter of coil 200 mm
- Perceived noise level: Approx. 80dBA
- Power consumption: Approx. 1.0KW
- Power connection: 110V/60HZ/1PH
- Dimensions: 1440W×600L×1529Hmmm

CHAPTER 2 : Operation Instruction

2.1

Control Elements



1. Power switch

Position 0 = Power Off.

Position 1 = Power On, heater warm up.

2. Power indicator lamp

Illuminating when power on.

3. E-STOP push button

Push E-stop button in case of emergency. Strapping process stops immediately.

4. Start switch button

Actuate start switch or foot switch to initiate strapping operation.

Push it for strapping operation.

(If strap feeding failed, start button will be flashing.)

5. Selector switch Auto / Manual

5.1 As individual machine

“  ” position: Place package on ball switch for single strapping. Machine will execute strapping continuously, if package stays on ball switch.

“  ” position: Push start switch button for single strapping.

5.2 Connect with the carton sealer:

① Manual mode:

Applying straps according to carton sealer's signals.

② Auto mode:

Do not choose auto mode when two machines are connected.

6. Feeding/Retracting switch

Turn counter-clockwise to feed PP strap.

Turn clockwise to retract PP strap.

7. Reset push button

Reset machine to home position status.

1st pushing: Left strap guide opened.

2nd pushing: Complete one cycle to home position.

8. Auto-Load Push button (Only equipped on auto - load machine)

Insert the strap pass through pool magazine feeding roller for about 7 cm then push the Auto - Load push button (8). The strap accumulating and feeding process will start automatically.

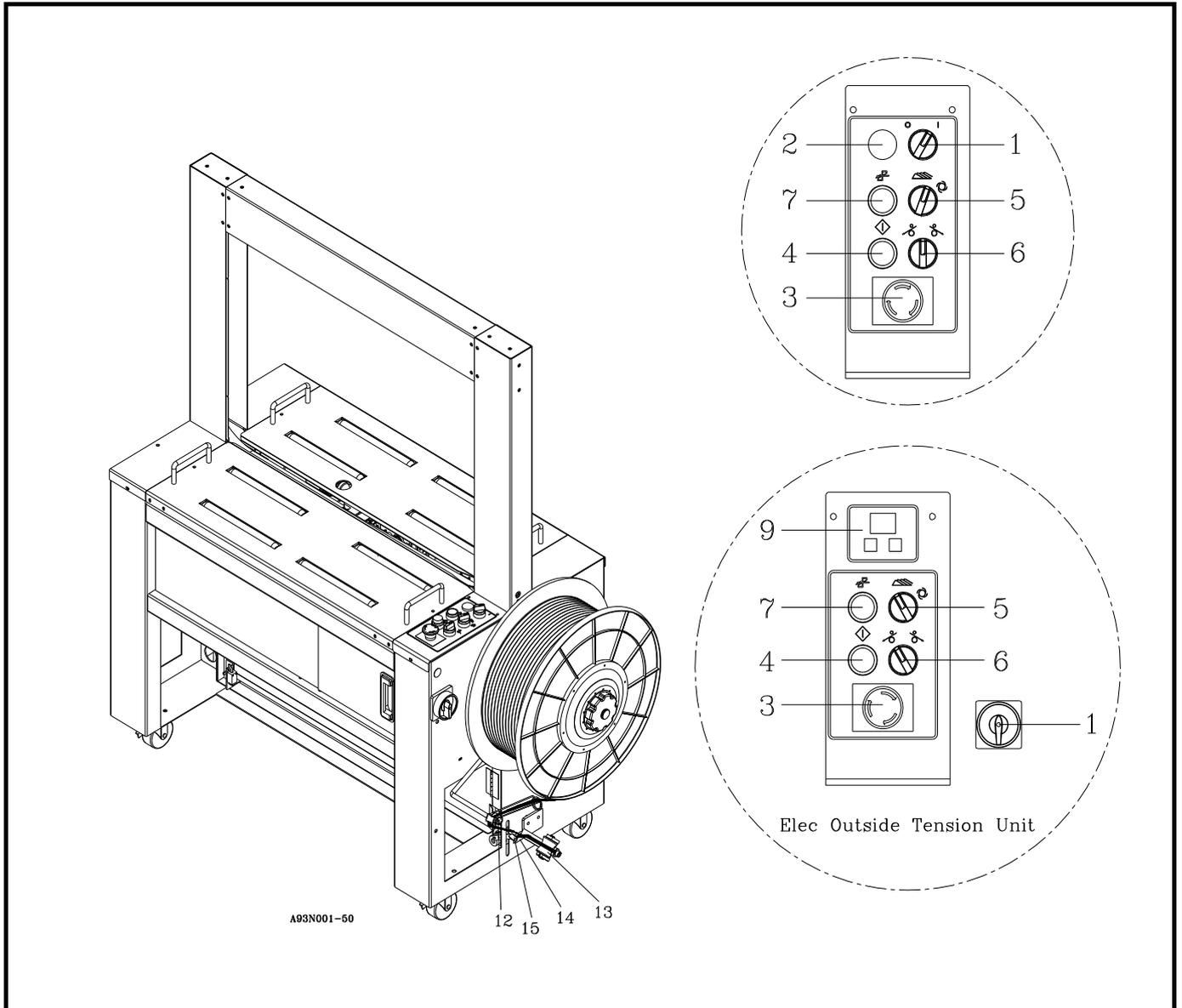
9. Membrane button (Only equipped on electronic tension control type)

Tension increasing by push “ + “ button.

Tension decreasing by push “ – “ button.

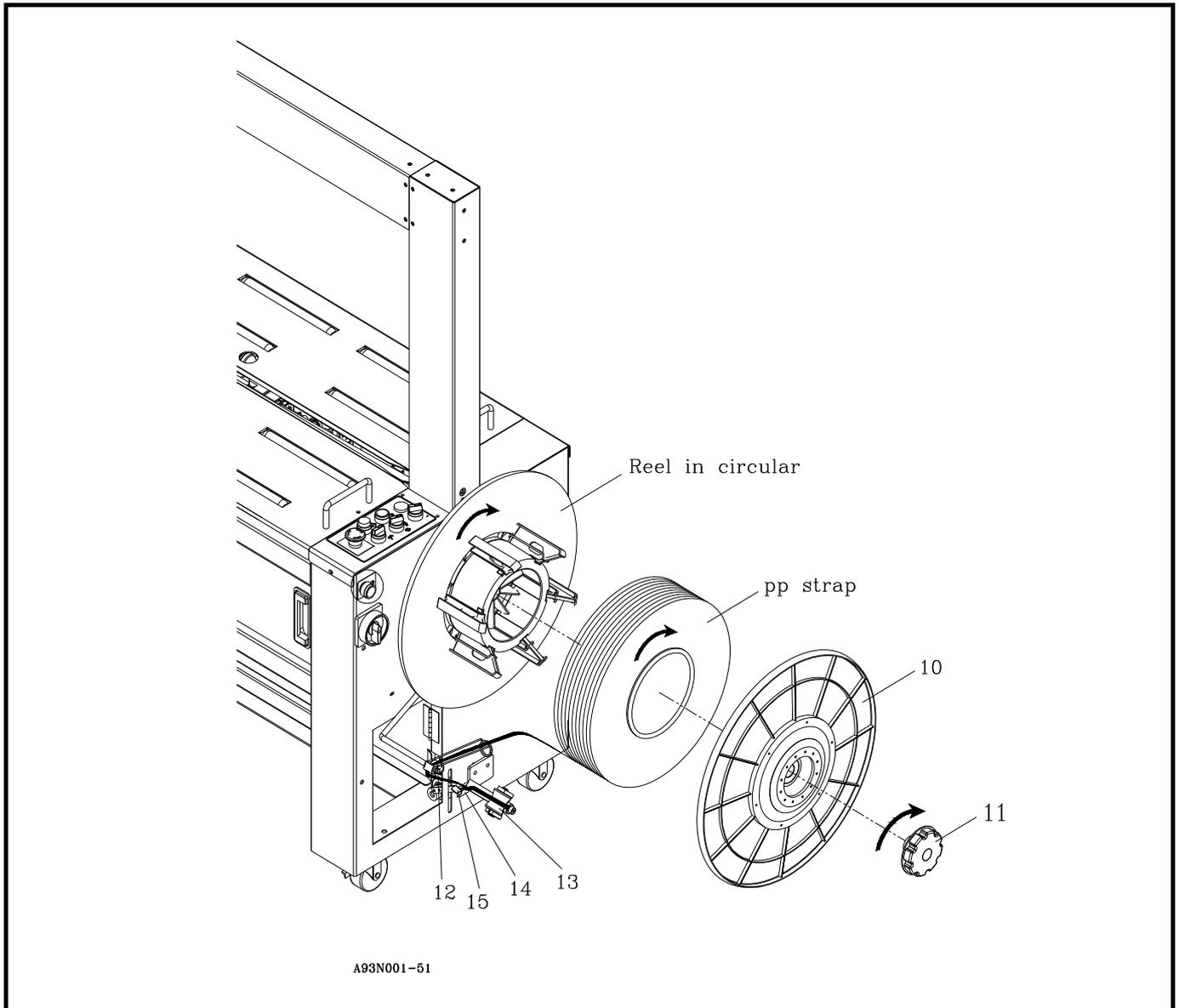
10. Tension set knob (Equipped on standard mechanical tension control type)

Set strapping tension by pull out the knob and turn to expect tension scale value then release to lock the knob at setting position.



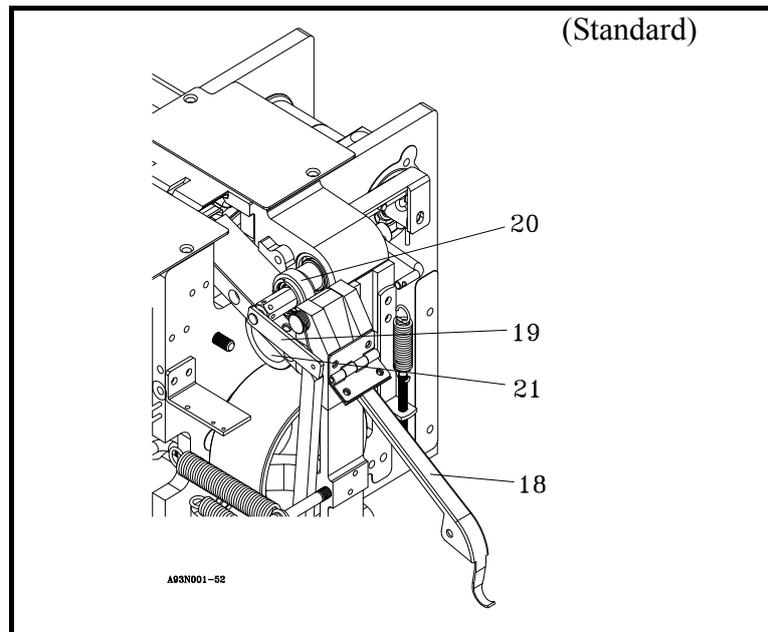
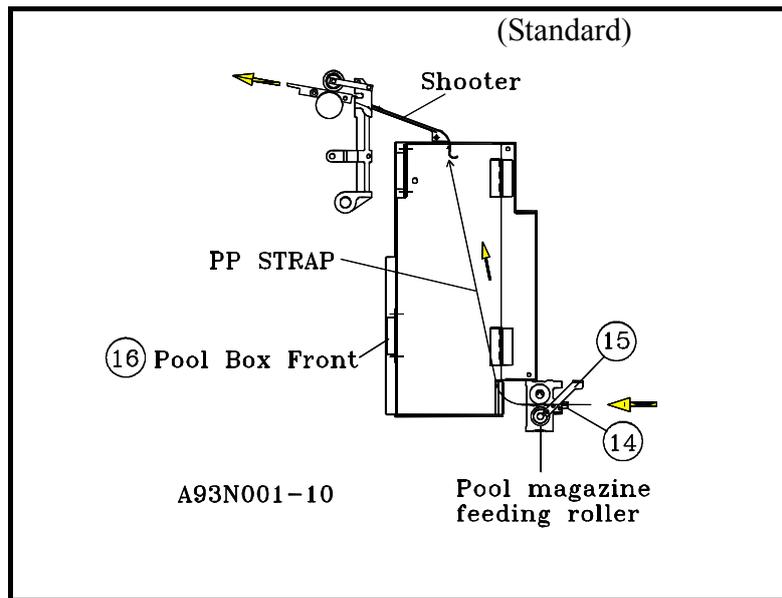
1. Load P.P strap (See 2.3)
2. Turn power switch (1) on. The pilot lamp will illuminate.
3. Release emergency stop push button.
4. Wait for about 30 seconds until the heater element reaches the operating-temperature.
5. Set strapping tension according to 2.1.9 or 2.1.10. per your need, then place a package on the center of sealing head.
6. With selector switch (5) to set required operating modes (see 2.1.5).then execute strapping process by push start button (4) if under manual mode or actuated by ball switch if under auto mode.
7. After operation completed, turn off the power switch (1).

Loading Strap Coil (Standard)

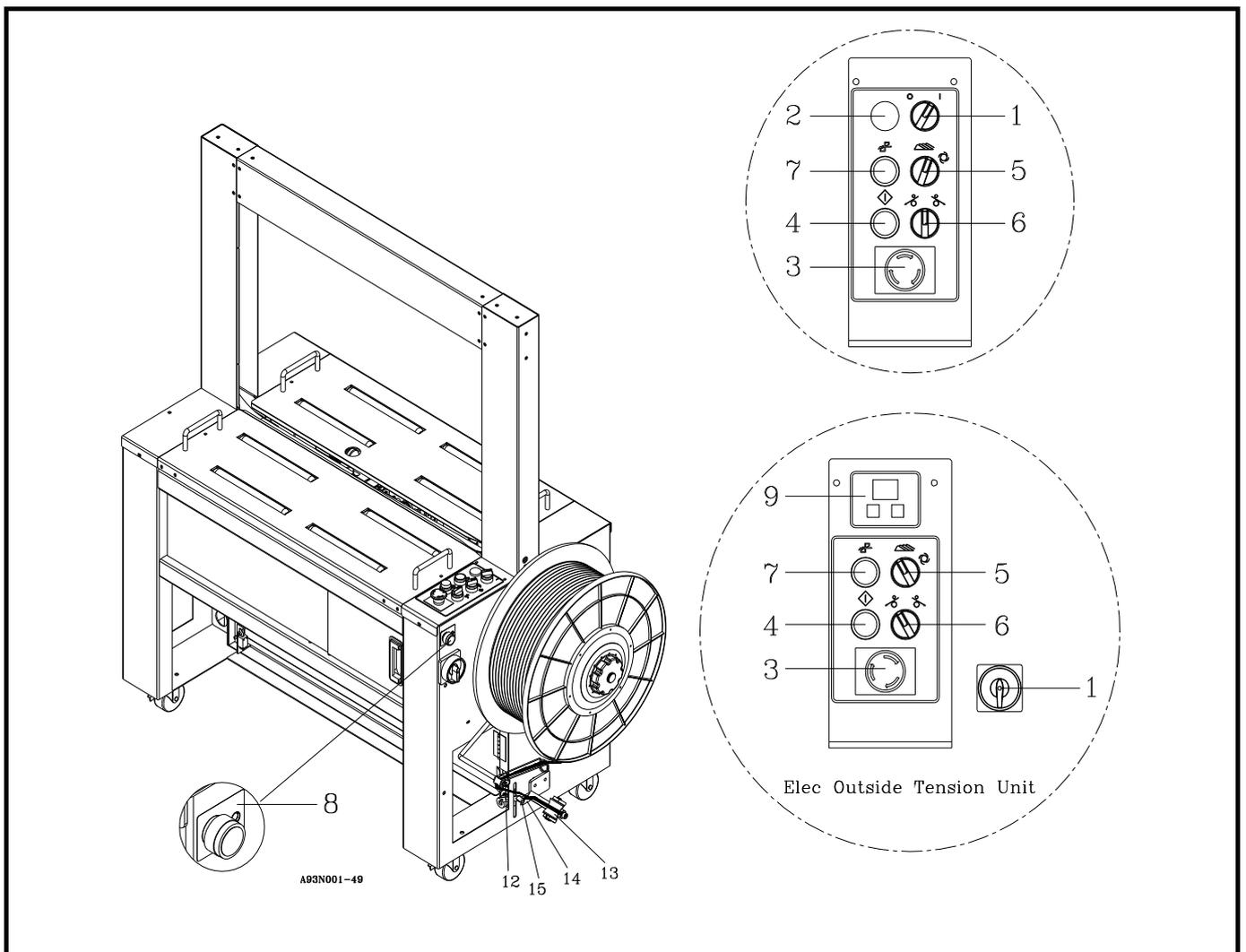


1. Ensure that power supply switch is turned off before setting polypropylene strap.
2. Place strap coil on the reel drum in accord with the arrow direction as indicated on the reel out circular (10). After placing it, put the reel out circular on the strap coil and tighten it by the reel nut handle (11).
3. Thread the tip of PP strap into the strap guide roller (12). After that, push it trough the free angle roller (13). At this moment, twist the strap so that the inside part of the PP strap turns out downward and outside surface touches on the roller. See the drawing.

Loading Strap Coil (Standard)



4. Open the door of pool box (16). Insert strap into the pool feed shooter (14) push the lever (15) downward. Pull out about 1 m of the strap through the pool feed shooter (14) and insert it into the pool box. Reaching upper department as drawing shown.
5. Manually turn the upper roller grip (19) counter-clock-wise to create a gap between upper roller (20) and lower roller (21), while inserting the tip of strap under the strap cover (18). Release the upper roller grip (19), strap will be held by upper and lower rollers.
6. Turn Feeding / Retracting switch (6) counter-clockwise to feed the strap into arch till reaching the actuating lever to actuate switch ready for strapping.



1. Turn power switch (1) on. The pilot lamp (2) will illuminate.
Release the emergency stop push button (3)
2. Thread the tip of PP strap into the strap guide roller (12). After that, push it trough the free angle roller (13). At this moment, twist the strap so that the inside part of the PP strap turns out downward and outside surface touches on the roller. See the drawing.
3. Push the lever (15) downward. Insert P.P. straps into the inlet guide about 7 cm. Push Auto-Load button (8) to execute strap loading process, as soon as start button (4) turn to illuminate means the feeding process is completed.
4. Wait for about 30 seconds until the heater element reaches the required operating-temperature .
5. Set strapping tension according to 2.1.9 or 2.1.10. per your need.
6. With selector switch (5) to set required operating modes (see 2.1.5).then execute strapping process by push start button (4) if under manual mode or actuated by ball switch if under auto mode.
7. After operation completed, turn off power switch (1).

CHAPTER 3 : Maintenance

3.1 General Notices

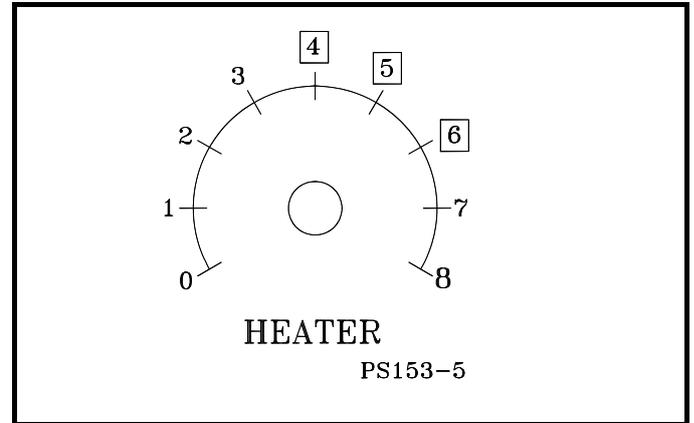
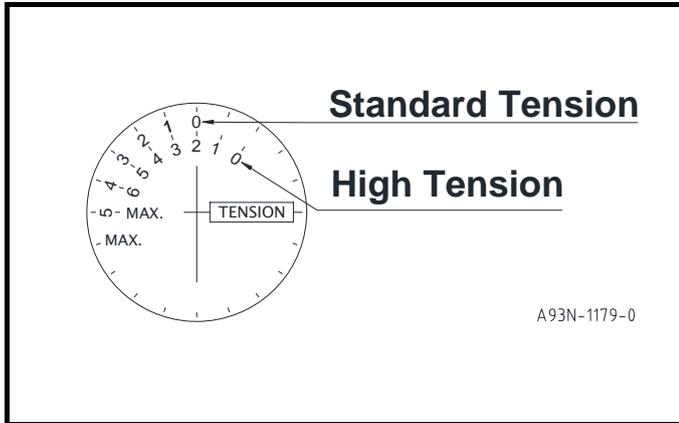
- Turn off power before performing maintenance work or changing strap coil.
- Pull strap out from strap magazine and wind it back to strap coil prevent strap deformation if machine is not in use for a prolonged time.
- If changed electrical outlet socket or cable connector, check rotation direction of motor.
- Keep the machine clean. Follow below instructions to remove contaminations near the sealing unit and deposits on the heater.
- To clean heater tongue only after it cool down.

3.2 Period of Maintenance

Item	Treatment	Period			
		Per Day	Per Week	Per Month	Per Year
Wipe off strap bits	Wiping with hairbrush or clean with vacuum cleaner	●			
Clean heater & heater slide guide.	Eliminate the deposits or dirt on heater surface or slide guide.			●	
Gear motor oil	Open the cover on the top of the gearbox. It's at least over half. If not, add machine oil (SAE 40) in.				●

CHAPTER 4 : Adjustment

Adjustment



4.1 Strap tension

Pull & turn the knob for adjusting tension strength.

Standard Tension: adjustment range 0-MAX (6).

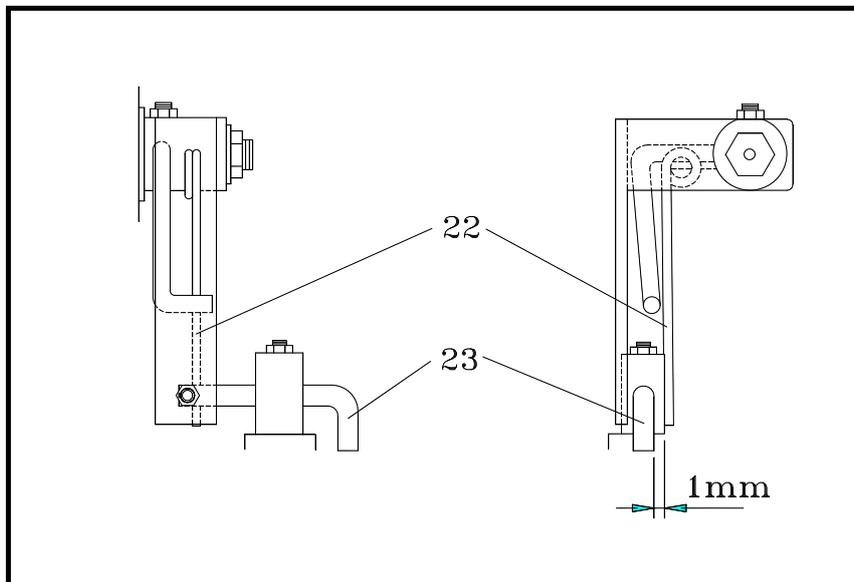
High Tension(optional): adjustment rang 0-MAX (7).

Please adjust the appropriate tension scale according to the characteristics of the packaged item.

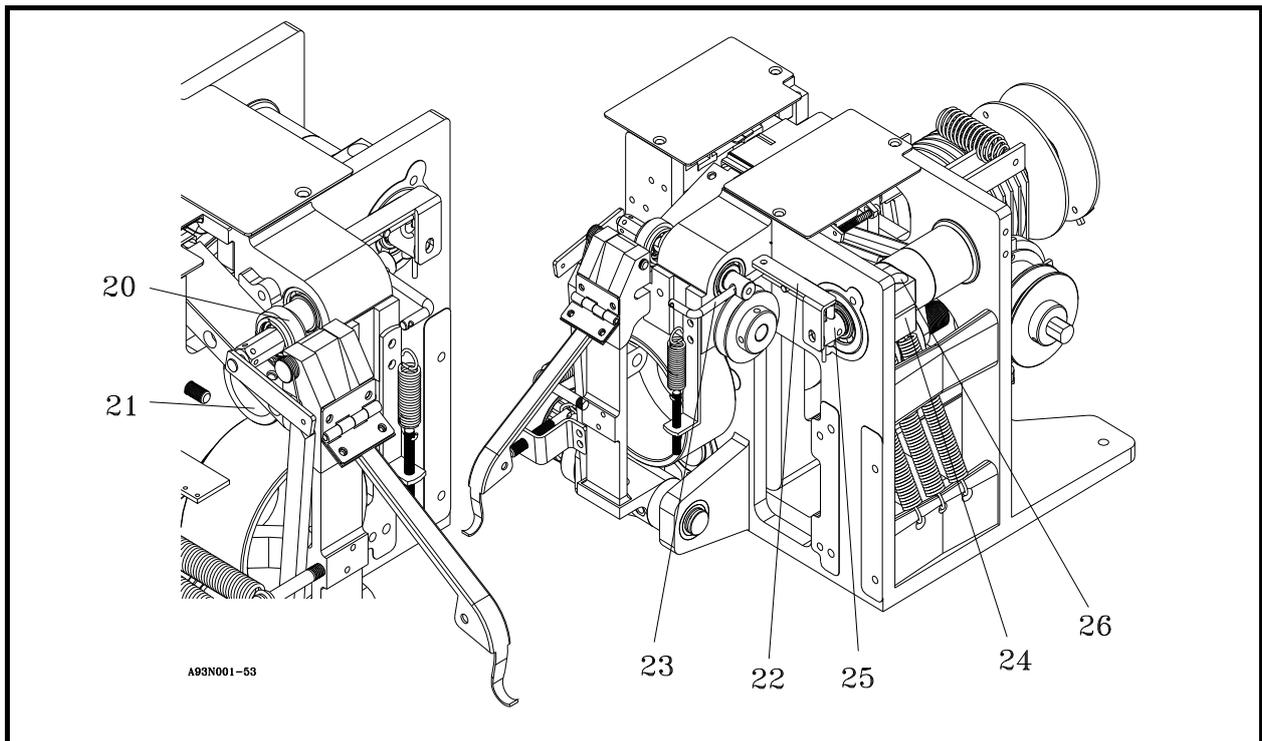
4.2 Heater temperature

Set dial at position 4 or 5 under normal usage.

Choose the suitable temperature, according to climate and working conditions of machine. Turn heater dial gradually higher or lower to select the proper temperature for best sealing.



Adjustment



4.3 Feeding / Retracting spring force

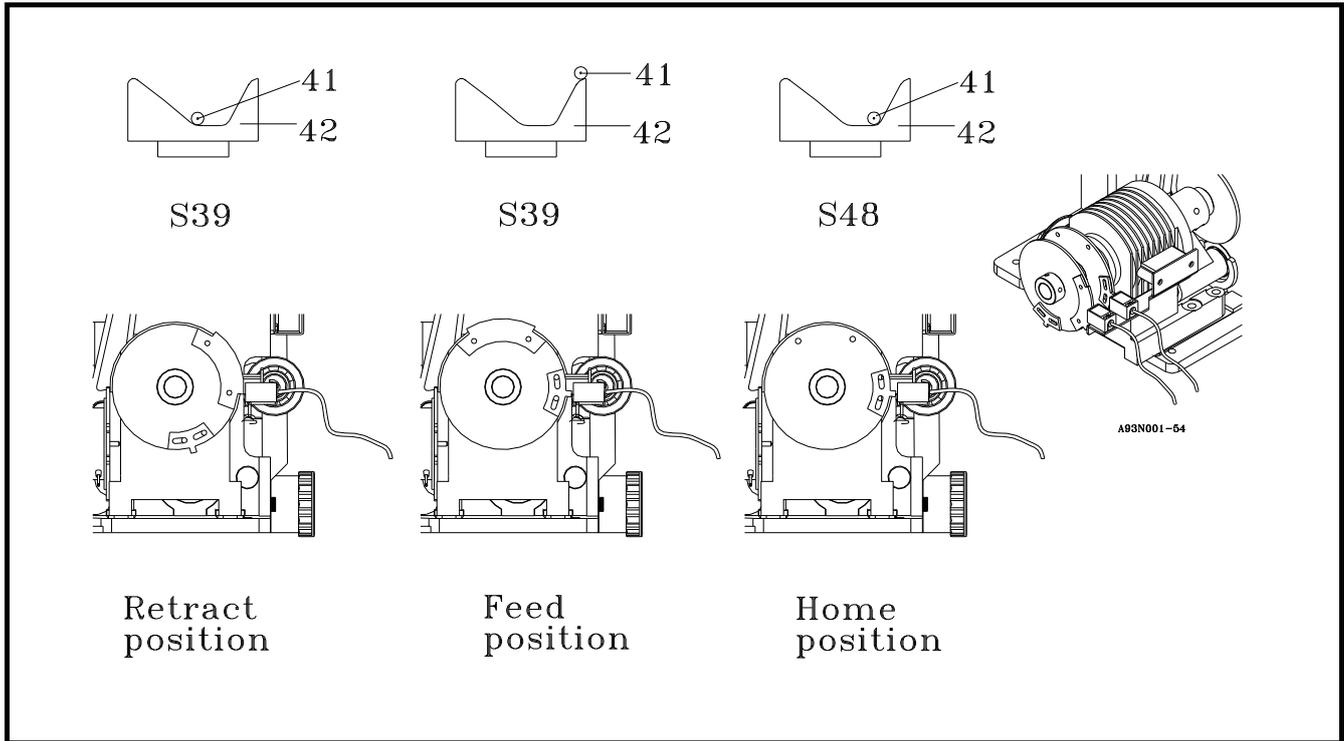
Adjust the clearance between related parts for keeping proper spring force on strap by feed roller (21) and upper roller (20) to ensure stable feeding and retracting process.

Original setting is for PP strap with thickness of 0,55mm - 0,65mm.

When thickness of strap varies, follow below steps to adjust the clearance between related parts:

1. Insert the strap between feed roller (21) and feed upper roller (20).
2. Loosen 2 bolts (26) holding the right-hand block arm (24) with the press arm shaft (25). Press arm shaft then moves easily by hand.
3. Adjust to have a clearance about the thickness of strap between the upper roller spring (22) and the upper shaft spring hook (23).
4. Tighten 2 bolts (26)

Adjustment



4.4 Home Positioning

Home position is determined by proximity sensor S48 and corresponding cam.

Execute one strapping cycle to confirm if the cam follow stops at the correct relative position (see drawing) with tension cam. If not, loose screw and rotate the cam appropriately to let proximity sensor S48 detecting the bulge point of cam for sending signal at appropriate time to stop cam shaft where cam follow just at the correct relative position with tension cam.

4.5 Retracting positioning

Retracting positioning is determined by proximity sensor S39 and first bulge part of corresponding cam.

Push Reset button once, cam shaft will rotate and stop at the retracting status where the cam follow is stop at the correct relative position with tension cam. (see drawing). If not, loose screw and rotate the cam appropriately to let proximity sensor S39 detecting the bulge point of cam for sending signal to stop cam shaft and makes cam follow stop at the correct relative position with tension cam.

4.6 Feeding positioning

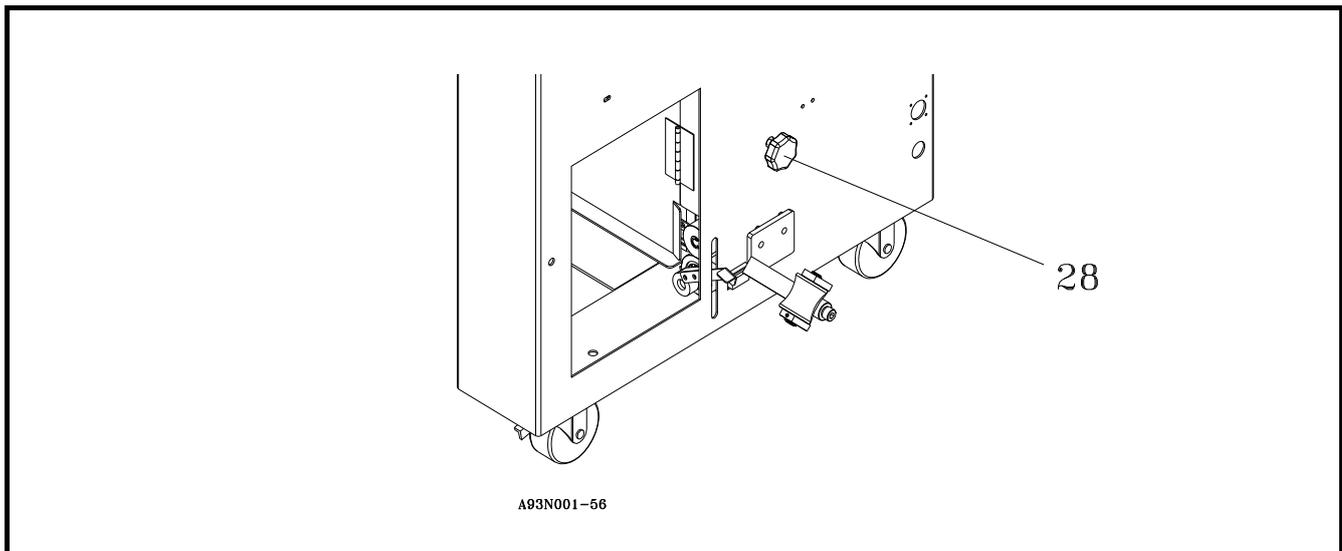
Feeding positioning is determined by proximity sensor S39 and second bulge part of corresponding cam.

Rotate the cam shaft turn reversely by pulling the V-belt until the cam follow is stop at the correct relative position (see drawing) with tension cam

(see drawing, three quarters of the cam follow just get over the peak profile of tension cam but one Quarter still hanging on the midair.)

Under above status, loose screw of the second bulge part of cam to adjust it to appropriate position for proximity sensor S39 detection. (light on).

Adjustment



4.7 Amount of strap magazine

1. In case amount of strap is insufficient in pool box, turn the star grip (28) counter-clockwise.
2. In case amount of strap is excessive in pool box, turn the star grip (28) clockwise.

4.8 Timer on PCB

— Timer F0

Timer F0 (or VR3) determines the time for strap retracting during strapping cycle. Set proper time (as short as possible but required to encircle the minimum size of package completely before execute second tension) .. Normally, timer F0 is set at about 0.4 seconds, but should be adjusted depending on the package size.

— Timer F1

Timer F1, determines the time for feeding the strap to the stopper at the sealing head The strap is fed according to the preset time on the dial of timer F1. If the setting time is too short, strap may not reach to the stopper at the sealing head and cause the feeding error. Normally, timer F1 is set at about 0.8 seconds, but may have to be adjusted depending on the arch size.

CHAPTER 5 : Troubleshooting

Troubleshooting

Trouble	Cause	Remedy
Machine does not work but pilot lamp is ON.	<ol style="list-style-type: none"> 1. E-button malfunction 2. Safety Switch malfunction 3. Overload Relay tripped or malfunction 4. Fuse blowout 	<ol style="list-style-type: none"> 1. Replacement 2. Replacement 3. Reset or replace overload relay 4. Replacement
Machine does not work and pilot lamp is OFF.	<ol style="list-style-type: none"> 1. Fuse blowout 2. Power supply malfunction (GS1) 3. No power 	<ol style="list-style-type: none"> 1. Replacement 2. Replacement 3. Check power supply
Strap feeding failed	<ol style="list-style-type: none"> 1. Proximity switch of short feeding malfunction 2. Motor malfunction 3. Pulley loosed 4. Improper adjustment of feeding spring 	<ol style="list-style-type: none"> 1. Replacement 2. Replacement 3. Tighten set screws of Pulleys 4. Proper adjustment of feeding spring position
Strap retracting failed	<ol style="list-style-type: none"> 1. Retracting time too short 2. Pulley loosed 3. Improper adjustment of retracting spring 4. Improper adjustment of arch flaps 5. Right and Left Bandway malfunction 	<ol style="list-style-type: none"> 1. Reset retracting time 2. Tighten pulley 3. Readjust gap of retracting spring (ref. to _____) 4. Readjust arch flaps 5. Adjust right and left bandway
Strap feeding out of arch or incessantly	<ol style="list-style-type: none"> 1. PC board transistor malfunction 2. PP strap out of arch flags due to big gap 3. PP strap out of right bandway due to incorrect height of left bandway 4. Left Bandway doesn't return 	<ol style="list-style-type: none"> 1. Replace PC board 2. Readjustment of arch flaps 3. Readjustment height of right bandway 4. Adjust Left bandway and make it working correctly
Package cannot be strapped well because of strap cannot escape from track flaps completely during retracting process.	<ol style="list-style-type: none"> 1. Force of retracting is weak 2. Left bandway doesn't open 3. Short retracting time 4. Improper spring gap of arch flaps 	<ol style="list-style-type: none"> 1. Readjust gap of retracting 2. Check if left bandway out of shape or damaged 3. Increase retracting time 4. Readjust arch flaps
Incessant retracting	<ol style="list-style-type: none"> 1. PC board transistor malfunction 2. Improper setting of retracting time 	<ol style="list-style-type: none"> 1. Replace PC board 2. Reset PC board

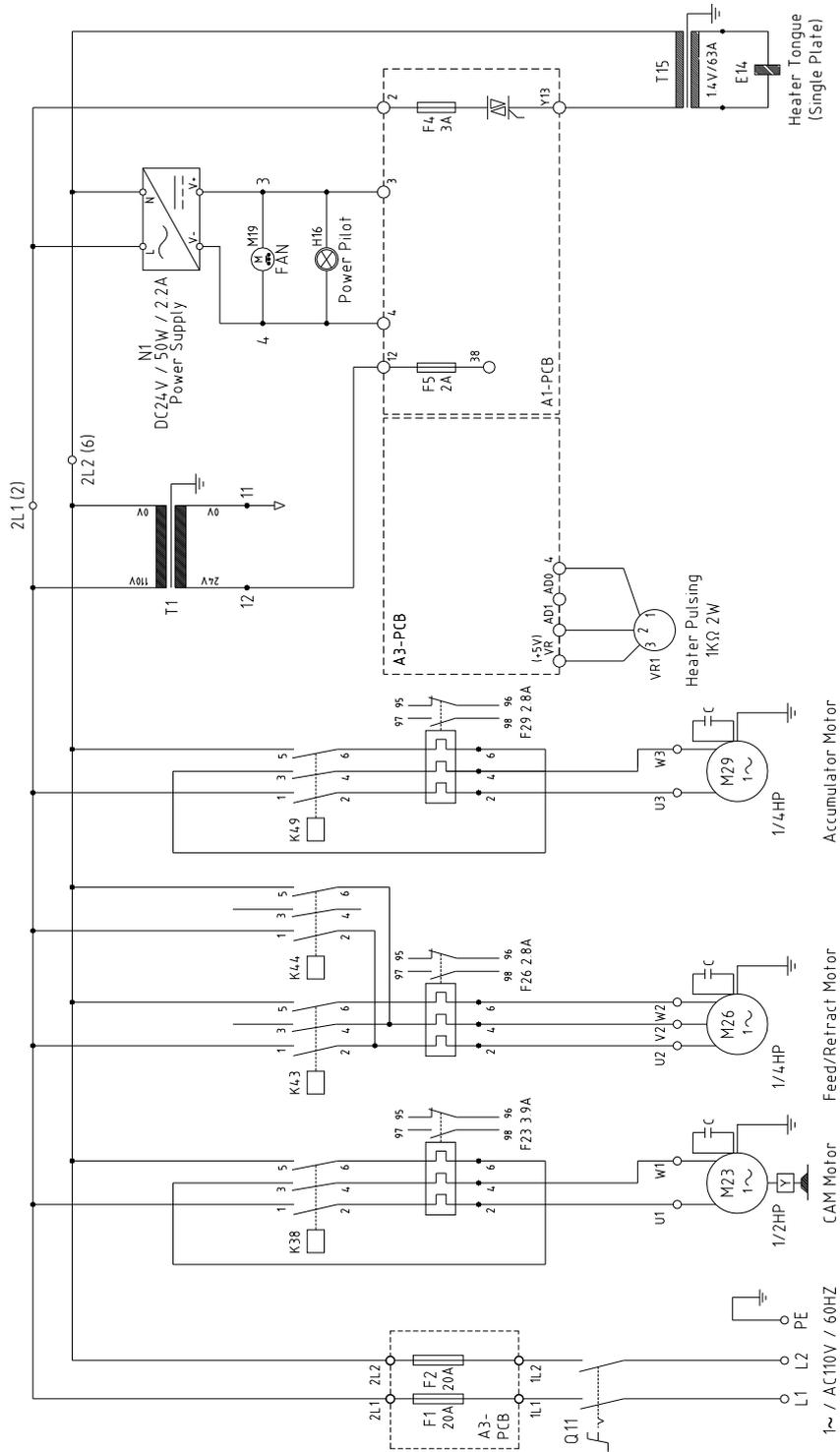
Troubleshooting

Trouble	Cause	Remedy
Abnormal mechanical movements after pushing start button, ex: marked points are out of alignment or cam shaft doesn't stop after cycle completed.	<ol style="list-style-type: none"> 1. Brake worn out 2. Proximity switch of Positioning malfunction (S48) 3. Reducer malfunction 4. Connecting shaft loosed between reducer and cam shaft 	<ol style="list-style-type: none"> 1. Readjust or replace 2. Replace proximity switch 3. Replace reducer 4. Tighten connecting shaft
Poor strap cutting	<ol style="list-style-type: none"> 1. Spring loosed or force is weak 2. Dull press bar or cutter gripper 	<ol style="list-style-type: none"> 1. Adjust spring of press bar 2. Replace press bar or cutter gripper
Strap feeding failed	<ol style="list-style-type: none"> 1. Force of feeding is weak 2. Arch flaps are blocked 3. Machine cannot feed PP strap through cutter gripper to sealing point due to incorrect height of right bandway 	<ol style="list-style-type: none"> 1. Adjust spring for feeding force 2. Clean up dust among arch flaps and track. 3. Adjust height of right bandway and fix it.
Temperature of heater abnormal	<ol style="list-style-type: none"> 1. Temperature too high (System crashed) 2. PC board transistor malfunction 3. Heater is cold, fuse blowout or heater plate broken 	<ol style="list-style-type: none"> 1. Reboot machine 2. Replace PC board 3. Replace fuse or heater plate
Temperature of heater plate correct but poor sealing	<ol style="list-style-type: none"> 1. Poor movement of heater set slide 2. Carbon deposition on heater plate 3. Both sides of strap are not aligned 	<ol style="list-style-type: none"> 1. Clean up slide 2. Clear up carbon deposition 3. Adjust right and left bandways
Auto loading function unworkable	<ol style="list-style-type: none"> 1. Proximity switch of accumulation failed 2. B1 Proximity switch malfunction 3. Proximity switch of short feeding malfunction 4. Auto loading switch malfunction 	<ol style="list-style-type: none"> 1. Adjust gap between Alu. Lever and proximity switch 2. Adjust position of sensor lever or replace proximity switch 3. Clean up and adjust short feeding sensor lever or replace proximity switch 4. Replacement
Lack of tension	<ol style="list-style-type: none"> 1. Poor movement of tension Jaw 2. Worn tension Jaw 3. Tension jaw spring disconnected or broken 	<ol style="list-style-type: none"> 1. Clean up actuated position 2. Replacement 3. Replace jaw spring correctly
Volume of accumulator too much or too little.	<ol style="list-style-type: none"> 1. Poor movement of Alu. lever. 2. Stretching bolt loosed and position moved 	<ol style="list-style-type: none"> 1. Clean up shaft or replace bearing 2. Lock it properly after readjustment

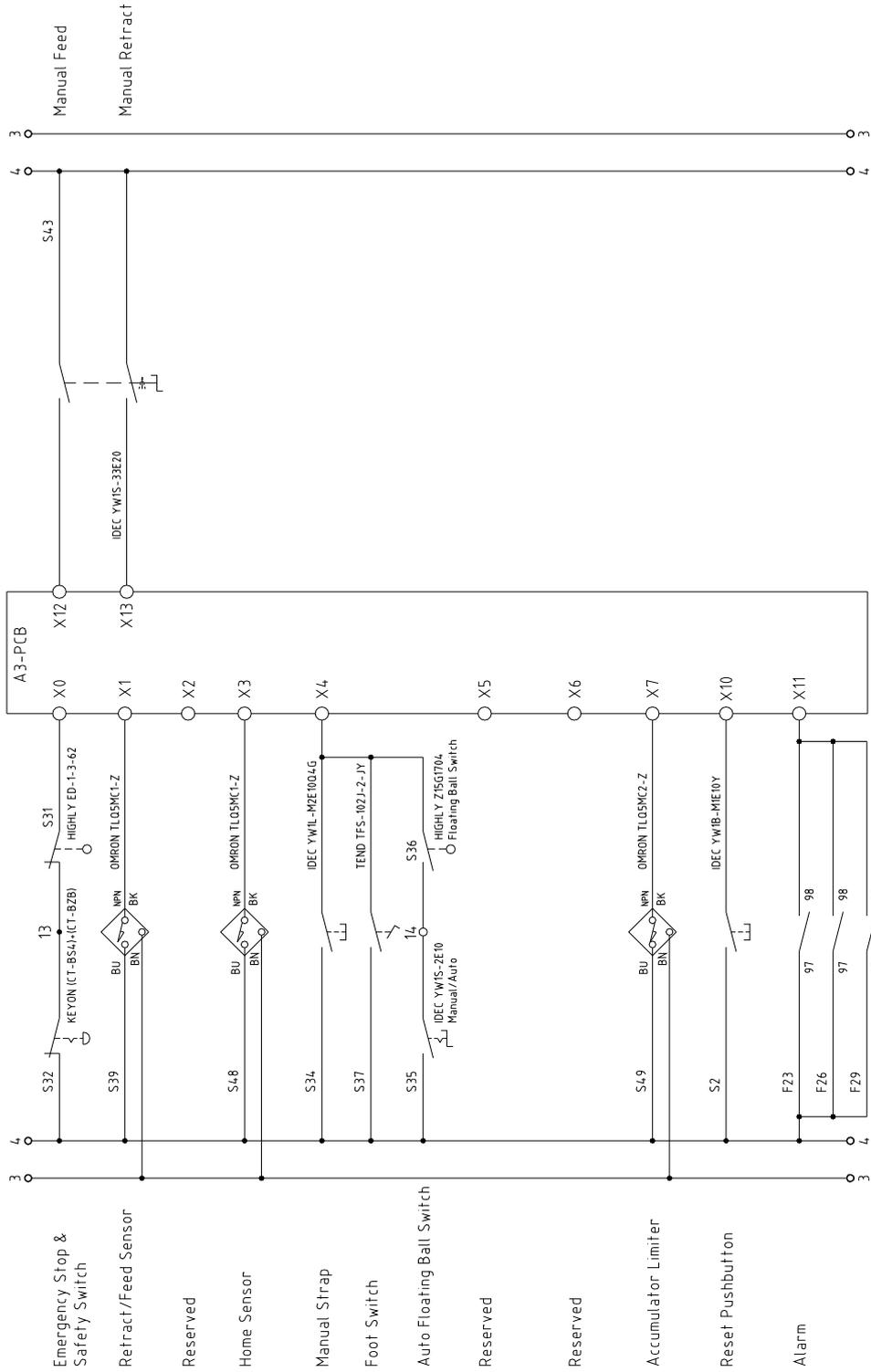
CHAPTER 6 : Electrical diagram

6.1

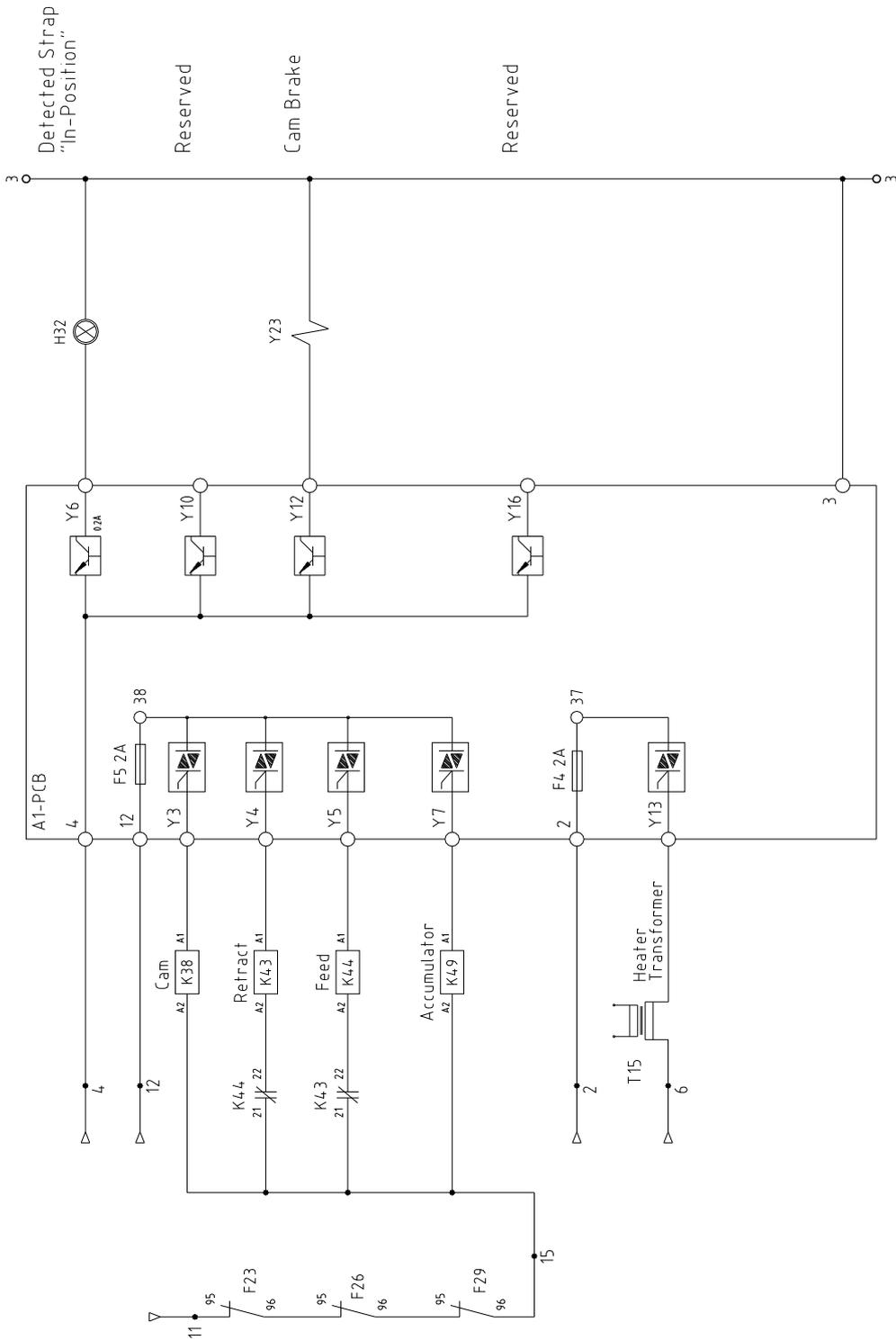
Main circuit



Input Connecting Diagram



Output Connecting Diagram

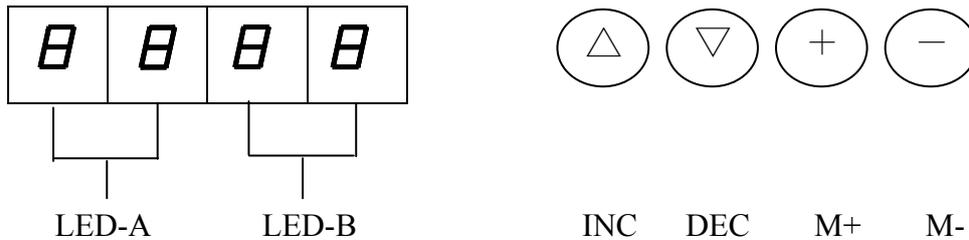


Parameter	Description	Range	Unit	Ex work setting
P0	Reserved	00—01		
P1	Start the machine 00 → YES / 01 → NO	00—01		
P2	Reserved	00—01		
P3	Looping ejector 00 → NO / 01 → YES	00—01		
P4	Looping numbers range 00 → (75-174) / 01 → (164-263)	00—01		
P5	Reserved	00—01		
P6	Retracking / Feeding time 00 → 0.1S / 01 → 0.01S	00—01		
P7	Re-feeding 00 → NO / 01 → YES	00—01		
F0	Retracking time P6=00	0.02—0.99S	0.01S	
	Retracking time P6=01	0.2—9.9S	0.1S	
F1	Feeding time P6=00	0.05—0.99S	0.01S	
	Feeding time P6=01	0.5—9.9S	0.1S	
F2	Weld cooling position	0.25—0.60S	0.01S	
F3	Weld cooling time	0.0—1.0S	0.1S	
F4	Heater temperature lower limit (250~300°C)	10—38%	1%	
F5	Heater compensate time	1.5—6.0S	0.1S	
F6	Instant heating time	25—35S	1S	
F7	Heating temperature upper limit (400~450°C)	41—95%	1%	
E0	Heater delay position (PET)	0.10—0.60S	0.01S	
E1	Heater delay time (PET)	0.10—0.40S	0.01S	
E2	Re-retraction counter(with looping ejector)	00—99	Pulse	
E3	Re-feeding time (with looping ejector)	0.10—0.70S	0.002S	
E4	Feeding in position 00 → NO / 01 → YES	00—01		
E5	Reserved			
E6	Store the settings			
E7	Recover to ex-work setting			
H0	Reserved	Looping numbers: Tens digit / Units digit		N/A
H1	Reserved	Looping numbers: Hundreds digit		N/A
H2	Counter	1st, 2nd digit , XXXXXX88		N/A
H3	Counter	3st, 4nd digit , XXXX88XX		N/A
H4	Counter	5st, 6nd digit , XX88XXXX		N/A
H5	Counter	7st, 8nd digit , 88XXXXXX		N/A
H6	Manufacture month	Read only		N/A
H7	Manufactured year	Read only		N/A

LED Alarm & Warnings

AL00	Main shaft doesn't rotate or S39,48 Alarm	AL04	Reserved
AL01	Short feeding	AL05	B2 Sensor non-counting
AL02	Reserved	AL06	Motor Overload (Alarm)
AL03	Reserved	AL07	Reserved

A93N PCB Settings



(A)

1. LED-A : Functions mode.
2. LED-B : Parameter values.
3. INC : Function mode increase P0→P7→F0
4. DEC : Function mode decrease P0→H7→E7
5. M+ : Increasing of Parameter value.
6. M- : Decreasing of Parameter value.

(B) Procedures of functions parameter settings

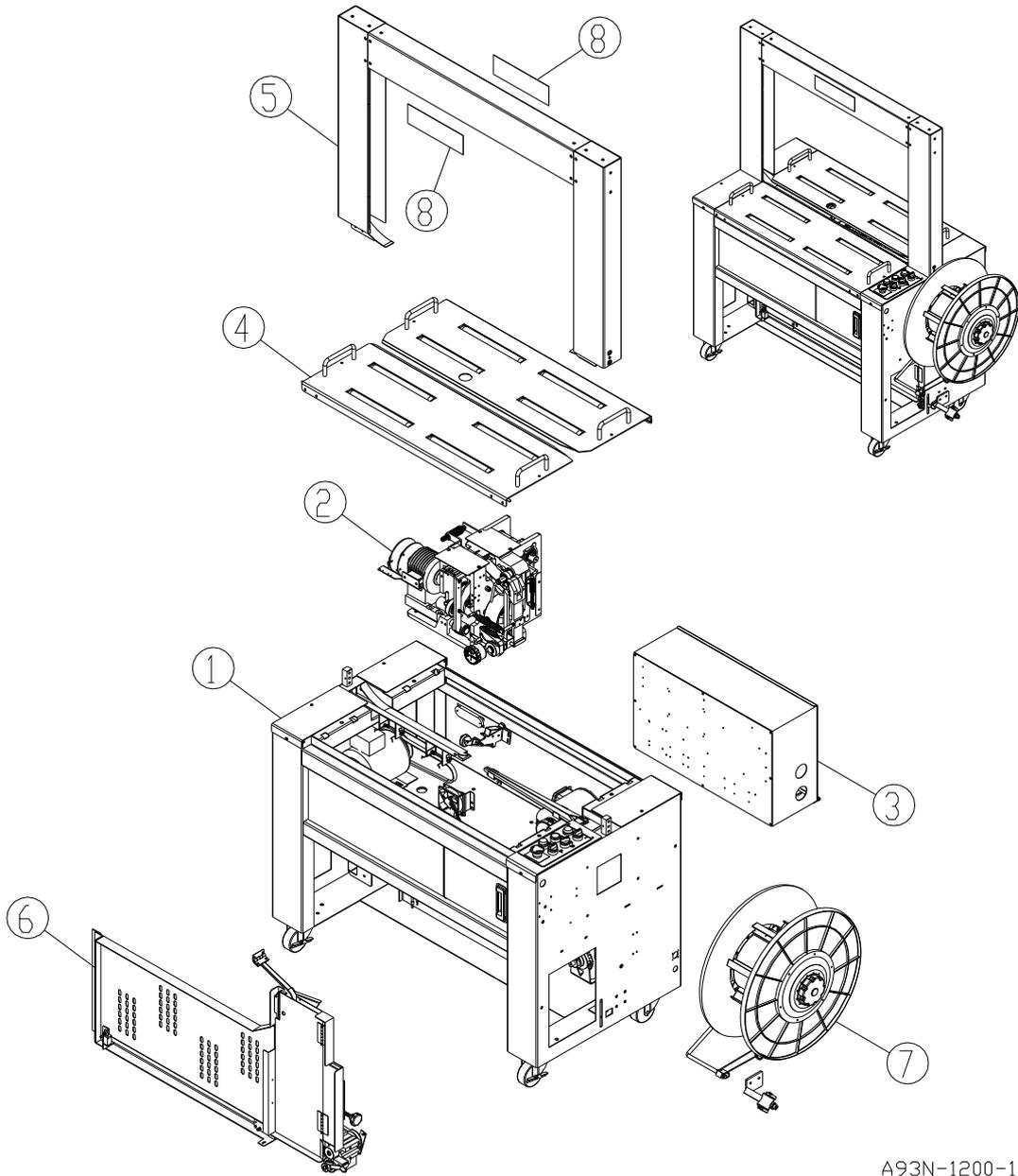
- (1) Push “M+”“M-” Simultaneously for 3 seconds then LED Flashing which means enter in setting mode.
- (2) Push “M+”or“M-”to select the function mode.
- (3) To push “INC”or“DEC” to change the parameters values.
- (4) To store the value by pushing “M+”and“M-” simultaneously.
- (5) If idle for 3 minutes then LED returns to counter automatically.

(C) Read mode

To push either “M+”or“M-”to read the current setting values.

Part List

General unit



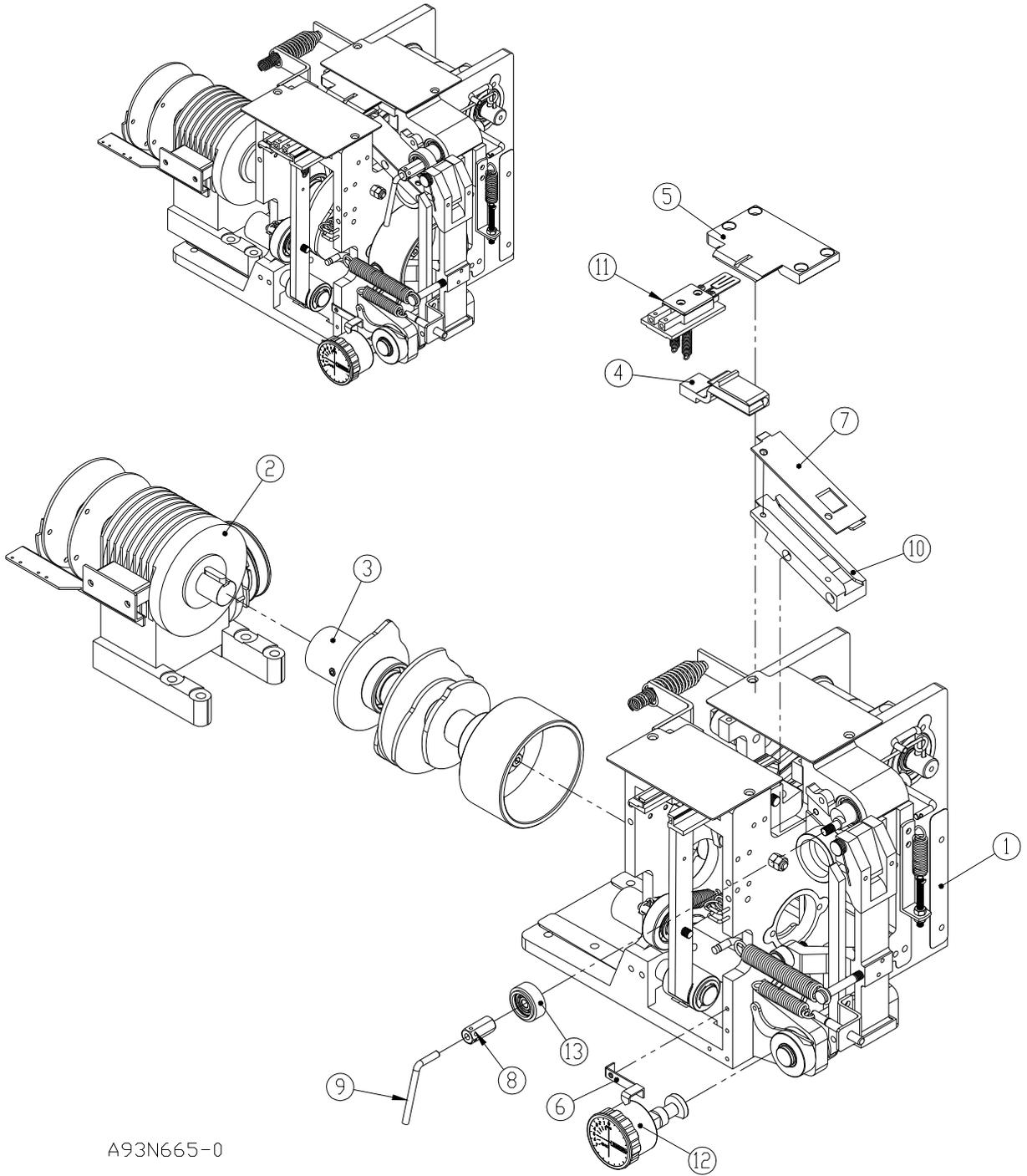
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7.0

General unit

No.	Part No.	Part Name	Q'TY
1	CA93N-300108-0	Body Unit	1
2	CA93N-100013-0	Control Unit 12mm	1
3	A93N-220000-0	Electric Control Box Unit	1
4	A93N-300000-0	Table Unit	1
5	A93-410000-0	Arch Unit(850Wx600H)	1
6	A93N-580000-0	Pool Unit	1
7	A20-670000-120	Reel Unit(200mm)	1
8	P08-100106-0	Sticker	2

Control unit

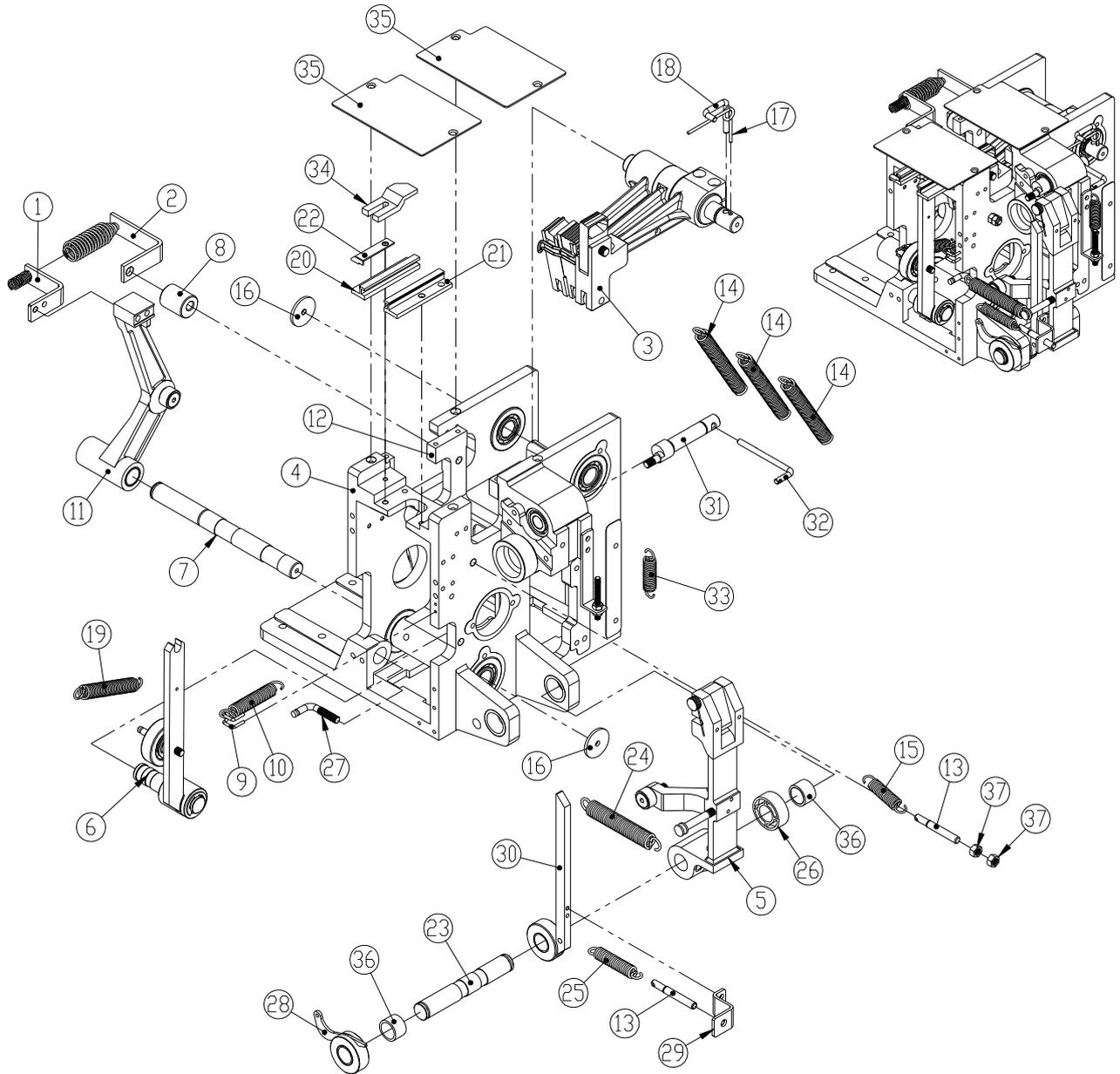


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Control unit

No.	Part No.	Part Name	Q'TY
1	CA93N-101001-0	Control Unit	1
2	CA93N-102001-0	Reducer Unit	1
3	A20-111000A	Cam	1
5	A20-120003-2-DAA	Slide Table 12mm	1
6	A20-163009	Tightness Index	1
7	A20-171008	Feed Shooter Cover	1
8	A20-171011-0	Screw	1
9	A20-171012-1	Lever	1
10	A20-171013-0-DAA	Feed Shooter (12mm)	1
4	A20-120007	Guide Block	1
11	BA14001	Heater Assembly	1
12	BA16002	Tension Adjustment Cam	1
13	BA17001-DAA-01	Feed Upper Roller	1

Sealing Head Assembly

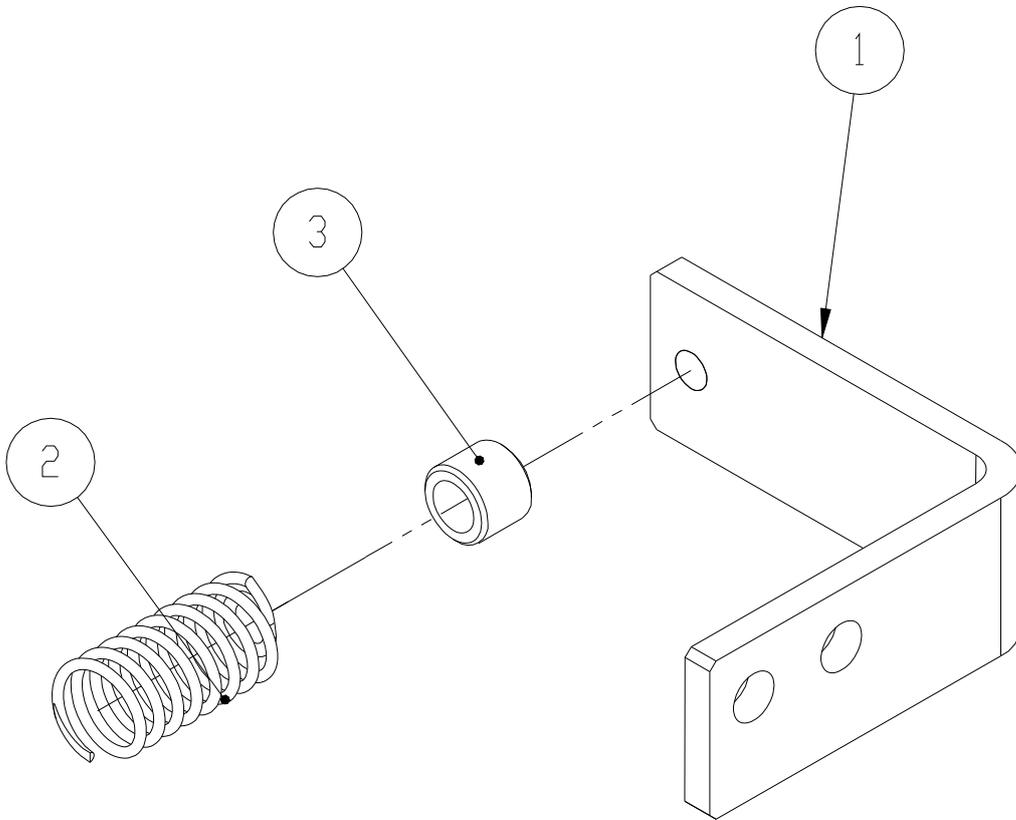
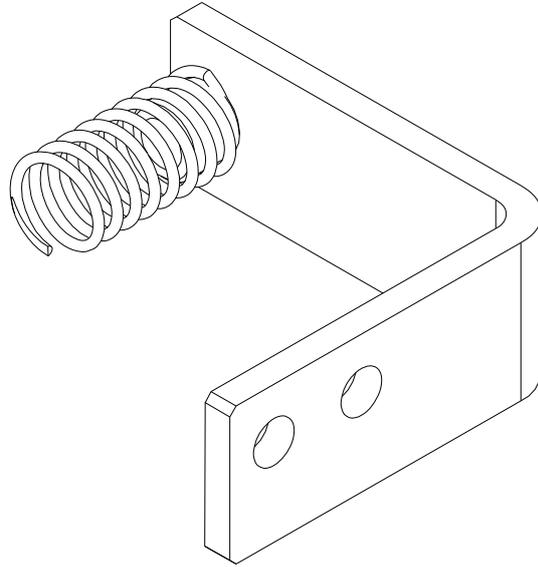


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Sealing Head Assembly

No.	Part No.	Part Name	Q'TY
1	BA12001	Flap Connecting Spring Bracket (Short)	1
2	BA12002	Flap Connecting Spring Bracket (Long)	1
3	BA13001	Cutter and Press Bar Set	1
4	BA15001	Sealing Head Base	1
5	BA16004	Tension Arm Set	1
6	A11-142100	Heating Arm Set A2	1
7	A20-120002	Shaft	1
8	A20-120004-1	Guiding Arm Baffle	1
9	A20-120011	Spring Hook	1
10	A20-120012	Spring	1
11	A20-121000A	Strap Guide Arm	1
12	A20-123050	Bracket	1
13	A20-130002	Hook Block	2
14	A20-130005	Spring	3
15	A20-130006	Spring	1
16	A20-130007	Spacer	2
17	A20-130010-0	Spring	1
18	A20-130011-0	Tension Arm Adjustment Rod	1
19	A20-140002	Spring	1
20	A20-140003	Guide Block	1
21	A20-140004	Guide Block	1
22	A20-140007	Stop pad	1
23	A20-160001	Tension Arm Shaft	1
24	A20-160002	Tension Arm Spring	1
25	A20-160003	Spring	1
26	A20-160004-1	Collar	1
27	A20-160006-1	Tension Spring Hook	1
28	A20-164000	Tension Adjustment Unit	1
29	A20-165003	Spring Adjustment Plate	1
30	A20-165100	Tension Adjustment Arm Unit	1
31	A20-171003	Roller Shaft	1
32	A20-173002	Spring Rod	1
33	A20-173004	Spring	1
34	A25-110007-0	Bandway Stop Block	1
35	A93N-150003-0	Plate	2
36	G13-202516	Bearing Ring 20x25x16L	2
37	W15-110800	NUT-M8x6.5tx12	2

Flap Connecting Spring Bracket Assembly



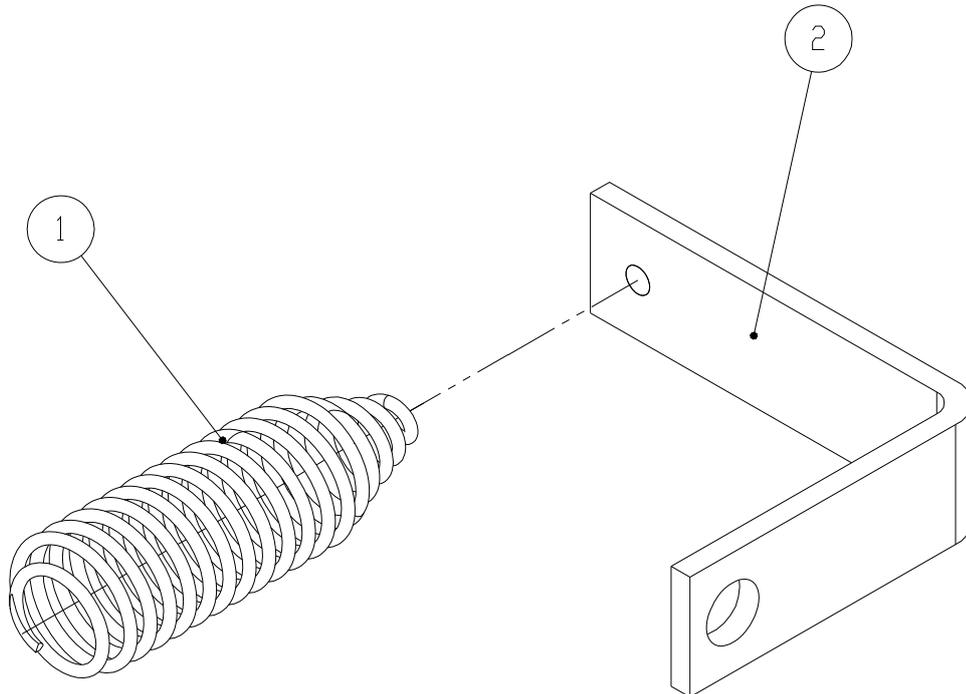
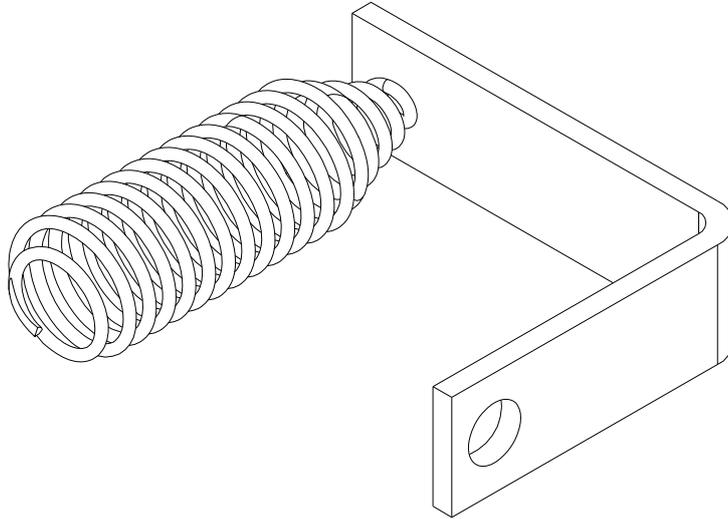
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Flap Connecting Spring Bracket Assembly

No.	Part No.	Part Name	Q'TY
1	A20-120008	Flap Connecting Spring Bracket	1
2	A20-410003	Spring	1
3	A77-500010-0-HAA	Collar	1

Spring Bracket Assembly(Long)



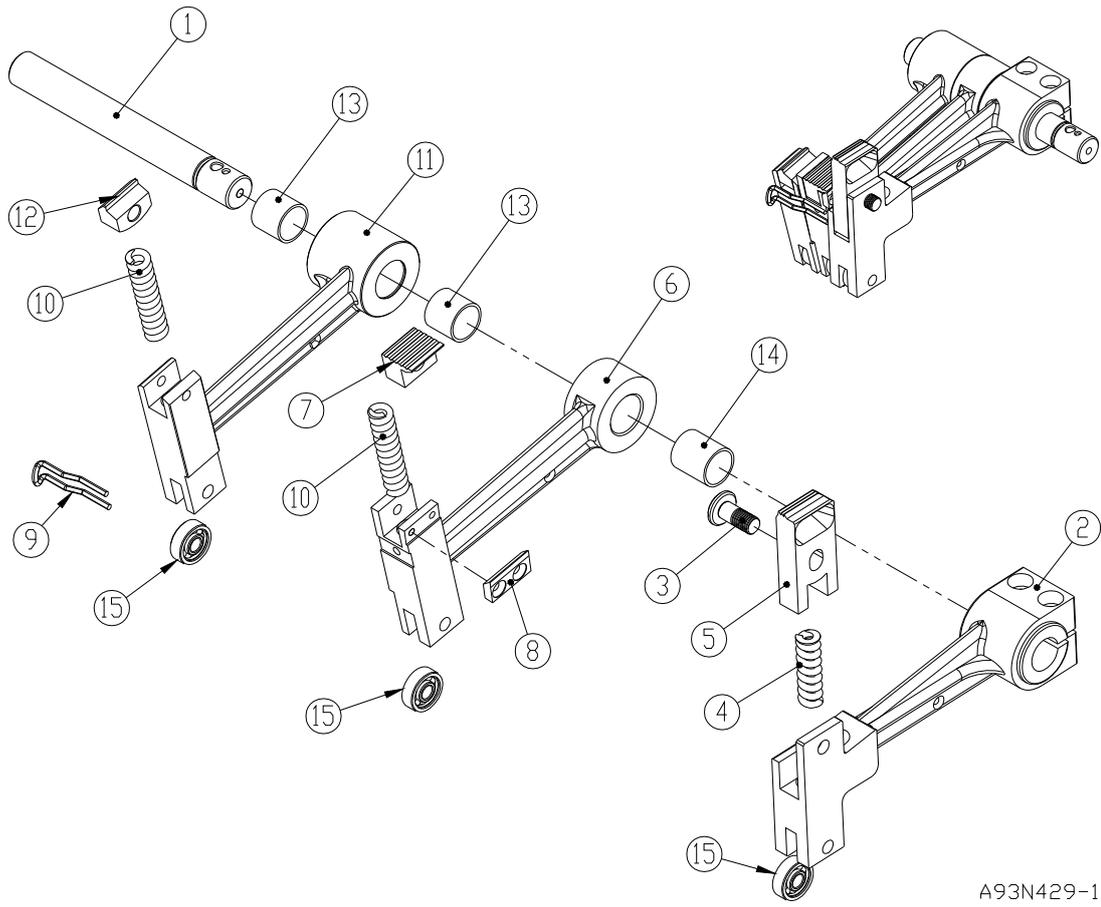
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Spring Bracket Assembly(Long)

No.	Part No.	Part Name	Q'TY
1	A20-122001	Band Guide Spring	1
2	A20-122002	Band Guide Spring Bracket	1

Cutter Unit



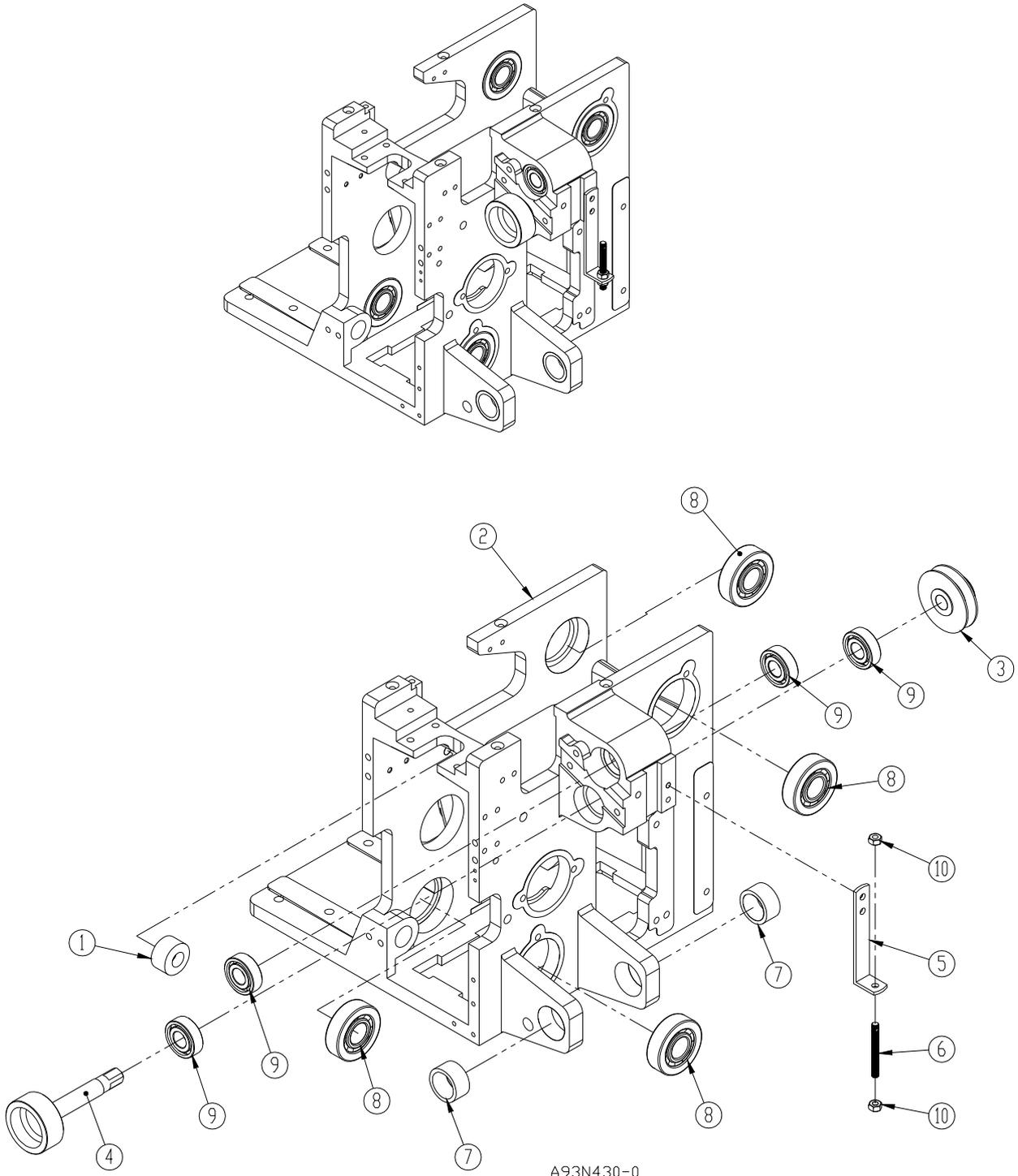
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Cutter Unit

No.	Part No.	Part Name	Q'TY
1	A20-130001	Shaft	1
2	A20-131001	RH, Block Arm	1
3	A20-131003-1	Cutter Upper Rod	1
4	A20-131004-1	RH. Block Spring	1
5	A20-131005-0	Cutter Upper	1
6	A20-132001	Center Block Arm	1
7	A20-132002	Universal Press	1
8	A20-132003-1	Cutter Lower	1
9	A20-132004	Cutter Spring Hook	1
10	A20-132005	LH & Center Block Spring	2
11	A20-133001	LH. Block Arm	1
12	A20-133002	Jaw Left	1
13	G01-202320	Metal Bush, MB2020	2
14	G01-202325	Metal Bush	1
15	G04-210628	Ball Bearing 628ZZ	3

Control Frame Unit



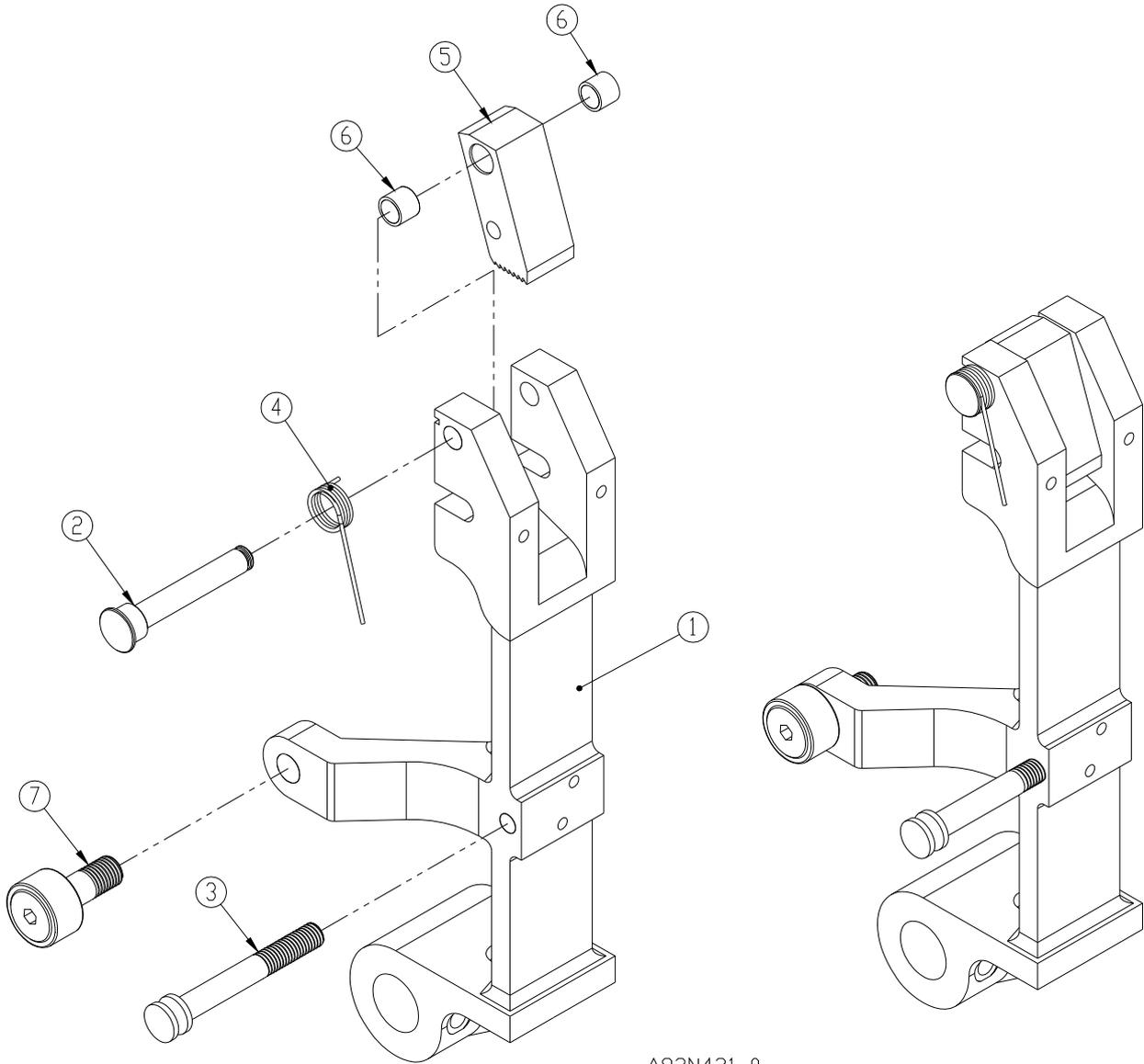
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Control Frame Unit

No.	Part No.	Part Name	Q'TY
1	A20-120005-1	Side Table Stop Block	1
2	A20-150001	Control Frame	1
3	A20-171006	Feed Roller Pulley M3	1
4	A20-171201-CR	Feed Roller	1
5	A20-173001	Fixed Plate	1
6	A20-173003	Upper Adjust Spring Rod	1
7	G10-253216	Needle Bearing 25x32x16L	2
8	G04-216304	Ball Bearing 6304ZZ	4
9	K1930140154	Ball Bearing(C-52)(6202 -2RS)	4
10	W15-110600	Nut M6	2

Tension Arm Unit



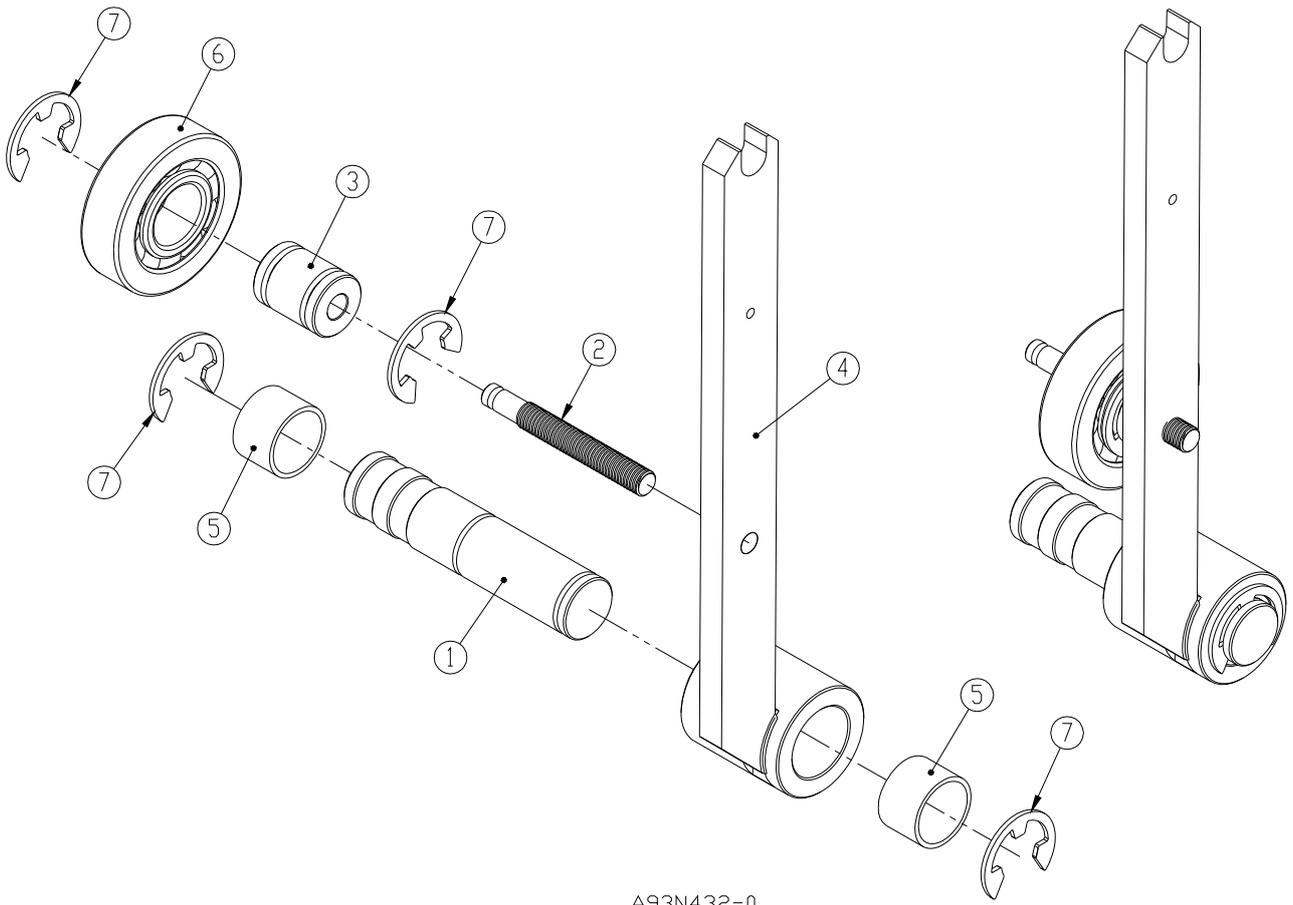
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Tension Arm Unit

No.	Part No.	Part Name	Q'TY
1	A20-161001-0	Tension Arm	1
2	A20-161002-1	Tension jaw Shaft	1
3	A20-161003	Tension Arm Spring Hook	1
4	A20-161004-2	Spring	1
5	A20-162001-1	Tension Jaw(PP)	1
6	G01-081008	Metal Bush, MB0808	2
7	G07221210	Cam Follower, KR22xLL	1

Heater Arm Unit



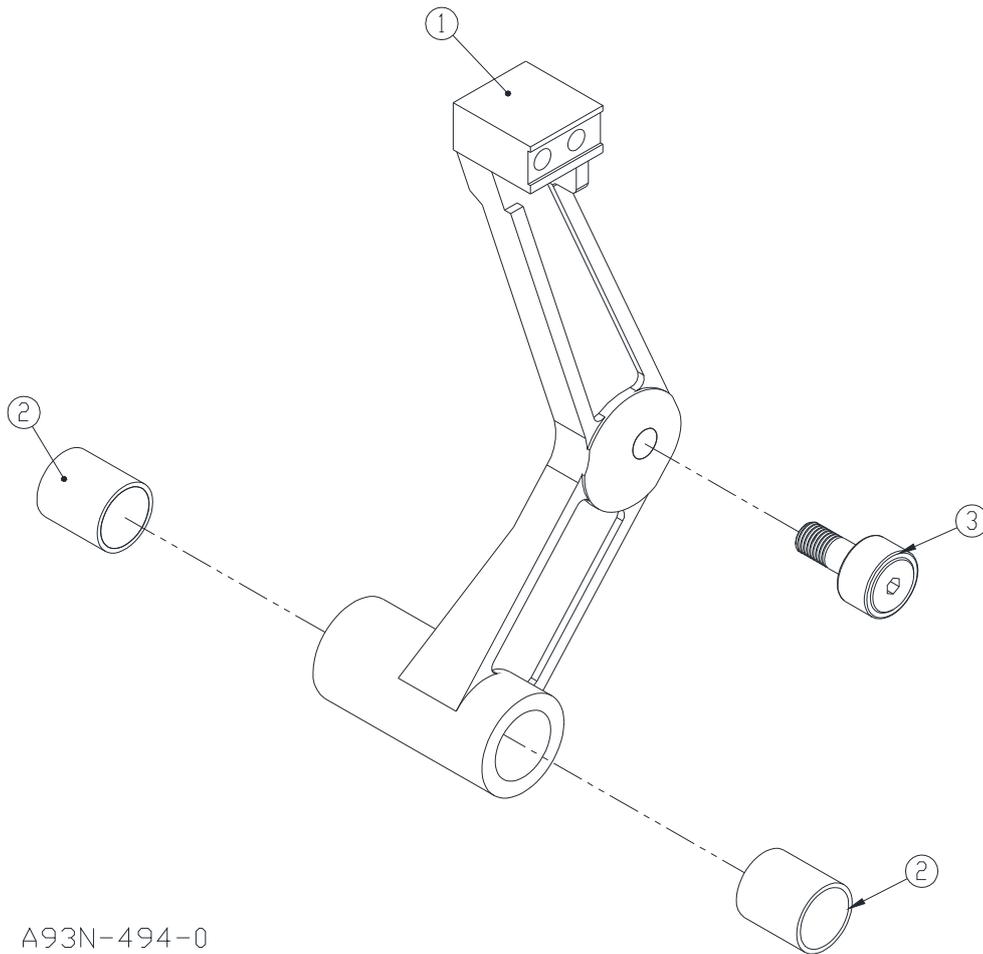
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Heater Arm Unit

No.	Part No.	Part Name	Q'TY
1	A20-140005	Shaft	1
2	A20-142002-1	Heater Arm shaft	1
3	A20-142003	Collar	1
4	A11-142150-1	Heater Crank	1
5	G01-202315	Metal Bush, (20x23x15)	2
6	G04-216304	Ball Bearing 6304ZZ	1
7	W33-030150	E-Type Stop Ring (E15)	4

Guide Arm Unit



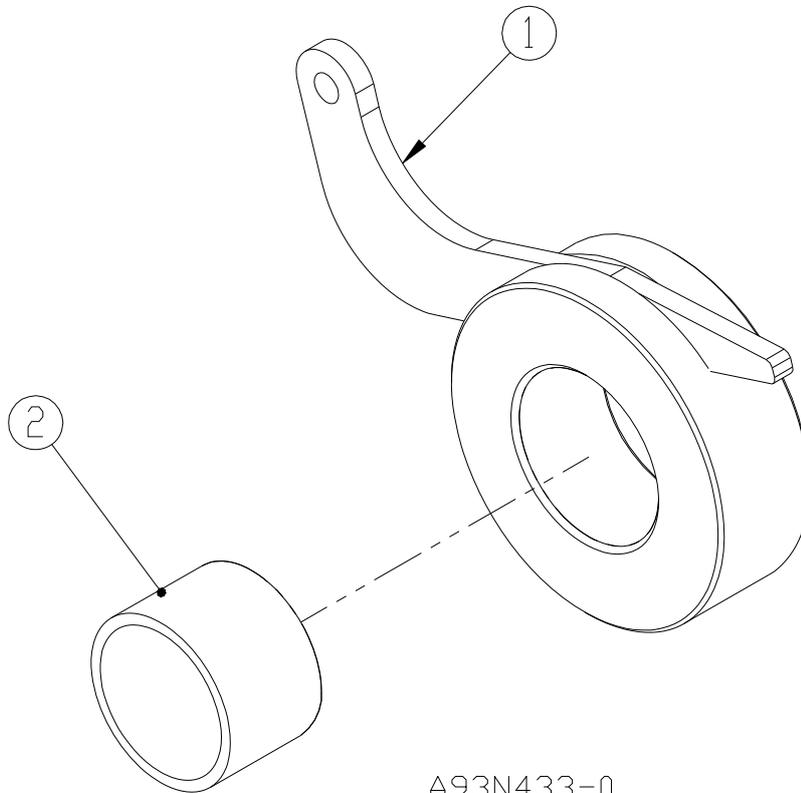
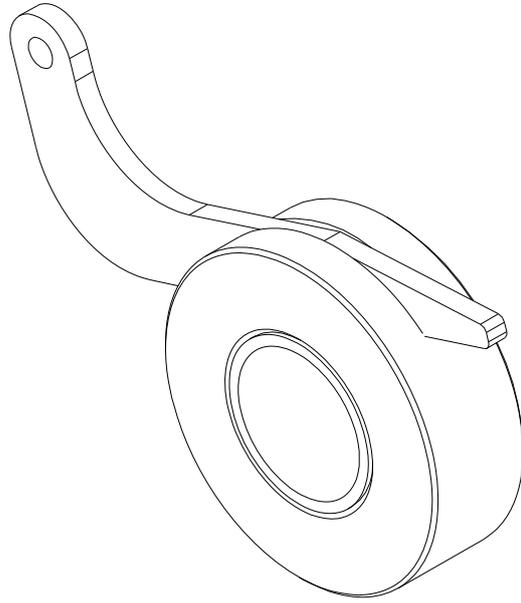
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Guide Arm Unit

No.	Part No.	Part Name	Q'TY	Remark
1	A20-121001	Guide Arm	1	
2	G01-202325	Metal Bush	2	20x23x25
3	G07221210	Cam Follower, KR22xLL	1	CF10VB

Tension adjustment Unit



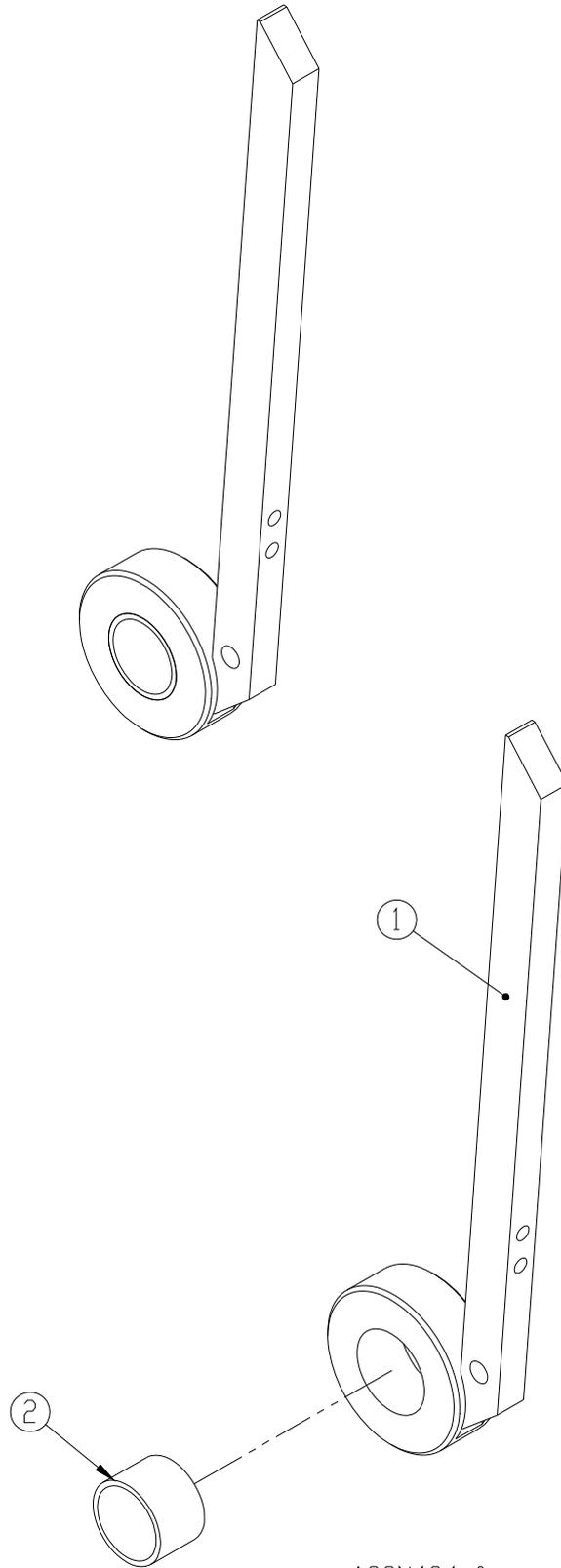
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7.10

Tension adjustment Unit

No.	Part No.	Part Name	Q'TY	Remark
1	A20-164150	Tension adjustment Base	1	
2	G01-202315	Metal Bush, (20x23x15)	1	

Elastic adjustment Arm Unit



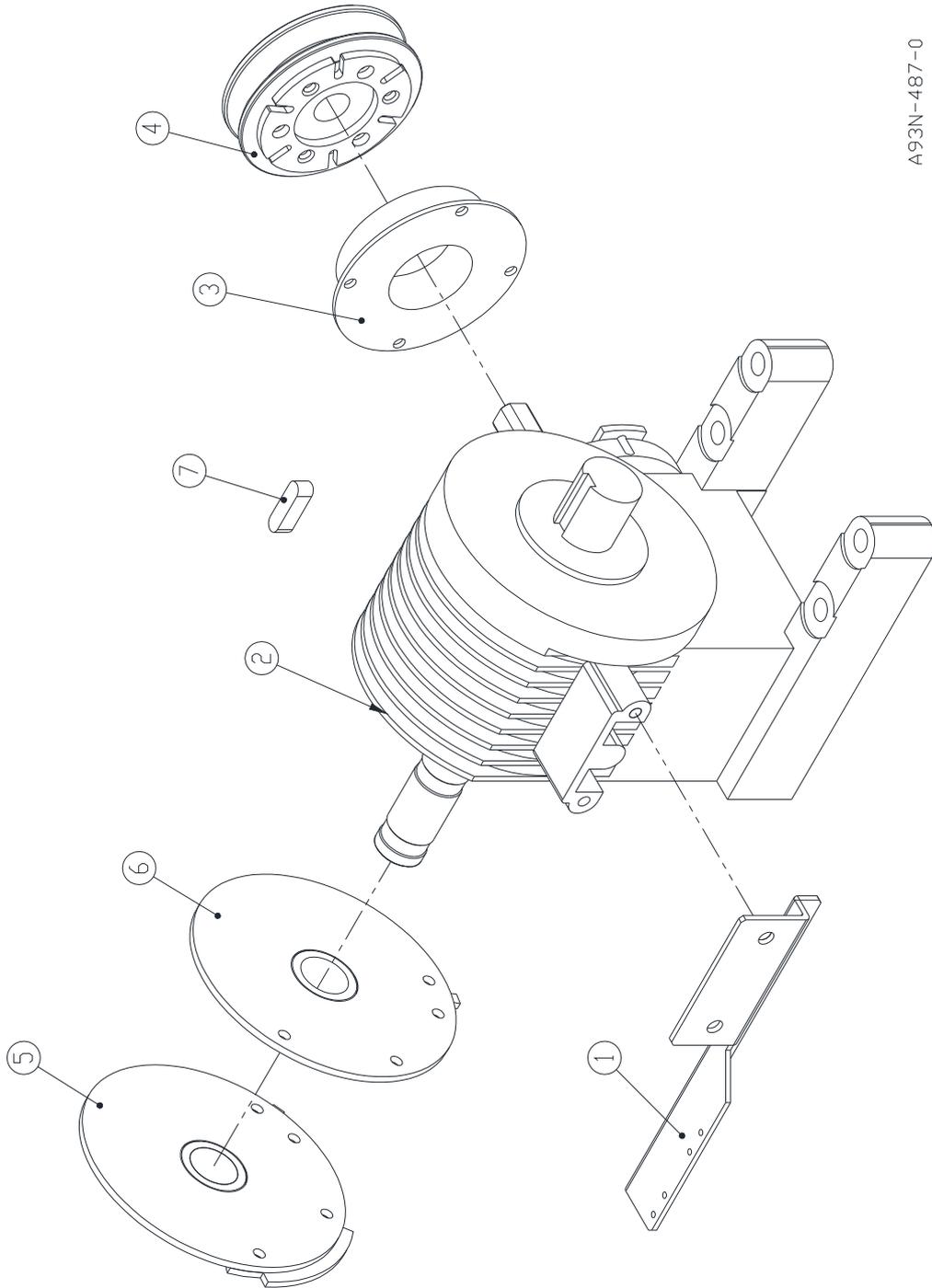
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7.11

Elastic adjustment Arm Unit

No.	Part No.	Part Name	Q'TY	Remark
1	A20-165150-1	Elastic adjustment Arm	1	
2	G01-202315	Metal Bush, (20x23x15)	1	

Reducer Unit

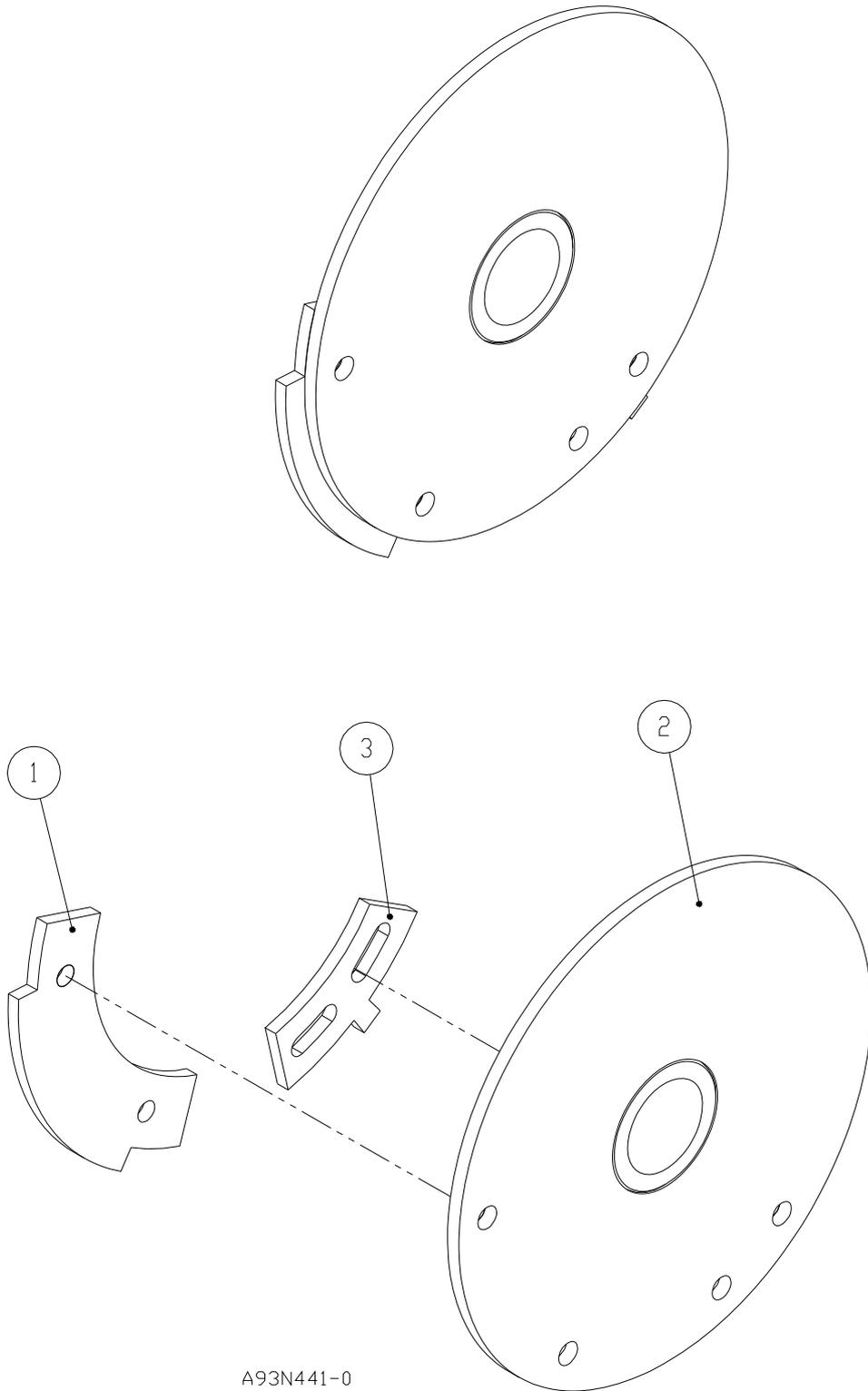


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7.12

Reducer Unit

No.	Part No.	Part Name	Q'TY
1	A20-110018-0	Proximity Switch Fixed Socket	1
2	A93-112000	Reducer	1
3	E21010002S	Stator 111-06-13S	1
4	BA11001	Pulley	1
5	BA11002	Sensor Cam Unit	1
6	BA11003	Sensor Cam Unit	1
7	W35-070725	Key 7x7x25L	1

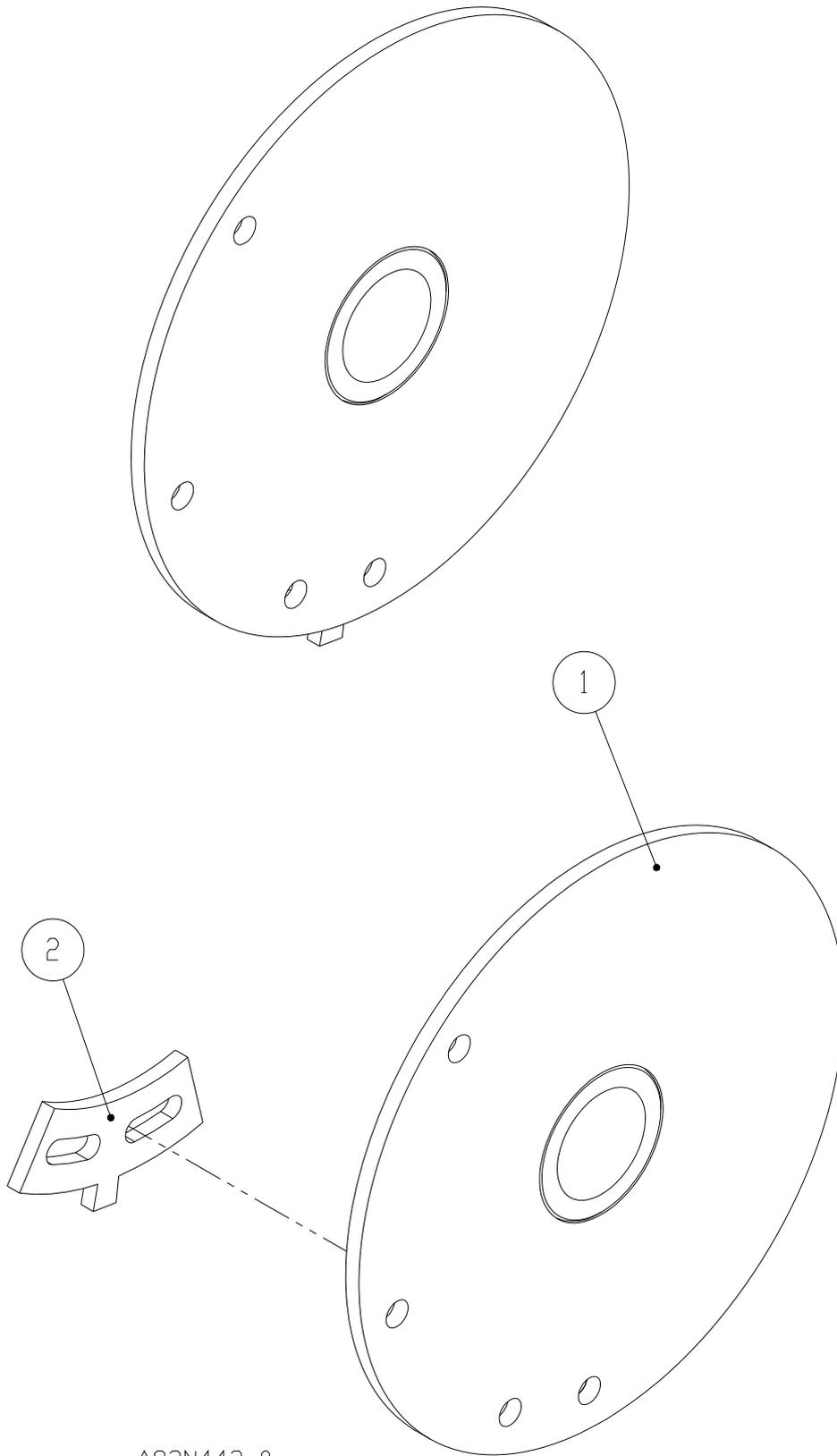


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7.13

Sensor Cam Unit

No.	Part No.	Part Name	Q'TY	Remark
1	A20-113001-0	Sensor Block	1	
2	A20-113250-0	Sensor Cam Unit	1	
3	A20-114001-0	Sensor Block	1	



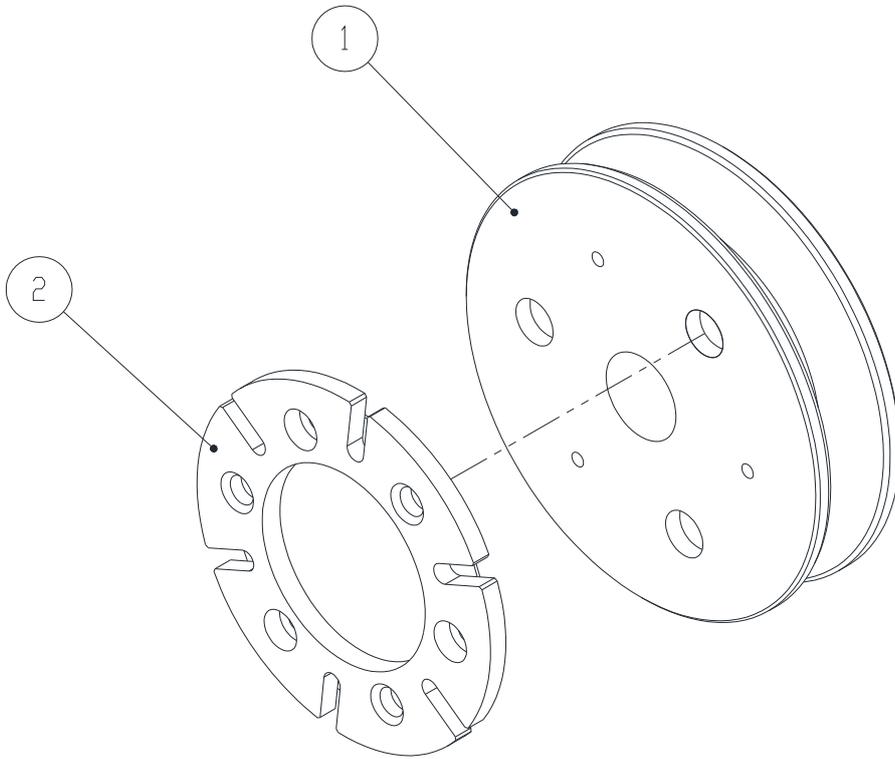
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7.14

Sensor Cam Unit

No.	Part No.	Part Name	Q'TY	Remark
1	A20-113250-0	Sensor Cam Unit	1	
2	A20-114001-0	Sensor Block	1	

Pulley Unit



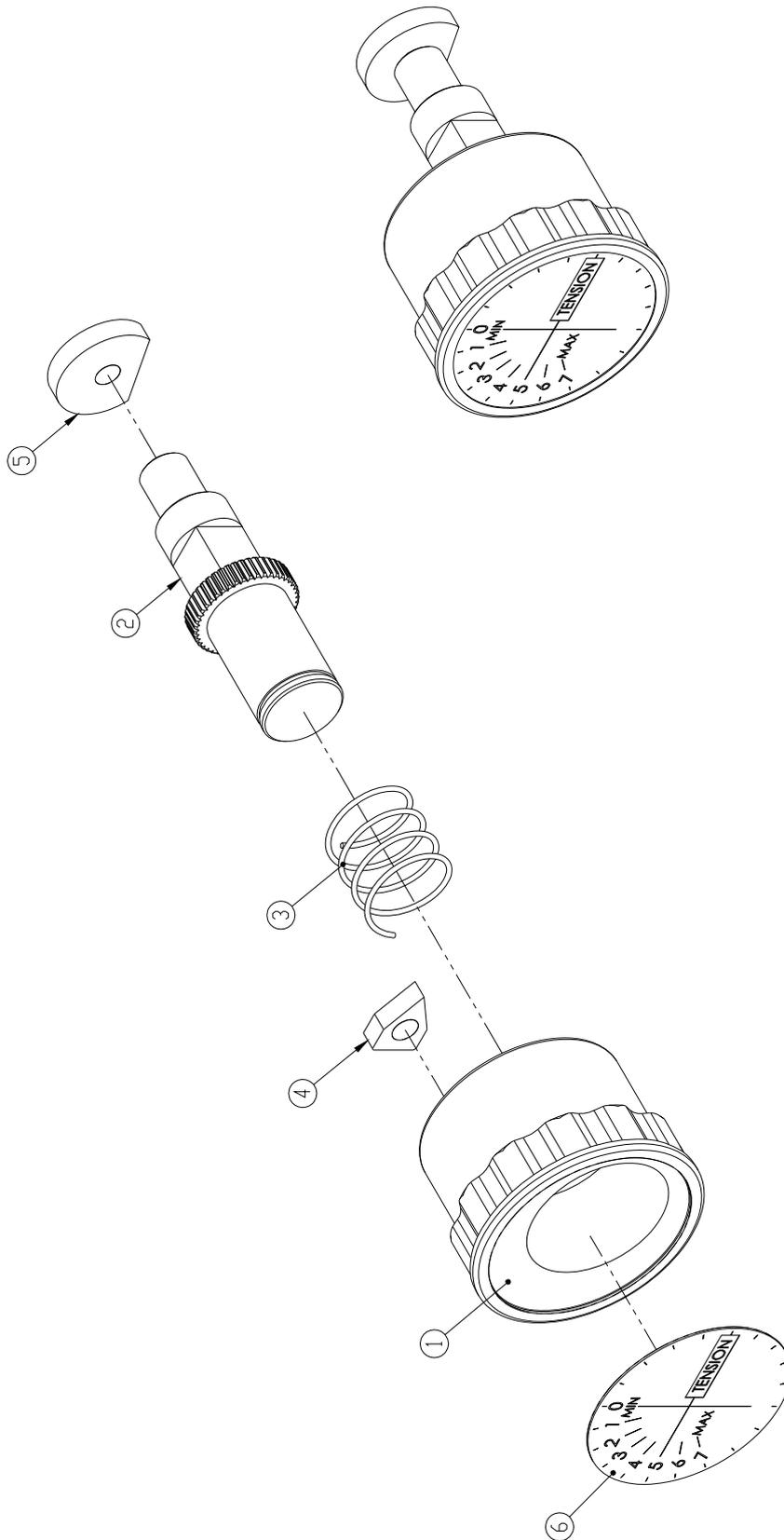
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7.15

Pulley Unit

No.	Part No.	Part Name	Q'TY
1	A20-110007R1	Pulley	1
2	E21-010002R1T	Brake Pad 5S50-41109	1

Tension Adjustment Cam Unit



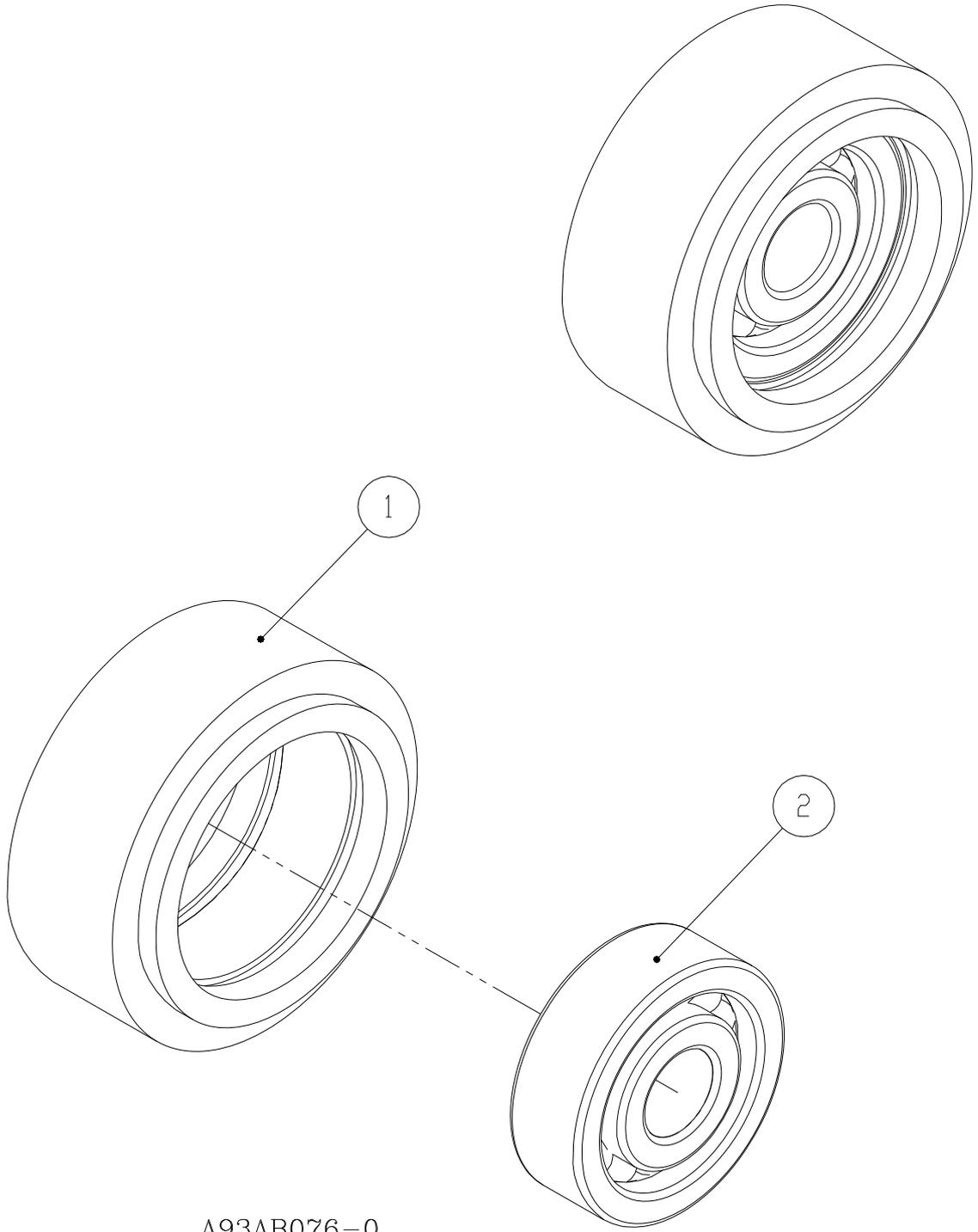
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7.16

Tension Adjustment Cam Unit

No.	Part No.	Part Name	Q'TY
1	A20-163001	Tension Adjustment Cam	1
2	A20-163002-1	Adjustment Shaft	1
3	A20-163004	spring	1
4	A20-163005	Fixed Plate	1
5	A20-163008	Collar	1
6	A20-163021-0	Name Plate	1

Feed Upper Roller



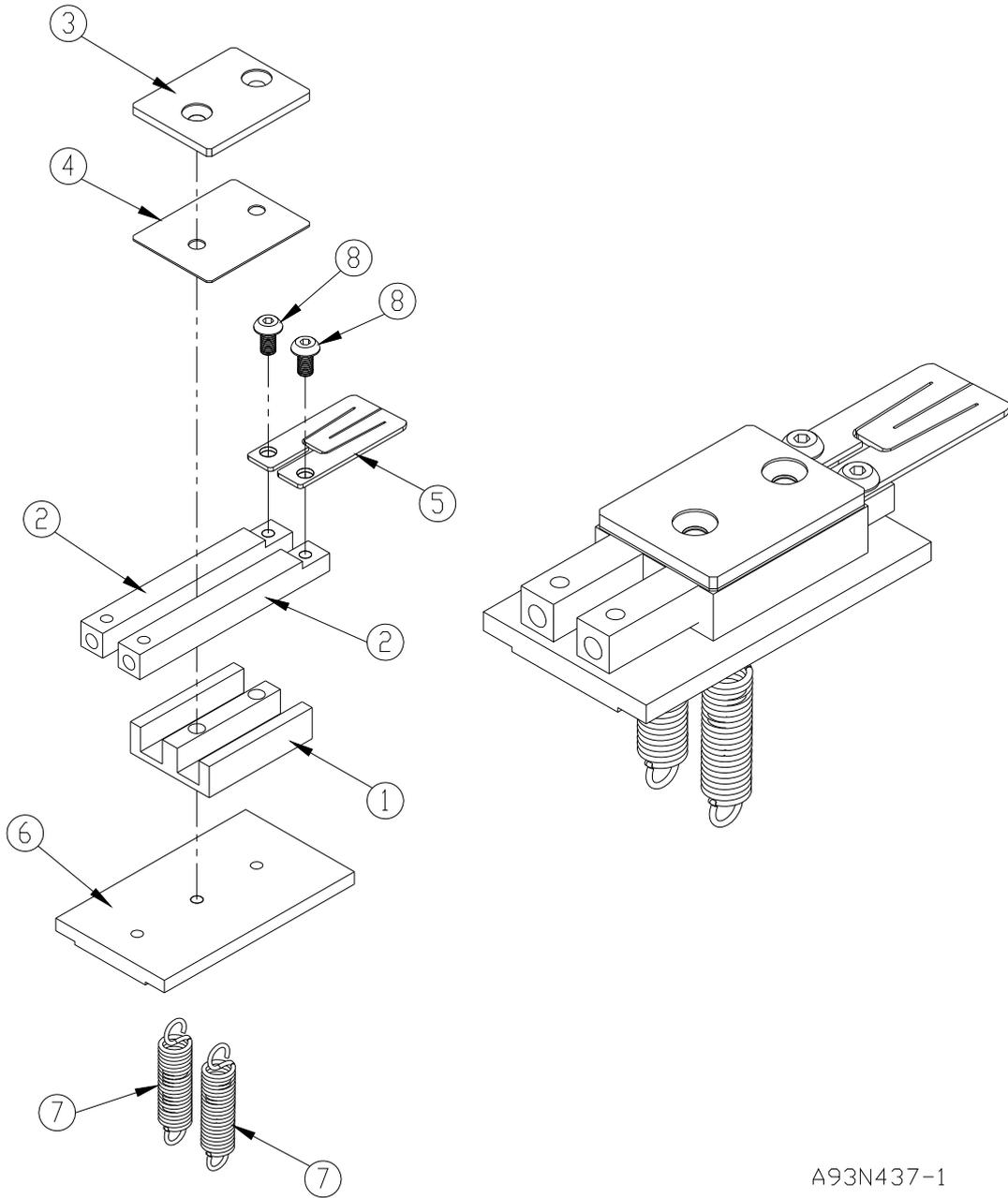
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7.17

Feed Upper Roller

No.	Part No.	Part Name	Q'TY
1	A20-171103-DAA	Feed Upper Roller 12mm	1
2	G04-210628	Ball Beaning 628ZZ	1

Heater Unit



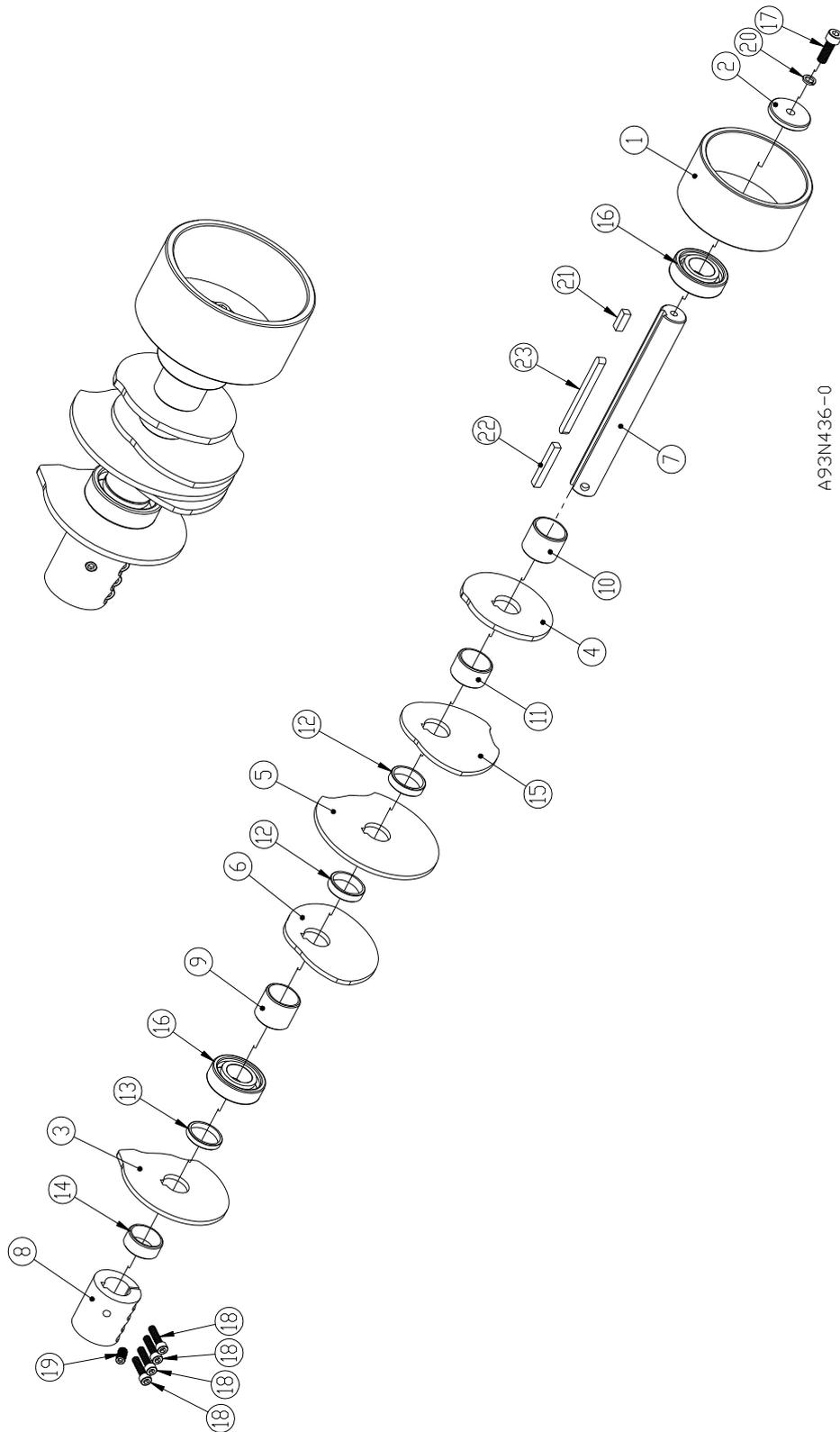
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7.18

Heater Unit

No.	Part No.	Part Name	Q'TY	Remark
1	A20-143001-1	Isolation Block	1	
2	A20-143002	Connector	2	
3	A20-143003-1	Press Plate(Upper)	1	
4	A20-143004	Plate	1	
5	A20-143007-2	Heating Film (1.5tX20W)	1	
6	A11-141250-1	Electric Heater Seat	1	
7	XOW342	Spring	2	
8	W12-410408	HBS M4x8L	2	

Healing Head Came Unit



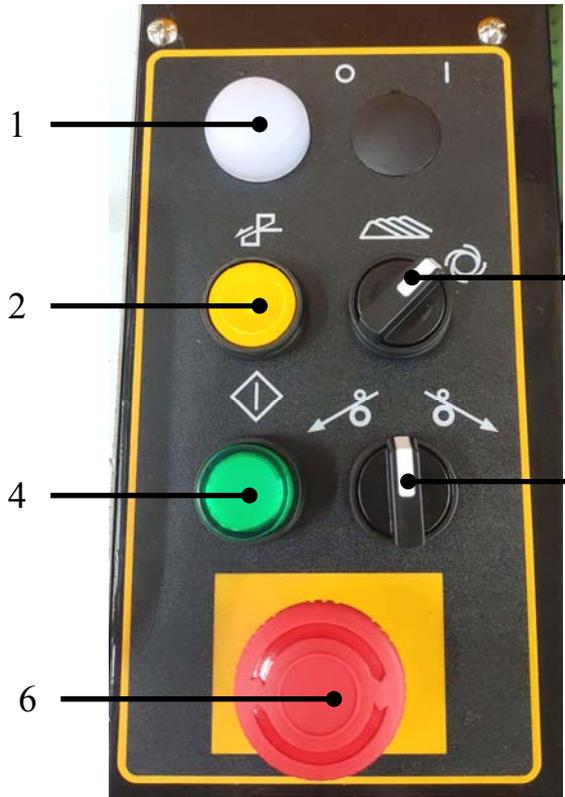
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7.19

Healing Head Came Unit

No.	Part No.	Part Name	Q'TY
1	A20-110001	Tension Cam	1
2	A20-110002	Collar	1
3	A20-111001	Slide Table Cam	1
4	A20-111002	RH Press Cam	1
5	A20-111004	Heater Cam	1
6	A20-111005	LH. Press Cam	1
7	A20-111006	Cam Shaft	1
8	A20-111007	Cam Shaft Coupling	1
9	A20-111008-1	Collar 28.8x34x28.3	1
10	A20-111008-2	Collar 28.8x34x27.8	1
11	A20-111009	Collar	1
12	A20-111010	Collar	2
13	A20-111011	Collar	1
14	A20-111012	Collar	1
15	A20-111015-2	Cam	1
16	G04-216205	Ball Bearing 6205	2
17	W01-210825	HBS (M8x25L)	1
18	W01-210625	HBS M6*25	4
19	W02-210816	Screw M8x16L	1
20	W19-020108	SW M8x2.0t	1
21	W37-070720	Key 7x7x20L	1
22	W37-070748	Key 7x7x48L	1
23	W35-070790	Key 7x7x90L	1

Control Panel



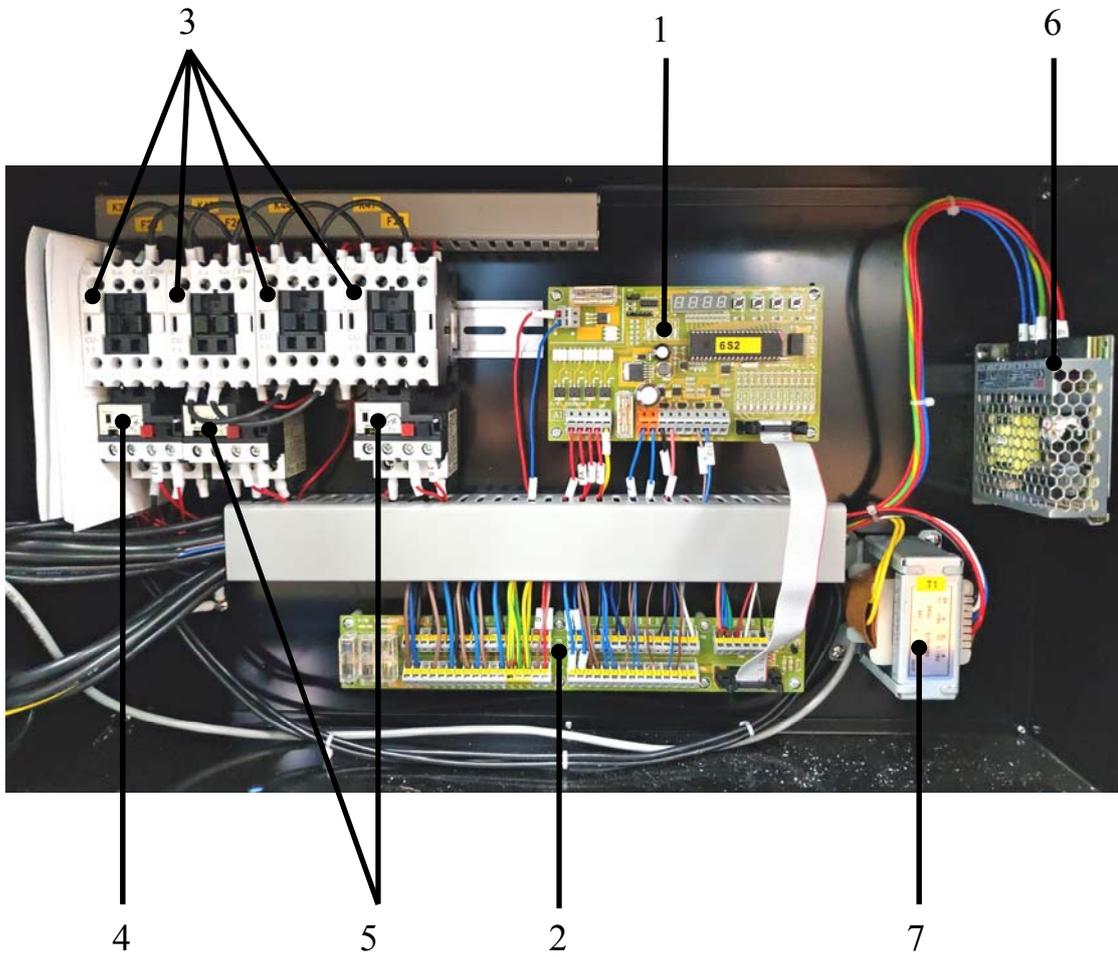
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Control Panel

Ref. No.	Code Name	Parts No.	Product Name	Specification	Qty	Remark
1	H16	E07050046	Pilot Lamp	IDEC YW1P-2EQ7W	1	Panel
2	S2	E07020061	Pushbuttons	IDEC YW1B-M1E10Y	1	Panel
3	S35	E07010042	2-Position Selector Switches	IDEC YW1S-2E10	1	Panel
4	S34, H32	E07020062	Illuminated Pushbuttons	IDEC YW1L-M2E10Q4G	1	Panel
5	S43	E07010041	3-Position Selector Switches	IDEC YW1S-33E20	1	Panel
6	S32	E07020077	EMG Stop	KEYON (CT-BS4)+(CT-BZB) 1NC	1	Panel
7	Q11	E07010057	Main Switch	ZH-HD-1-80-BY	1	Machine
8	S39,48	E07090045	Proximity Sensors	OMRON TLQ5MC1-Z	2	Machine

Control box

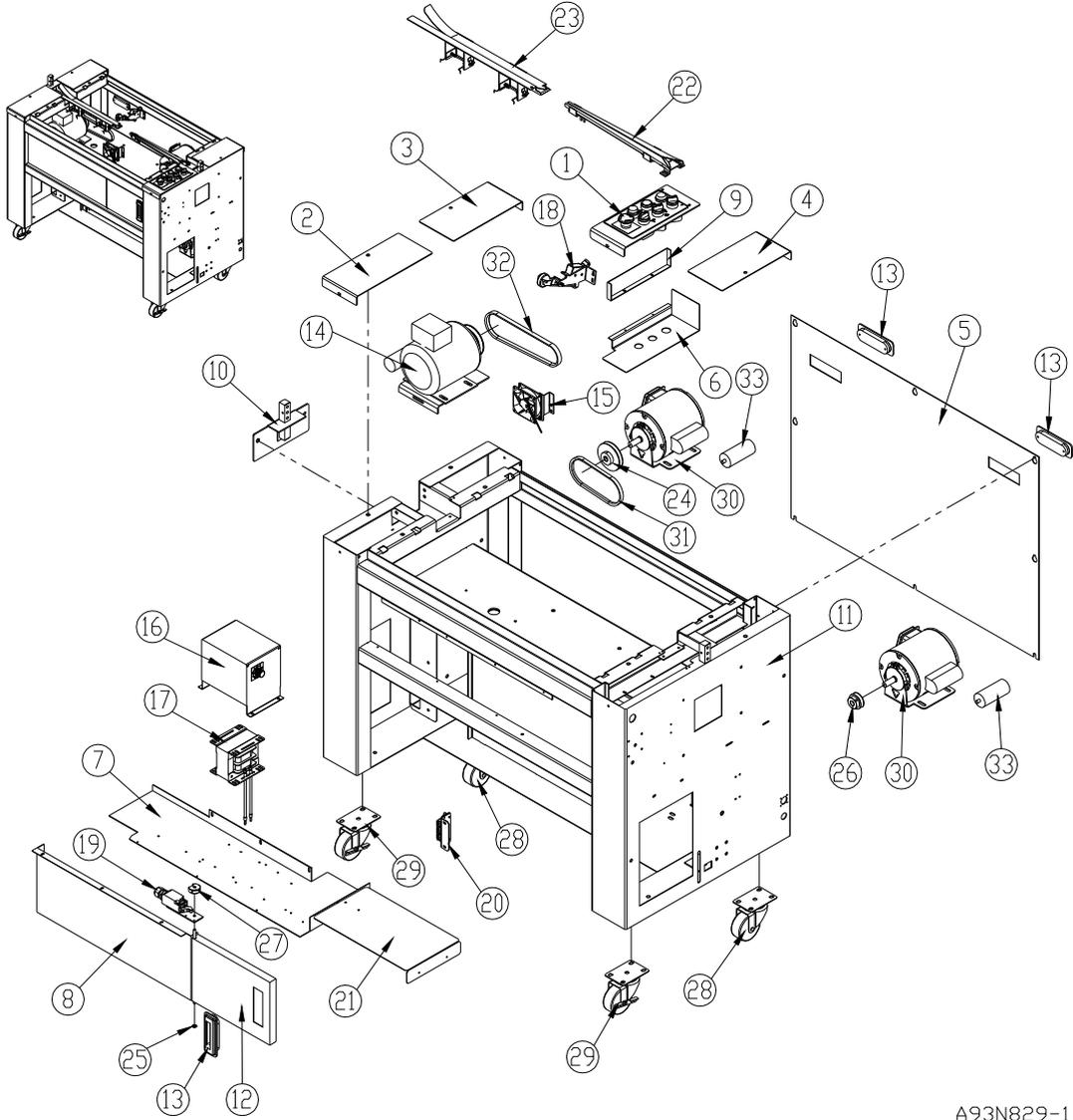


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Control box

Ref. No.	Code Name	Parts No.	Product Name	Specification	Qty	Remark
1	A1	E25101046-1	Main PCB (Standard)/A1	A-93S(ROHS)A1-1ph/3ph (No Automatic Tape Feeding)	1	Control Box
		E15050032	Single Chip (New) ★	PIC18F46K22-I/P DIP40	1	Control Box
	F4	E23010010	Fuse	5*20mm 3A	1	Control Box
	F5	E23010007	Fuse	5*20mm 2A	1	Control Box
2	A3	E25101047	PCB (Standard)/A3	A-93S(ROHS)A3 (14PIN/21CM Line)	1	Control Box
	F1,F2	E23010032	Fuse	5*20mm 20A	2	Control Box
3	K38,43,44,49	E03010026R1	Magnetic Contactor	TECO CU-11 3a1b AC24V	4	Control Box
4	F23	E23030071	Overload Relay	TECO RHU-10K1(7.2-10A)	1	Control Box
5	F26,29	E23030069	Overload Relay	TECO RHU-10K1(3.5-4.8A)	2	Control Box
6	N1	E25101281	Power Supplier	LRS-50-24 2.2A	1	Control Box
7	T1	E17010052	Transformer	230V/110V(ROHS) 24V;2A	1	Control Box

Body unit

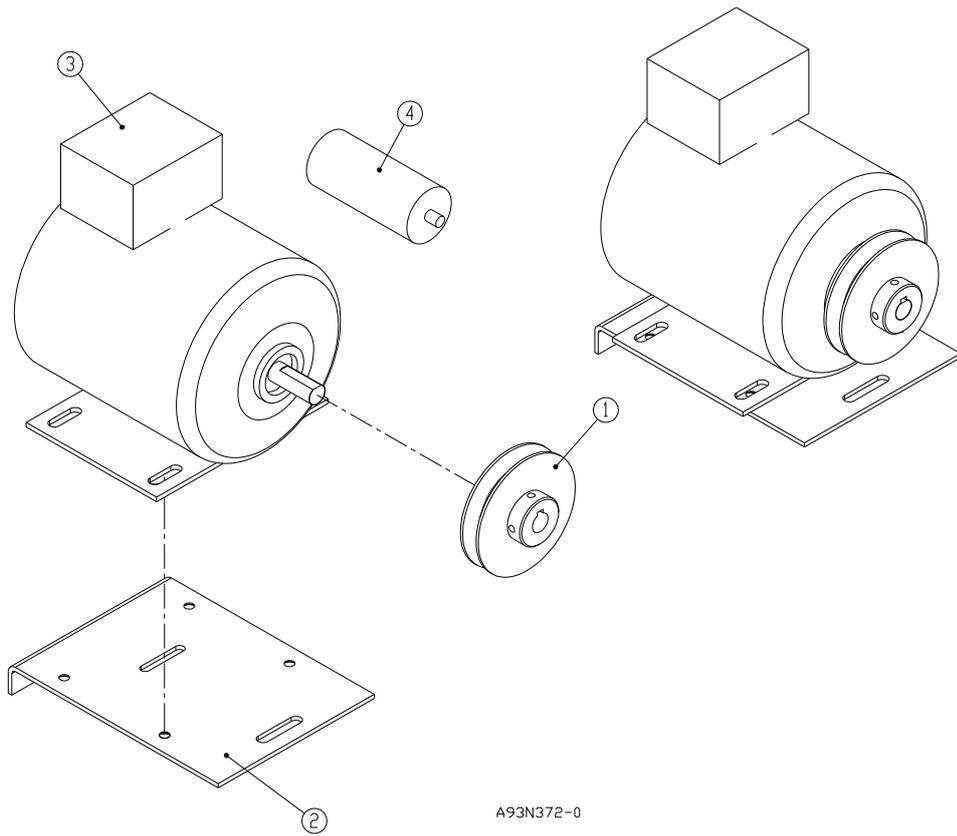


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Body unit

No.	Part No.	Part Name	Q'TY
1	A93N-201100-0	Operation Panel	1
2	A93N-300001-1	Front Plate Cover(L)	1
3	A93N-300002-1	Rear Plate Cover(L)	1
4	A93N-300003-1	Rear Plate Cover(R)	1
5	A93N-300004-1	Rear Panel	1
6	A93N-300010-1	Lower Plate	1
7	A93N-300012-4	Front Bottom Panel	1
8	A93N-300016-1	Left Door (Inside Tension Adjust)	1
9	A93N-300017-0	Plate (L)	1
10	A93N-300150-2	Arch Seat (L)	1
11	A93N-310450-5	Frame	1
12	A77-321150-1	Right Door	1
13	S35-300027	Edge Guard	3
14	BA20001-03	Motor M1-110V/60HZ/500W	1
15	BA20002	Fan Assembly 80x80X25T/220V	1
16	BA21001	Temperature Control Transformer Cover	1
17	BA21002	Temperature Control Transformer	1
18	BA24001	Table Ball Switch	1
19	BA24003	Safety Switch	1
20	BA33001	Magnet H-22	1
21	BA34001	Right Plate	1
22	BA42001	RH Bandway Unit (850W)	1
23	BA43002-ACA	LH Bandway Unit (850W)	1
24	A20-210003	M2 Pulley 60HZ	1
25	A20-300015	Nylon Washer	1
26	A93-171010-0	Pulley	1
27	A93-300002	Switch Cam	1
28	A93-900004	Caster	2
29	A93-900005	Caster	2
30	E01-010039	M2/M3-0.24KW/110V/60HZ	2
31	G16-010021	V-Type Belt M-21Y	1
32	G16020026	A26 Belt	1
33	E11-080007		1
33	E11-080007	Run capacitor 60UF/250VAC	2



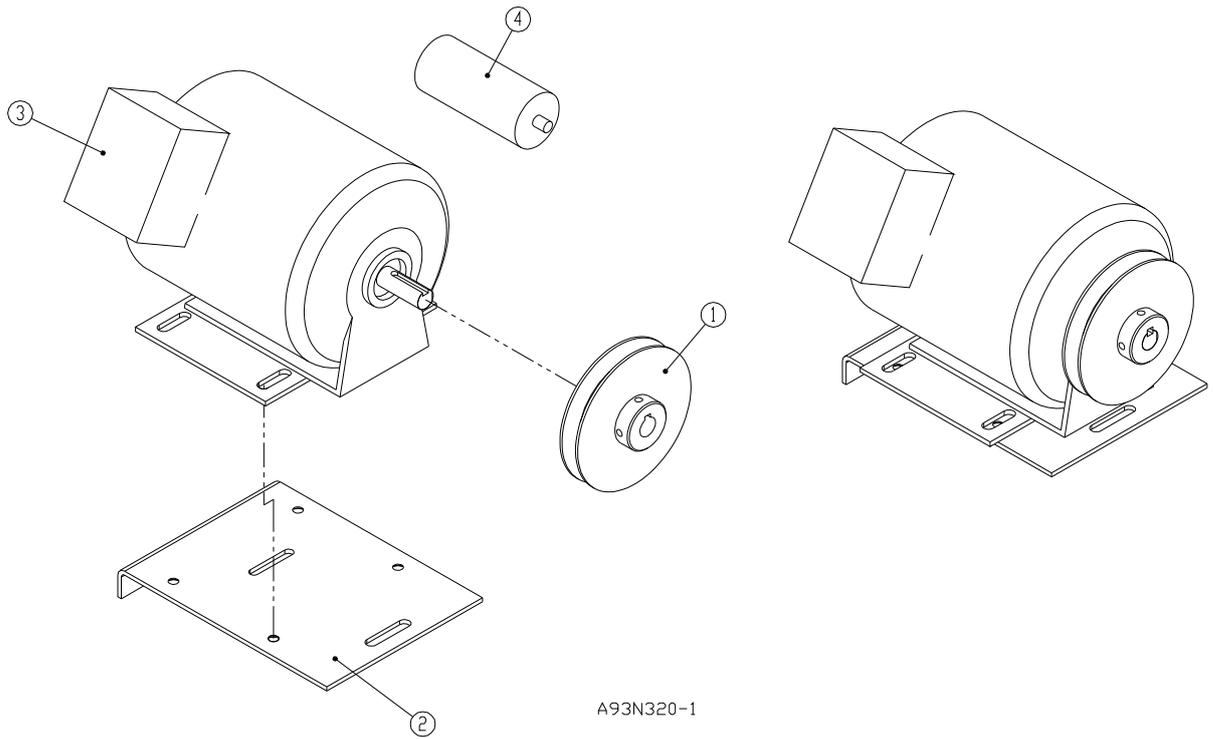
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9.1

Motor unit

No.	Part No.	Part Name	Q'TY
1	A20-210001	Pulley M1	1
2	A20-210021	Gear Motor Holder	1
3	E01-010064	Motor M1-110V/60HZ/500W	1
4	E11-080003	Run Capacitor 105UF/180VAC	1

Fan unit

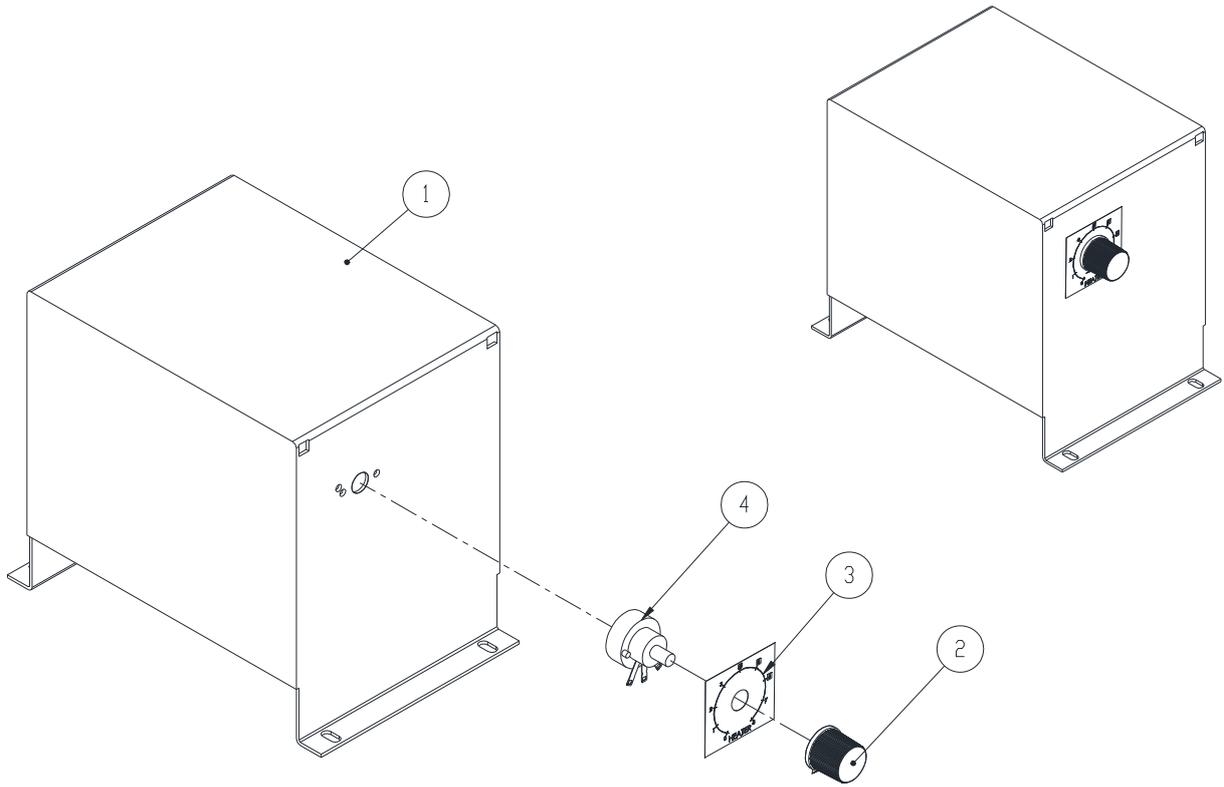


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Fan unit

No.	Part No.	Part Name	Q'TY
1	E01-040005-1	Fan 8025D2HBPL,DC24V	1
2	A20-210016-1	Fan Bracket	1

Temperature Control Transformer Cover Unit



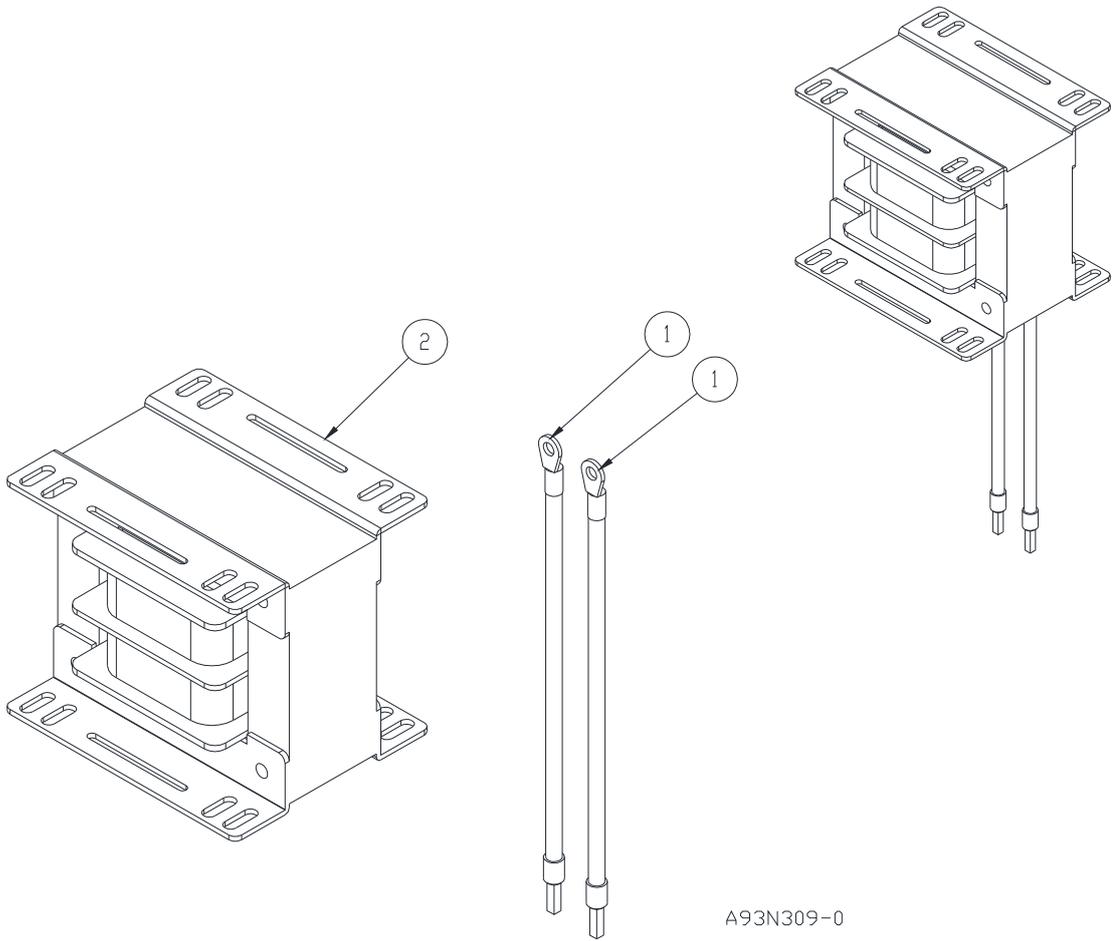
A93N308-0

93

Temperature Control Transformer Cover Unit

No.	Part No.	Part Name	Q'TY
1	A93N-210001-2	Temperature Control Transformer Cover	1
2	SK32956-1	Knob RN-110 EH/BLOCK	1
3	P08-100014	Heater Sticker	1
4	E13020011	Variable Resistance RV24YN20SB1K	1

Temperature Control Transformer Unit



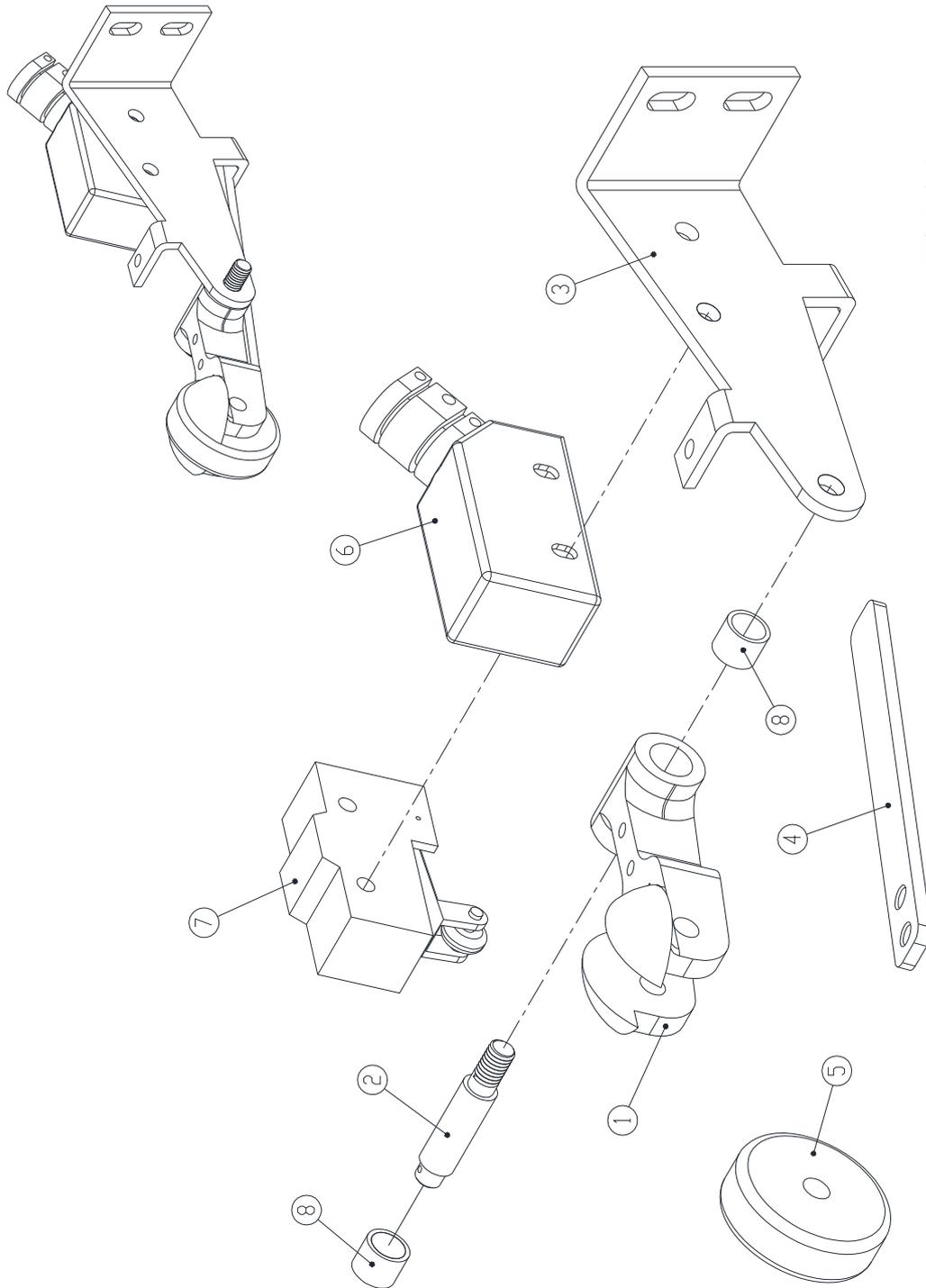
A93N309-0

94

Temperature Control Transformer Unit

No.	Part No.	Part Name	Q'TY
1	A20-143010-0	Electric Heater Line Assembly	2
2	E17-010051	Temperature Control Transformer (ROHS)	1

Table Ball Switch Unit



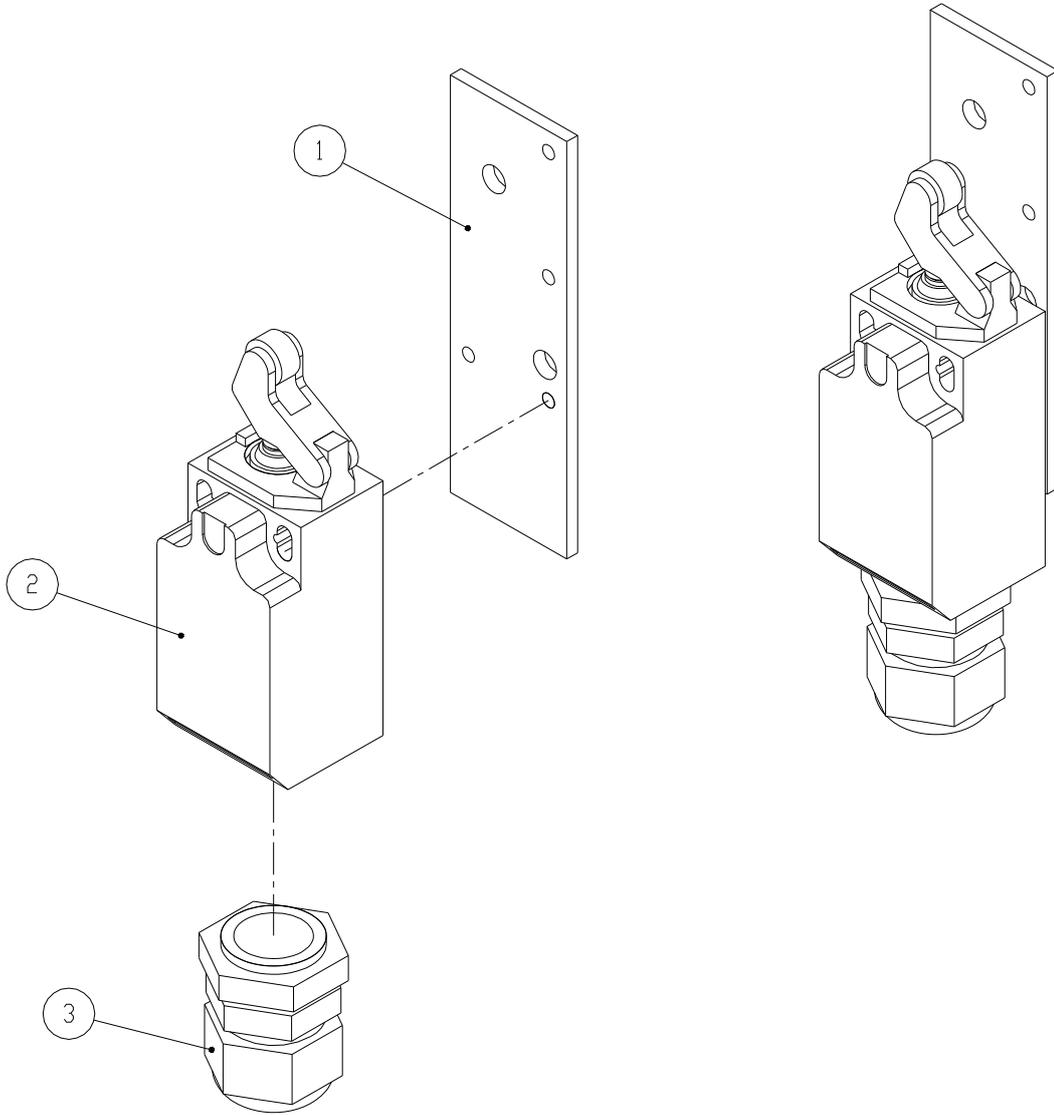
A93N304-0

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Table Ball Switch Unit

No.	Part No.	Part Name	Q'TY
1	A93-210002	Roller Holder	1
2	A93-210004	Fixed Shaft	1
3	A93-210005-1	Limit Switch Holder	1
4	A93-210006	Induction Shaft	1
5	A93-210007	Roller	1
6	A20-210027	Limit Switch Cover CB-2	1
7	E07-040047	Limit Switch (Z15G1704)	1
8	G01-081008	Metal Bush,MB0808	2

Safety Switch Unit



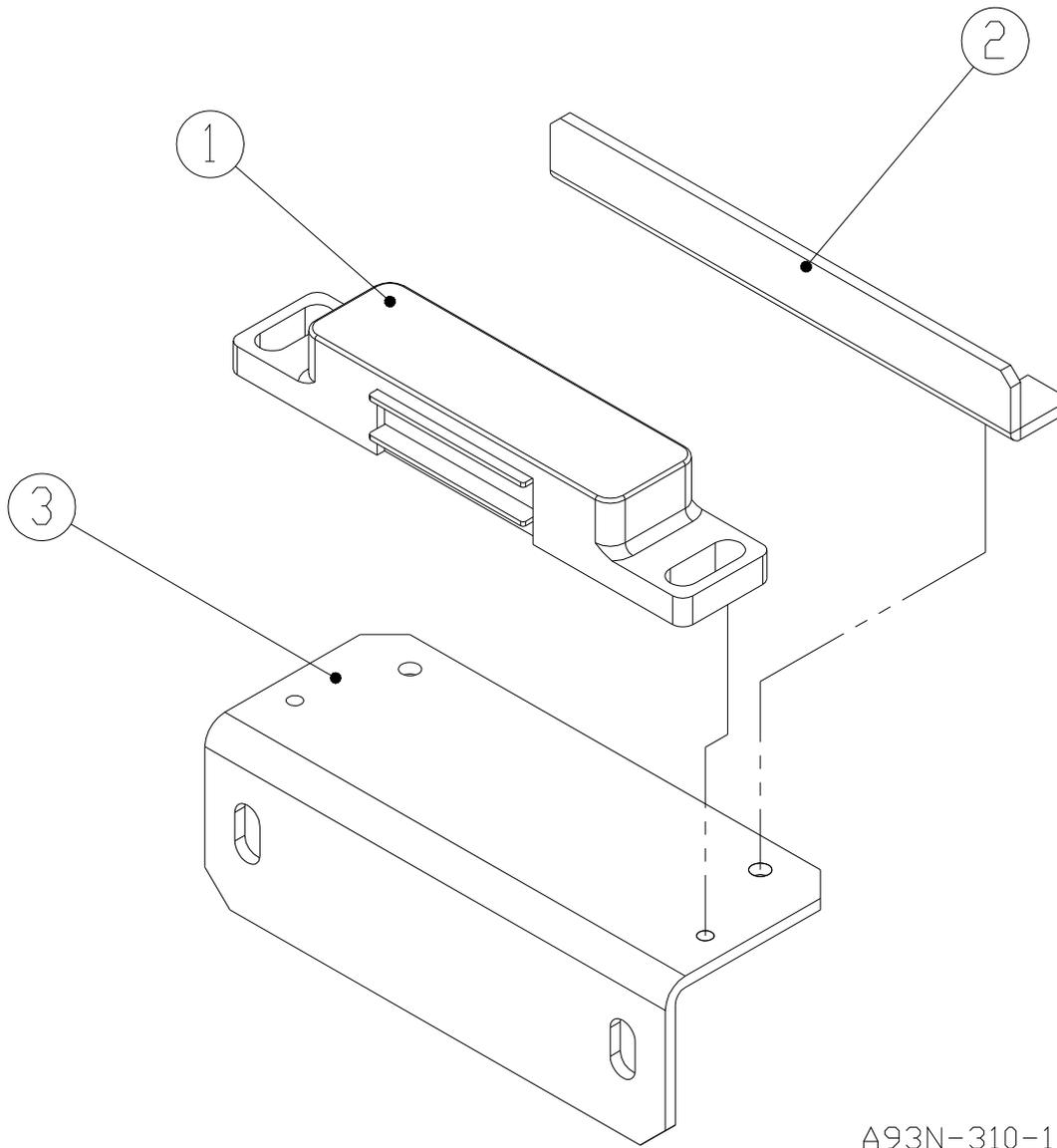
A93N306-0

96

Safety Switch Unit

No.	Part No.	Part Name	Q'TY
1	A93-300004	Mounting Plate	1
2	E07-040050	Safety Switch	1
3	E55-030005	Cable Socket PG13.5	1

Front Door Fixed Magnet Unit



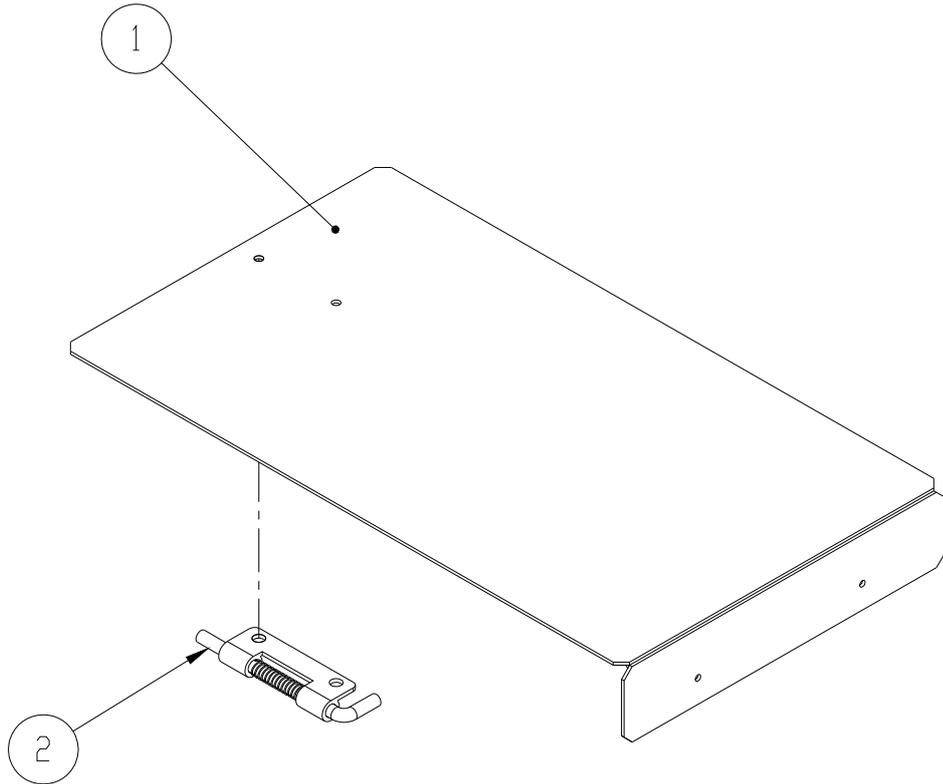
A93N-310-1

9.7

Front Door Fixed Magnet Unit

No.	Part No.	Part Name	Q'TY
1	FA93N-3200028-0	Magnet H-22	1
2	A20-300018	Magnet Block	1
3	A20-300021-0	Front Door Magnet Seat	1

Safety Plate Unit(R)



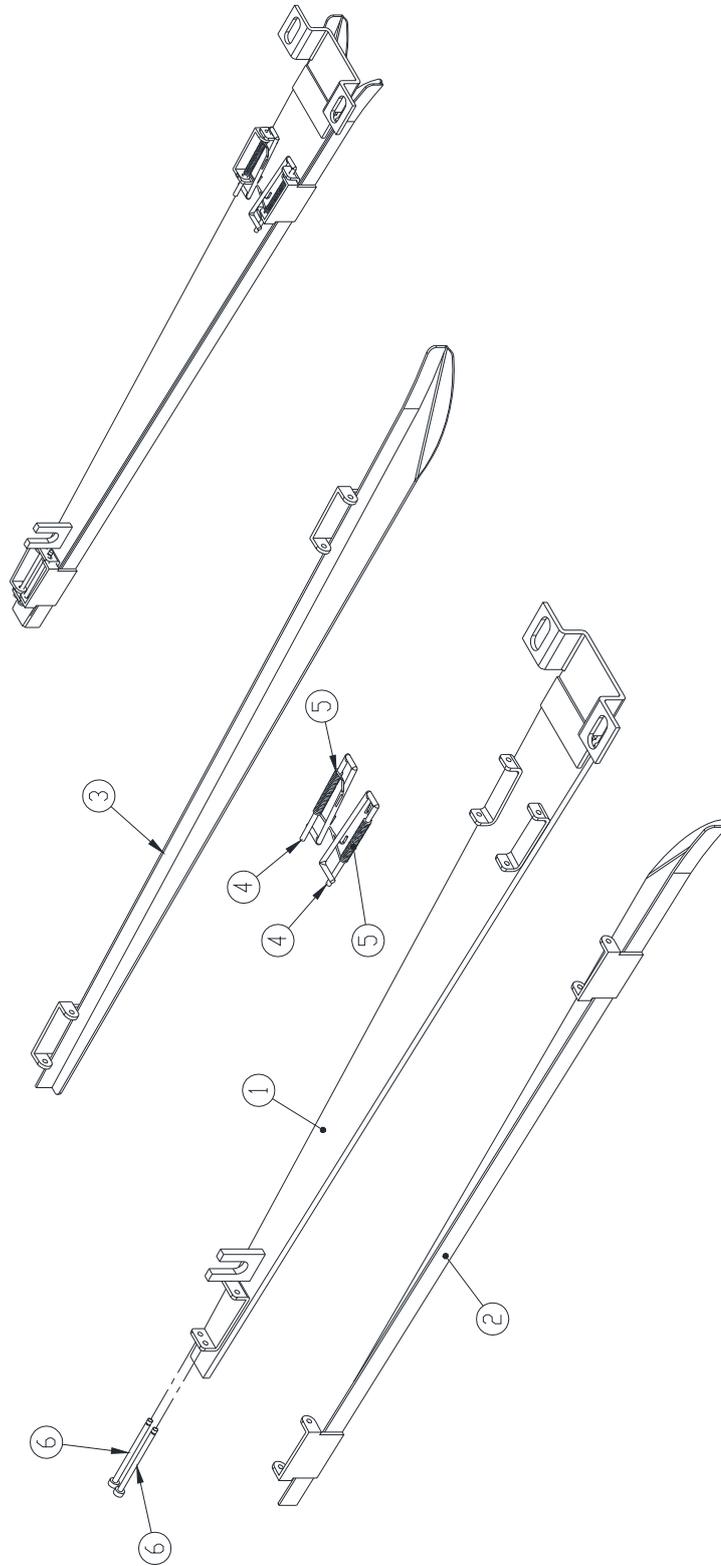
A93N377-0

98

Safety Plate Unit(R)

No.	Part No.	Part Name	Q'TY
1	A93N-300350-0	Safety Plate Unit(R)	1
2	A77-300006-0	Spring Hinge(L)	1

Bandway Unit(R)



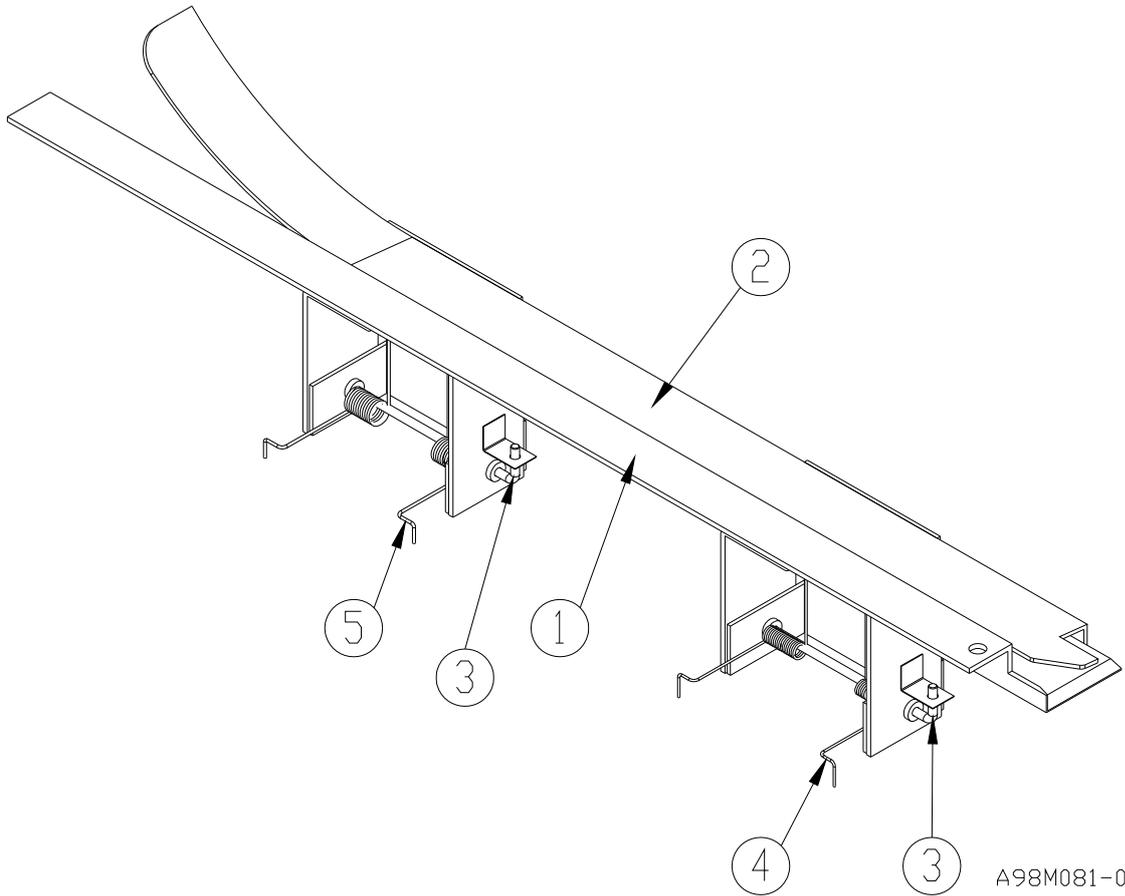
A93N374-0

99

Bandway Unit(R)

No.	Part No.	Part Name	Q'TY
1	A20-411150-DHA	Bandway (R)(850W) 12mm	1
2	A20-411250-DHA	Bandway Edge Assembly(R)(850W) 12mm	1
3	A20-411350-DHA	Right Bandway Edge Assembly (F)(850W) 12mm	1
4	A20-411004	Pin(Rear)	2
5	A20-411005	Spring	2
6	A20-411007-0	Pin	2

Bandway Unit(L)

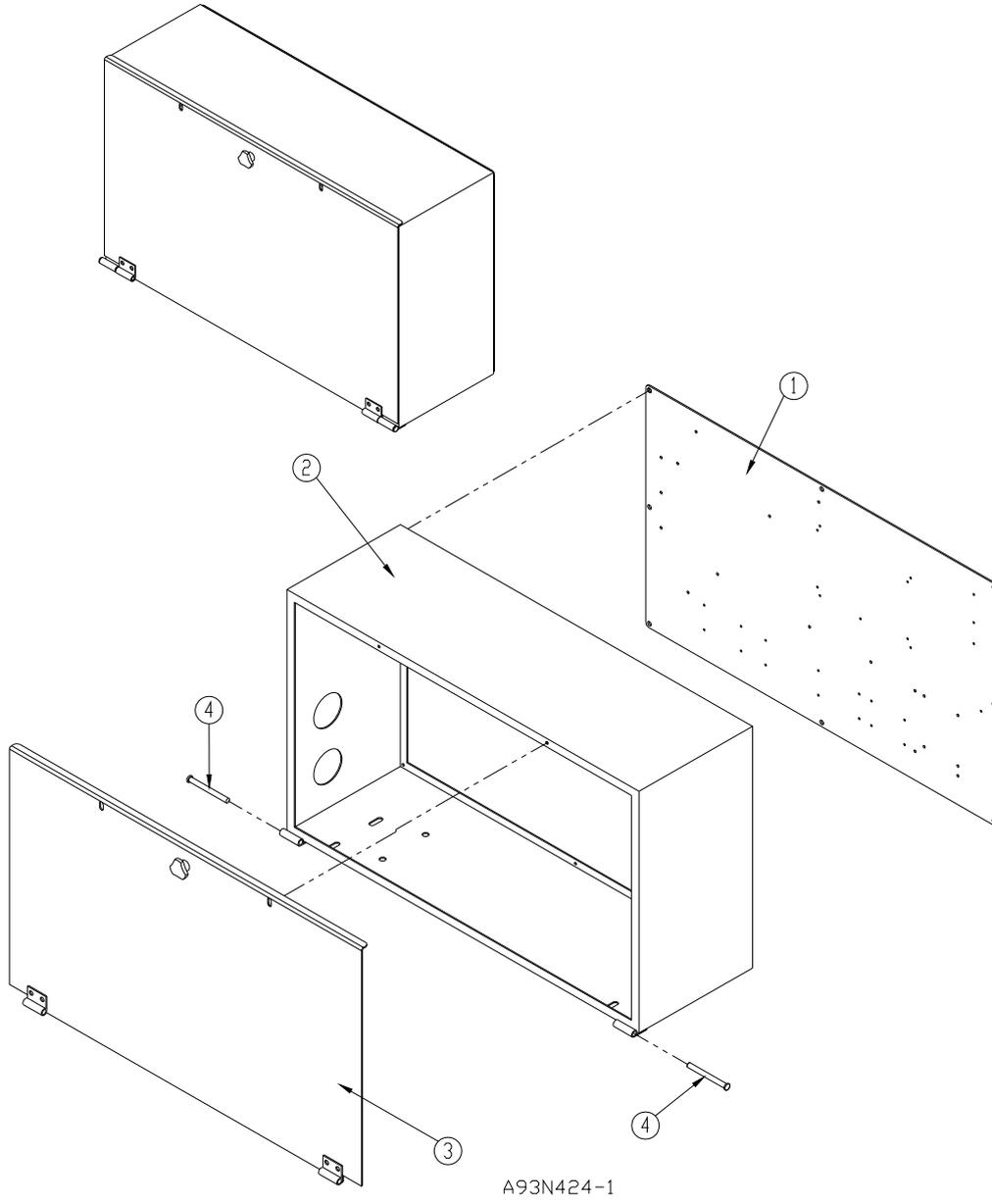


9.10

Bandway Unit(L)

No.	Part No.	Part Name	Q'TY
1	A20-412150-ACA	Left Bandway (850W)	1
2	A20-412250-ACA	Left Bandway Edge Assembly (850W)	1
3	A20-412003	Pin	2
4	A20-412004	Spring(S)	1
5	A20-412005	Spring(B)	1

Electric Box Unit



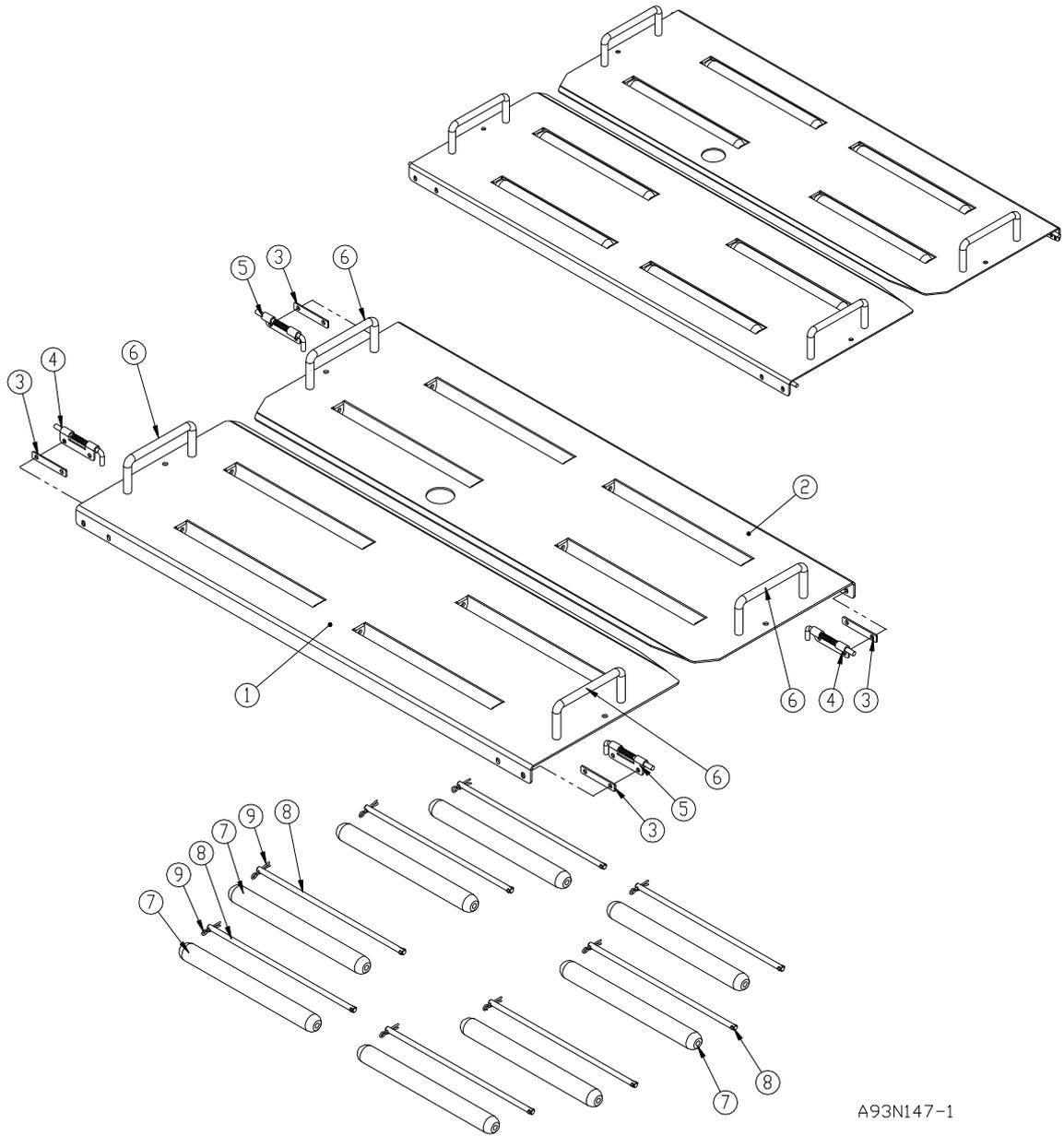
A93N424-1

9.11

Electric Box Unit

No.	Part No.	Part Name	Q'TY
1	A93N-220001-2	Control Panel	1
2	A93N-220050-0	Electric Box Unit	1
3	BA22003	Electric Box Cover Unit	1
4	S13-300013	Rear Knob Stud	2

Table Unit



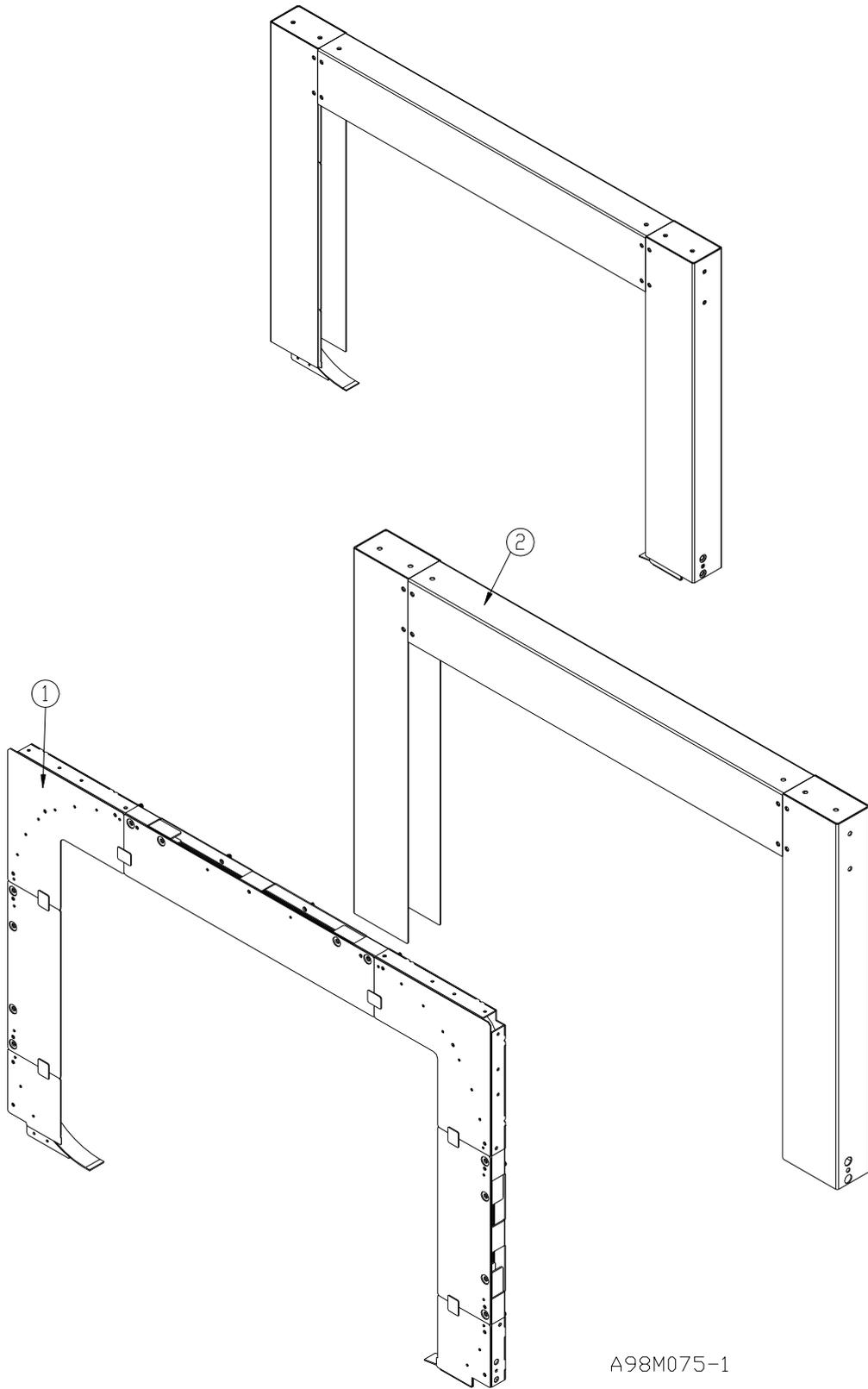
A93N147-1

100

Table Unit

No.	Part No.	Part Name	Q'TY
1	A93N-300005-0	Table Front(850W)	1
2	A93N-300006-0	Table Rear (850W)	1
3	A93N-300007-0	Spring Hinge Pad	4
4	A77-300005-0	Spring Hinge(R)	2
5	A77-300006-0	Spring Hinge(L)	2
6	A20-320005	Handle	4
7	A20-321001	Table Roller	8
8	A20-321002	Table Roller Shaft	8
9	W31-208000	Pin R8	8

Arch unit



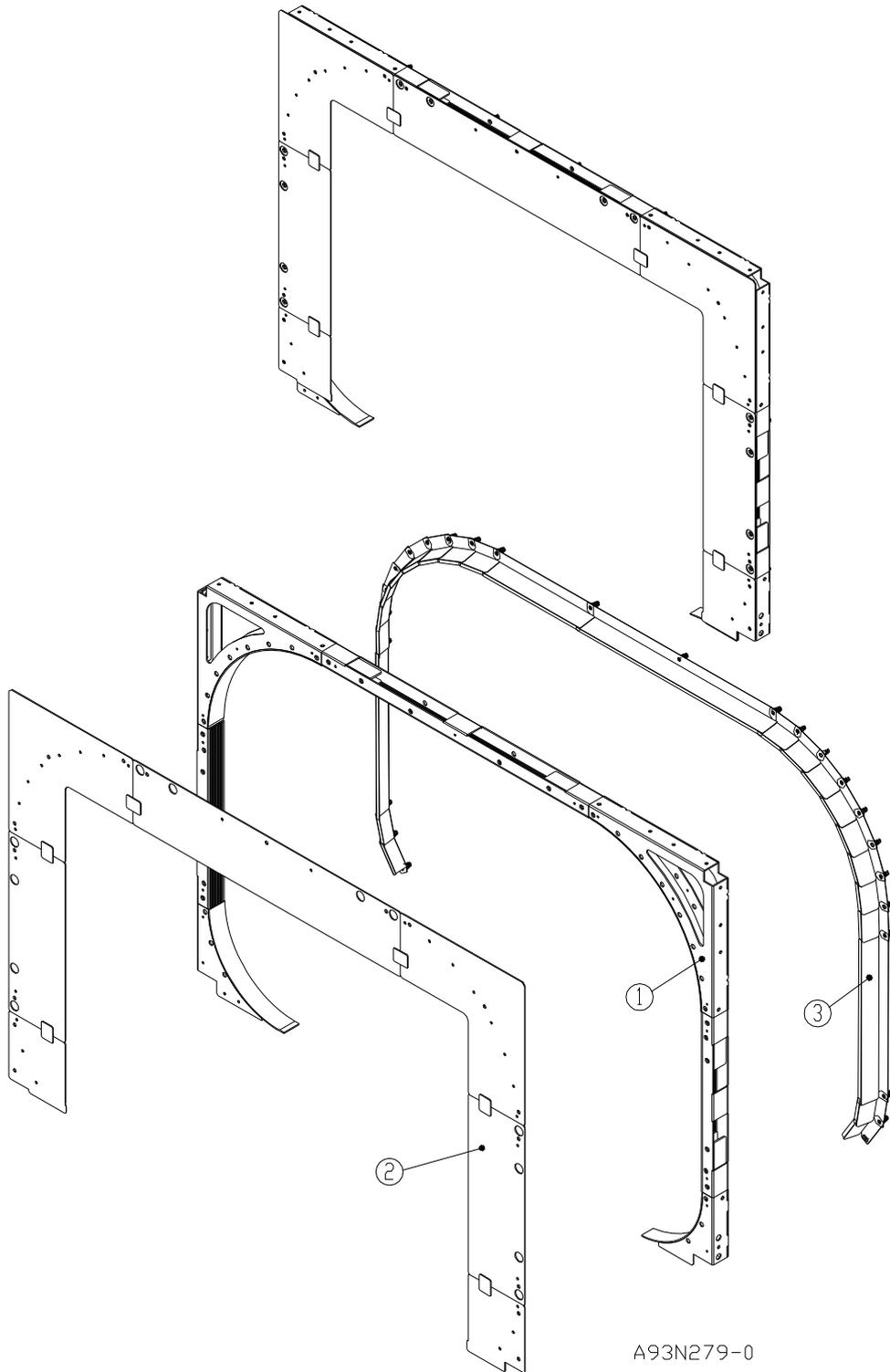
A98M075-1

11.0

Arch unit

No.	Part No.	Part Name	Q'TY
1	DA93N-402002-0	Arch Frame(850Wx600H)	1
2	A93-414000-0-ACC	Arch Cover Unit(850Wx600H)	1

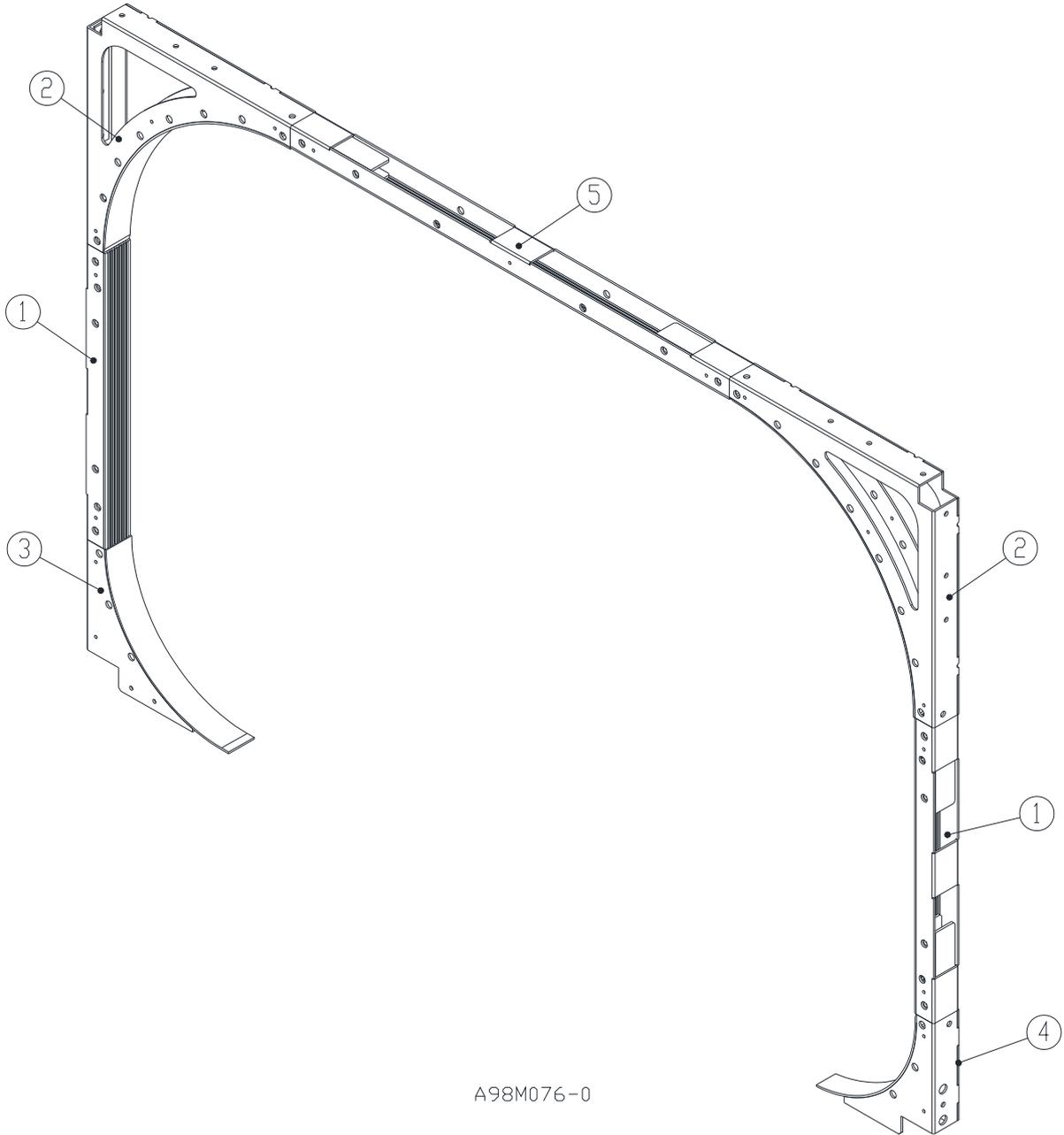
Arch Frame



A93N279-0

11.1**Arch Frame**

No.	Part No.	Part Name	Q'TY
1	A93-411000-0	Arch Frame (850Wx600H)	1
2	A93-412000-0	Guide Plate Unit (850Wx600H)	1
3	A93-413000-0	Arch Flap Hinge Unit (850Wx600H)	1



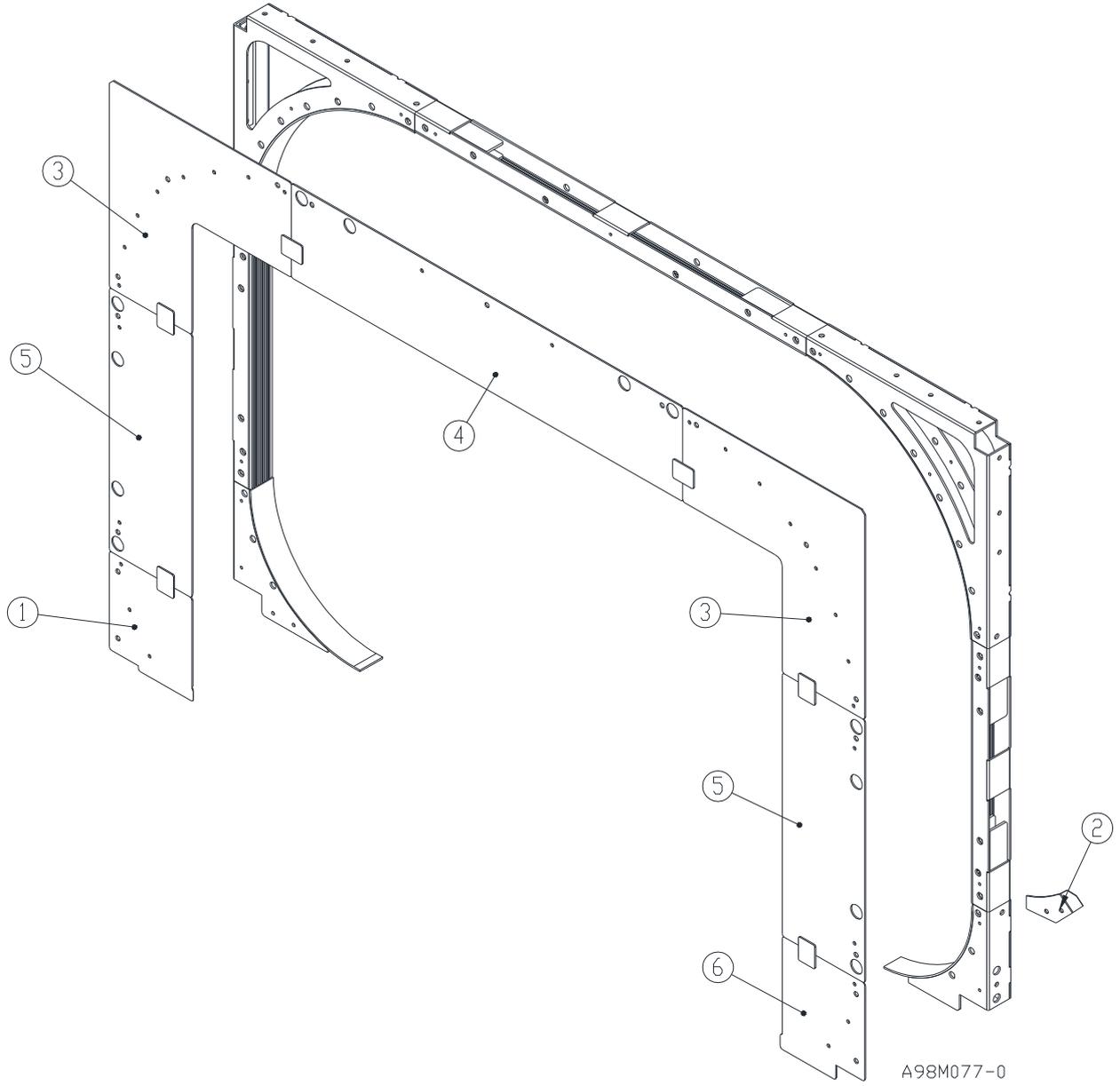
A98M076-0

11.2

Arch Frame

No.	Part No.	Part Name	Q'TY
1	A93-411050-0	Bandway(R,L) (600H)	2
2	A93-411150-0	Corner Unit (Upper)	2
3	A93-411250-0	Left Corner Unit (Lower)	1
4	A93-411350-0	Right Corner Unit (Lower)	1
5	A93-411450-0	Bandway Unit(Upper)(850W)	1

Guide Plate Unit

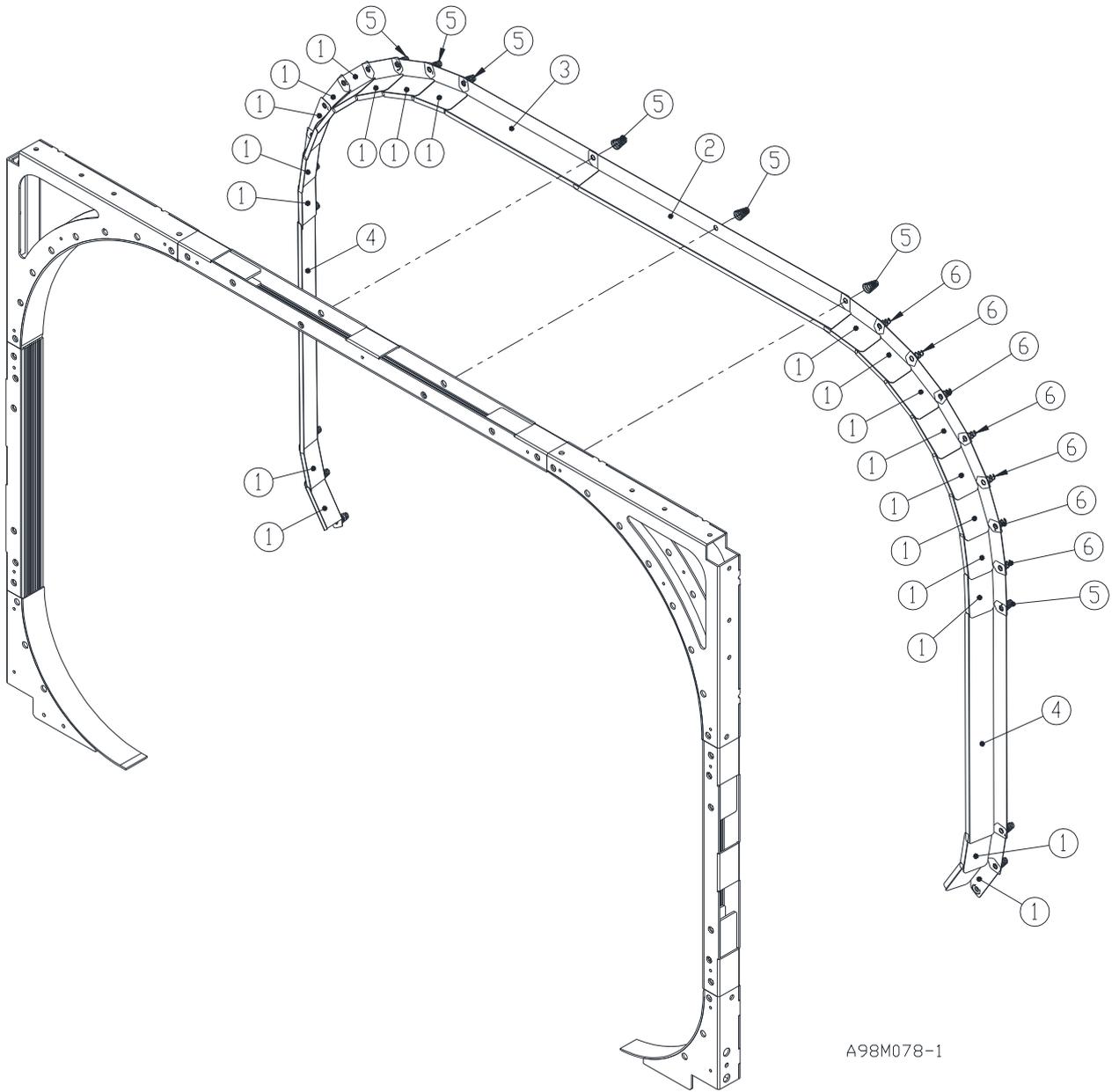


113

Guide Plate Unit

No.	Part No.	Part Name	Q'TY
1	A93-412001-0	Lower Guide Plate (L)	1
2	A93-412002-0	Plate	1
3	A93-412050-0	Front Corner Guide Plate (Upper)	2
4	A93-412150-0	Guide Plate (Upper) (850W)	1
5	A93-412250-0	Guide Plate(L,R) (600H)	2
6	A93-412350-0	Lower Guide Plate (R)	1

Arch Flap Hinge Unit



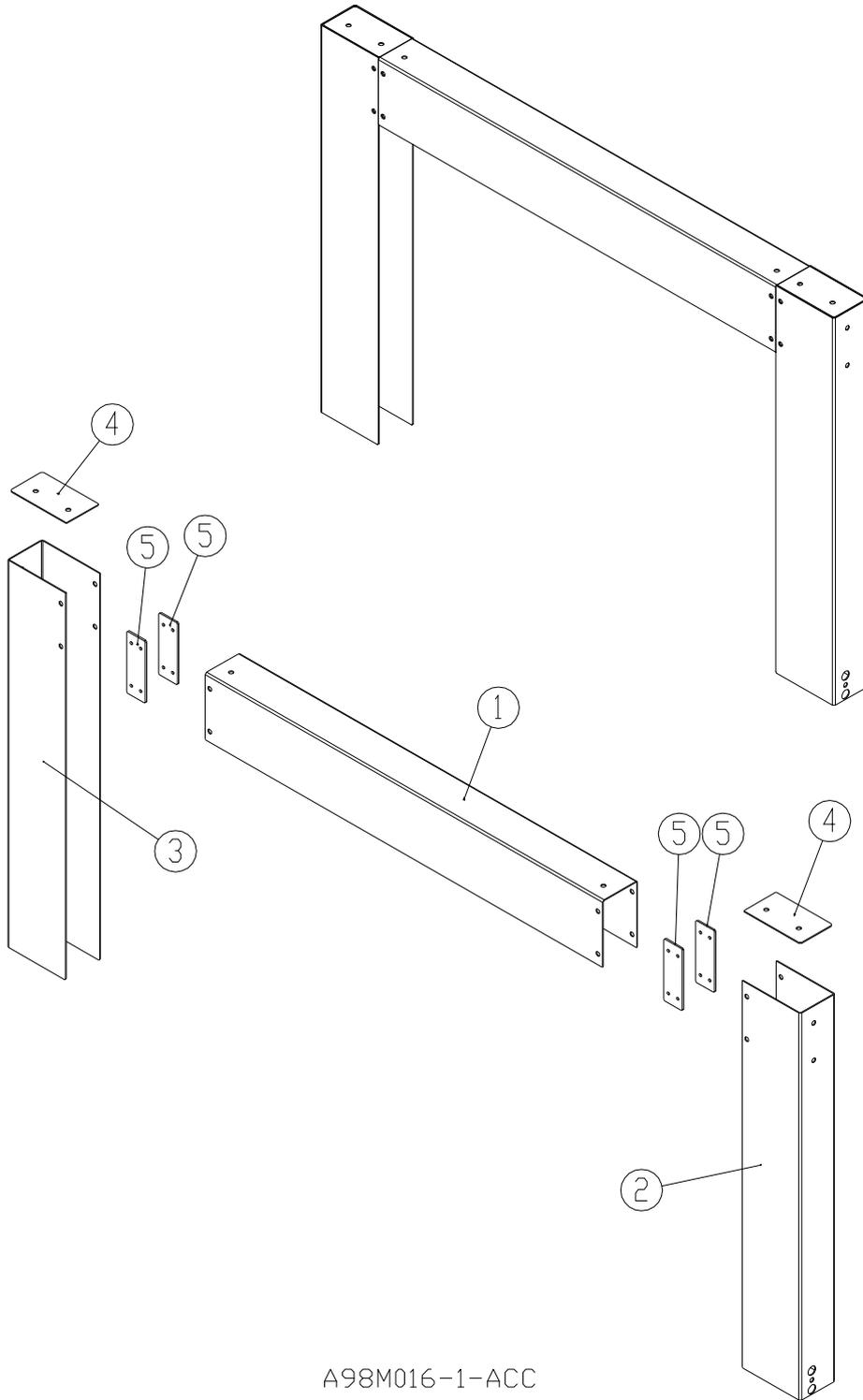
A98M078-1

11.4

Arch Flap Hinge Unit

No.	Part No.	Part Name	Q'Ty
1	A93-413001-0	Corner Flap	20
2	A93-413002-0	Upper Bandway Fixed Flap	1
3	A93-413003-0	Extension Flap	1
4	A93-413004-0	Bandway Flap(R,L)	2
5	A88-443004-2	Arch Flap Spring	19
6	A93L-441054	Spring	7

Arch Cover Unit

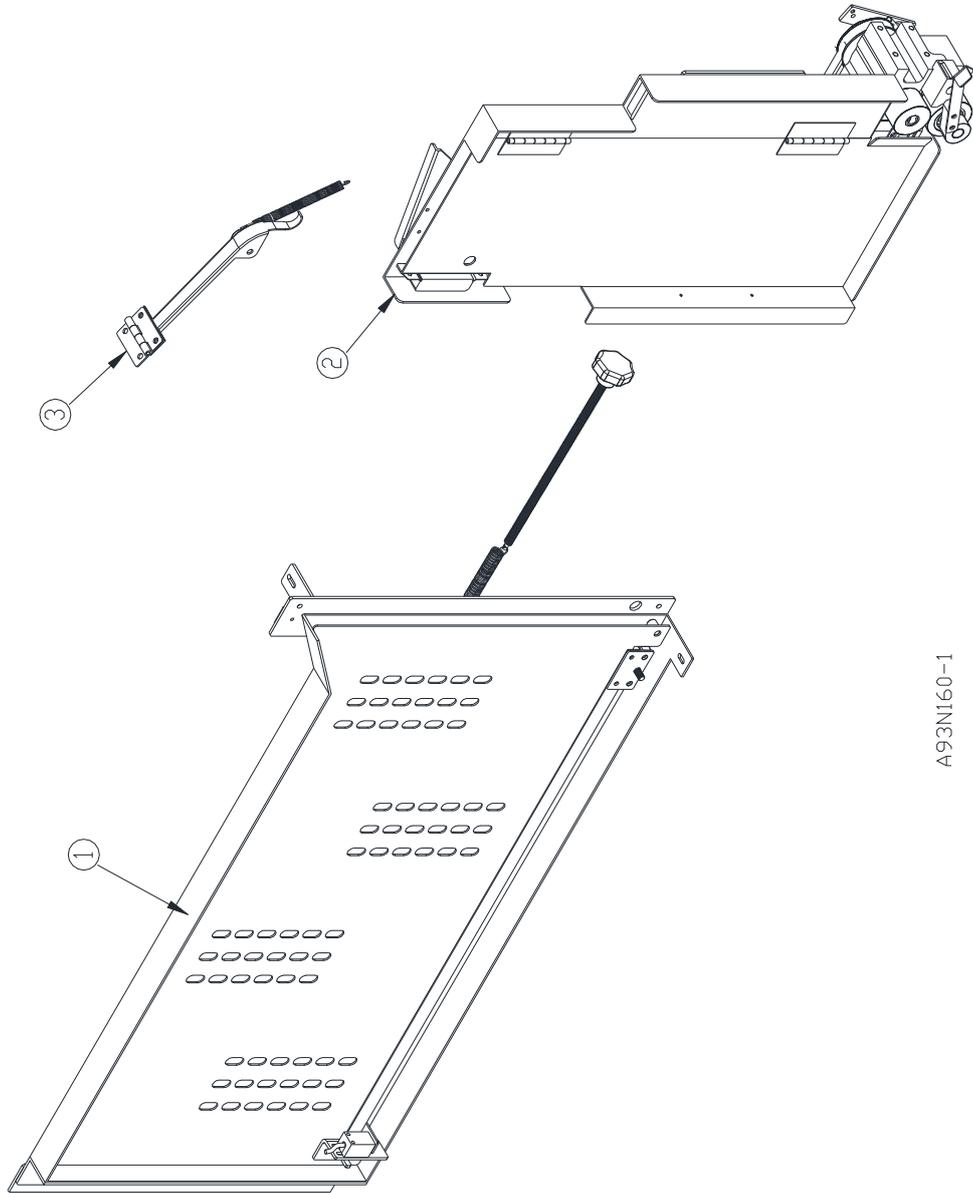


A98M016-1-ACC

115

Arch Cover Unit

No.	Part No.	Part Name	Q'TY
1	A93-414001-0-ACA	Arch Cover(Upper) (850W)	1
2	A93-414002-0-AAC	Arch Cover(Right) (600H)	1
3	A93-414003-0-AAC	Arch Cover(Left) (600H)	1
4	A93-414004-0	Plate(Upper)	2
5	A93N-401008-0	Join Plate	4



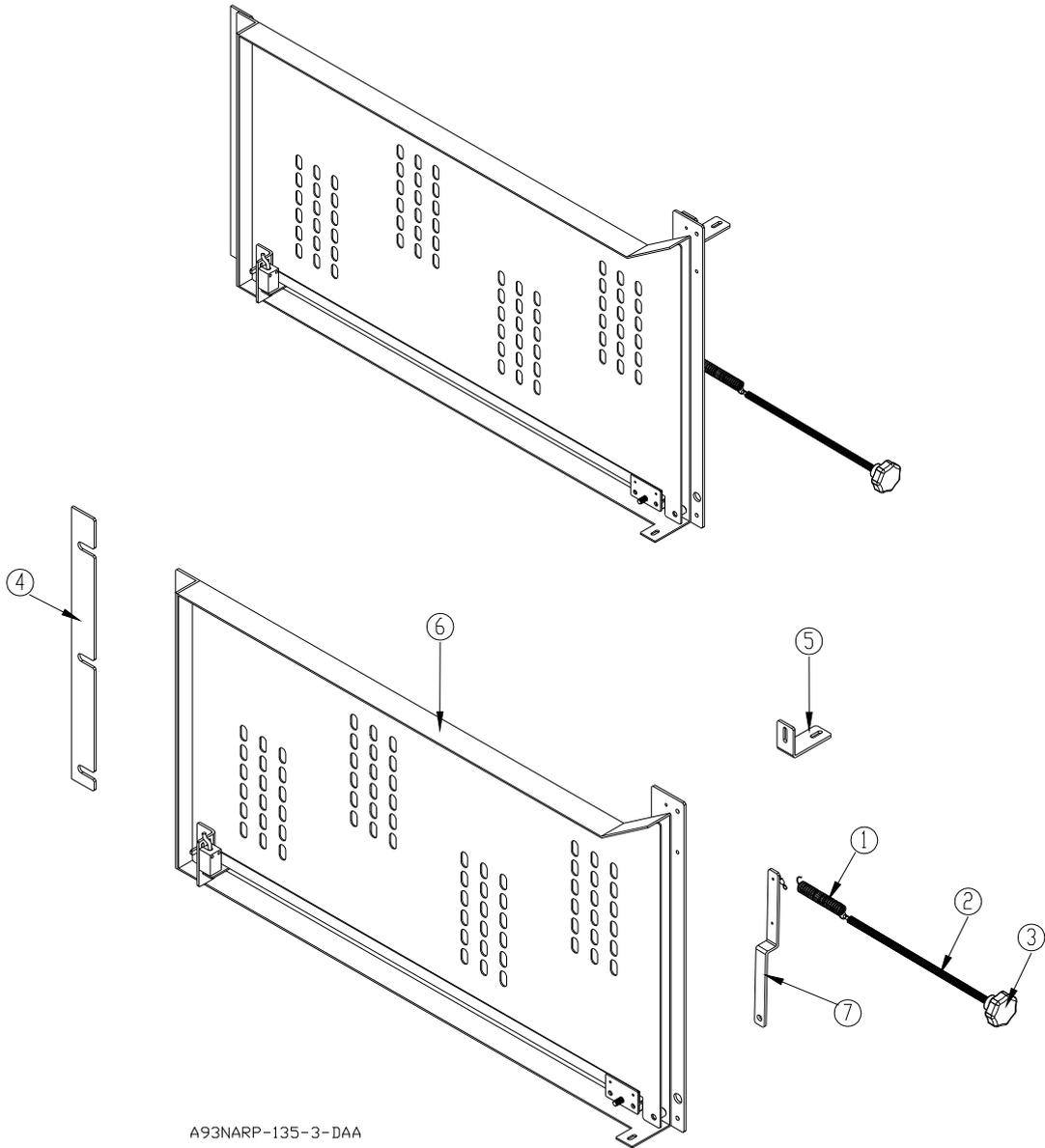
A93N160-1

120

Pool unit

No.	Part No.	Part Name	Q'TY
1	A93N-501000-1-DAA	Pool Box Unit(L) 12mm	1
2	A93N-572000-0-DAA	Feed / Retract Box Unit 12mm	1
3	BA52006-DAA	Feed Strap gun Unit 12mm	1

Pool Box unit(L)



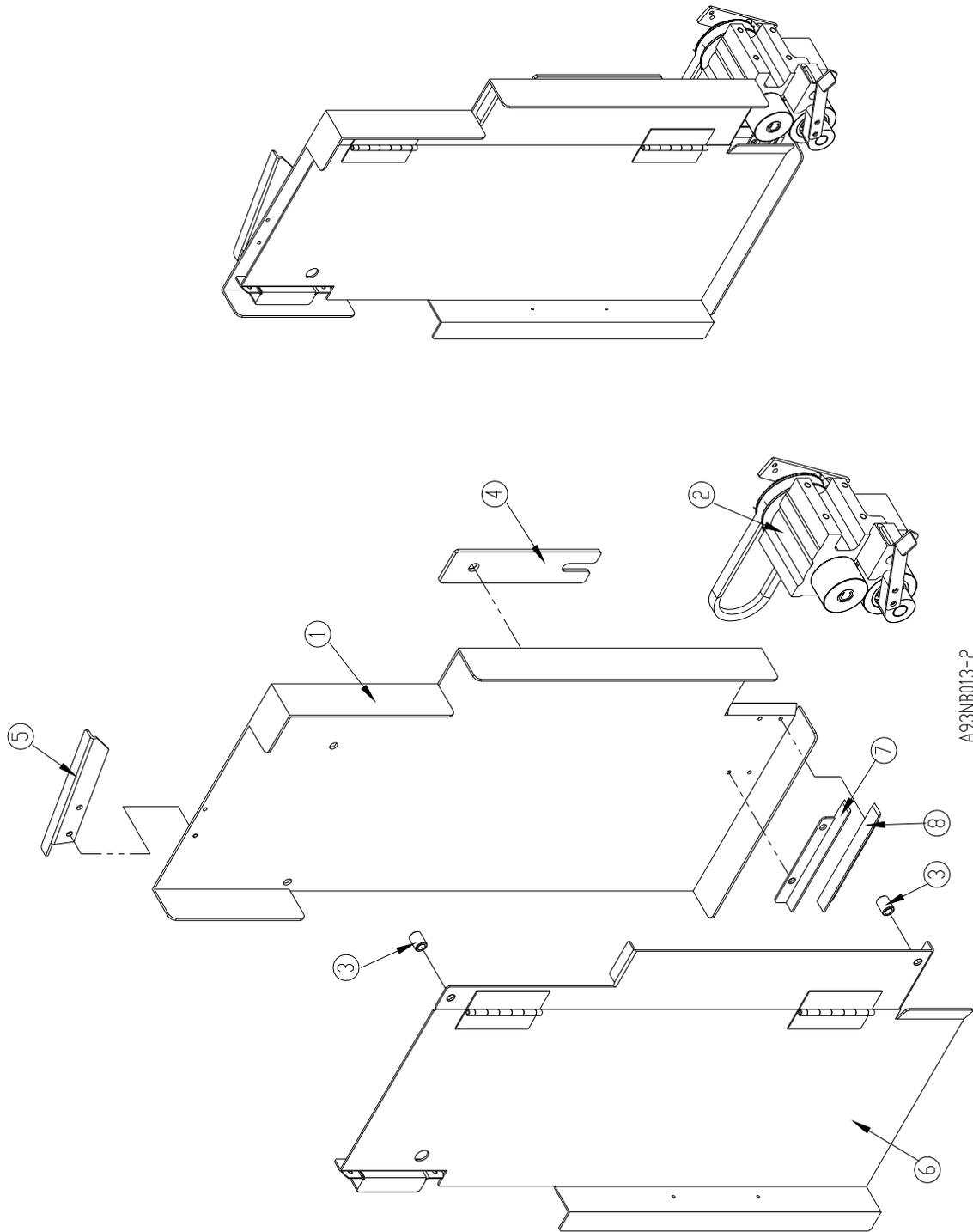
A93NARP-135-3-DAA

121

Pool Box Unit(L)

No.	Part No.	Part Name	Q'Ty
1	A20-510006	Spring	1
2	A70U-501005-1	Pool Adjuster Pin	1
3	A70U-602408	Star grip (6020-KT-40-M8)	1
4	A77-500014-2-DAA	Band Adjustment Plate 12mm	1
5	A77-500022-0	Fixed Plate	1
6	BA52001-DAA	Pool Box Rear, LH 12mm	1
7	BA52005	Balance Bar Adjustment Plate	1

Feed / Retract Box Unit



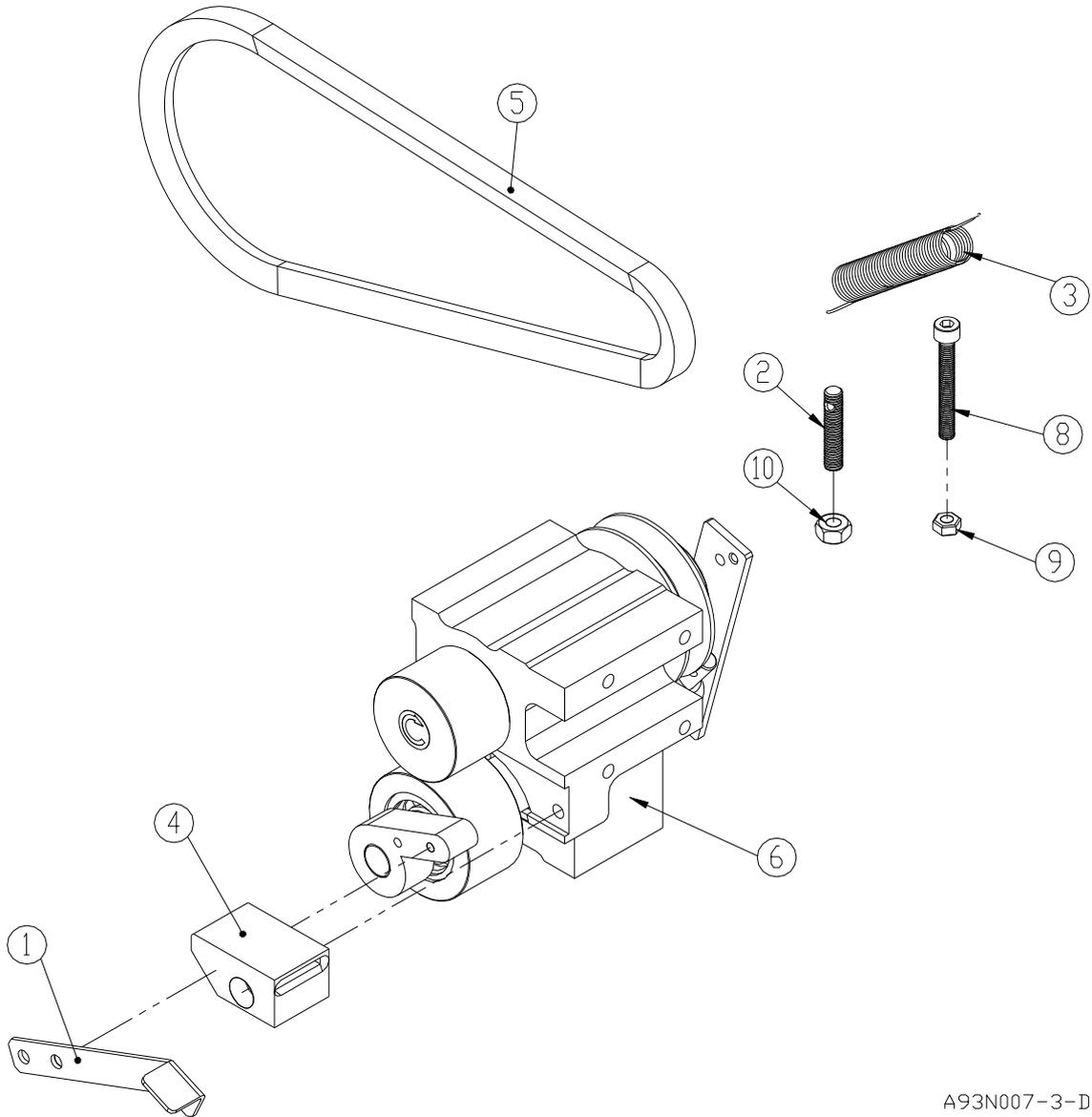
A93NB013-2

122

Feed / Retract Box Unit

No.	Part No.	Part Name	Q'TY
1	A93N-500050-2	Feed / Retract Box	1
2	A93N-502100-0	Pool Seat unit	1
3	A77-500010-0-DAA	Collar	2
4	A77-500016-0-DAA	Band Adjustment Plate	1
5	A77-500018-0	Feed gun Guide Rail	1
6	BA52004	Feed / Retract Box Cover Unit	1
7	A20-531004-1-DAA	Inlet Guide Plate (Upper)	1
8	A20-531005-2-DAA	Inlet Guide Plate (Lower)	1

Pool Seat unit



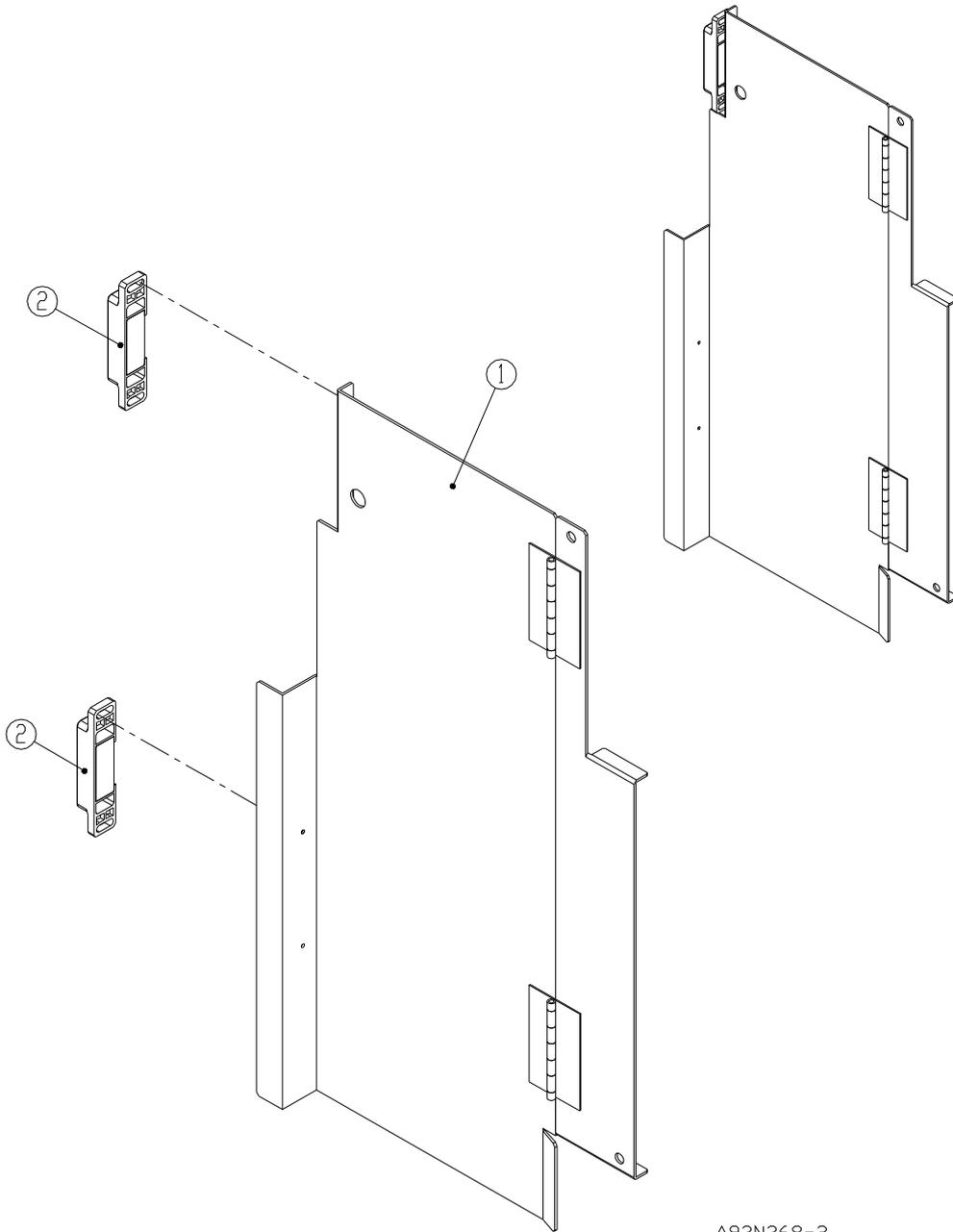
A93N007-3-DAA

123

Pool Seat unit

No.	Part No.	Part Name	Q'TY
1	A93N-500005-1	Rod	1
2	A93N-500006-0	Spring Rod	1
3	A20-510006	Spring	1
4	A20-511006-DAA	Pool Feed Shooter 12mm	1
5	G16-010019-1	V-Belt M-19	1
6	BA51001	Pool Unit	1
8	W01-610560	HBS	1
9	W15-110500	M5 Nut	1
10	W15-110600	M6 Nut	1

Pool Box Rear Cover Unit



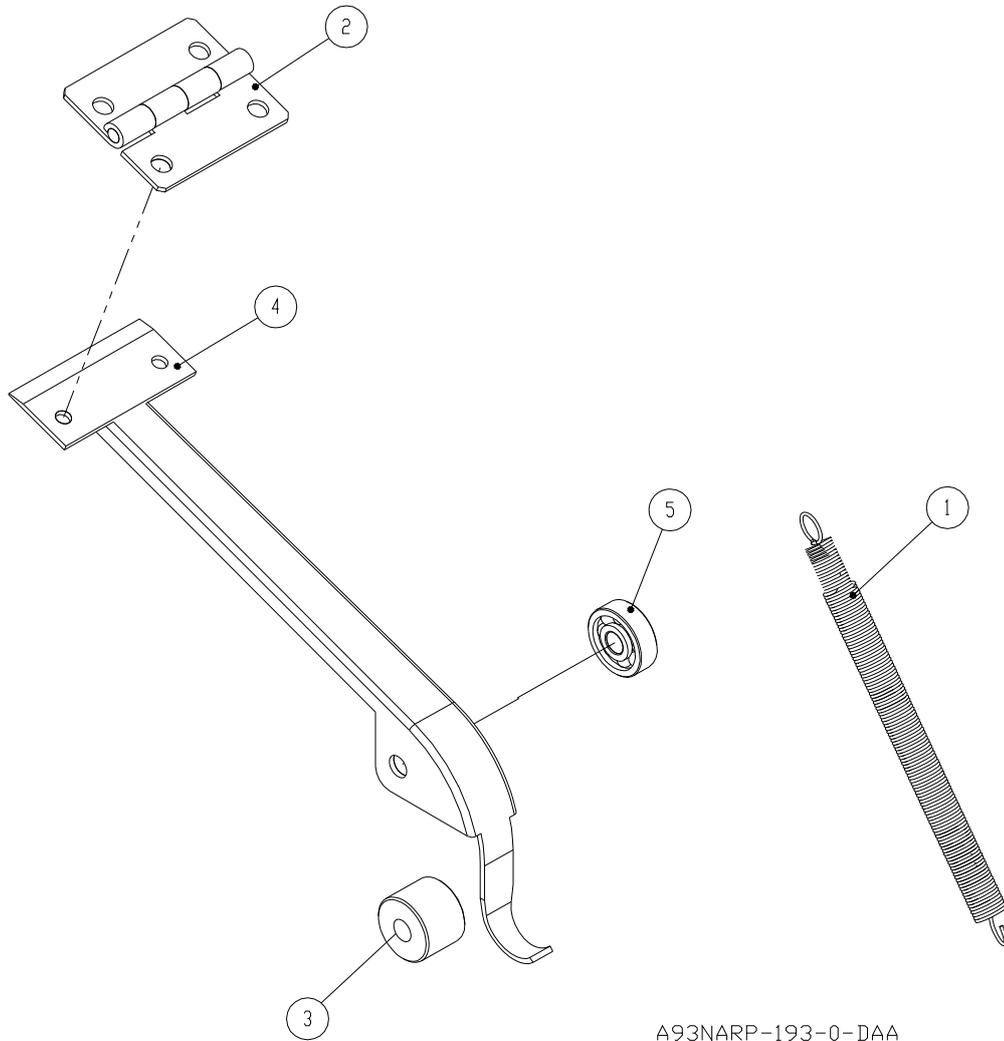
A93N368-2

124

Pool Box Rear Cover Unit

No.	Part No.	Part Name	Q'TY
1	A93N-542050-1	Pool Box Front, RH	1
2	FA93N-3200028-0	Magnet	2

Feed Strap gun Unit



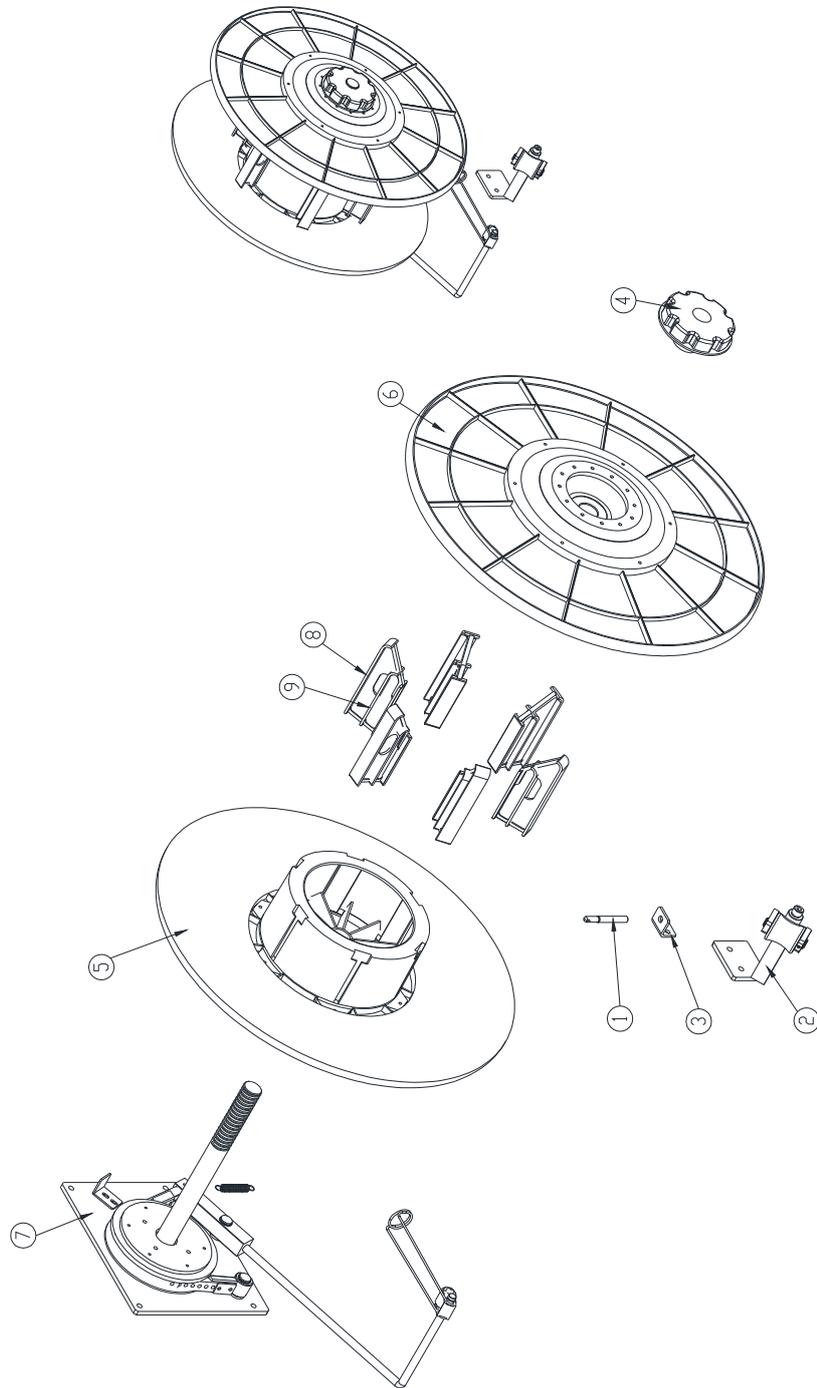
A93NARP-193-0-DAA

125

Feed Strap gun Unit

No.	Part No.	Part Name	Q'TY
1	A20-240010	Spring	1
2	A77-500023-0	Activity Plate	1
3	A77-500024-1-DAA	Feed Strap gun Roller 12mm	1
4	A77-500450-2-DAA	Feed Strap gun 12mm	1
5	G04-210626	Ball Bearing 626ZZ	1

Reel unit



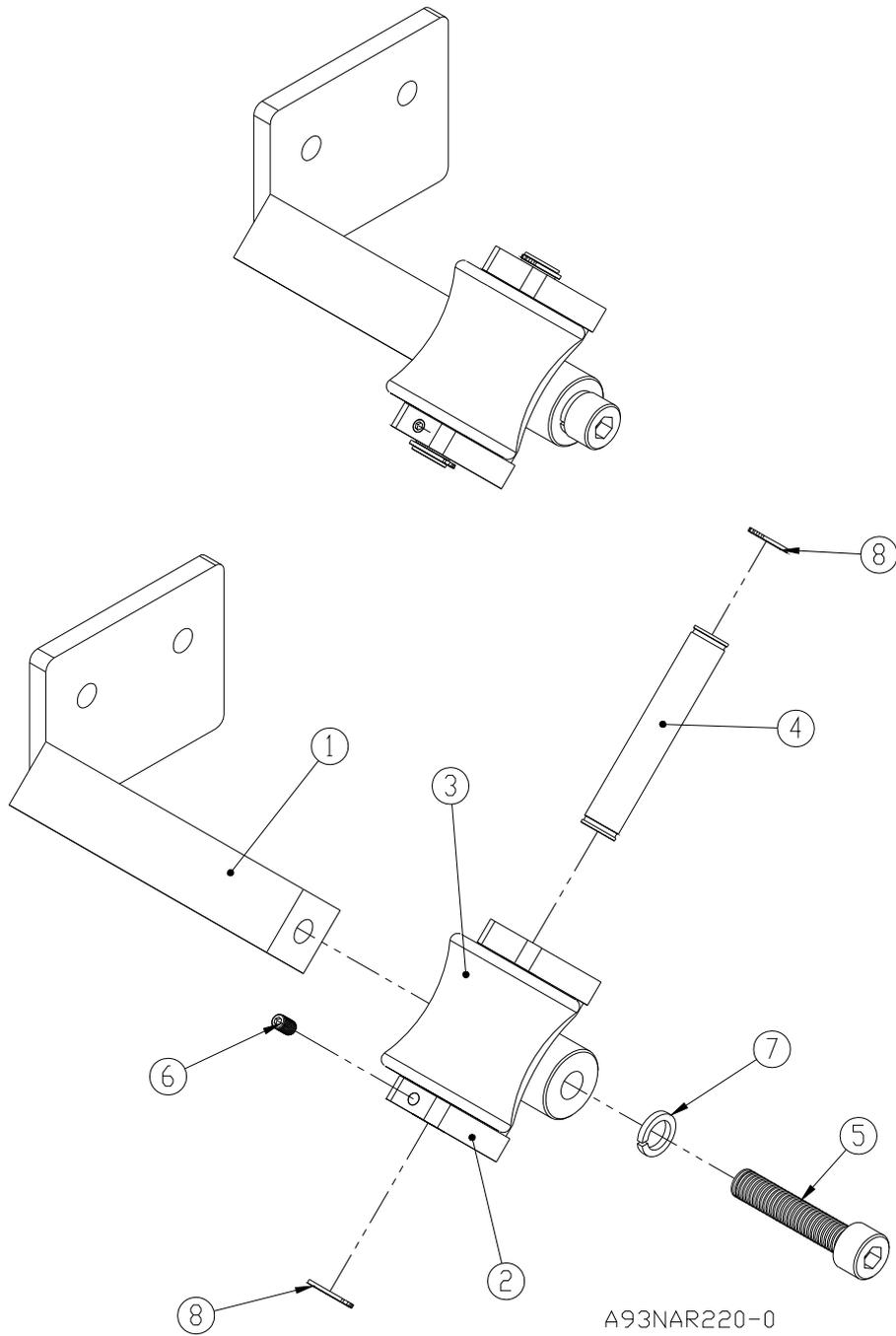
A93NARP-205-0

13.0

Reel unit

No.	Part No.	Part Name	Q'TY
1	A20-130002	Cutter Tension Spring Hook	1
2	BA63001	Inlet Roller Holder Unit	1
3	A20-670004-1	Fixed Holder	1
4	S13-450001	Reel Nut Handle (R)	1
5	S13-451050-120	Reel In Circular	1
6	S23-430003-120	Reel Out Circular	1
7	BA61001	Reel Holder	1
8	S13-450002	Reel Holder -280	6
9	S13-450003	Reel Holder -230	6

Inlet Roller Holder

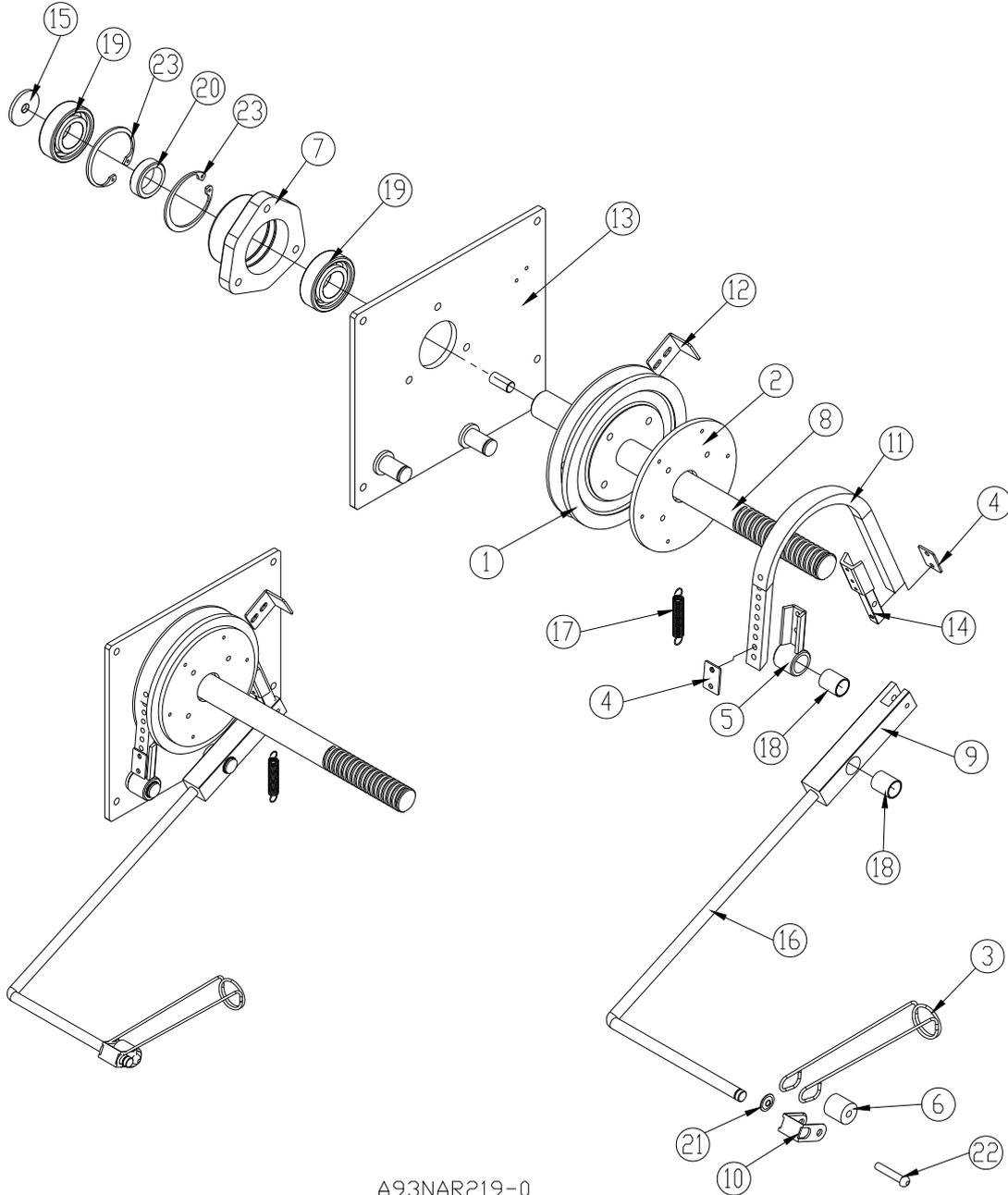


13.1

Inlet Roller Holder

No.	Part No.	Part Name	Q'TY
1	A20-611150-1	Inlet Roller Holder	1
2	A20-611250-0	Guide Roller Holder Unit	1
3	A93N-600003-1	Guide Roller	1
4	S14-424003	Guide Roller Shaft	1
5	W01-210840-1	HBS(M8x40L)	1
6	W02-210406	HSS M4x6	1
7	W19-020108	SW M8*1.8t	1
8	W33-020100	C Type Stop Ring	2

Reel unit Base



A93NAR219-0

132

Reel unit Base

No.	Part No.	Part Name	Q'TY
1	A20-620010	Reel Brake Pulley	1
2	A20-620011	Plate	1
3	A20-620016-1	Band Regulator	1
4	A20-621002	Belt Holder Plate	2
5	A20-621150	Brake Belt Holder	1
6	A20-622002	Roller	1
7	A20-670001-0	Bearing Housing	1
8	A20-670002-0	Reel Shaft	1
9	A20-670006-0	Brake Tension Holder	1
10	A20-670007-0	Roller Holder	1
11	A20-670013-0	Brake B-Belt	1
12	A20-670014-0	Stop Plate	1
13	A20-670050-0	Reel unit Base	1
14	A20-670150-1	Brake Belt Holder	1
15	S14-420005	Washer	1
16	A93N-600006-0	Arm	1
17	EX689	Spring	1
18	G01-151720	Metal Bush	2
19	G04-216205	Ball Bearing 6205	2
20	H70-100019	Collar	1
21	W19-150306	Serrated Washer	1
22	W23-206030	Rivet	1
23	W33-010520	C Type Stop Ring	2

EC DECLARATION OF CONFORMITY

We **JIA-IN INDUSTRY CO., LTD.**
No.18.6th Road, Taichung Industrial Zone, Taichung, Taiwan R.O.C

declare that the product name: Auto Strapping Machine
 Model name : Please reference to the Annex for detail

conform with the essential safety requirements of the relevant European Directive:

- Machinery Directive 2006/42/EC
- Low Voltage Directive 2014/35/EU
- Electromagnetic Compatibility Directive 2014/30/EU

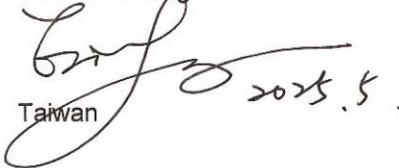
The person who compile technical file established within the EU:

Name:
 Address:

Mounting and connecting instructions defined in catalogues and technical construction files must be respected by the user.

They are based on the following standards :

- EN ISO 12100:2010 Safety of Machinery - General principles for design / Risk Assessment and Risk reduction.
- EN 60204-1:2018 Safety of machinery – Electrical equipment of machines, part 1: General requirements.
- EN 13849-1:2023 Safety of machinery – Safety – related parts of control systems Part 1: General principles for design
- EN 415-8:2025 Safety of packaging machines — Part 8: Strapping machines
- EN 415-10:2014 Safety of packaging machines - Part 10: General Requirements
- EN IEC 61000-6-2:2019 / Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments
- EN IEC 61000-6-4:2019 / Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments
- EN 61000-4-2: 2009 / Electrostatic discharge (ESD)
- EN 61000-4-4: 2012/ Electrical fast transient/burst requirements (EFT/Burst)
- EN 61000-4-6: 2014/ Immunity to conducted disturbances, induced by radio-frequency fields (CS)
- Mobile phone test: 2013

Name : Eric Fang
 Responsibility : General Manager
 Authorized Signature : 
 Date : 2025.5.
 Place : Taiwan



Annex

Series Model(s):

A8 Series Items	A9 Series Items
A-85N, A-88N, A-85NM, A-88NM, A-85NAR, A-88NAR, A-85NAB, A-88NAB, A-88NY, A-85NP, A-88NP, A-85NARP, A-88NARP, A-85NABP, A-88NABP, A-88ND	A-93, A-98, A-93M, A-98M, A-93AR, A-98AR, A-93AB, A-98AB, A-93Y, A-98Y, A-93YT, A-98YT, A-93YMT, A-98YMT, A-93L, A-98L, A-93LAR, A-98LAR, A-93LAB, A-98LAB, A-93ARP, A-98ARP, A-93LARP, A-98LARP

Series Model(s) regulation:

	Models	Code	Description
A-	85 / 88 / 93 / 98	S	Standard
		Y	Side Seal
		AR	Roller Driving
		AB	Belt Driving
		L	Low Table
		M	Stainless
		P	Press
		T	Desktop