

OPERATION, PARTS AND SAFETY MANUAL

 **SIGNODE®**

M410-S-114

NEW REVERSE KEY SEALLESS JOINT

(New Reverse Key type)

POWER STRAPPING MACHINE HEAD

IMPORTANT!

DO NOT DESTROY

It is the customer's responsibility to
have all operators serviceman
read and understand this manual.

Contact your local Signode representative
for additional copies of the manual.

READ ALL INSTRUCTIONS BEFORE OPERATING THIS SIGNODE RPRODUCT

TABLE OF CONTENTS	Page
PARTS LIST, JAW STACK	30
PARTS LIST, SEALLESS MODULE PARTS LIST, GATE ASSEMBLY	31
PARTS LIST, FEED AND TENSION, FRAME	33
PARTS LIST, TRACTION WHEEL UNIT	35
PARTS LIST, BACK UP WHEEL UNIT	37
PARTS LIST, STRAP GUIDE SYSTEM	39
PARTS LIST, STRAP STRAIGHTENER	41
PARTS LIST, SEALING AIR CYLINDER	43
PARTS LIST, AIR MOTOR/TRANSMISSION	45
AIR MOTOR/TRANSMISSION MANUAL	47
	49

PARTS LIST



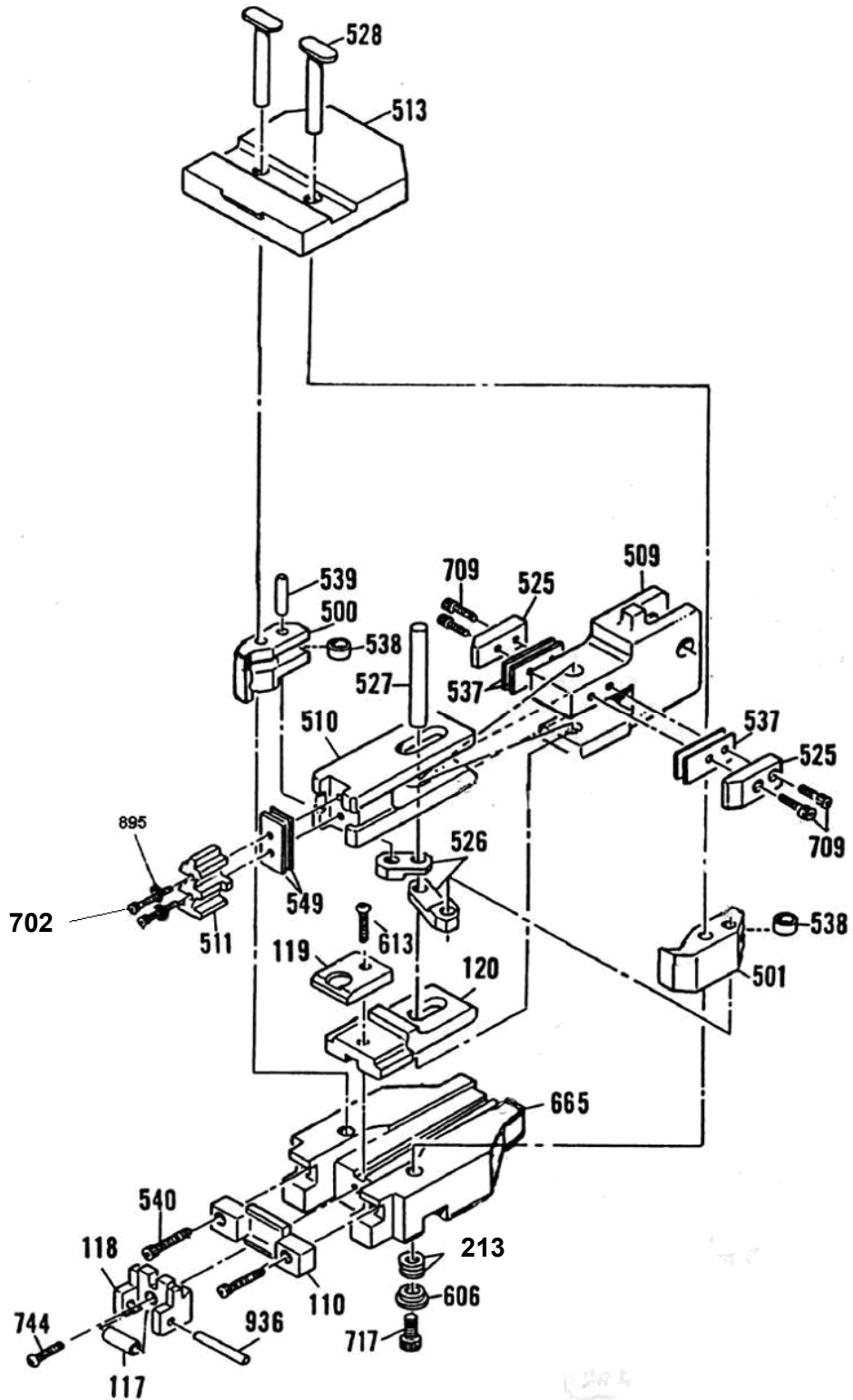
WARNING

All parts must be periodically inspected and replaced if worn or broken. Failure to do this can affect a machine's operation and present a safety hazard.

PARTS LIST,**569145, JAW STACK ASSEMBLY, S-114-RK**

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
110	1	569104	STATIONARY CUTTER
117	1	568017	ROLLER
118	1	568018	BAFFLE PLATE
119	1	568019	MOVING CUTTER
120	1	569063	CUTTER HOLDER
500	1	569084	RIGHT JAW
501	1	569085	LEFT JAW
509	1	569009	LOWER YOKE
510	1	569010	PUNCH HOLDER
511	1	569083	PUNCH
513	1	569307	UPPER GUIDE BLOCK
525	2	569025	CAM
526	2	569026	JAW LINK
527	1	569056	YOKE PIN
528	2	569310	JAW PIN
537	A/R	569037	CAM SHIM
538	2	569038	ROLLER
539	2	569039	LINK AND JAW PIN
540	2	568079	SCREW, STATIONARY CUTTER
549	A/R	569049	PUNCH SHIM
213	A/R	016213	SHIM
606	2	016212	JAW PIN WASHER
613	1	569994	S.H.C. SCREW, M10x15
665	1	569057	LOWER GUIDE BLOCK
702	2	569702	S.H.C. SCREW, M4X20
709	4	569709	S.H.C. SCREW, M6X20
717	2	569717	S.H.C. SCREW, M8X25
744	1	569744	B.H.C. SCREW, M8X16
895	2	569887	CONICAL DISK SPRING
936	1	569937	ROLL PIN, 5x45

JAW STACK ASSEMBLY

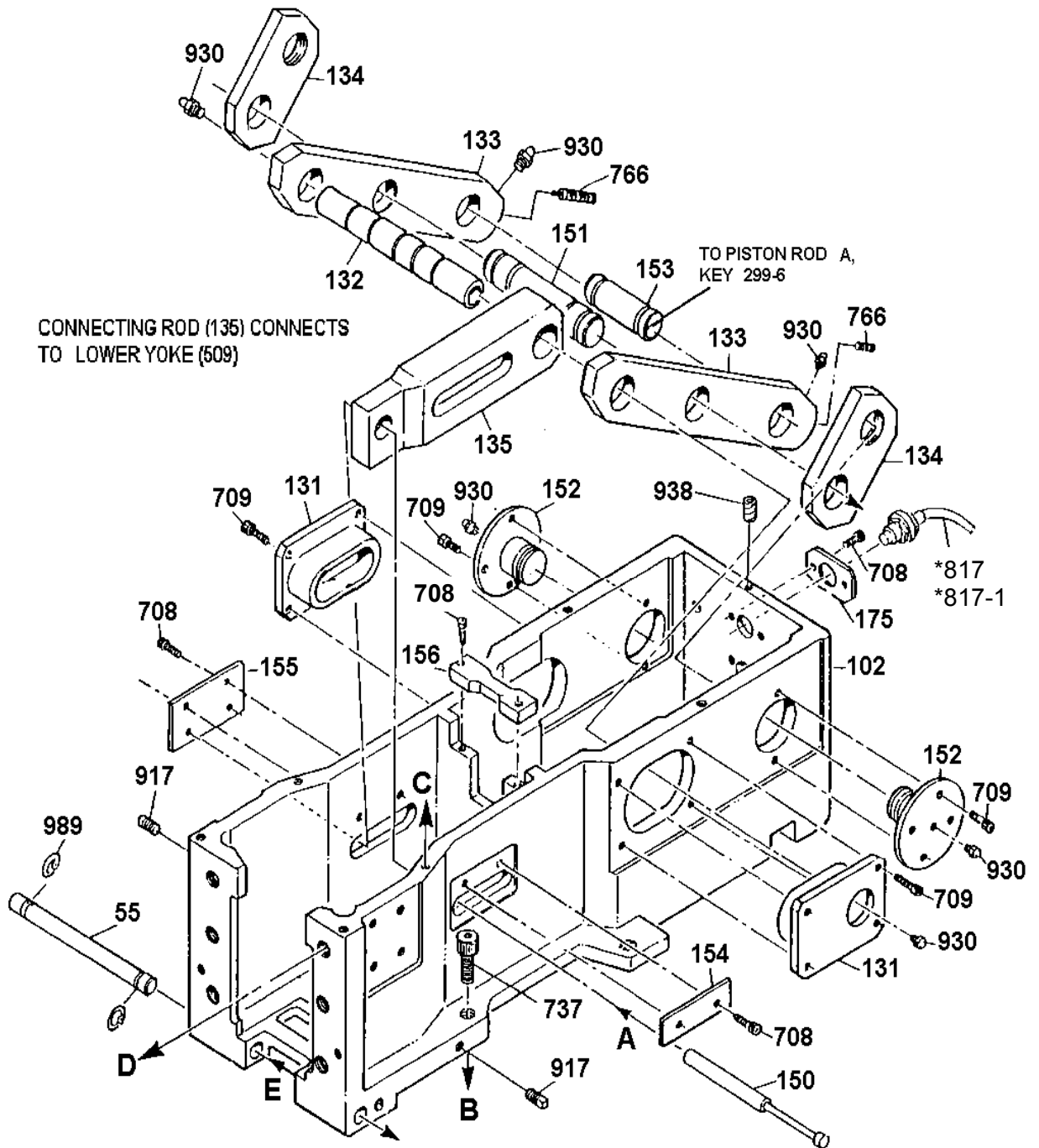


PARTS LIST, SEALLESS MODULE

UPPER WELDMENT AND LINKAGE ASSEMBLY

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
55	1	569985	LONG PIN, STRAP GUIDE
102	1	568002	SEALER MECHANISM HOUSING
131	2	568031	GUIDE BLOCK, LONG TOGGLE PIN
132	1	568032	LONG TOGGLE PIN
133	2	568033	LONG TOGGLE LINK
134	2	568034	SHORT TOGGLE LINK
135	1	568035	CONNECTING ROD
150	1	568050	CONNECTING ROD PIN
151	1	568051	CENTER PIN
152	2	568052	SIDE PIN
153	1	568053	PISTON PIN
154	1	568054	CAP PLATE (1)
155	1	568055	CAP PLATE (2)
156	1	568056	CONNECTING ROD GUIDE
175	3	568075	SENSOR BRACKET, JAW STACK
708	12	569708	S.H.C. SCREW, M6X12
709	12	569709	S.H.C. SCREW, M6X20
737	4	569737	S.H.C. SCREW, M14X30
766	4	569766	SET SCREW, LONG DOG POINT, M6X6
*817	3	569817	PROXIMITY SENSOR, AC100V
*817-1	3	569817-1	PROXIMITY SENSOR, DC24V
917	2	569917	PLUG, R1/8
930	6	569930	GREASE NIPPLE, A-MT6X1
938	1	569938	SPRING PIN, 6X20
989	2	569989	RETAINING RING

* Parts are determined by choice.

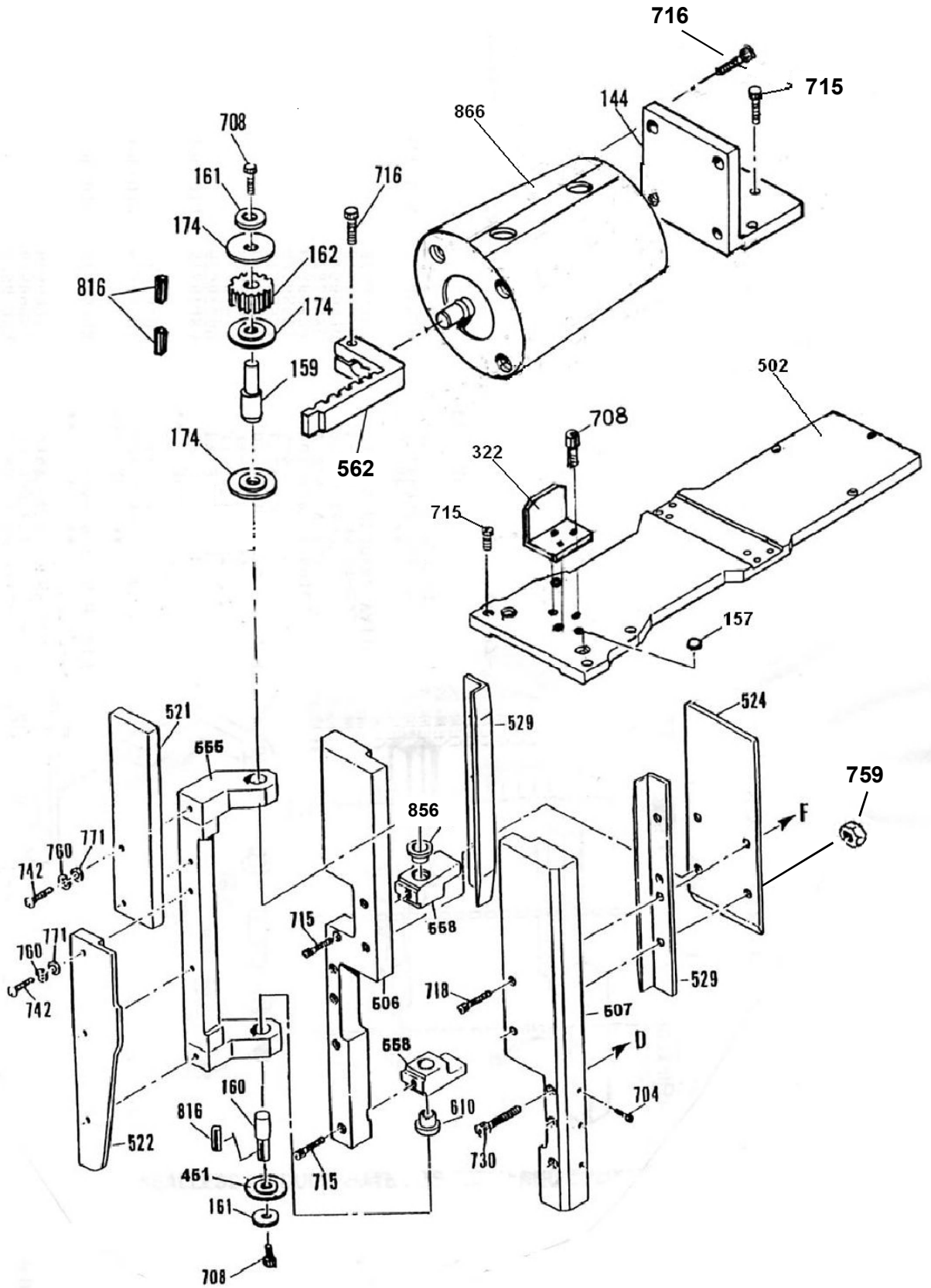


UPPER WELDMENT AND LINKAGE ASSEMBLY

**PARTS LIST,
GATE ASSEMBLY AND CYLINDER**

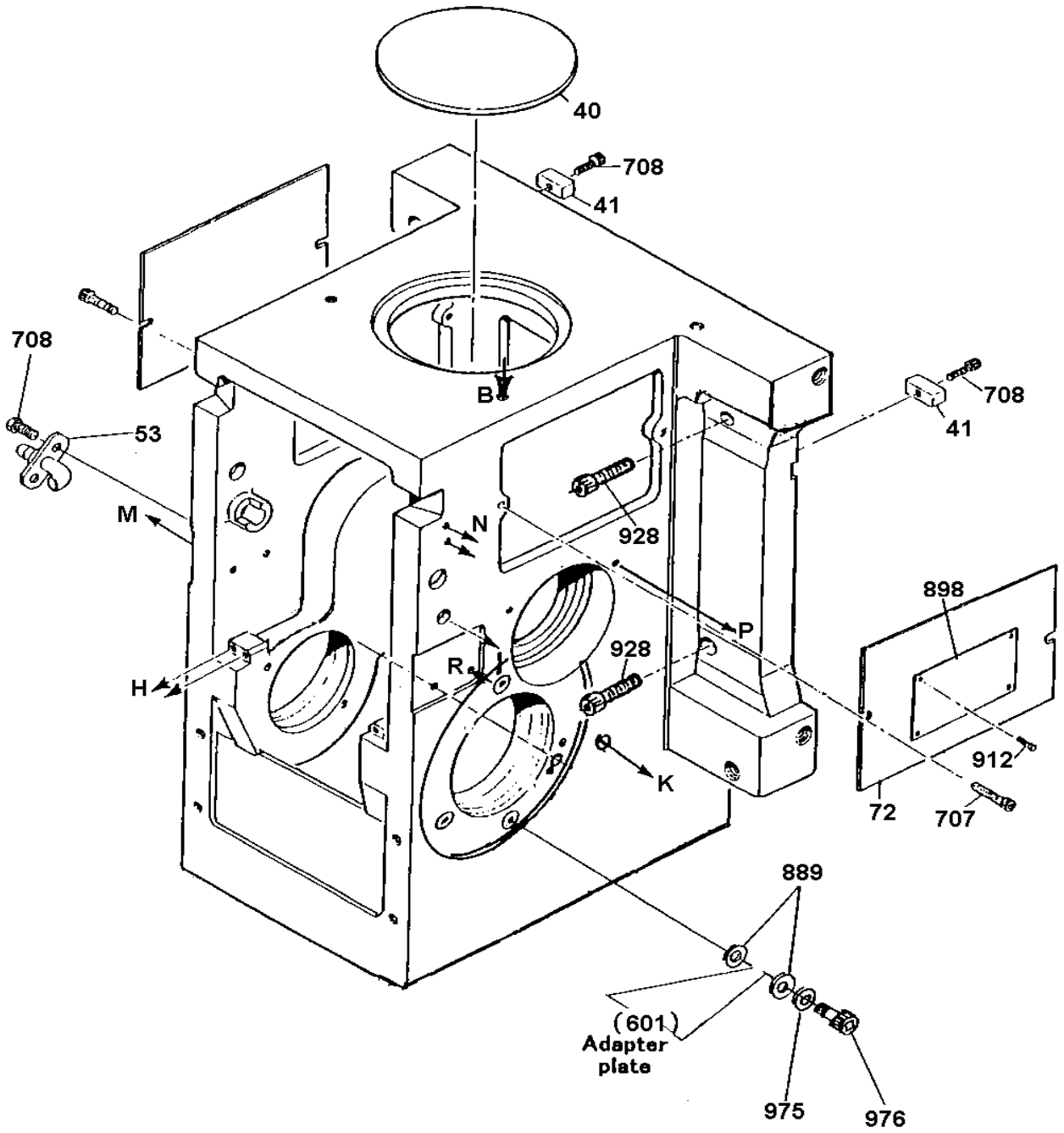
<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
144	1	569087	FACE GATE CYL. MOUNT
157	1	568057	BLIND CAP
159	1	568059	GATE SHAFT (1)
160	1	568060	GATE SHAFT (2)
161	2	568061	WASHER
162	1	568062	PINION
174	2	568074	WASHER, GATE SHAFT
322	1	569322	ROD END GUIDE
451	1	568451	WASHER, GATE SHAFT
502	1	569302	TOP COVER
506	1	569096	EJECTOR GUIDE, RH (New)
507	1	569097	EJECTOR GUIDE, LH (New)
521	1	569021	UPPER GATE
522	1	569022	LOWER GATE
524	1	569088	STRAP GUIDE
529	2	569029	EJECTOR GUIDE INSERT
555	1	569055	GATE BRACKET WELDMENT
558	2	569058	GATE BRACKET
562	1	569062	AIR CYLINDER ROD END
856	2	569856	GATE BUSHING
704	6	569704	S.H.C. SCREW, M5X10
708	5	569708	S.H.C. SCREW, M6X12
715	11	569715	S.H.C. SCREW, M8X16
716	5	569716	S.H.C. SCREW, M8X20
718	4	569718	S.H.C. SCREW, M8x30
730	6	569730	S.H.C. SCREW, M12x30
742	5	569742	B.H.C. SCREW, M6x25
759	4	569759	HEXAGON NUT, M8
760	5	569760	SPRING LOCK WASHER, M6
771	5	569771	PLAIN WASHER, M6
816	3	569816	KEY, 5X5X20
866	1	569866	AIR CYLINDER, 50X30

GATE ASSEMBLY AND CYLINDER



**PARTS LIST, FEED AND TENSION
FRAME ASSEMBLY**

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
0	1	567600	FRAME
40	1	567540	COTTER PLATE
41	2	567541	KEY
53	1	567553	AIR BLOW PIPE
72	2	567572	COVER PLATE
707	4	569707	S.H.C. SCREW, M6X10
708	4	569708	S.H.C. SCREW, M6X12
889	6	569889	THRUST WASHER
898	1	569898	MACHINE NAME PLATE
912	4	569912	SETTING RIVET, #2X4.8
928	4	569928	LOCK BOLT, M12X35
975	3	569975	SHIM RING
976	3	569976	SHOULDER BOLT



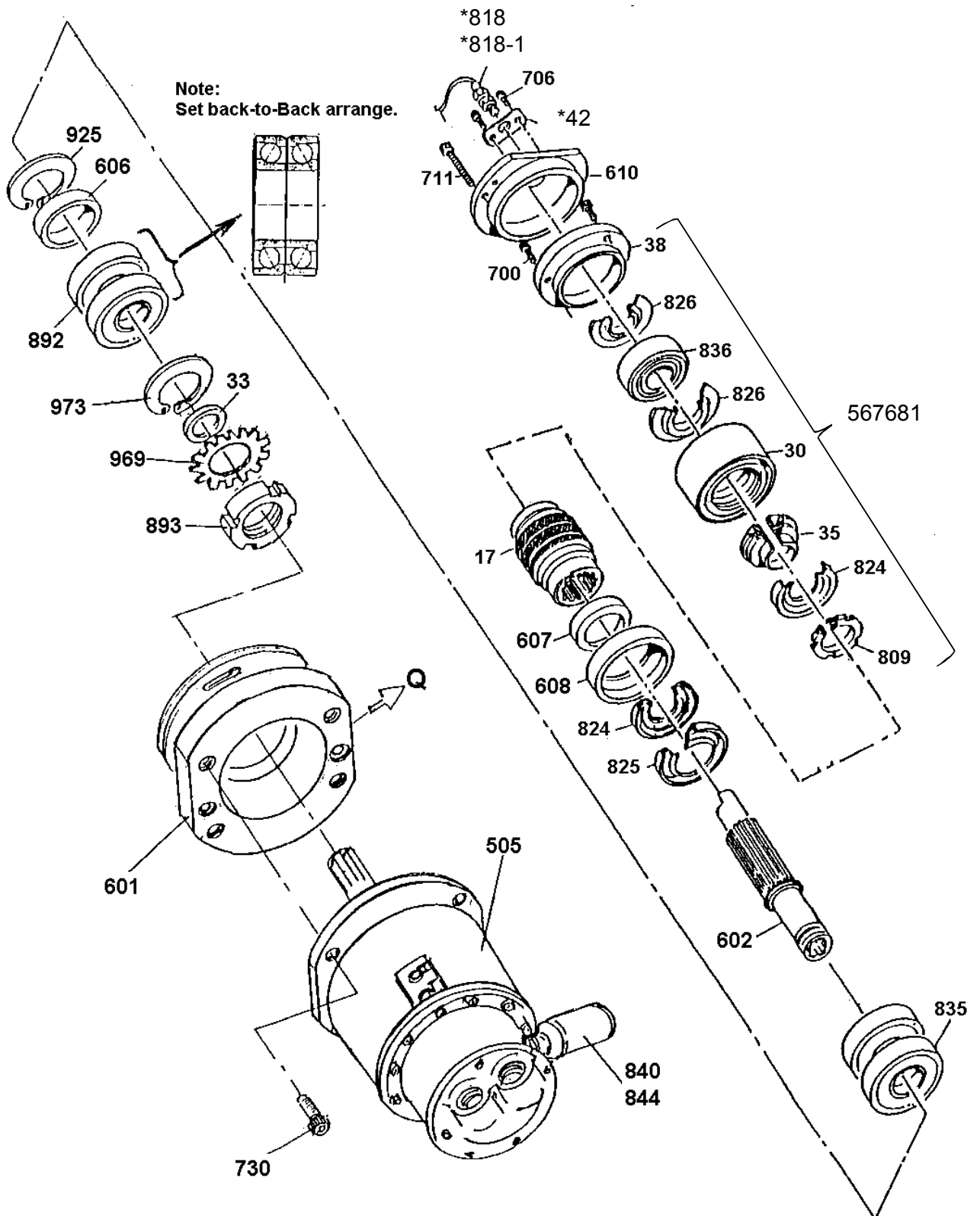
FRAME ASSEMBLY

**PARTS LIST, FEED AND TENSION
FEED / TENSION COMPONENTS**

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
17	1	567517	TRACTION WHEEL
30	1	567530	BEARING CASE
33	1	567533	WASHER (2)
35	1	567535	DISTANCE RING (2)
38	1	567538	DISTANCE RING (5)
*42	1	568418	BLIND PLATE,OPTION
*42	1	568419	SENSOR BRACKET (M12X1.0 TAP),OPTION
*42	1	567542	SENSOR BRACKET (M8)
505	1	569505	AIR MOTOR/TRANSMISSION
601	1	567601	ADAPTER PLATE
602	1	567602	DRIVE SHAFT
606	1	567606	SPACER, DRIVE SHAFT
607	1	567607	SPACER, TRACTION WHEEL
608	1	567608	DISTANCE RING, DRIVE SHAFT
610	1	567610	BEARING CAP (1), DRIVE SHAFT
700	2	569700	S.H.C. SCREW, M3X8
706	2	569706	S.H.C. SCREW, M6X8
711	2	569711	S.H.C. SCREW, M6X50X18
730	4	569730	S.H.C. SCREW, M12X30
809	1	569809	BEARING NUT, AN09 MODIFIED
*818	1	569818	PROXIMITY SENSOR, AC100V
*818-1	1	569818-1	PROXIMITY SENSOR, DC24V
824	2	569824	NILOS RING, #16010AV
825	1	569825	NILOS RING, #22209AV
826	2	569826	NILOS RING, #22207AV
835	2	569835	BEARING, NJ209
836	1	569836	BEARING, 22207H
840	1	569840	SOUNDPROOF CAP
844	1	569844	SILENCER
892	1	569892	ANGULAR BALL BEARING UNIT, 7009DB
893	1	569893	BEARING NUT, AN09
925	2	569925	RETAINING RING, C-85
969	1	569969	LOCK WASHER, AW09
973	1	569973	RETAINING RING, C-75

* Parts are determined by choice.

FEED AND TENSION ASSEMBLY, TRACTION WHEEL UNIT



**PARTS LIST, FEED AND TENSION, CONTINUED
FEED/TENSION COMPONENTS**

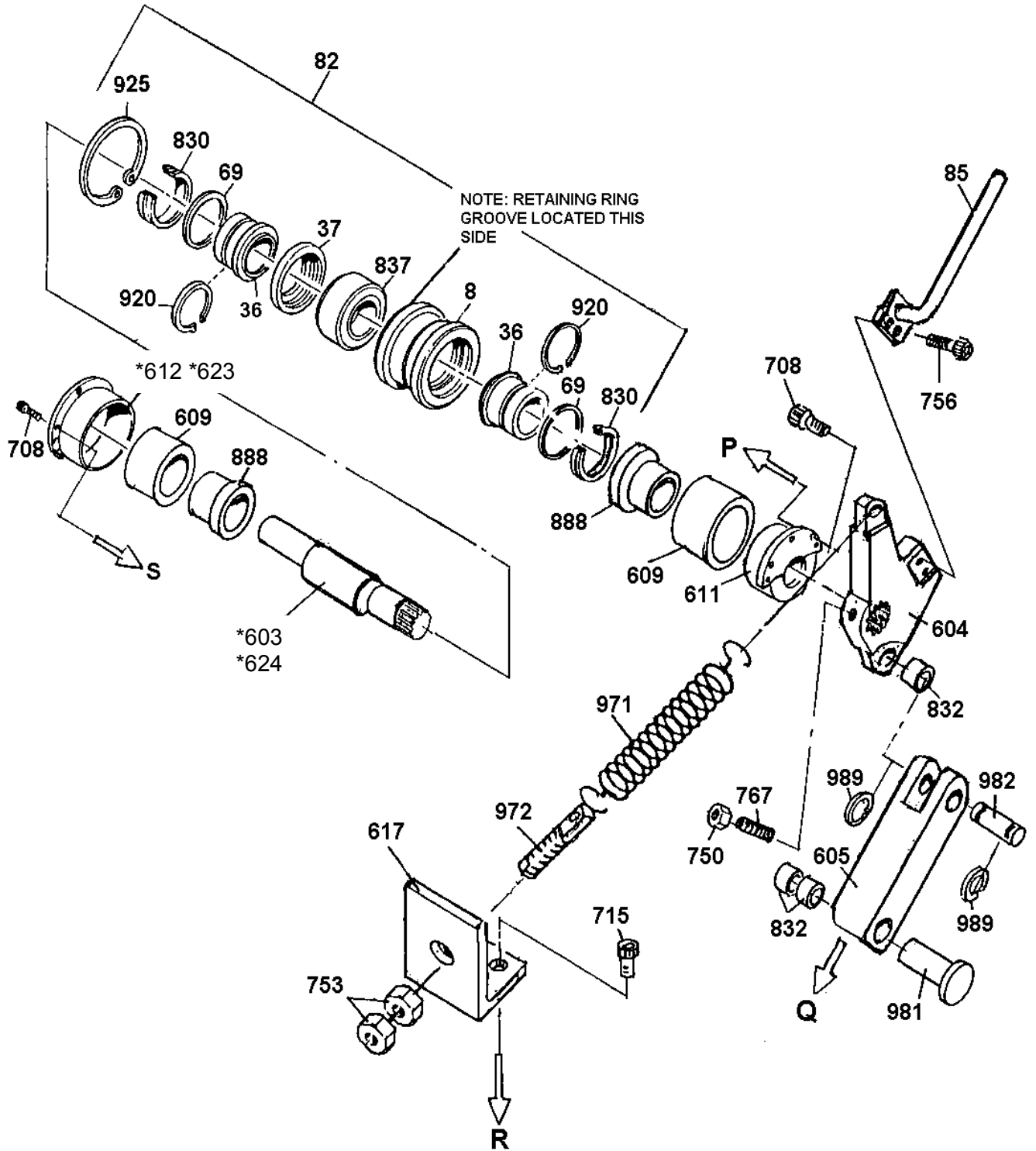
<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
8	1	567508	BACK UP WHEEL
36	2	567536	DISTANCE RING (3)
37	1	567537	DISTANCE RING (4)
69	2	567569	FELT RING, BACK UP WHEEL
82	1	567482	BACK UP WHEEL ASSEMBLY, 114"
85	1	567585	RELEASE HANDLE
*603	1	567603	ECCENTRIC SHAFT
*624	1	567624	ECCENTRIC SHAFT, Both Handle
604	1	567604	SELF LEVER
605	1	567605	SELF LINK
609	2	567609	SLEEVE, METAL BEARING
611	1	567611	BEARING CAP (2)
*612	1	567612	BEARING CAP (3)
*623	1	567623	BEARING CAP (3), USE Both Handle 567624
617	1	567617	SPRING BRACKET
708	4	569708	S.H.C. SCREW, M6X12
715	2	569715	S.H.C. SCREW, M8X16
750	1	569750	HEX NUT, M6
753	2	569753	HEX NUT, M12
756	2	569756	NYLOK BOLT, M6X20
767	1	569767	SET SCREW, M6X16
830	2	569830	V-RING, V-55A
832	3	569832	DU-BUSH, MB1212
837	1	569837	BEARING, 22209H
888	2	569888	METAL BEARING
920	2	569920	RETAINING RING, C-55
925	1	569925	RETAINING RING, C-85
971	1	569971	ENERGIZING SPRING
972	1	569972	SPRING POST
981	1	569981	LINK PIN
982	1	569982	LEVER PIN
989	2	569989	RETAINING RING

* Parts are determined by choice.

REVERSE HANDLE(Option)

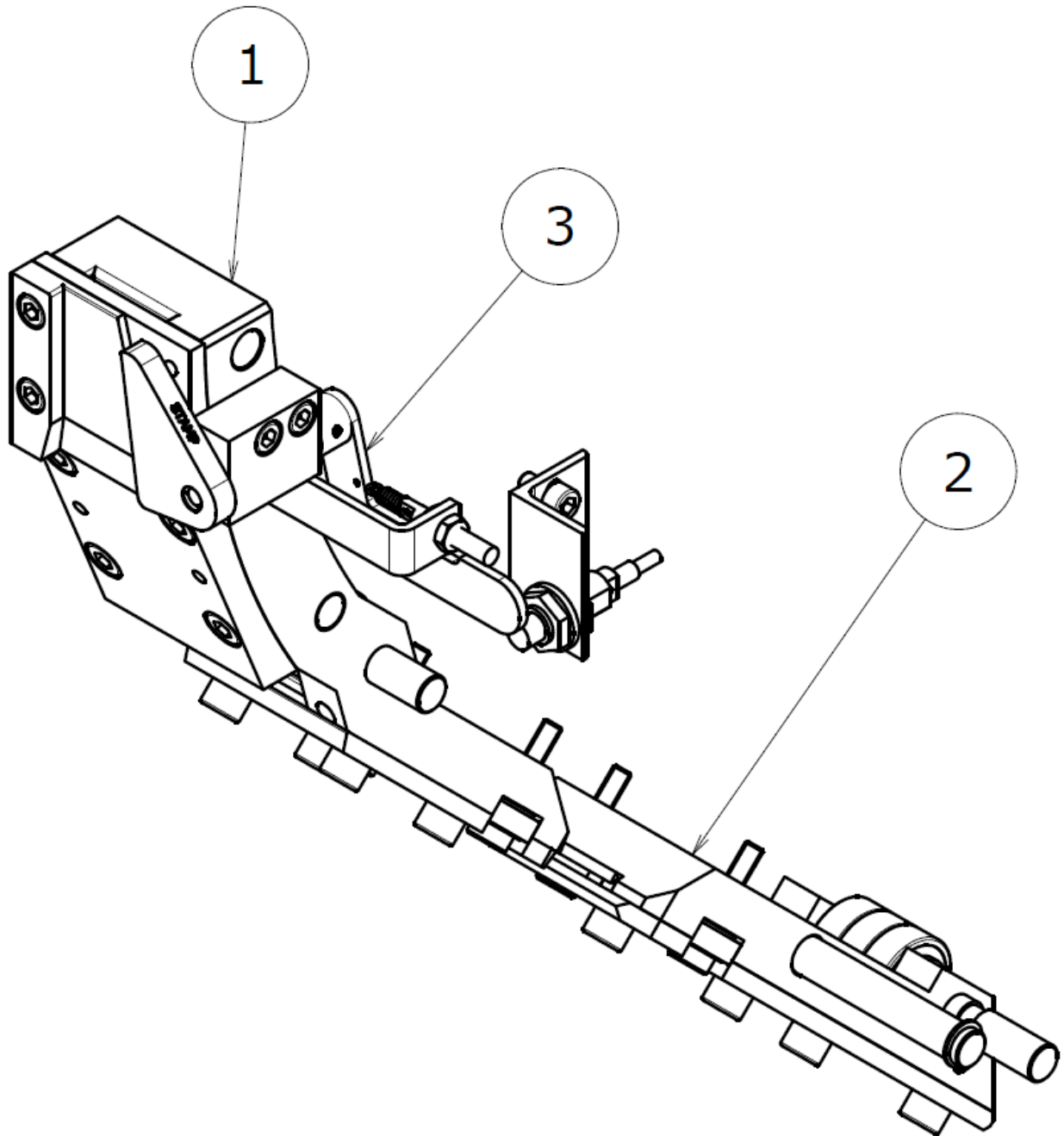
612→623	1	567623	BEARING CAP(3), Mod.
603→624	1	567624	ECCENTRIC SHAFT, Both Handle

FEED AND TENSION ASSEMBLY, BACK UP WHEEL UNIT



PARTS LIST, STRAP GUIDE SYSTEM ASSEMBLY

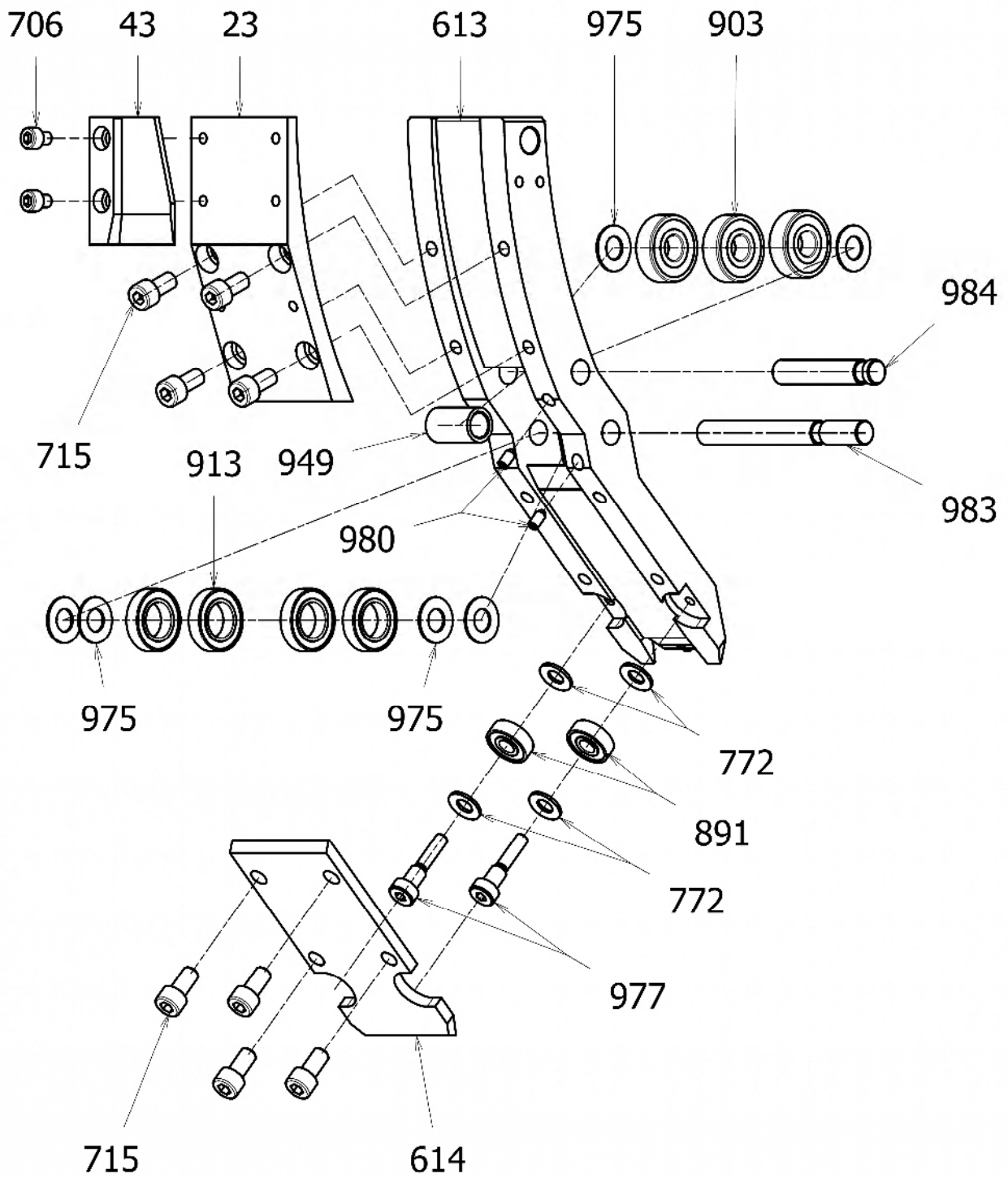
	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
①	1	E567977	UPPER GUIDE UNIT ASSEMBLY, 114
②	1	E567978	LOWER GUIDE UNIT ASSEMBLY, 114
③	1	E567979	LIMIT FINGER ASSEMBLY, 114



**PARTS LIST, FEED AND TENSION
STRAP GUIDE SYSTEM ASSEMBLY
567977, UPPER GUIDE UNIT ASSEMBLY, 114**

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
23	1	567523	UPPER GUIDE UNIT #2 OUTER SIDE
43	1	567543	LOWER STRAP GUIDE(1 1/4")
613	1	567613	UPPER GUIDE UNIT INNER SIDE (1 1/4")
614	1	567614	UPPER GUIDE NO.1 OUTER
706	2	569706	S.H.C. SCREW, M6X8
715	8	569715	S.H.C.SCREW, M8X16
772	4	569772	FLAT WASHER, M8
891	2	569891	SMALL BALL BEARING, B608ZZ
903	3	569903	BALL BEARING, 6201ZZ
913	4	569913	BALL,BEARING, B6903ZZ
949	1	569949	SPACER,CLBSB 17-28
975	6	569975	SHIM RING M8
977	2	569977	SHOULDER BOLT MSB8-LC10.2
980	2	569980	SET SCREW, MSSU 5-10
983	1	569983	ROLLER PIN
984	1	569984	ROLLER PIN

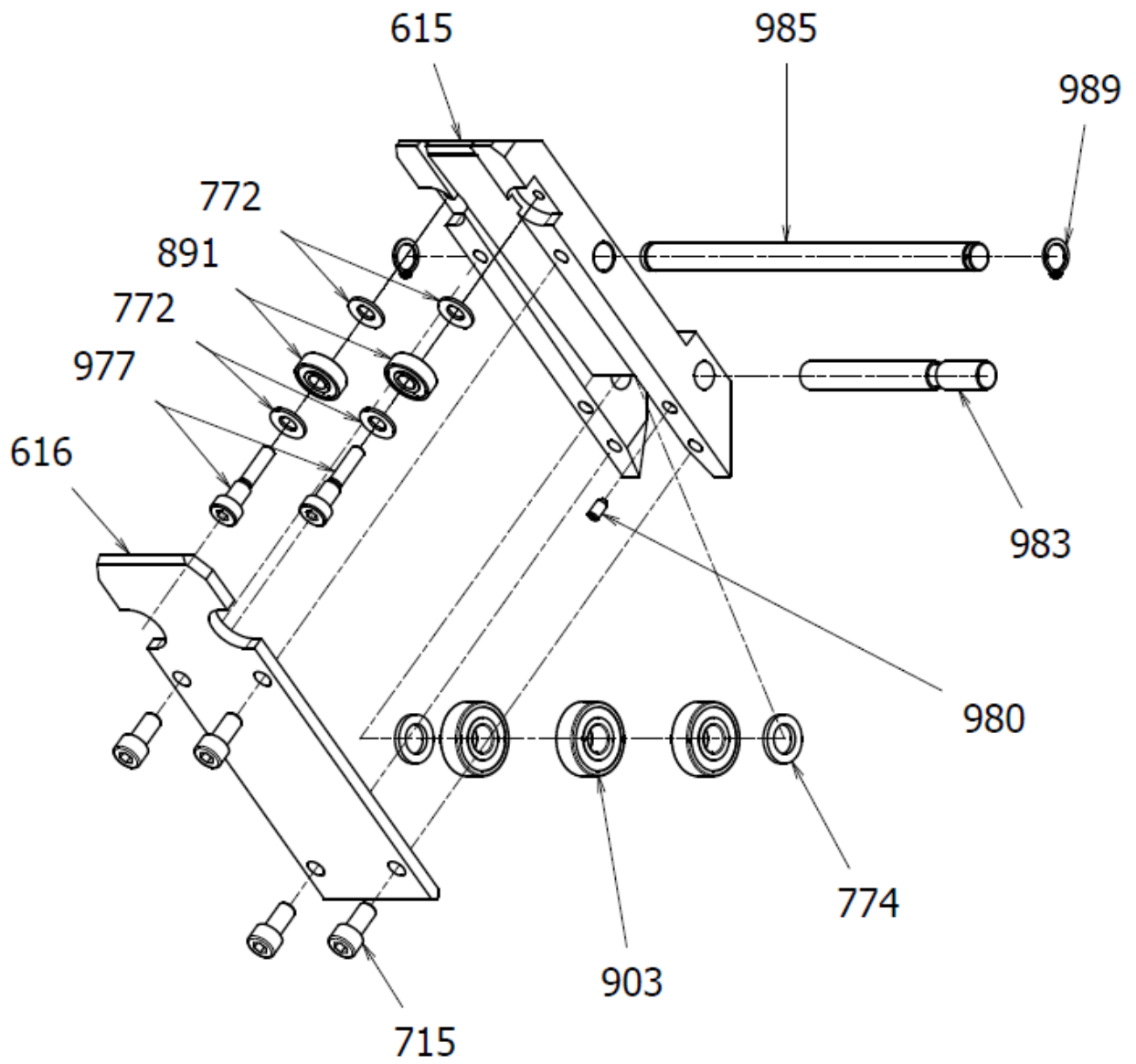
UPPER GUIDE UNIT ASSEMBLY, 114



**PARTS LIST, FEED AND TENSION
567978, LOWER GUIDE UNIT ASSEMBLY, 114**

<u>KEY</u>	<u>QTY</u>	<u>PART NO</u>	<u>DESCRIPTION</u>
615	1	567615	LOWER GUIDE UNIT INNER
616	1	567616	LOWER GUIDE UNIT OUTER
715	4	569715	S.H.C.SCREW, M8X16
772	4	569772	FLAT WASHER, M8
774	2	569774	WASHER M12
891	2	569891	SMALL BALL BEARING, B608ZZ
903	3	569903	BALL BEARING, 6201ZZ
977	2	569977	SHOULDER BOLT MSB8-LC10.2
980	1	569980	SET SCREW, MSSU 5-10
983	1	569983	ROLLER PIN
985	1	569985	GUIDE HOLDER PIN
989	2	569989	RETAINING RING

LOWER GUIDE UNIT ASSEMBLY, 114

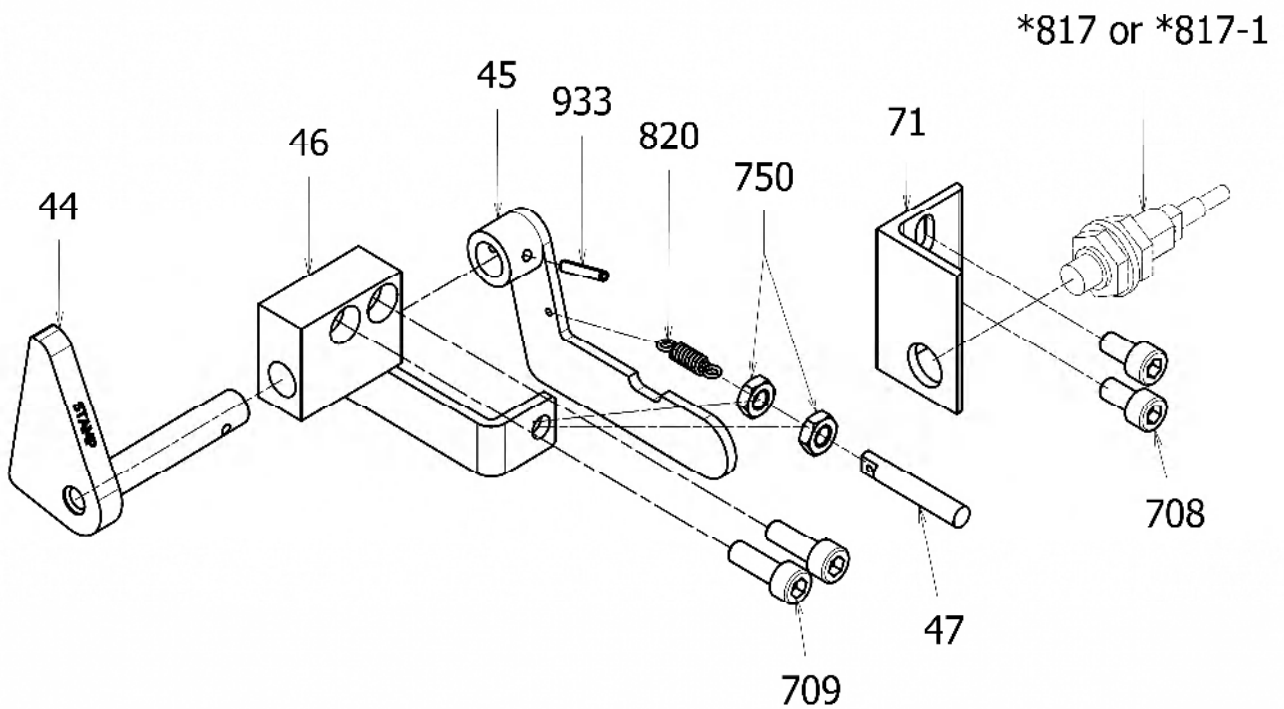


PARTS LIST, FEED AND TENSION

567979, LIMIT FINGER ASSEMBLY, 114 (Not included sensor)

<u>KEY</u>	<u>QTY</u>	<u>PART NO</u>	<u>DESCRIPTION</u>
44	1	567544	LIMIT FINGER (1 1/4")
45	1	567545	STRIKER
46	1	567546	BRACKET, COMPLETE FEED
47	1	567547	TENSION BOLT
71	1	567571	SENER BRACKET,FEEDING 30 x 30 x 3
708	2	569708	S.H.C.SCREW,M6X12
709	2	569709	S.H.C.SCREW M6X20
750	2	569750	HEX NUT, M6
820	1	569820	EXTENSION SPRING,H05-13
933	1	569933	SPRING PIN, 3X16
*817	1	569817	PROXIMITY SENSOR AC100V
*817-1	1	569817-1	PROXIMITY SENSOR DC24V

* Parts are determined by choice.

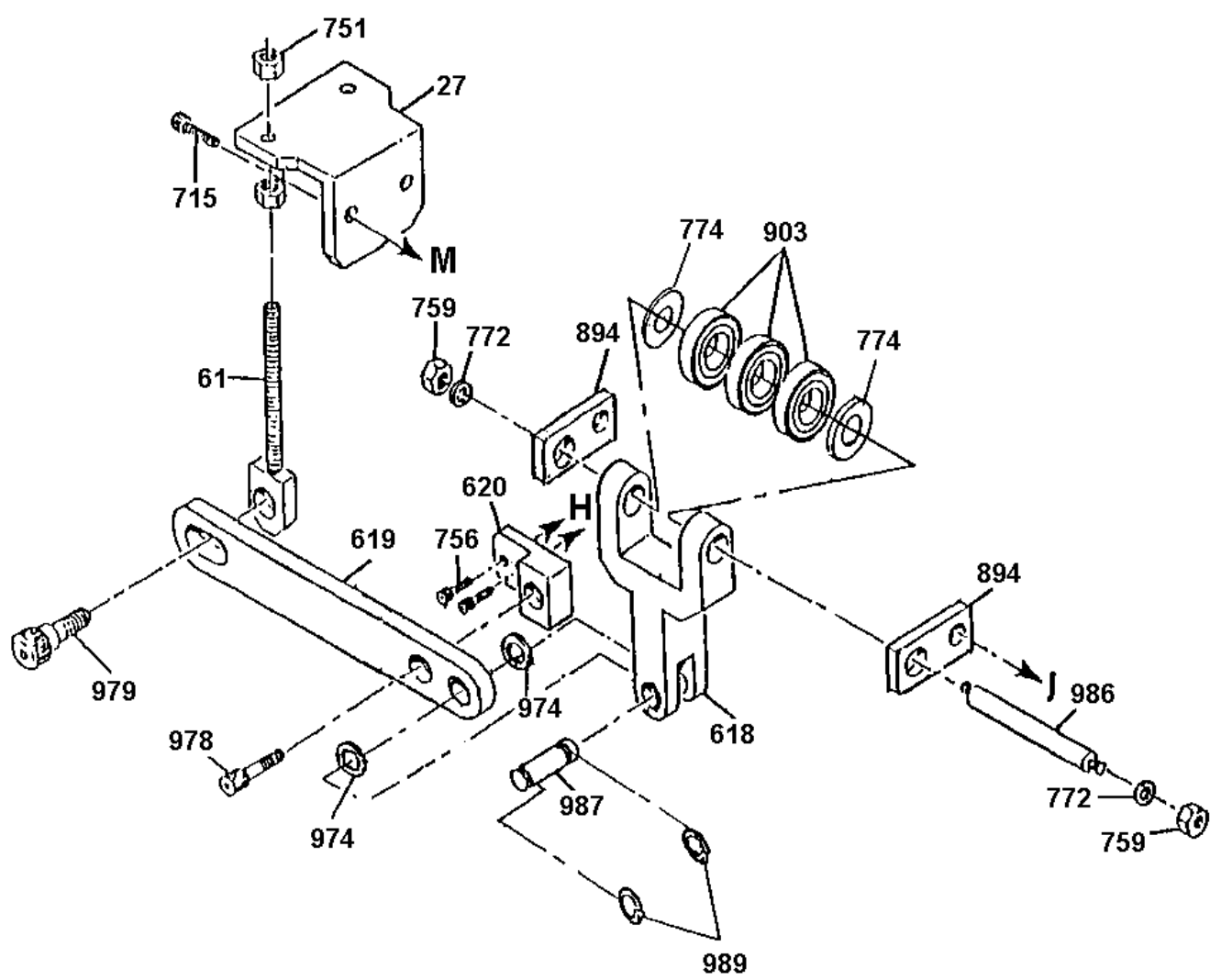


PARTS LIST, FEED AND TENSION

567980, STRAP STRAIGHTENER ASSEMBLY, 114

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
27	1	567527	STRAIGHTENER BRACKET
61	1	567561	ADJUST SCREW
618	1	567618	CONNECTOR
619	1	567619	LEVER
620	1	567620	LEVER MOUNT
715	2	569715	S.H.C. SCREW, M8X16
751	2	569751	HEX. NUT, M8
756	2	569756	NYLOK BOLT, M6X20
759	2	569759	U-NUT, M8
772	2	569772	WASHER, M8
774	2	569774	WASHER, M12
894	2	569894	LINK PLATE
903	3	569903	BALL BEARING, 6201ZZ
974	2	569974	SHIM RING
978	1	569978	SHOULDER BOLT
979	1	569979	SHOULDER BOLT
986	1	569986	STRAIGHTENER SHAFT
987	1	569987	STRAIGHTENER PIN
989	2	569989	RETAINING RING, STWN12

STRAP STRAIGHTENER ASSEMBLY

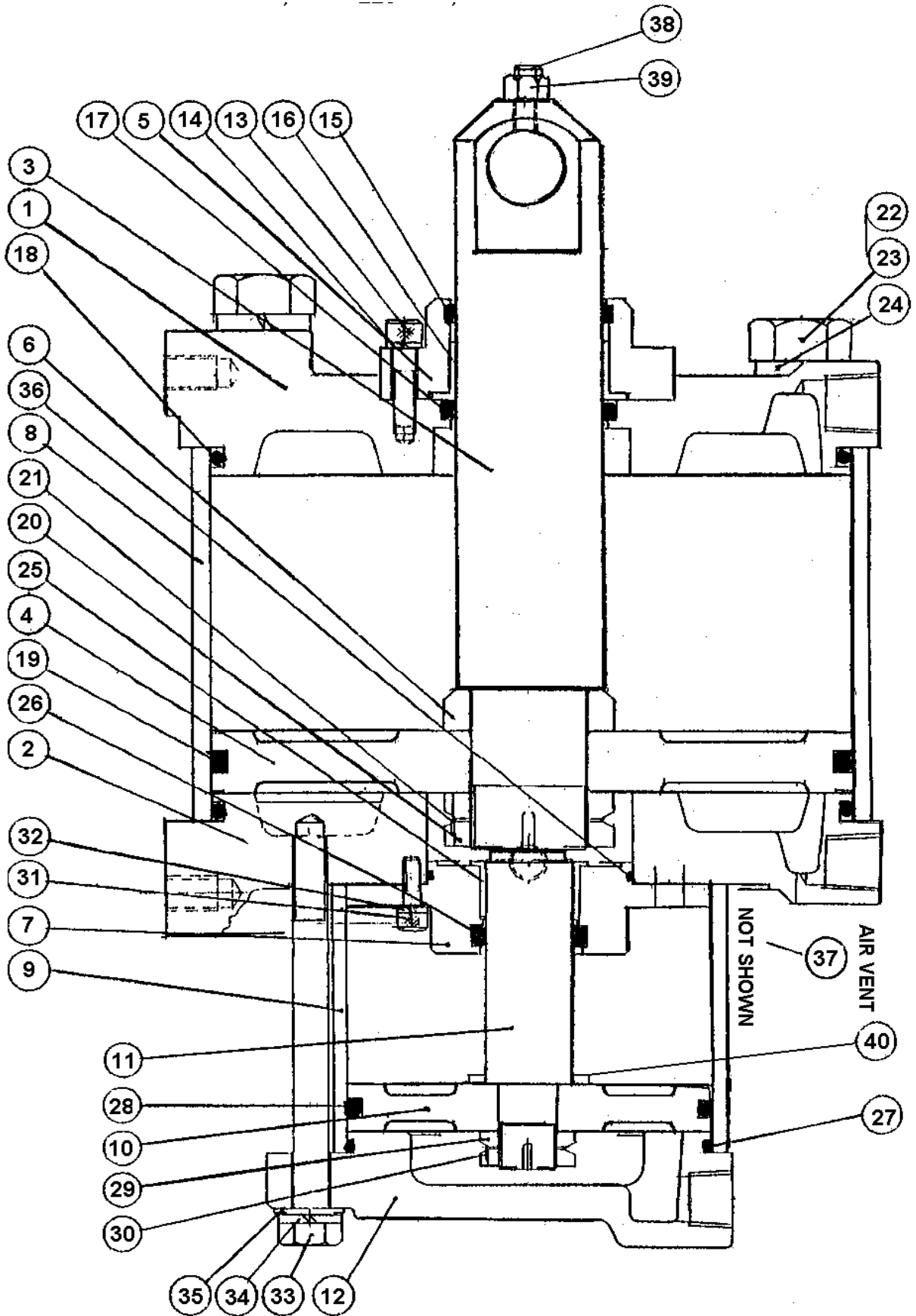


PARTS LIST,

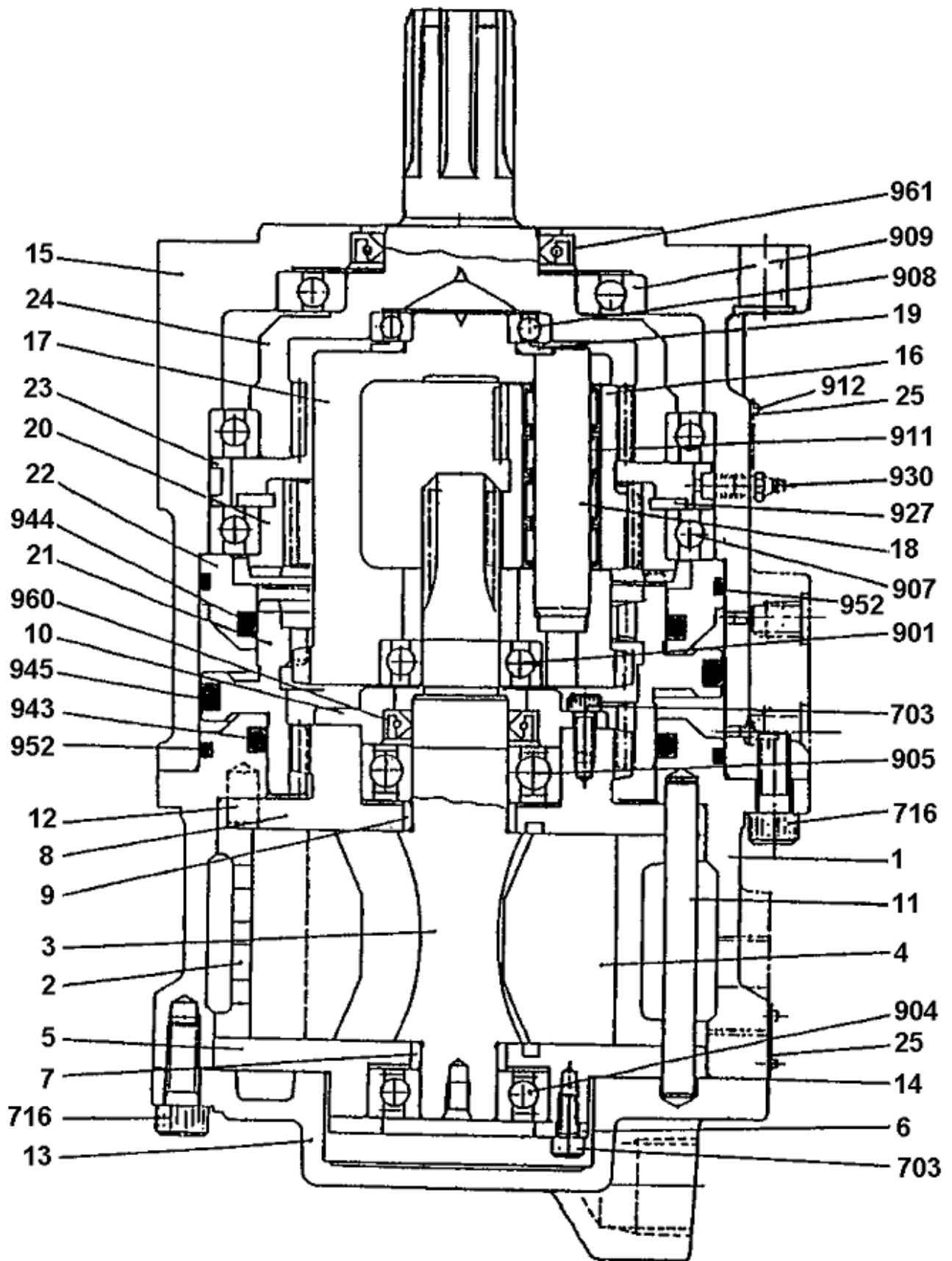
569400-1, AIR CYLINDER, 220mm

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	1	569405	FRONT HEAD COVER
2	1	569406	REAR HEAD COVER
3	1	569407	DIA.50 SHAFT
4	1	569408	PISTON (A)
5	1	569409	SEAL CASE (A)
6	1	569410	SPACER
7	1	569411	SEAL CASE (B)
8	1	569412	DIA. 220 CYLINDER PIPE
9	1	569413	DIA. 125 CYLINDER PIPE
10	1	569414	PISTON (B)
11	1	569415	DIA.30 SHAFT
12	1	569416	BACK COVER
13	4	569718	S.H.C. SCREW M 8X 30X22
14	4	569761	SP. WASHER M 8
15	1	569419	DUST SEAL, SDR50, NBR
16	1	569421	OILES BUSH, LFF5020
17	1	569422	PACKING, PNY50, NBR
18	2	569424	O-RING, G210, NBR
19	1	569445	O-RING, P200, NBR
20	2	569428	BEARING NUT, AN-08
21	1	569429	BEARING NUT WASHER, AW-08
22	2	569430	HEX. HEAD BOLT, M20X190X1.5P
23	2	569431	HEX. HEAD BOLT, M20X220X1.5P
24	4	569432	SPRING WASHER, M20
25	1	569433	OILES BUSH, LFF3020
26	1	569434	PACKING, PNY30, NBR
27	1	569436	O-RING, G120, NBR
28	1	569447	O-RING, P-110, NBR
29	2	569440	BEARING NUT, AN-04
30	1	569441	BEARING NUT WASHER, AW-04
31	4	569709	S.H.C. SCREW M 6X 20X18
32	4	569760	SP. WASHER M 6
33	4	569442	HEX. HEAD BOLT, M12X140X1.25P
34	4	569763	SP. WASHER M12
35	4	569774	WASHER M12
36	1	569443	O-RING, G65, NBR
37	1	569625	AIR VENT
38	1	569768	SET SCREW, LONG, DOG POINT,M8X22
39	1	569751	HEX. NUT, M8
40	1	569061	SPACER, GRIP CYLINDER ROD

AIR CYLINDER, 220mm



AIR MOTOR AND TRANSMISSION ASSEMBLY



Revision History

Rev.	Date	Details
01	2015/08/12	
02	2015/09/25	
03	2016/04/03	P29, #613 was 56994
		P29, #702 was #798 569798 (M3X20)
		P30, #702 was #798
		P32, #708 was #709
		P33, #708 QTY was 9 and #715 QTY was 9
		P33, #716 QTY was 1 and #760 QTY was 11
		P34, # add the #715 and #759
		P34, #831 Deleted
		P39, #82 was 567490 (1")
04	2016/11/18	P34, #562 was #142
05	2017/03/31	P33,add the #759
06	2018/11/19	P20, (507) was (50)
		P30, #213 was #605
		P23, #856 was #610
		P31, Add the *817-1 569817-1 DC24V Sensor
		P32, Add the *817-1
		P37, Add the # *42,#*818 ,#*818-1
		P33, #856 was #610 and P34, #856 was #610
		P38, Add the # *42,#*818 ,#*818-1 and the 567681
		P39, Add the #624 567624,#623 567623
		P40,Add the *623,*624
		P39,40,Add REV. HANDLE Option
		P41,42,Add the *817-1
07	Jul. 09, 2019	The unit assembly pages were added, so it differs from the version.
		Deleted the Air Motor Transmission Maintenance Manual pages