

OPERATING MANUAL
FOR THE
XL8 AIR RING TYER



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GENERAL INFORMATION

Thank you for purchasing the XL8 Air Ring Tyer from Plas-Ties, manufacturers of high quality twist-tying equipment.

Please familiarize yourself and/or any person operating this machine with all functions by carefully reading this manual.

The Plas-Ties XL8 Air Ring Tyer is an all-pneumatic machine that twist-ties products inserted into the ring shaped tying area. The machine can be adjusted to tie almost any product gathered into a round or nearly round shape from 1-inch diameter up to a maximum of 4, 6 or 8-inch diameter (dependent upon final ring size selection).

Model designation is located on the serial plate on the machine. It is important that you have the correct model for your input source.

Supplies and Service

PLAS-TIES twist-tie material and service should be ordered from:

PLAS-TIES
14272 Chambers Road
Tustin, CA 92780
Telephone: (714) 542-4487
(800) 854-0137
Fax: (714) 972-2978
Email: info@plasties.com
www.plasties.com

When ordering, please provide the following:

1. Part Number or description
2. Model Number and Serial Number (use Name Plate)
3. Tie Material in use

SAFETY INSTRUCTIONS

CAUTION: **DO NOT ATTEMPT TO OPERATE YOUR XL8 MACHINE BEFORE READING THE OPERATING INSTRUCTIONS**

The operating procedures outlined in this manual are prepared to facilitate the XL8 Air Ring Tyer machine.

1. **KEEP ALL SAFETY DEVICES IN PLACE** and in working order.
2. **KEEP WORK AREA CLEAN.** Cluttered areas invite accidents.
3. **DO NOT USE IN DANGEROUS ENVIRONMENT.** Do not use machines in a damp or wet location, or where any flammable or noxious fumes may exist. Keep work area well lighted.
4. **KEEP UNAUTHORIZED PEOPLE AWAY.** All unauthorized people should be kept out of work area and away from machine.
5. **DO NOT FORCE MACHINE.** It will do the job better and safer at the rate for which it was designed.
6. **USE THE RIGHT MACHINE.** Do not force machine to do a job it is not designed to do.
7. **DO NOT USE UNDER THE INFLUENCE OF DRUGS OR ALCOHOL**
8. **DIRECT CONNECTION TO AIR COMPRESSOR IS HIGHLY RECOMMENDED.** If use of hose extensions is necessary, make sure your hose extensions and connectors in good condition. Always repair or replace hose extension and connectors if they become damaged.
9. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry, which may get caught in moving parts. Wear protective hair covering to contain long hair.
10. **MAINTAIN MACHINE WITH CARE.** Keep machine clean for best and safest performance. Follow instructions for lubricating and keeping machine free of lint.
11. **DISCONNECT MACHINE BEFORE SERVICING AND WHEN CHANGING SPOOL.**
12. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before turning on air supply.
13. **USE THE RECOMMENDED MATERIALS AND REPLACEMENT PARTS.** Listing of recommended material and replacement parts is found in operating manual. The use of improper material and replacement parts may result in malfunction and possible risk of injury.
14. **CHECK DAMAGED PARTS.** Before further use of the machine, any part that is damaged should be carefully checked to determine that it would operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A part that is damaged should be properly repaired or replaced.
15. **NEVER LEAVE MACHINE RUNNING UNATTENDED.** Turn the power off, and do not leave machine until it comes to a complete stop.
16. **NEVER ALLOW UNTRAINED USERS TO RUN THIS MACHINE.**
17. **IF YOU ARE UNSURE OF THE INTENDED OPERATION, STOP USING THE MACHINE.**

WARRANTY

Purchaser acknowledges that there are no warranties, expressed or implied, made by **PLAS-TIES**, its distributors or sales representatives related to the XL8 machine except the manufacturer's warranty against defective materials and workmanship as follows:

PLAS-TIES warrants the XL8 machine to be free from defects in materials and workmanship at time of delivery. Liability under this warranty is limited to the repair or exchange of any defective part or parts of the unit providing the same is returned to **PLAS-TIES**, transportation prepaid, within 180 days or 300,00 cycles (whichever comes first based on machine counter). **THE WARRANTY BEGINS FROM THE DATE OF INSTALLATION AT CUSTOMER SITE AND NOT DATE OF PURCHASE. IN ORDER TO ACTIVATE THE WARRANTY, THE NAME, CITY/STATE, AND SERIAL NUMBER MUST BE REGISTERED ON-LINE AT WWW.PLASTIES.COM. FAILURE TO DO SO WILL RESULT IN LIMITATION OF THE FULL WARRANTY. THIS IS TO INSURE TOTAL QUALITY ASSURANCE AND 800 TOLL FREE TECHNICAL SUPPORT.**

The warranty is void on any XL8 machine that has been subject to negligence, accident, misuse, failure to use the equipment as instructed in the manual, or that has been tampered with.

This warranty is void if the XL8 machine is used with anything other than specified genuine **PLAS-TIES** twist-tie material.

IMPORTANT: If your XL8 machine does not operate properly, please bring it to the attention of **PLAS-TIES**, or the dealer or distributor from whom it was purchased. If repairs are needed, the dealer, distributor or other representative of **PLAS-TIES** will arrange to repair or replace parts within the terms of the warranty.

Warranty coverage is limited to the Continental US, Alaska, Hawaii, Puerto Rico, and Canada.

SPECIFICATIONS

Model Designation

This manual covers the model 530 XL8 Air Ring Tyer.

Performance

Production speeds vary depending on tying diameter, ring size, air pressure, tightness of tie, operator and processing/production requirements.

Air Requirements

Machine will operate on clean, dry air from 90 PSI to 120 PSI (must have single, designated air line)

Dimensions/Weight

Capacity	Self-Adjusting from 1" to 8"
Recommended Spool	Exclusive Plas-Ties 4000' all plastic 1/4" width 24 gauge double wire centered
Air Power	90 to 120 PSI (clean-dry air from single, designated air line)
Weight (with Stand)	200 lbs
Cabinet Depth Cabinet Width Cabinet Height	19" 10-1/4" 24"
Width (on stand) Depth (on stand) Height (on stand)	25-1/2" 29" 51-1/4" (max)
Clearance depth without table Clearance depth with table Clearance width to open door	Approximately 34" Approximately 40" Approximately 36"
Ring Options	Maximum 4", 6" 8" Diameter Rings

Spool Specification

Part# 419B Plas-Ties Exclusive 1/4" Plastic – White
4000' - 24-Gauge Double Wire (Center Spacing)

Options

Table Assembly	ATM-100
Set of Casters*	AFS -250
Foot Pedal Trigger Assembly	AFFPA-100

*Order 2 sets for ALL 4 casters

Additional Information

Send email request to: Info@plasties.com.

OPERATION

Major Component Description & Adjustments

This machine has 8 air-cylinders, 9 air pilot valves, 6 toggle valves, 2 one-shot valves, 4 pressure regulators, 4 pressure gauges, two flow regulators, a foot-switch or front trigger switch, a line pressure on-off switch, and a pilot/feed roller on-off switch.

The XL8 Air Ring Tyer, Model 530 is shipped on its stand and is ready to run. Just plug in clean, dry air. This unit can be easily adjusted up or down on pipe stand.

Machine Set-Up and Initiation

The XL8 Air Ring Tyer is factory tested and ready to run.

- (1) Connect to a clean, dry air supply. Recommend using air separation filters as needed.
- (2) Open the left door and check that the Cam-Stop is in place ([Figure 8](#))
- (3) Turn on the ribbon feed cylinder pressure switch (Toggle Switch on front lower left side).
- (4) Press foot switch or front trigger switch and note that unit cycles.
- (5) Turn off the ribbon feed toggle switch.
- (6) Load the ribbon spool on the ribbon pre-feed per ([Figure 1](#)).
- (7) Note that the ribbon brake is set per ([Figure 1](#)).
- (8) Pull approximately 12 inches of ribbon up through the No-back.
- (9) Feed the ribbon up through the guide until it is visible just below the twister as per ([Figure 2](#)).
- (10) Note that the approved ribbon for this unit is ¼ inch, 24 gauge double wire-centered or separated.
- (11) The unit is ready to run – place object to be tied in front of open ring and press the foot-switch. (Note that the ribbon length is correct per [Figure 7](#)).

Applying or removing air pressure from the valve pilot connectors operates pilot air valves. ([Figure 3](#))

For Air connections from the valves to the air cylinders see ([Figure 4](#)).

Regulator Settings

- (1) The inlet regulator (R1) is set just below the lowest line supply pressure- (90-110 PSI).
- (2) The 2 Gripper regulators R3 and R4 are set at 20-25 PSI. (If the product to be tied is soft like a collapsible bag etc. these pressures may be raised slightly).
- (3) The Ribbon feed pressure regulator R5 is set at 35-40 PSI.

OPERATIONAL SEQUENCE

See [Figure 5](#) for the operational sequence.

- (1) Pressing the foot switch or front trigger switch actuates Valve 1 (closes Cylinder 1) and the ring closes.
- (2) When the ring is closed, toggle Valve A1 actuates Valve 9 (engages cylinder 2) that feeds the ribbon.
- (3) At the end of the ribbon feed, Toggle Valve A is actuated which engages:
 - A. Valve 2 (power up Toggle B).
 - B. Valve 4 (engage right Gripper - cylinder 3).
 - C. Valve 9 (reverses Ribbon Feed - cylinder 2).
- (4) When Valve 9 returns to the, top it actuates Toggle Valve B, which:
 - A. Engages Valve 5 (left Gripper - cylinder 4).
 - B. Engages Valve 6 (Cutter - cylinder 5)
- (5) Cutter cylinder then engages Toggle Valve C, which engages:
 - A. Valve 8 (Turns Twister).
 - B. Valve 7 (Disengage Cam Lock - cylinder 6).
 - C. Valve 2 (Drop pressure to Toggle B).
 - D. Valve 6 (retract Cutter - cylinder 5).
- (6) When (Cylinder 7, Twister is extended it engages Toggle Valve D which:
 - A. Retracts Valve 1, which opens ring - cylinder 1).
 - B. Extends Valve 4, which opens right Gripper - (cylinder 3).
 - C. Extends Valve 5, which opens left Gripper - (cylinder 4).
 - D. Extends Valve 7, which re-engages Cam Stop - (cylinder 6).
- (7) When cylinder 6 (Cam-Lock is home), Toggle Valve E is engaged which:
 - A. Returns Valve 8 (Twister - cylinder 7) that completes the cycle.

Care of Machine

- 1) Apply grease on the rack gears, sparingly as needed. Avoid grease on the clutches, brake disc, or the draw wheel.
- 2) **It is very important that the machine runs on CLEAN, DRY AIR.** Check the water trap, and make sure it is draining properly. We highly recommend the use of water separation filters to address potential for excess water build up in air hoses and cylinders. This will prolong the life of the unit. Check units every 6 months for proper filtration/separation.

TROUBLE SHOOTING

Your XL8 Ring Tyer is a very reliable machine, but should you experience any of the following situations, please refer to this handy guide for assistance.

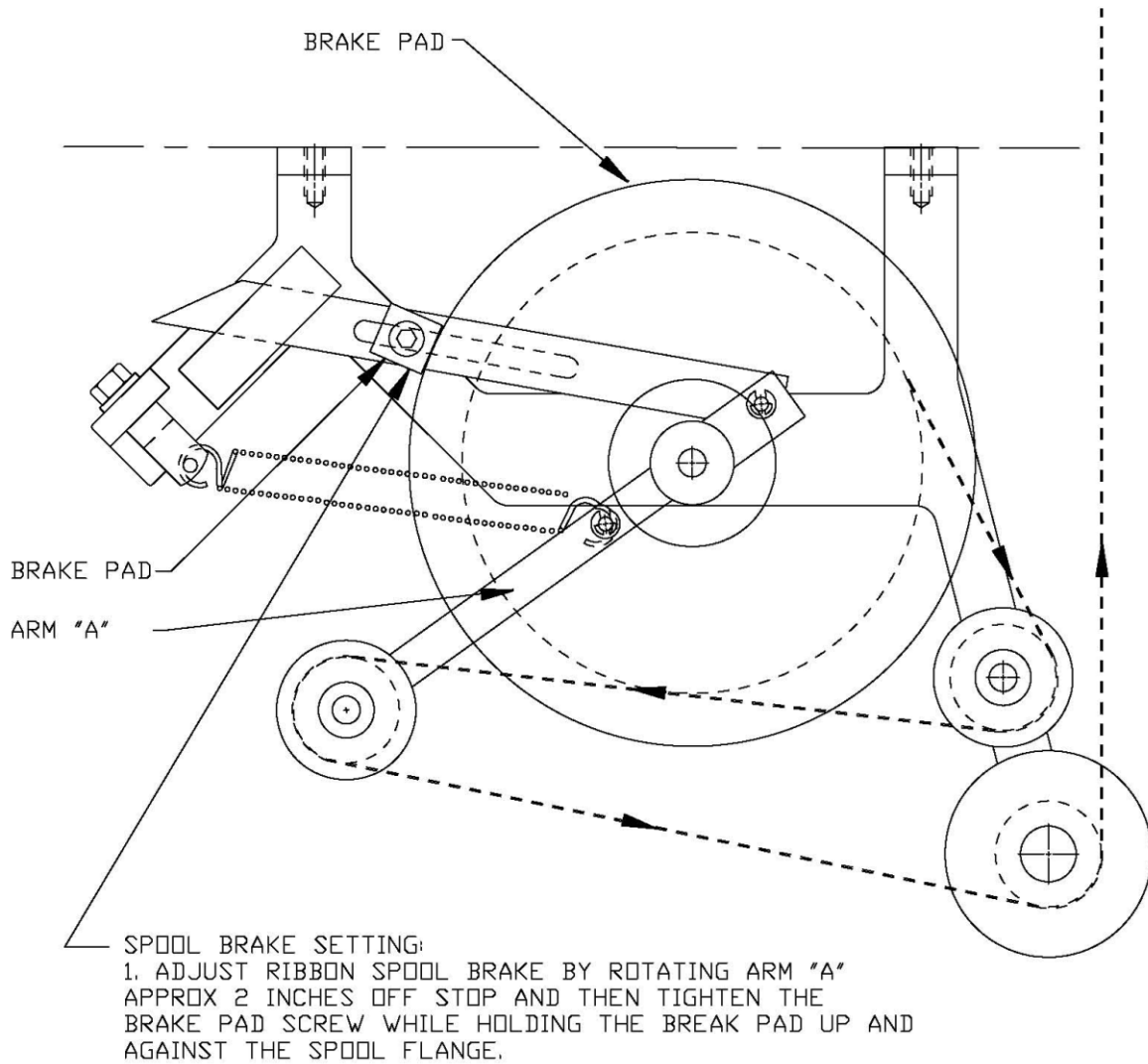
Problem	Cause	Resolution
(A) Air Hissing	Slider air switch not properly seated	Slide switch back to "ON" position
(B) Wire Jamming	Ribbon length is too long. The ribbon feeds too long, which causes a kink at the inlet guide and then the ribbon will not retract	Adjust the length slightly shorter (Figure 6).
(C) Ribbon Breaking	Slip-Clutch being too tight	Adjust the slip clutch nut ¼ turn CCW (Figure 2).
(D) Not Tying = Ribbon too short	One of the Grippers pressure may be too high, but unlikely if their pressures are 20-25 PSI.	Check Gripper pressure and adjust accordingly. Adjust the length slightly longer per (Figure 6).
(E) Product Bruising	Operators pulling bundles back too quickly	Instruct operators to avoid pulling back/away from trigger to quickly when removing tied product. Adjusting table height may also be helpful.
(F) Missed Ties	(1) Excess water in lines See Cause items (D) and (E)	(1) Water Separation Filter may be required to ensure use of CLEAN, DRY air. See Resolution items (D) and (E)

**Technicians and Web Based Support Available:
7:00am to 3:00pm (Pacific Standard Time)**

Please call Plas-Ties Technical Support at (800) 854-0137

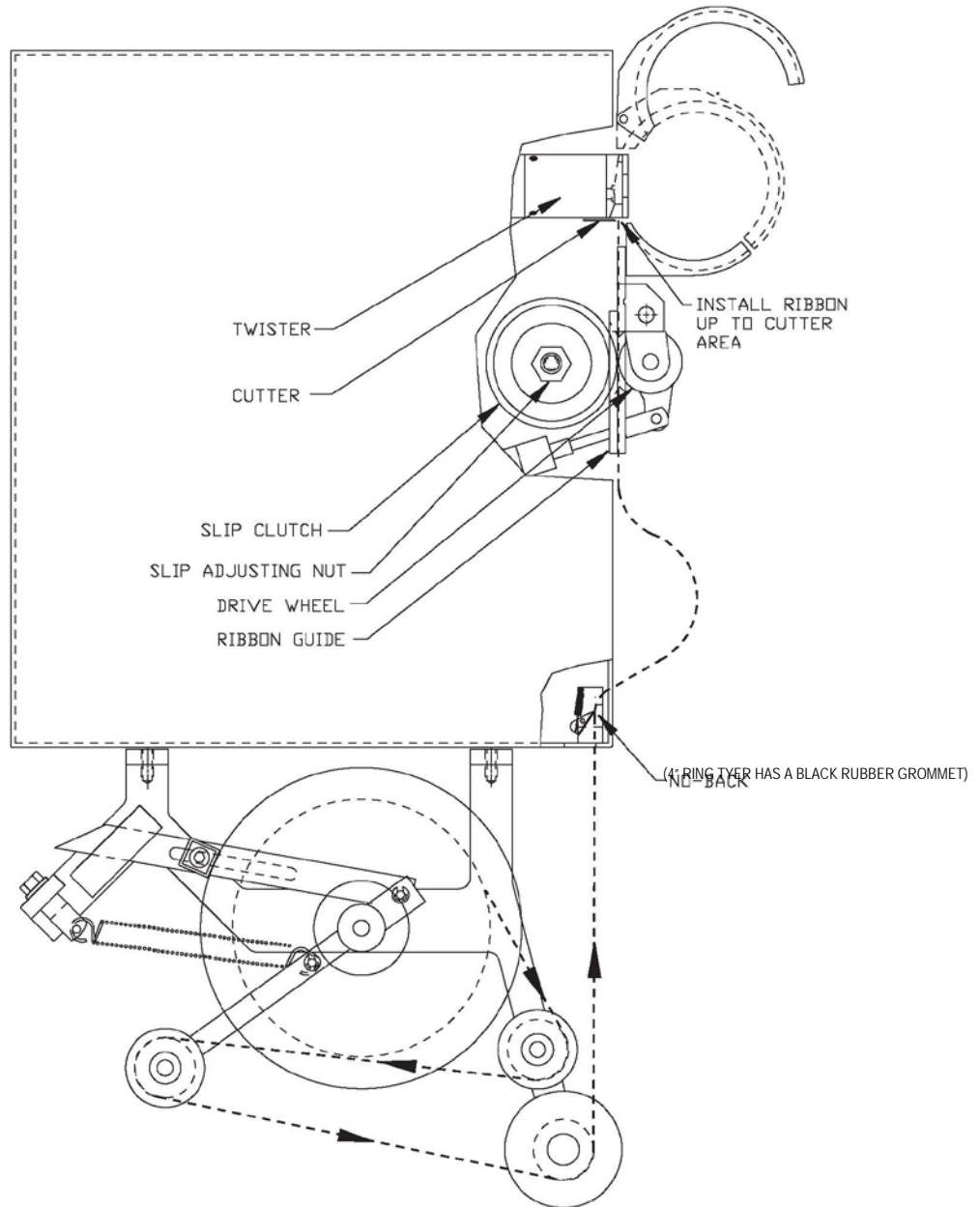
SPOOL MATERIAL LOADING

FIGURE 1

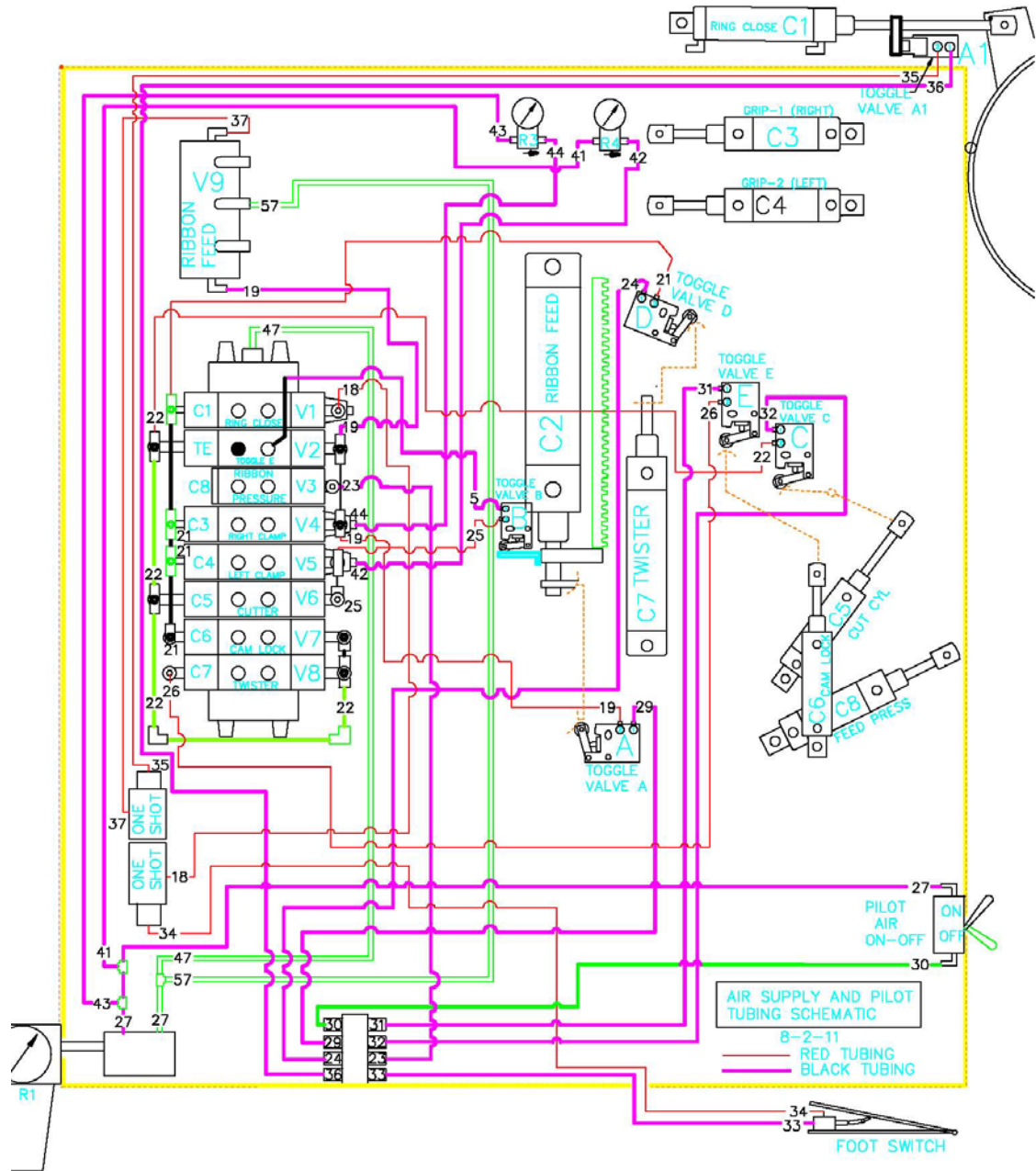


RIBBON LOADING

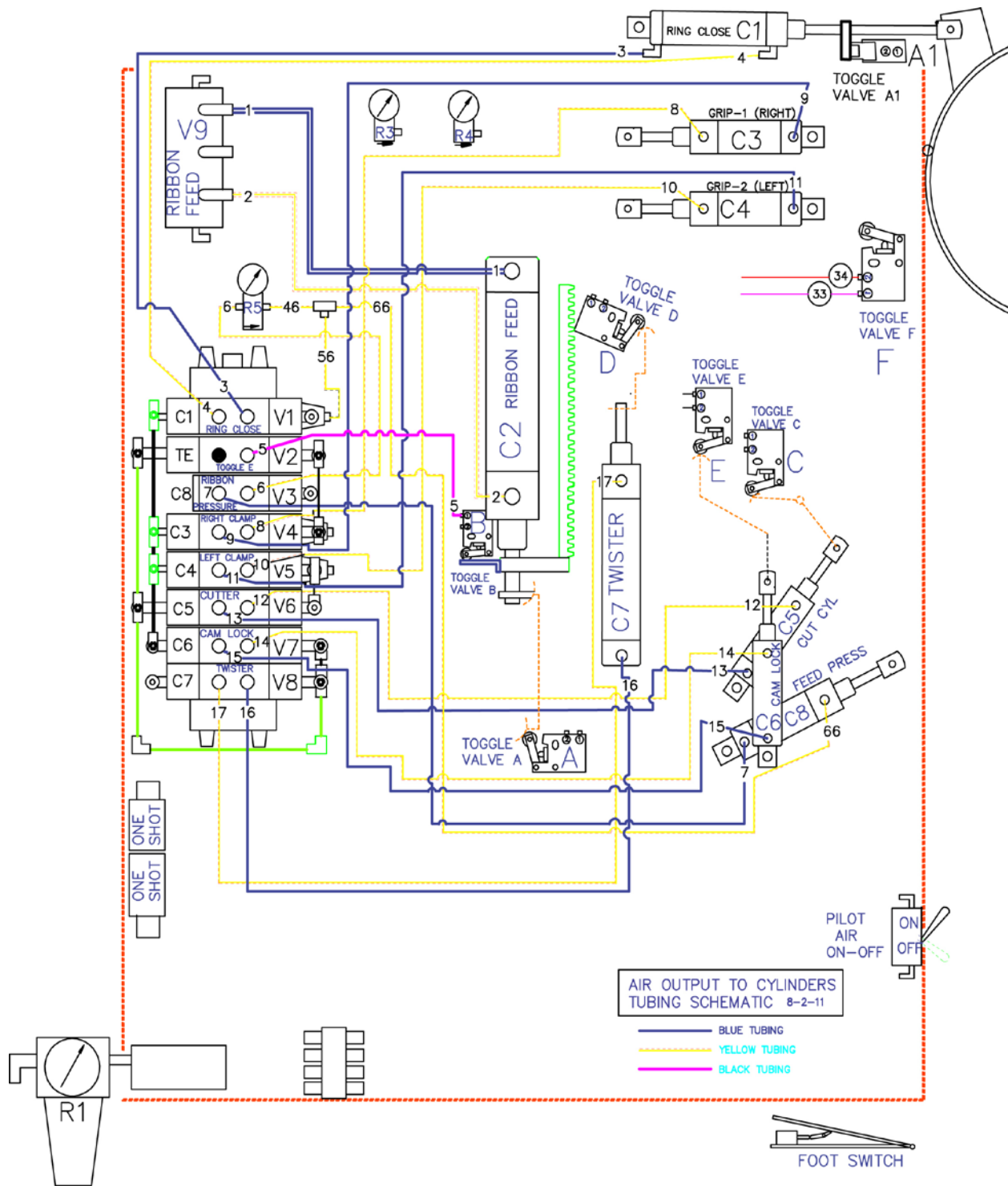
FIGURE 2



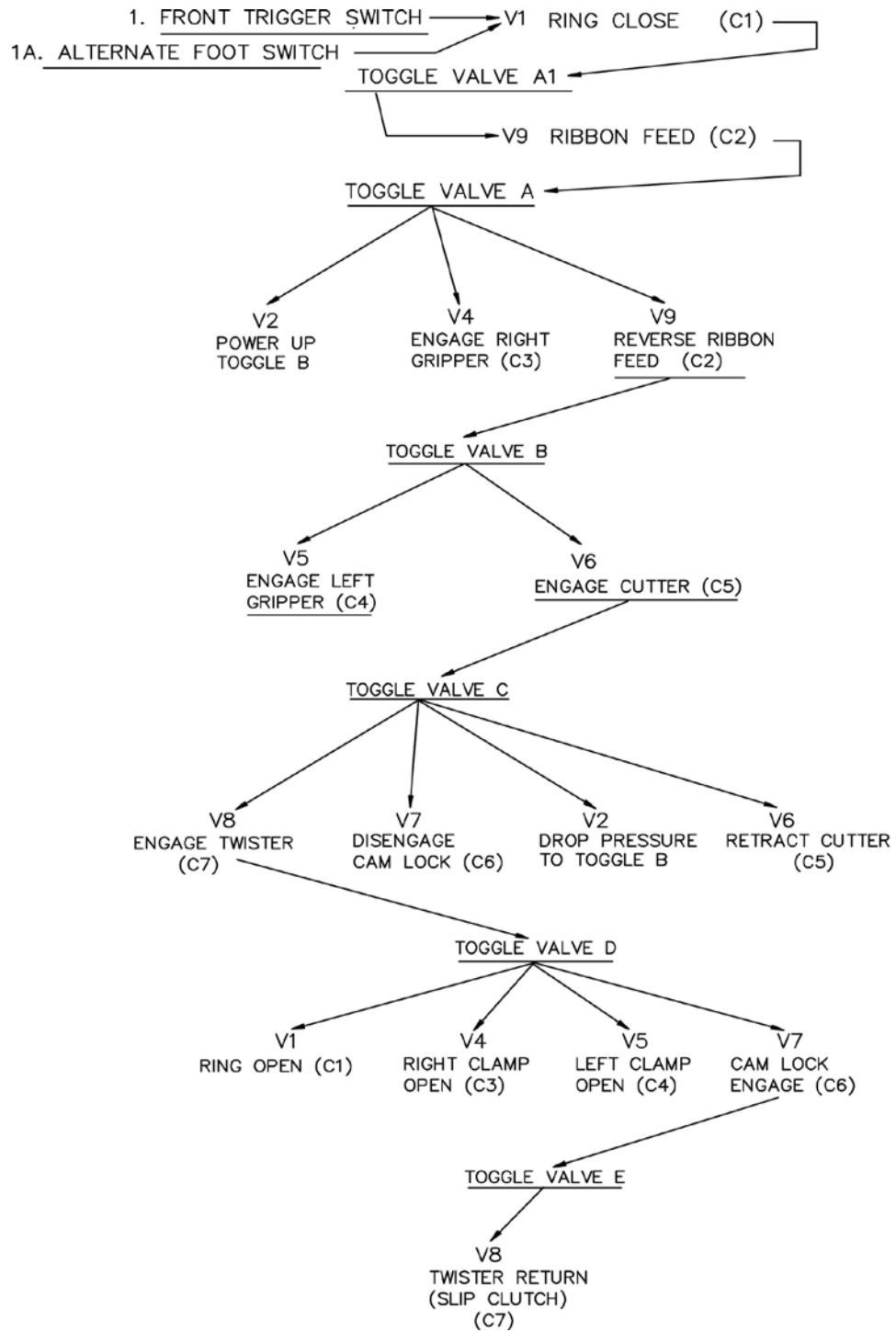
AIR SUPPLY & PILOT TUBING



AIR OUTPUT TO CYLINDER TUBING

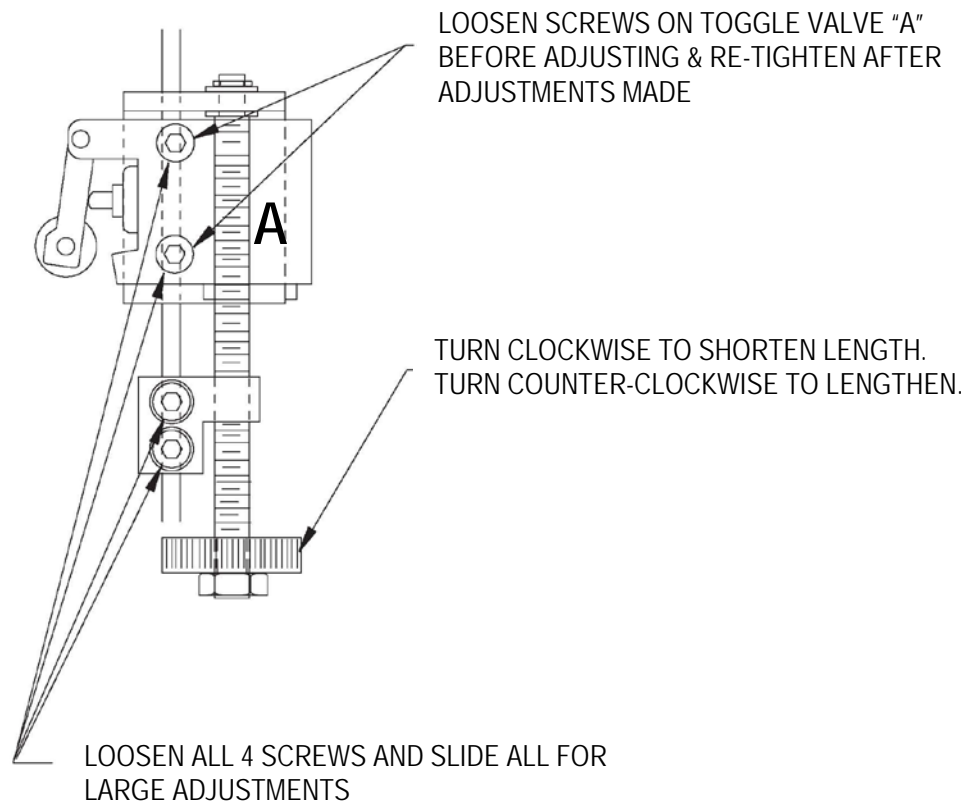


XL8 OPERATIONAL SEQUENCE

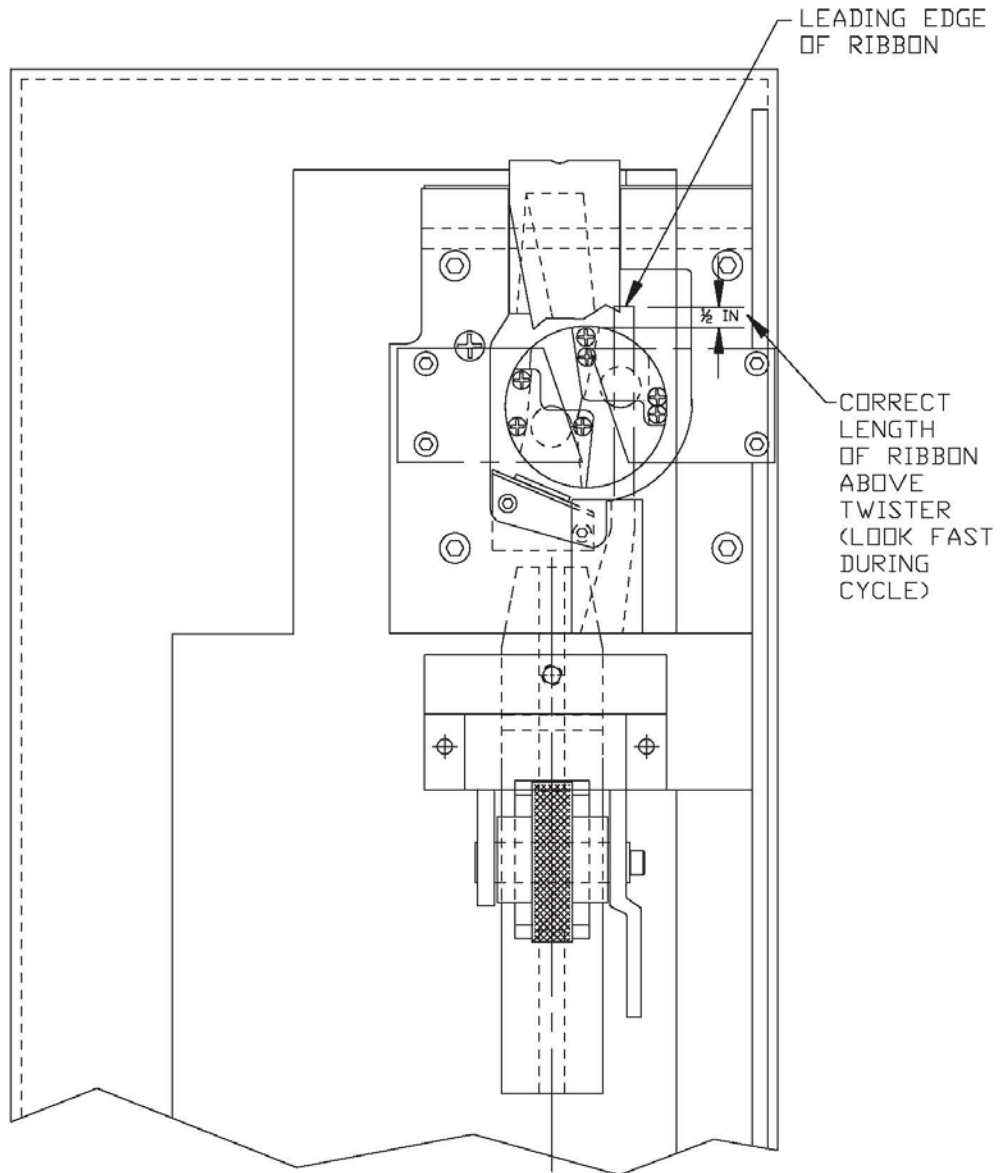


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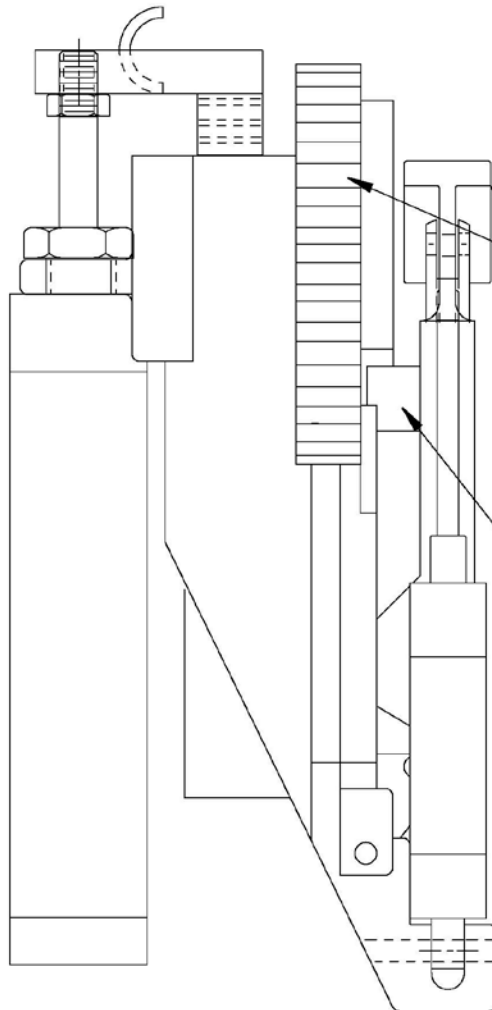
RIBBON LENGTH FINE ADJUSTMENT



FRONT VIEW SHOWING
RIBBON PATH & CORRECT LENGTH



SET CAM-STOP TIMING BY HAND



STEP 1: TURN OFF MASTER AIR VALVE TO RELEASE PRESSURE FROM THE CAM FOLLOWING BEARING.

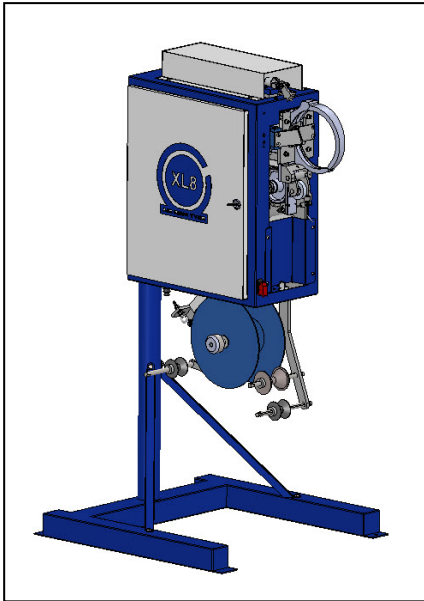
STEP 2: ROTATE LARGE GEAR CLOCKWISE WHILE HOLDING THE CAM FOLLOWING ARM (ACM-012) UP UNTIL THE CAM FOLLOWING BEARING IS SEATED IN THE GROOVE.

STEP 3: TURN MASTER AIR BACK ON TO ENGAGE PRESSURE ON THE CAM FOLLOWING BEARING.

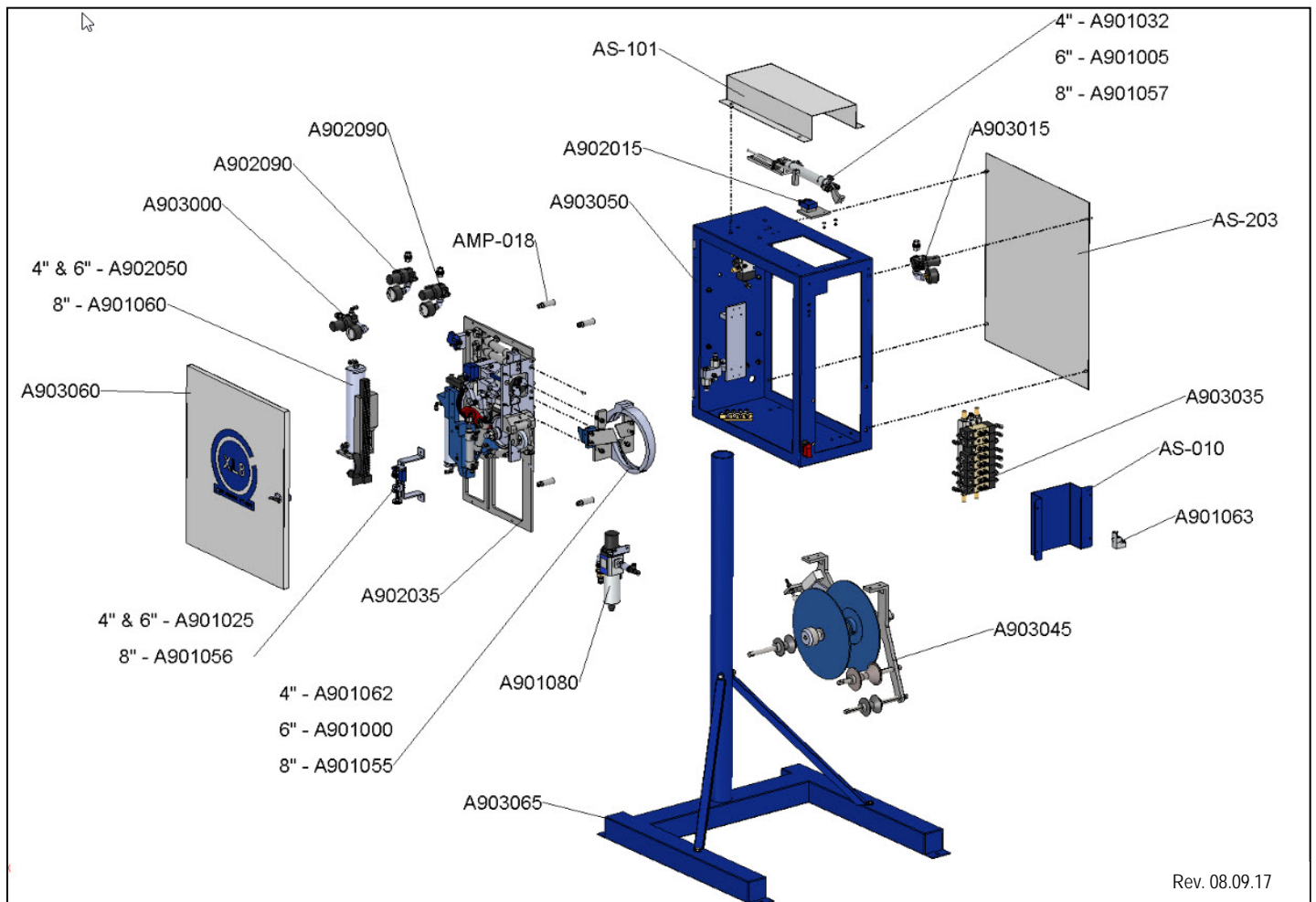
CAM FOLLOWER

XL8 PARTS LIST

XL8 (4", 6", 8") 530-4 / 530-6 / 530-8

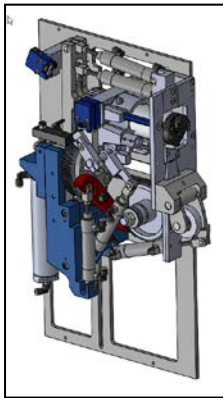


PART #	DESCRIPTION	QTY.	PART #	DESCRIPTION	QTY.
56805	1/4 Split Lock Washer	12	A903050	XL8 Cabinet Assembly	1
56810	1/4" Flat Washer	6	A903060	XL8 Front Door Assembly	1
506337	#10 Split Lock Washer	2	A903065	XL8 Pedestal Assembly	1
A901000	Face Plate & 6" Ring Assembly	1	AMA-008	Air Valve Manifold Assembly	1
A901005	6" Ring Cylinder #1 Assembly	1	AMP-010	Shield Guard	1
A901020	XL8 Trigger Assembly	1	AMP-018	Mounting Plate Spacer	4
A901025	Switch "A" Assembly	1	AS-010	Front Guard Cover	1
A901032	6" Ring Cylinder #1 Assembly	1	AS-101	XL8 Top Lid Cover	1
A901055	Face Plate & 8" Ring Assembly	1	AS-203	Stationary Side Door	1
A901057	6" Ring Cylinder #1 Assembly	1	FP-110	Trigger Arm Shell	1
A901062	Face Plate & 4" Ring Assembly	1	P001080	1/4 - 20 Hex Nut	6
A901063	XL8 No Back Assembly	1	P001430	#8 Flat Washer	2
A901080	Main Filter Regulator Assembly	1	P005010	6-32 x 1-1/4 Socket Head Cap Screw	4
A902015	A1 Switch Assembly	1	P005065	8-32 X 1/2" Socket Head Cap Screw	4
A902035	XL8 Back Mounting Plate	1	P005295	10-32 x 5/16 Button Cap Screw	14
A902050	Cylinder # 2 Complete Assembly	1	P005327	10-32 X 1/2 Flat Head Socket Screw	4
A902090	Gripper Pressure Regulator Assembly	2	P005410	#6 Split Washer	4
A903000	Gripper Pressure Regulator Assembly	1	P007060	1/4-20 x 3/4 Socket Head Cap Screw	6
A903015	Ring Pressure Regulator Assembly	1	P008060	#8 Split Lock Washer	4
A903045	XL8 Full Brake Assembly - 4" & 6" Rings	1			



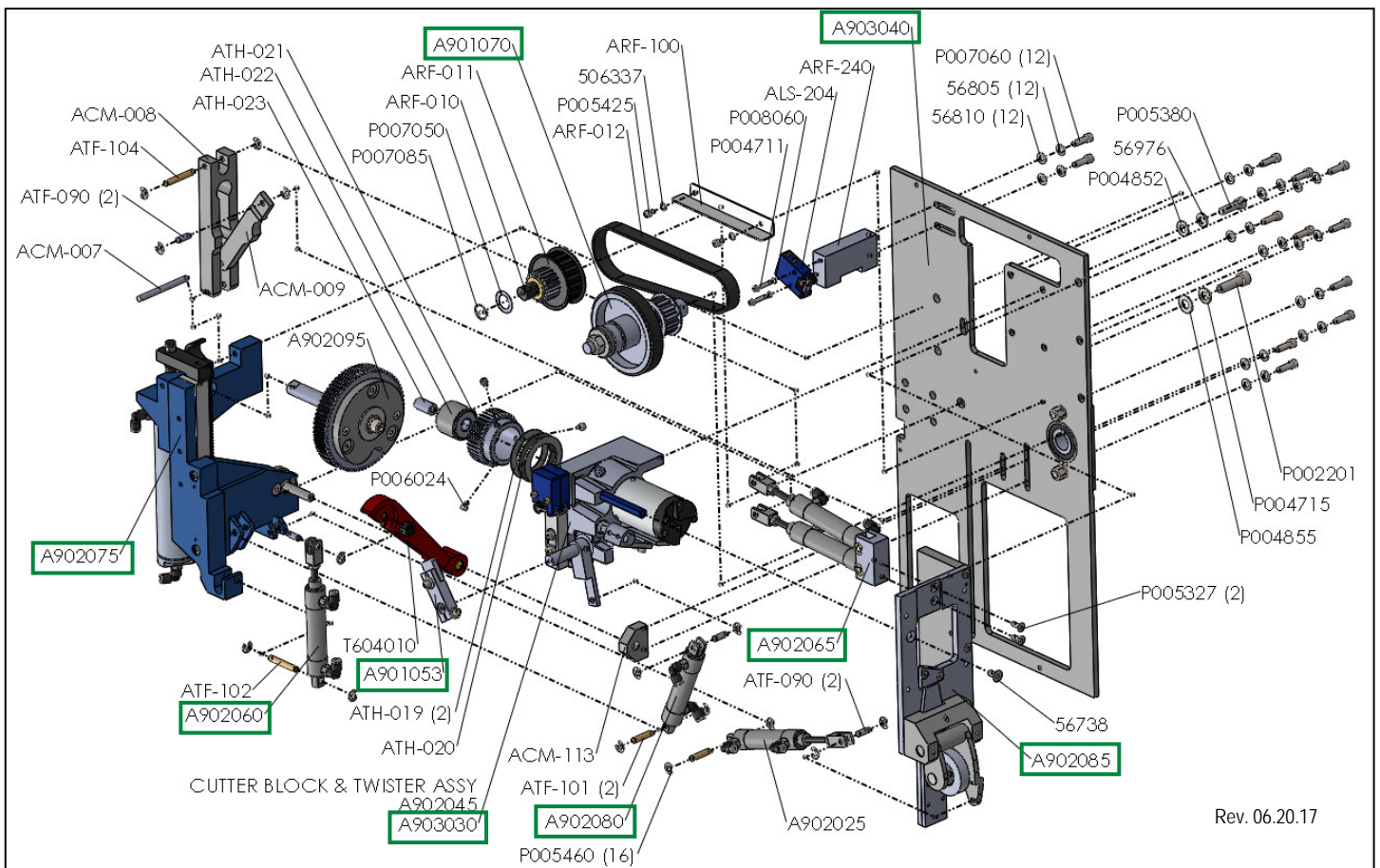
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XL8 BACK MOUNTING PLATE ASSEMBLY MASTER (A902035)



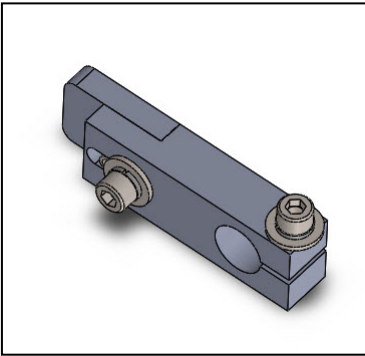
PART #	DESCRIPTION	Qty
56738	XL8 1/4-20 x 1/2 Flat Head Socket Cap Screw Stainless Steel	1
56802	XL8 #10 Flat Washer	2
56805	XL8 1/4 Split Lock Washer Stainless Steel	13
56810	XL8 1/4 Flat Washer	18
56976	XL8 5/16 Split Lock Washer Steel Zinc Plated	1
506337	XL8 #10 Split Lock Washer Stainless Steel	2
A901053	XL8 Limit Switch Actuator Assembly	1
A901054	XL8 Switch "B" Assembly	1
A901070	XL8 Pressure Wheel Assy	1
A902025	XL8 Cylinder # 8 Assembly	1
A902045	XL8 Cutter Block Assembly	1
A902060	XL8 Cylinder Assembly #3, 4 & 6	1
A902065	XL8 Gripper Cylinders Assembly	1
A902075	XL8 Cylinder #7 Mounting Assembly	1
A902080	XL8 Cylinder #5 Assembly	1
A902085	XL8 Face Plate Assembly	1
A902095	XL8 Pinion Gear Assembly	1
A903030	XL8 Twister Head Assembly	1
A903040	XL8 Back Plate Assembly	1
ACM-007	XL8 Gripper Actuator Hinge Pin	1
ACM-008	XL8 #1 Gripper Activator	1
ACM-009	XL8 #2 Gripper Activator	1
ACM-113	XL8 Support Block Twister	1
ALS-204	XL8 Limit Switch	1
ARF-010	XL8 Pinion Gear Shaft	1
ARF-011	XL8 Pulley Gear Cluster	1
ARF-012	XL8 Timing Belt	1
ARF-100	XL8 Belt Cover Bracket	1
ARF-240	XL8 Limit Switch Mounting Bkt	1

PART #	DESCRIPTION	Qty
ATF-090	XL8 Clevis Pin	4
ATF-101	XL8 Clevis Pin	2
ATF-102	XL8 Clevis Pin 1.6"	1
ATF-104	XL8 Clevis Pin	1
ATH-019	XL8 Thrust Washer 1/32	2
ATH-020	XL8 Thrust Needle Cage Assy	1
ATH-021	XL8 Twist Head Barrel Gear	1
ATH-023	XL8 Bullet	1
ATH-025	XL8 Thrust Washer	1
FP-006	XL8 Spacer For XL8	1
P001952	XL8 3/8-16 x 7/8 Socket Head Cap Screw Stainless Steel	1
P002201	XL8 3/8-16 x 1-1/4 Socket Head Cap Screw Stainless Steel	1
P002400	XL8 10-32 x 5/8 Socket Head Cap Screw Stainless Steel	2
P004711	XL8 8-32 x 3/4 Socket Head Cap Screw Stainless Steel	2
P004715	XL8 3/8 Split Lock Washer	2
P004852	XL8 1/4 USS Flat Washer Steel Zinc Plated	1
P004855	XL8 3/8 Flat Washer Stainless Steel	2
P005327	XL8 10-32 x 1/2 Flat Head Socket Cap Screw Stainless Steel	2
P005380	XL8 5/16-18 x 1 Socket Head Cap Screw Stainless Steel	1
P005425	XL8 10-32 x 1/4 Socket Head Cap Screw Stainless Steel	2
P005460	XL8 1/4 Side Mount External Retaining Ring Stainless Steel	16
P006024	XL8 5/16-18 X 5/16 Cone Point Set Screw Stainless Steel	3
P007050	XL8 5/8 X 1 X .020 Flat Washer Stainless Steel	1
P007060	XL8 1/4-20 x 3/4 Socket Head Cap Screw Stainless Steel	13
P007085	XL8 5/8 External Retaining Ring	1
P008045	XL8 3/8 X 1.5 x .065 Flat Washer	2
P008060	XL8 #8 Split Lock Washer	2
T602080	XL8 Activator Assembly	1
T604010	XL8 Cam Follower Mounting Arm Assembly	1

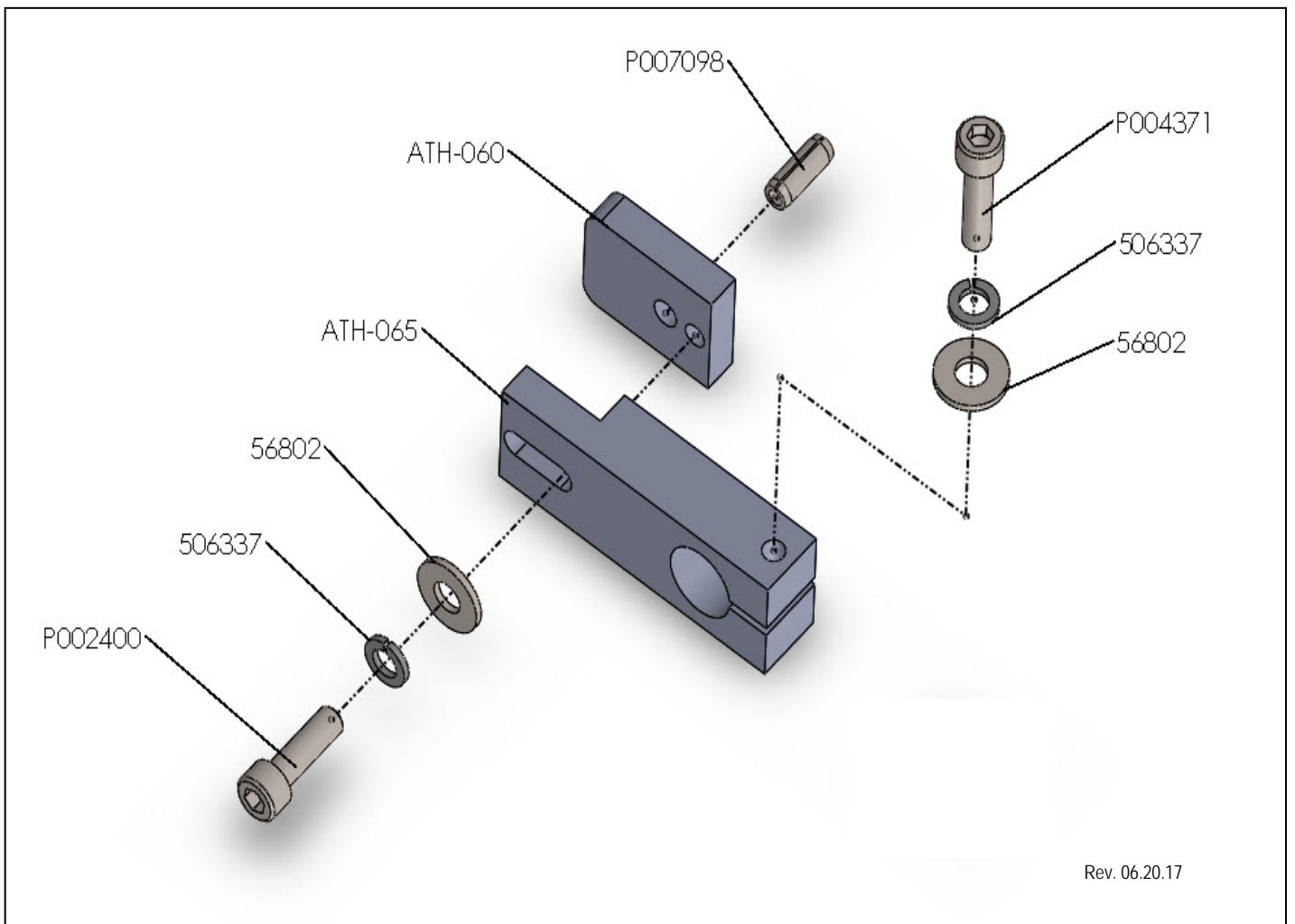


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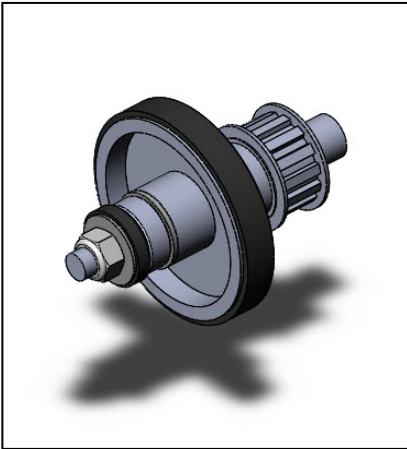
LIMIT SWITCH ACTUATOR ASSEMBLY (A901053)



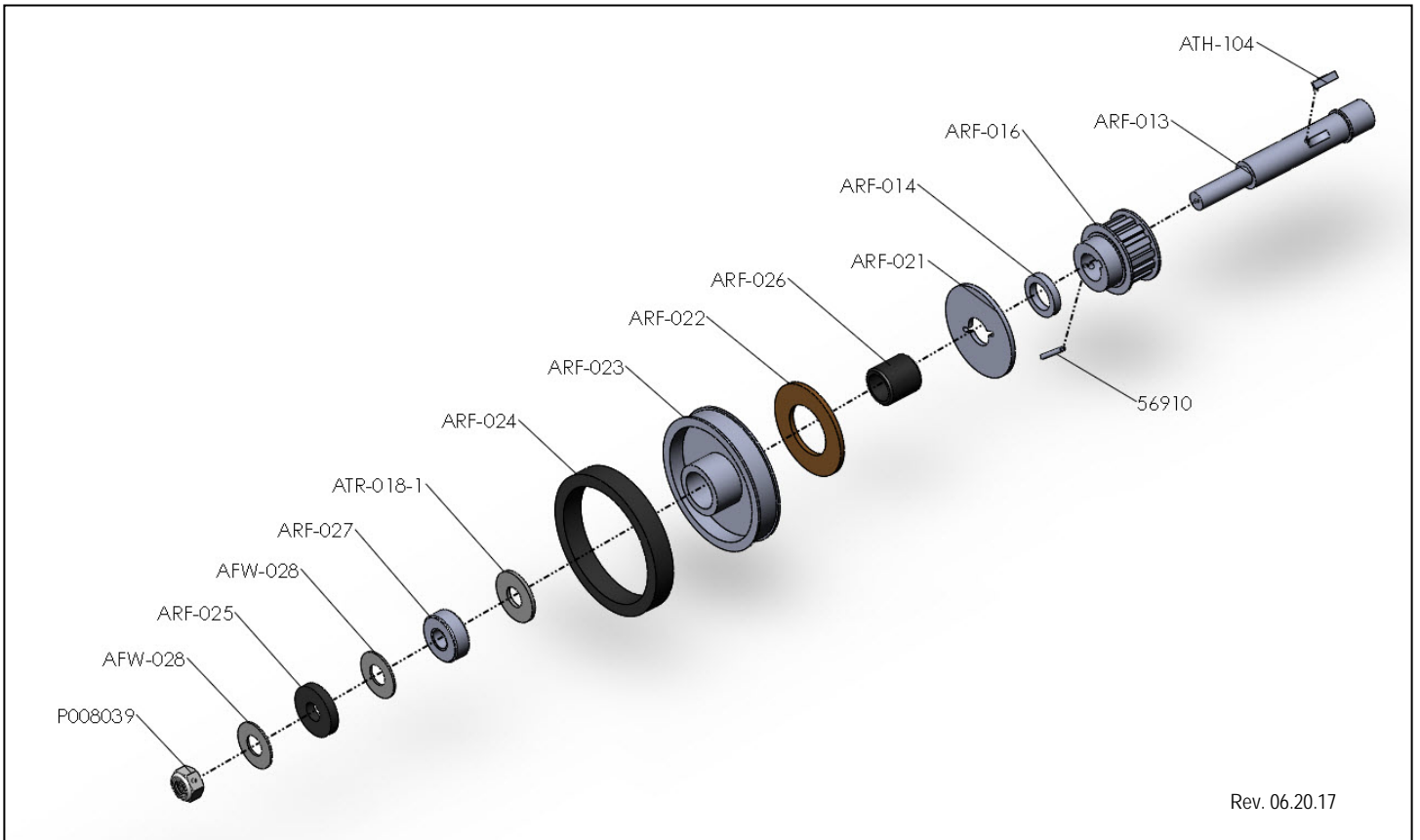
PART #	DESCRIPTION	QTY.
56802	#10 Flat Washer	2
506337	#10 Split Lock Washer	2
ATH-060	Limit Switch Actuator	1
ATH-065	Limit Bracket Switch	1
P002400	10-32 X 5/8 Fine Socket Head Cap Screw	1
P004371	10-32 X 3/4 Socket Head Cap Screw	1
P007098	3/16 X 1/2 Spring Pin	1



PRESSURE WHEEL ASSEMBLY (A901070)



PART #	DESCRIPTION	QTY.
56910	1/8 x 1 Roll Pin	1
AFW-028	18-8 X 1/2 Flat Washer	2
ARF-013	Draw Roll Shaft	1
ARF-014	Spacer	1
ARF-016	Timing Belt Pulley	1
ARF-021	Pressure Plate	1
ARF-022	Friction Disc	1
ARF-023	Draw Wheel	1
ARF-024	Draw Wheel Tire	1
ARF-025	Pressure Washer	1
ARF-026	1 Way Clutch Bearing	1
ARF-027	Ball Thrust Bearing	1
ATH-104	Metal Shim Spacer	1
ATR-018-1	Brake Arm Washer	1
P008039	3/8-16 Nylon Insert Hex Nut	1

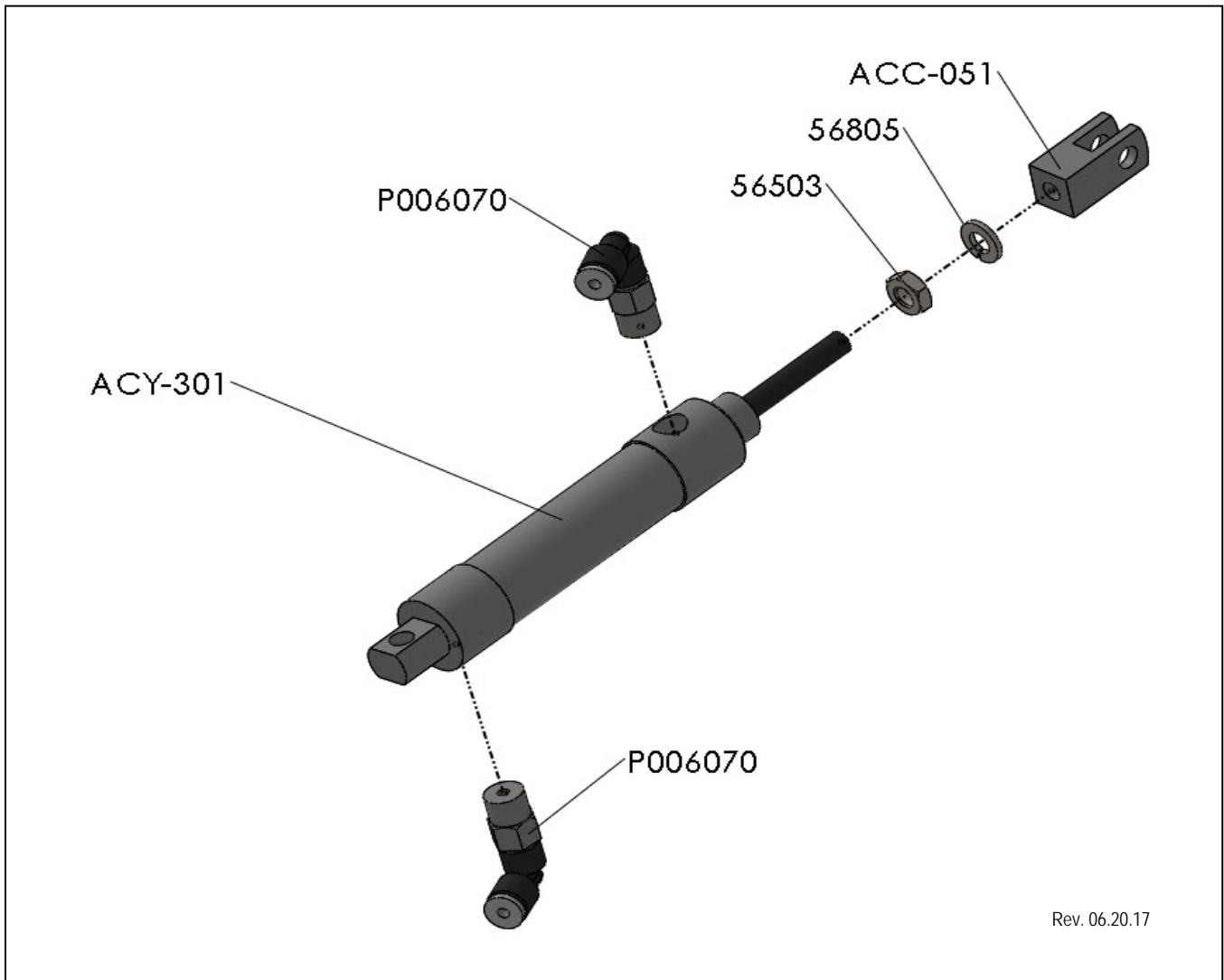


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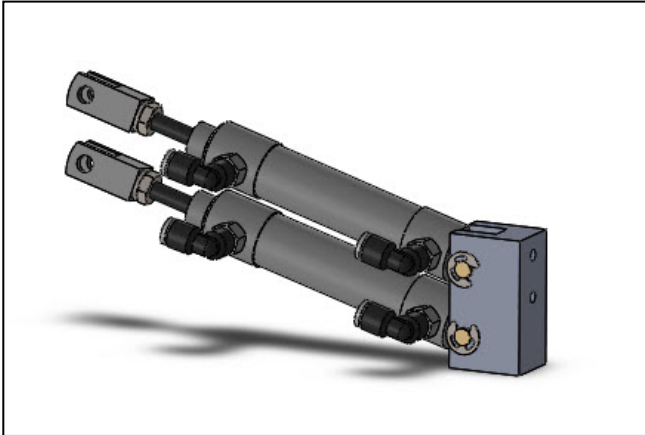
CYLINDER ASSEMBLY #3, 4 & 6 (A902060)



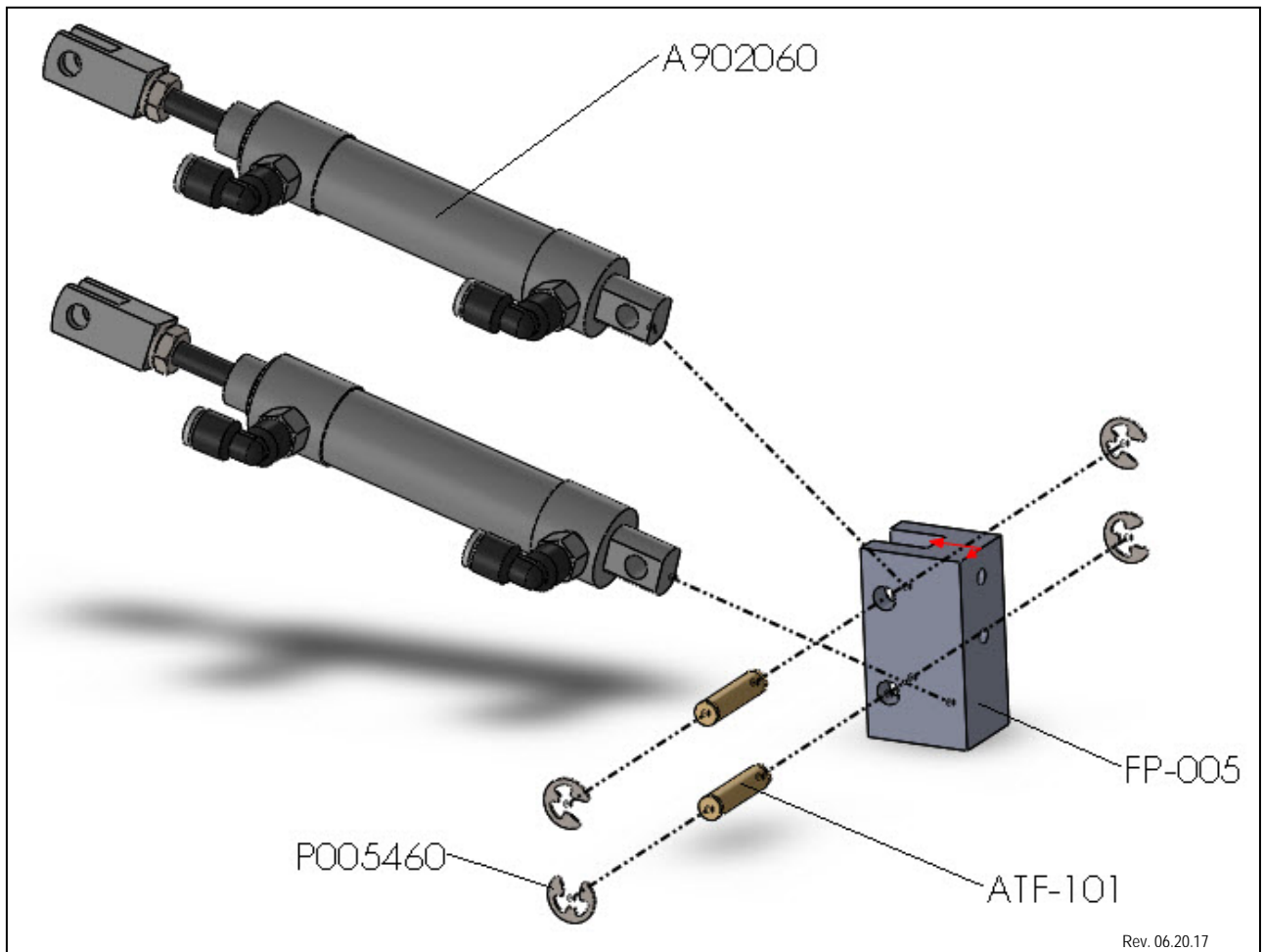
PART #	DESCRIPTION	QTY.
56503	1/4-28 Nut	1
56805	1/4 Split Lock Washer	1
ACC-051	Clevis - 1/4-28 Thread	1
ACY-301	Cylinder for 3, 4, 5 & 6	1
P006070	Straight Tube Fitting	2



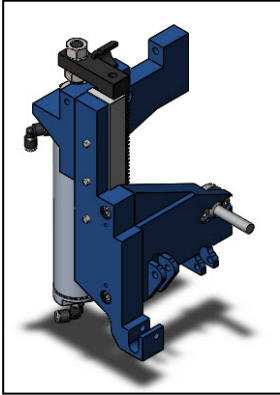
GRIPPER CYLINDERS ASSEMBLY (A902065)



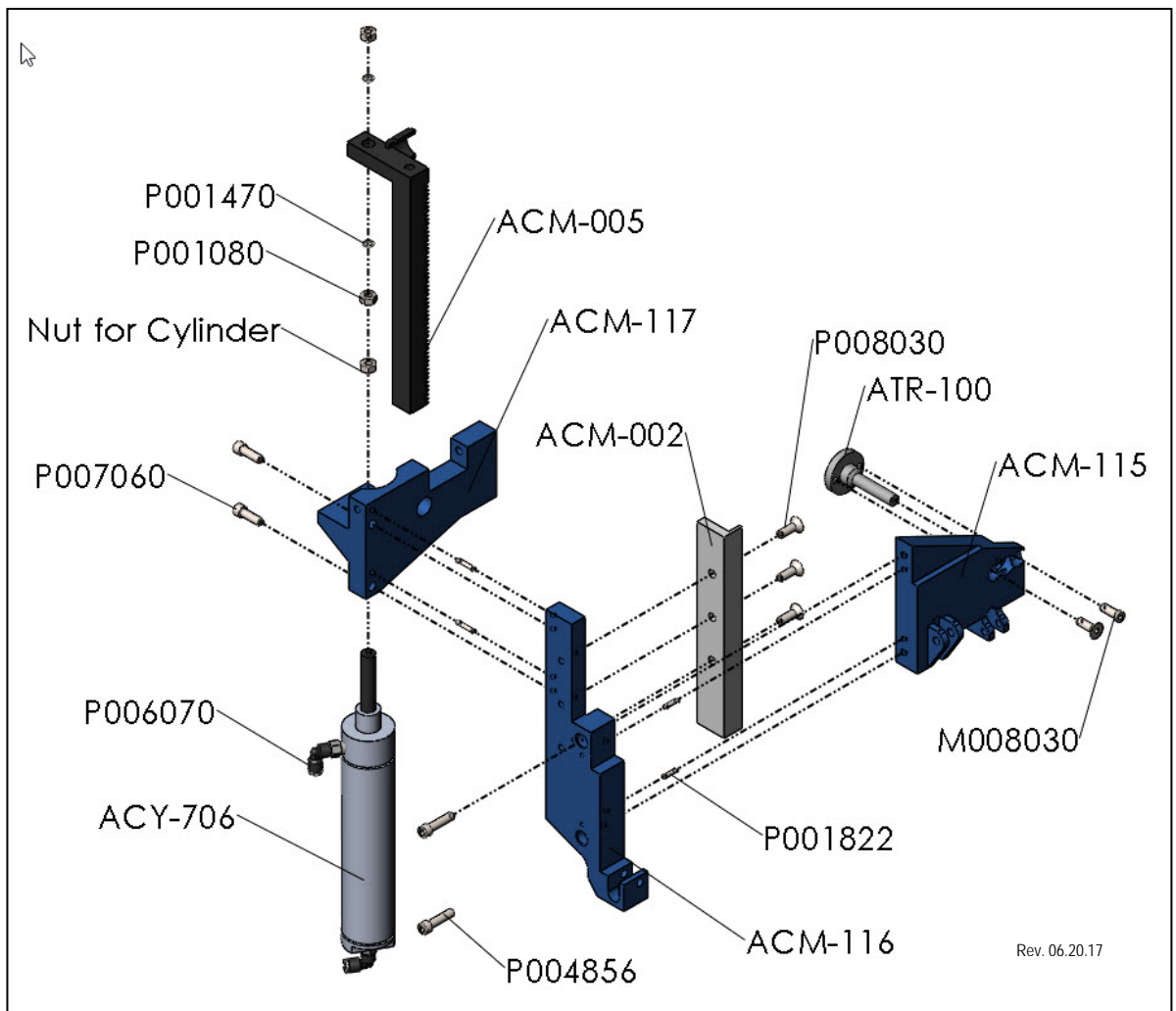
PART #	DESCRIPTION	QTY.
A902060	Cylinder for # 3, 4, 5 & 6	2
ATF-101	Clevis Pin	2
FP-005	Cylinder Mounting Block	1
P005460	1/4" External "E" Retaining Ring	4



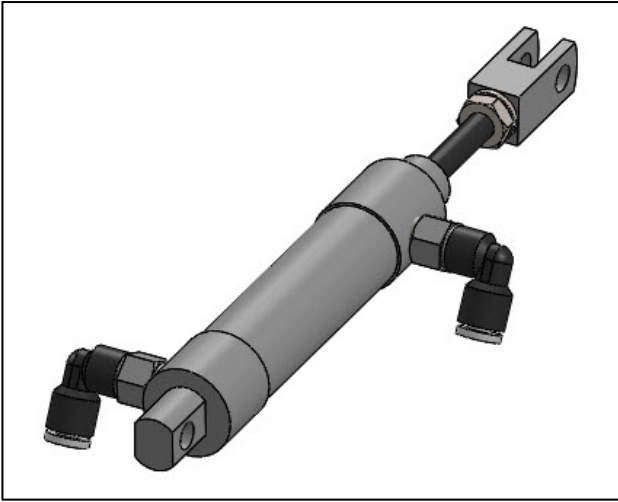
CYLINDER #7 MOUNTING ASSEMBLY (A902075)



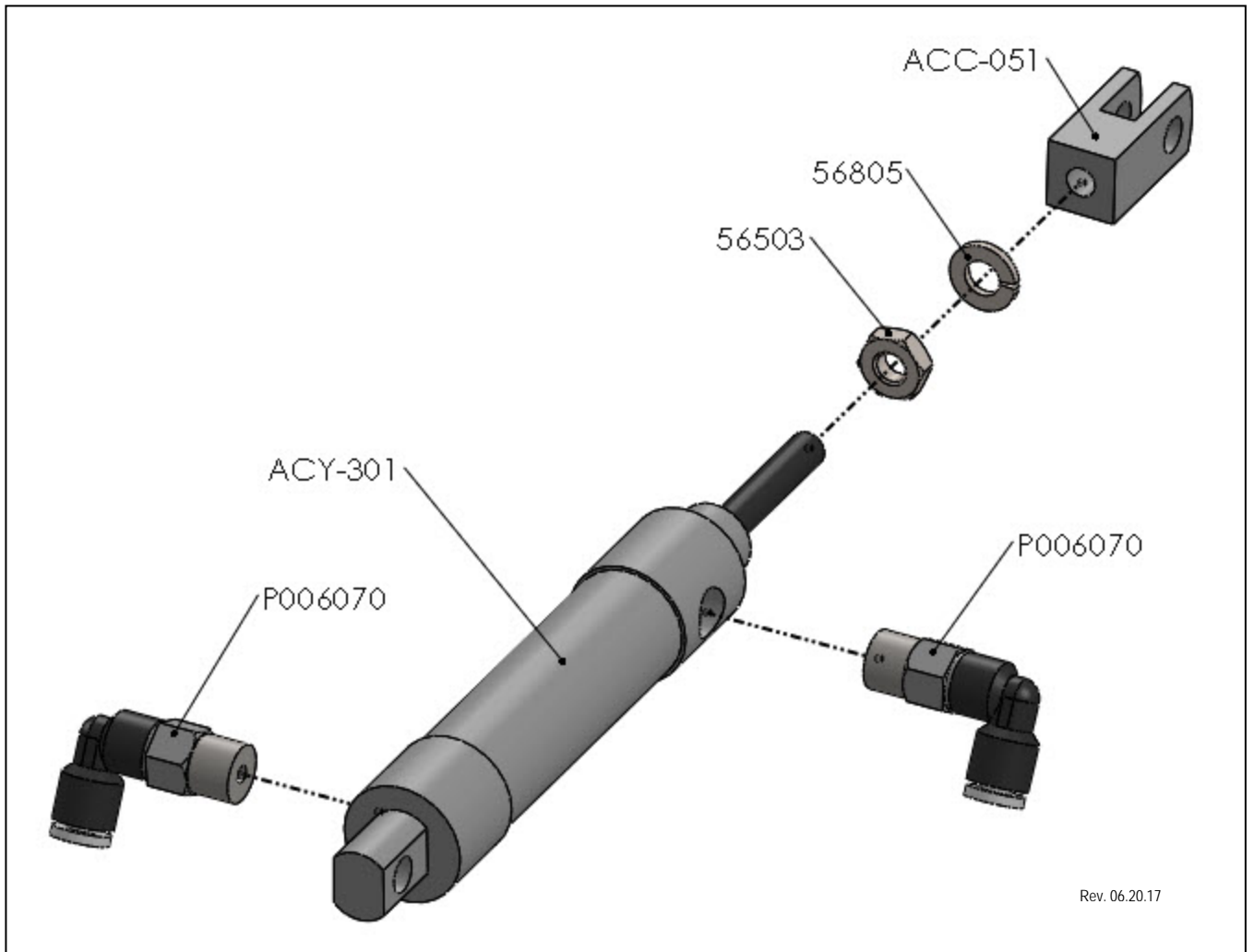
PART #	DESCRIPTION	QTY.
ACM-002	Rack Gear Guide	1
ACM-005	Twister Head Rack Gear	1
ACM-115	Cylinder Mounting Bracket Part 1	1
ACM-116	Cylinder Mounting Bracket Part 2	1
ACM-117	Cylinder Mounting Bracket Part 3	1
ACY-706	Cylinder 7	1
ATR-100	Mounting Plate	1
M008030	1/4-20 x 3/4 Flat Head Socket Cap Screw Modified	1
P001055	7/16-20 x 1/4" Hex Nut	2
P001485	7/16 Lock Washer	2
P001822	1/8 X 1/2 Dowel Pin	4
P004856	1/4-20 X 1" Socket Head Cap Screw	2
P006070	Straight Tube Fitting	2
P007060	1/4-20 x 3/4 Socket Head Cap Screw	2
P008055	1/4-20 x 1" Flat Head Socket Cap Screw	4



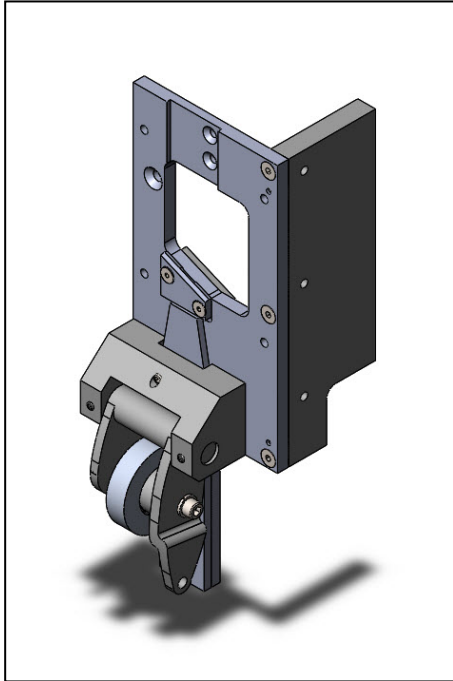
XL8 CYLINDER #5 ASSEMBLY (A902080)



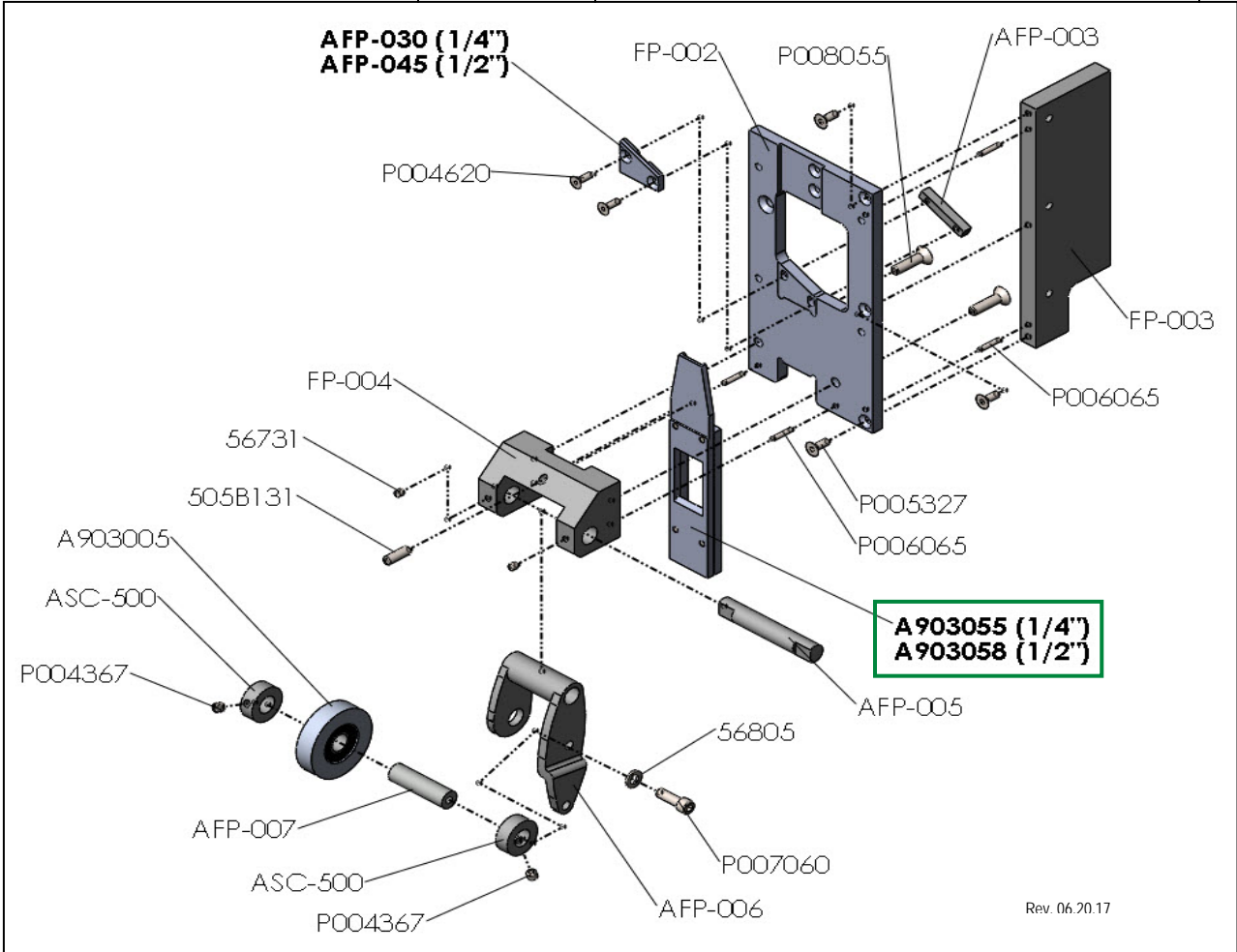
PART #	DESCRIPTION	QTY.
56503	XL8 1/4-28 Nut	1
56805	XL8 1/4 Split Lock Washer	1
ACC-051	XL8 Clevis - 1/4-28 Thread	1
ACY-301	XL8 Cylinder for 3, 4, 5 & 6	1
P006070	XL8 Straight Tube Fitting	2



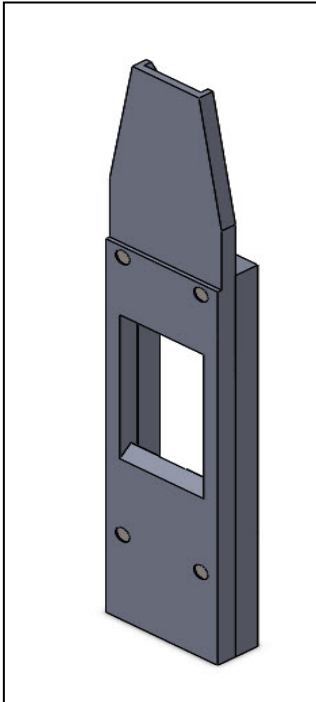
FACE PLATE ASSEMBLY (A902085)



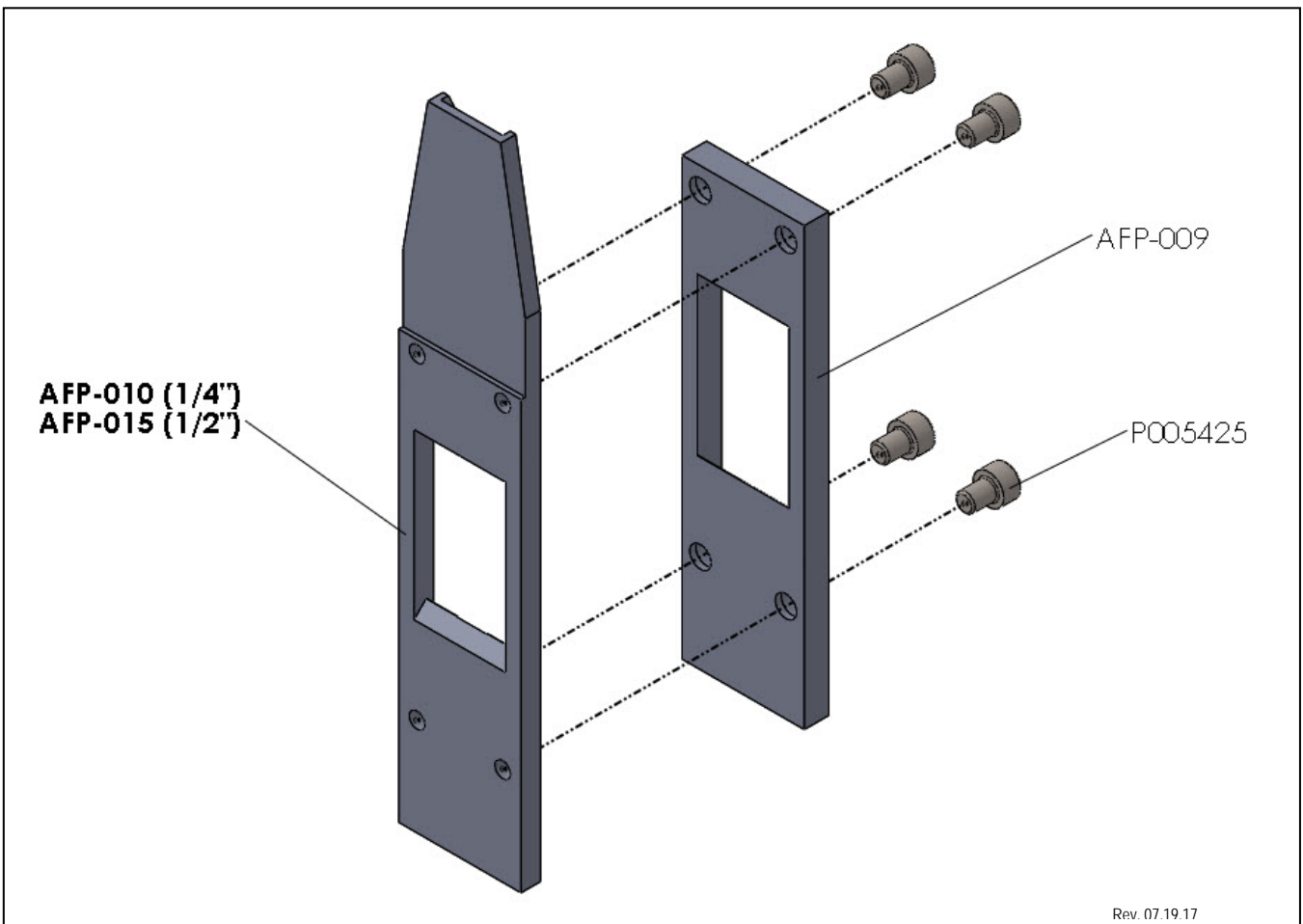
PART #	DESCRIPTION	QTY.
505B131	1/4-20 x 3/4 Cup Point Set Screw	1
56730	10-32 X 3/8 Hex Socket Set Screw	2
56805	1/4 Split Lock Washer	1
A903005	Pressure Wheel XL8 Assembly	1
A903055	Chute 1/4" XL8 Assembly	1
AFP-003	Anvil Mounting Block	1
AFP-005	Pressure Arm Shaft	1
AFP-006	Pressure Arm - Left	1
AFP-007	Pressure Wheel Shaft	1
AFP-030	XL8 Anvil	1
ASC-500	Retaining Coupler	2
FP-002	XL8 Face Plate	1
FP-003	XL8 Mounting Plate	1
FP-004	XL8 Mounting Plate	1
P004367	1/4 -20 x 1/4 Socket Set Screw	2
P004620	8-32 x 1/2" Flat Socket Head Screw	2
P005327	10-32 X 1/2 Flat Head Socket Screw	3
P006065	1/8 X 5/8 Dowel Pin	4
P007060	1/4-20 x 3/4 Socket Head Cap Screw	1
P008030	1/4-20 x 3/4 Flat Head Socket Cap Screw	2



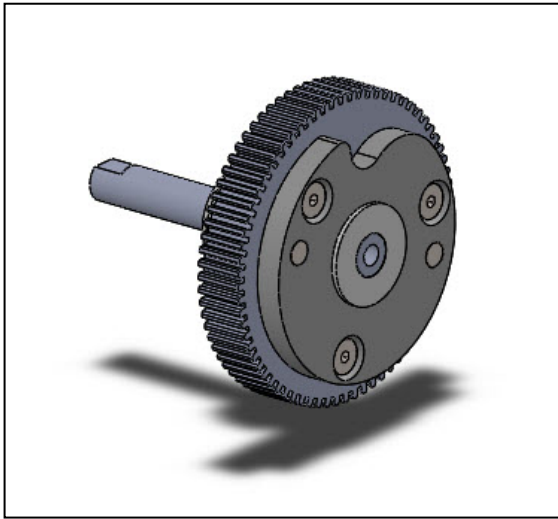
CHUTE ASSEMBLY ¼ (A903055)



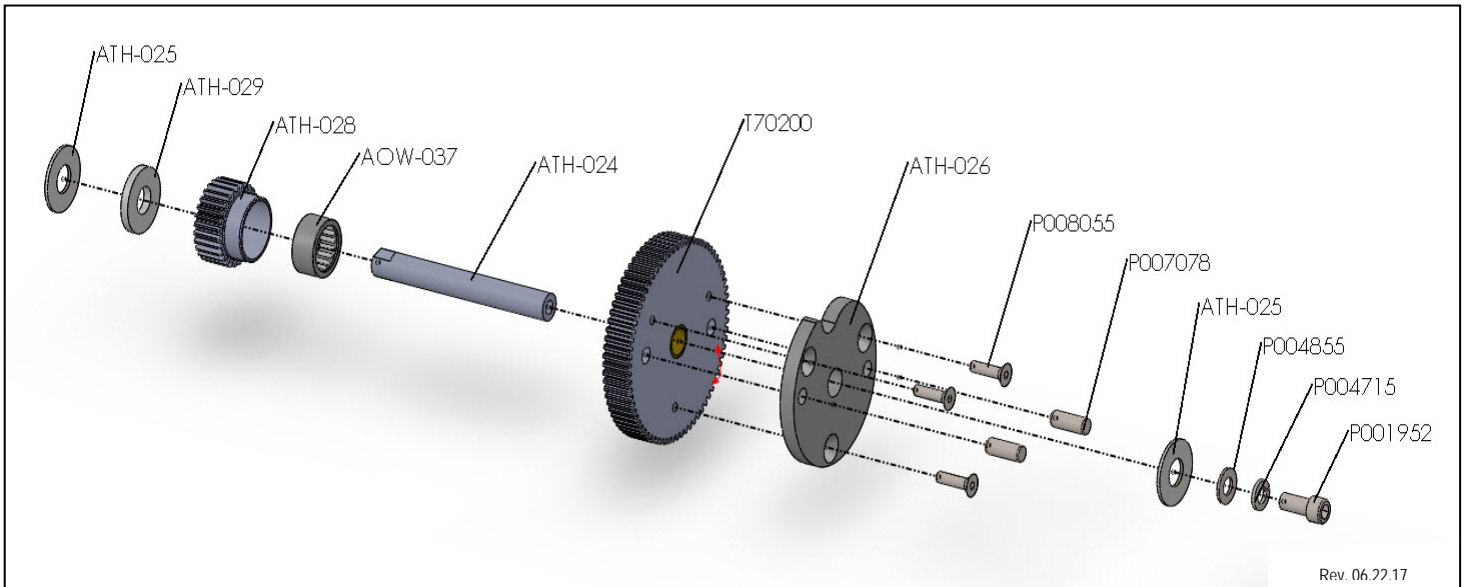
PART #	DESCRIPTION	QTY.
AFP-009	Tape Chute Back	1
AFP-010	XL8 ¼" Front Tape Chute	1
AFP-015	XL8 ½" Front Tape Chute	1
P005425	10-32 x 1/4" Socket Head Cap Screw	4



PINION GEAR ASSEMBLY (A902095)



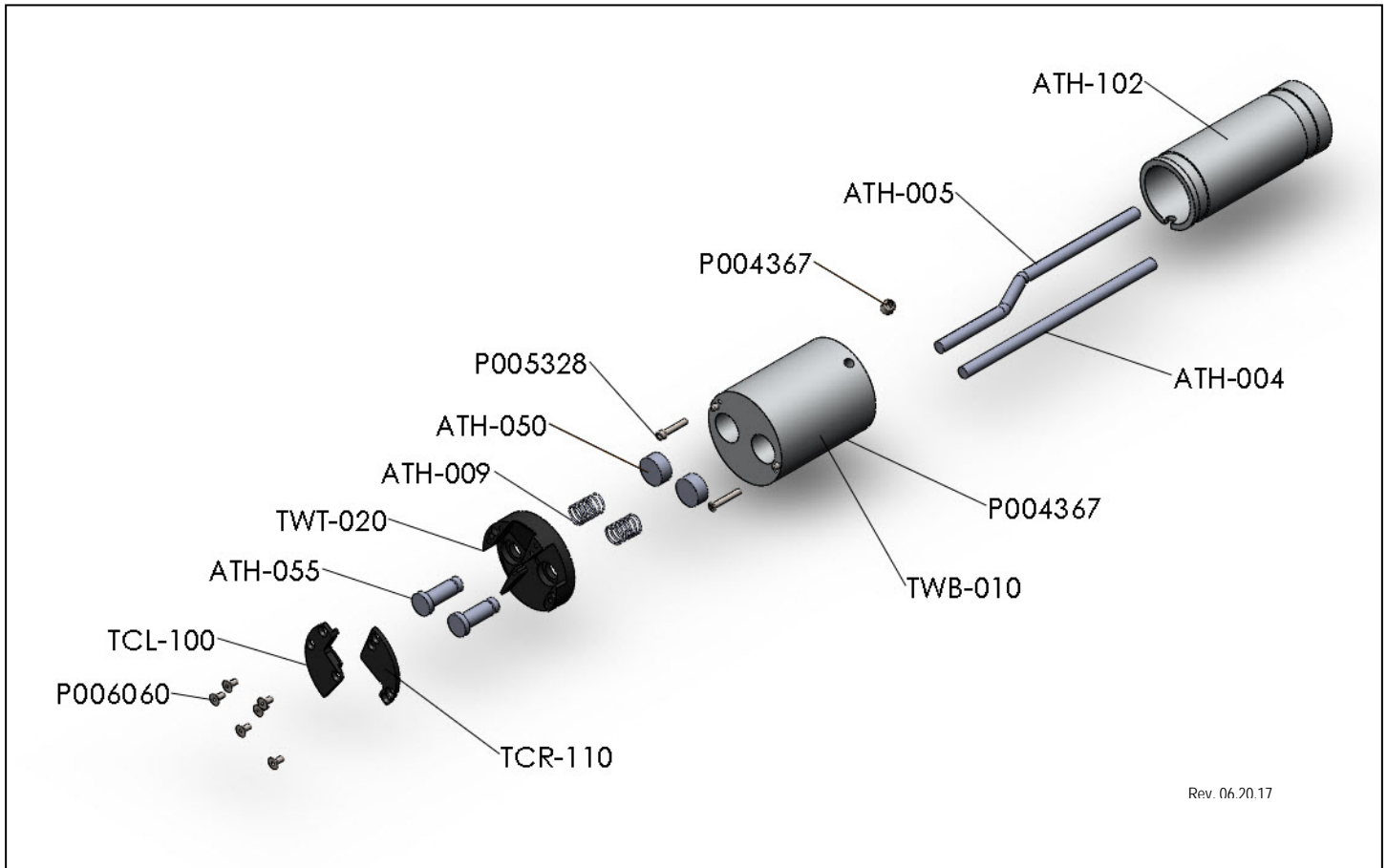
PART #	DESCRIPTION	QTY.
A901064	Pinion Gear Assembly	1
ATH-024	Cam Gear Shaft	1
ATH-025	Trust Washer	2
ATH-026	Twister Head Cam	1
ATH-029	Plastic Spacer	1
P001952	3/8-16 x 7/8" Socket Head Cap Screw	1
P004715	3/8 Split Lock Washer	1
P004855	3/8 Flat Washer	1
P007078	Dowel Pin 1" x 3/8"	2
P008055	1/4-20 x 1" Flat Head Socket Cap Screw	3
T70200	Twister Head Gear with Bushings	1



TWISTER HEAD ASSEMBLY (A903030)

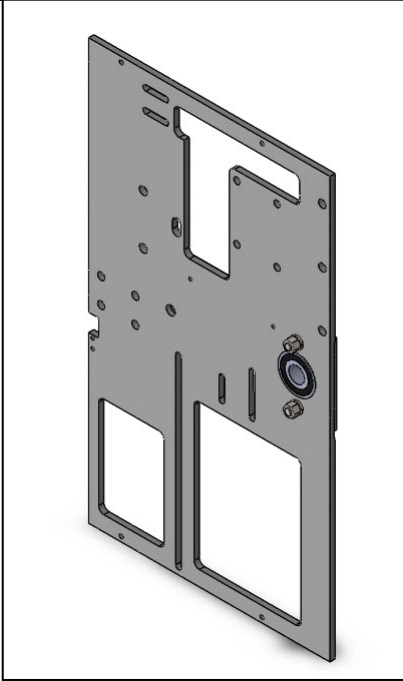


PART #	DESCRIPTION	QTY.
ATH-004	XL8 #1 PUSH ROD	1
ATH-005	XL8 #PUSH ROD	1
ATH-009	XL8 SPRING - GRIPPER RETURN	2
ATH-050	XL8 TWISTER SPACER	2
ATH-055	XL8 PUSHER PIN	2
ATH-102	XL8 TWISTER - SHAFT	1
P004367	XL8 1/4-20 x 1/4 Cup Point Set Screw	3
P005328	XL8 4-40 x 5/8 Socket Head Cap Screw	1
P005460	XL8 1/4 Side Mount External Retaining Ring	2
P006060	XL8 4-40 X 1/4 Flat Head Socket Cap Screw	6
P006065	XL8 1/8 X 5/8 Dowel Pin	2
P007098	XL8 3/16 X 1/2 Roll Pin	1
P008010	XL8 4-40 X 3/4 Philips Head Flat Screw	1
TCL-100	XL8 TWIST - COVER LEFT	1
TCR-110	XL8 Twister Cover Right	1
TWB-010	XL8 Twister Base	1
TWT-020	XL8 Twister Top	1

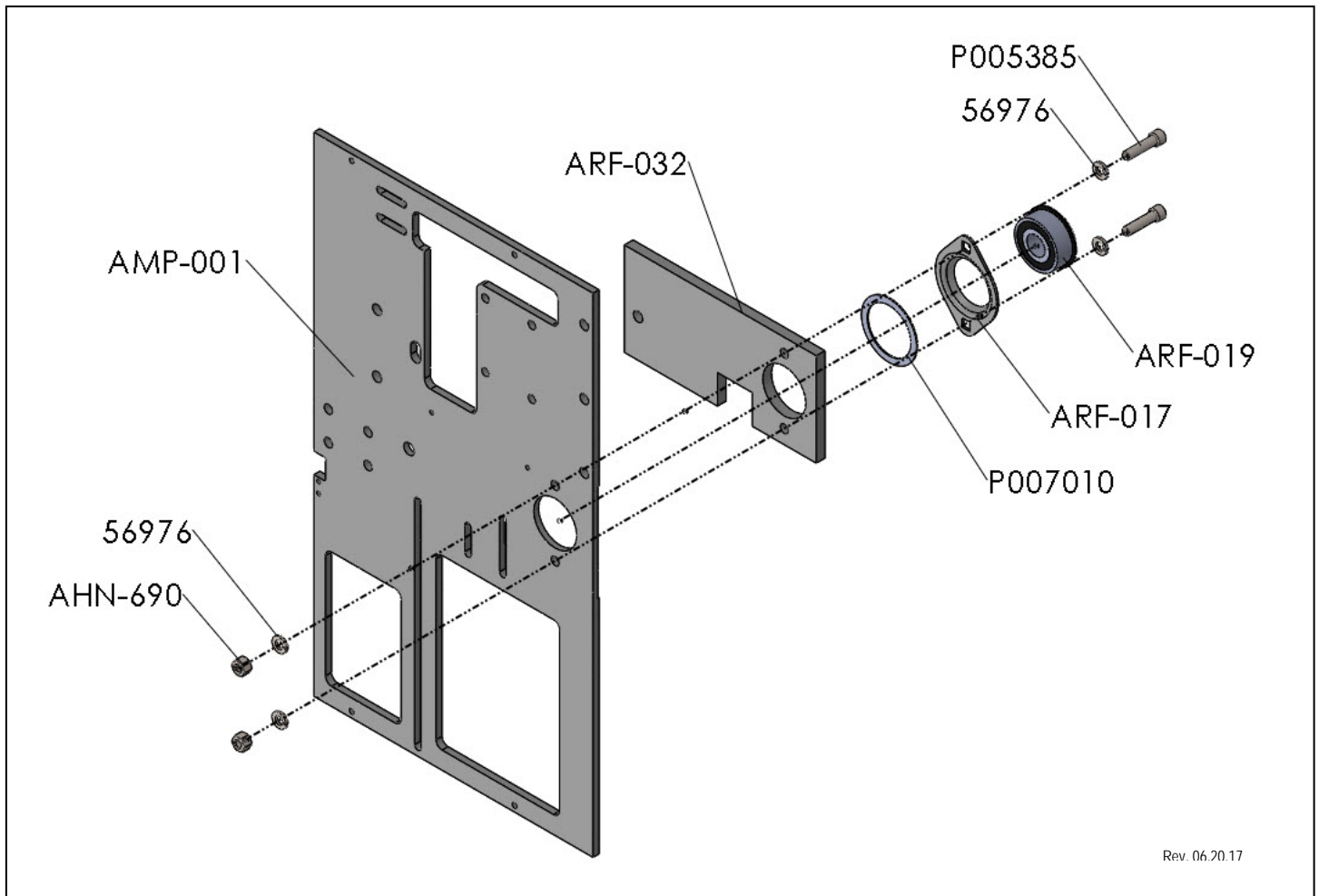


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BACK PLATE ASSEMBLY (A903040)

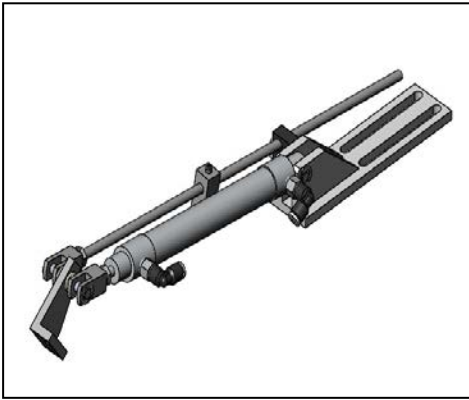


PART #	DESCRIPTION	QTY.
56976	5/16 Split Lock Washer	4
AHN-690	5/16-18 Hex Nut	2
AMP-001	Mounting Plate XL8	1
ARF-017	Bearing Flange	1
ARF-019	Retainer Ball Bearing	1
ARF-032	Backing Plate	1
P005385	5/16-18 x 1 1/4' Socket Head Cap Screw	2
P007010	2.375 x 1.875 x .045 Washer	1

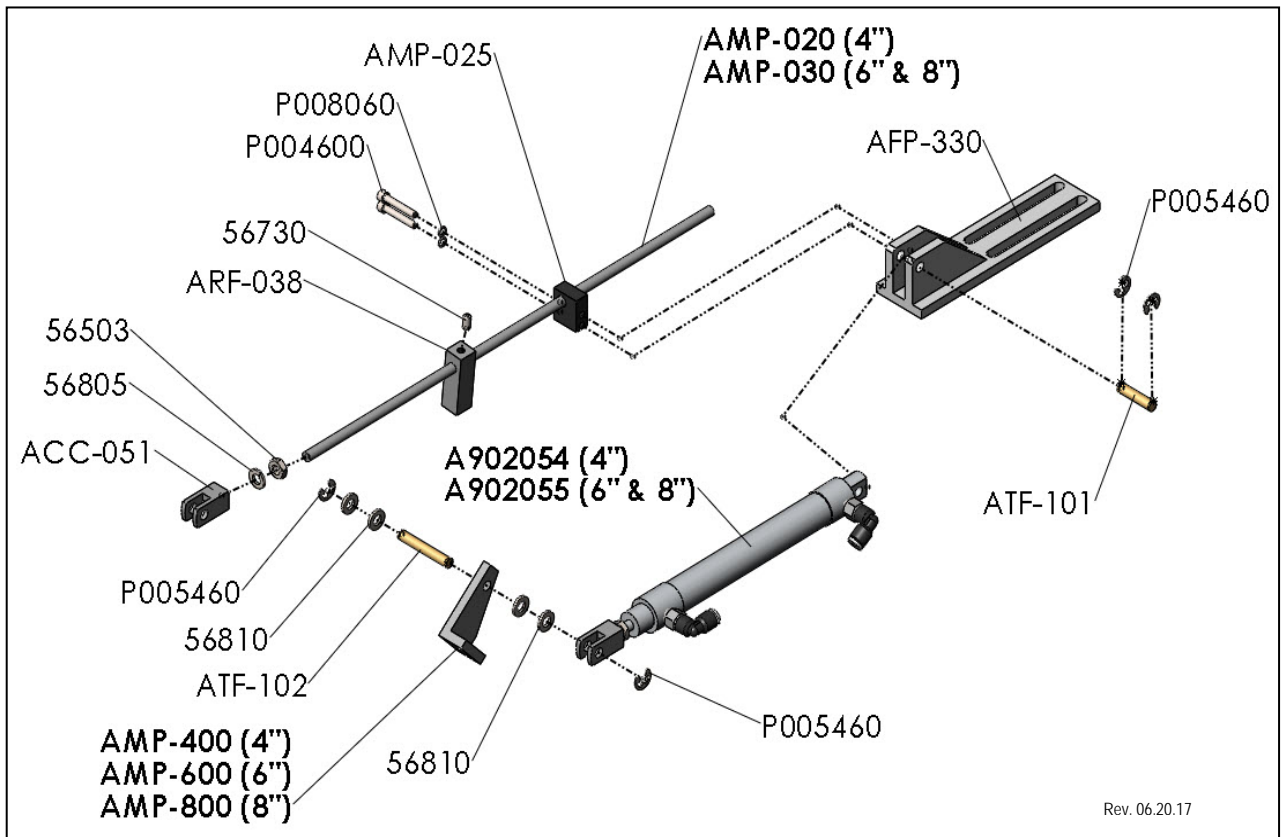


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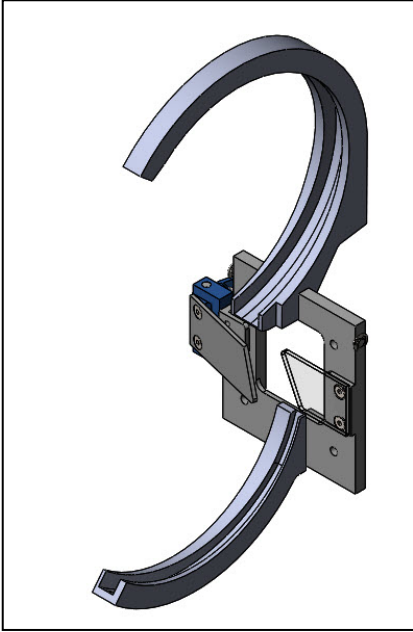
XL8 RING CYLINDER #1 ASSEMBLY (A901032: 4" / A901005: 6" / A901057: 8")



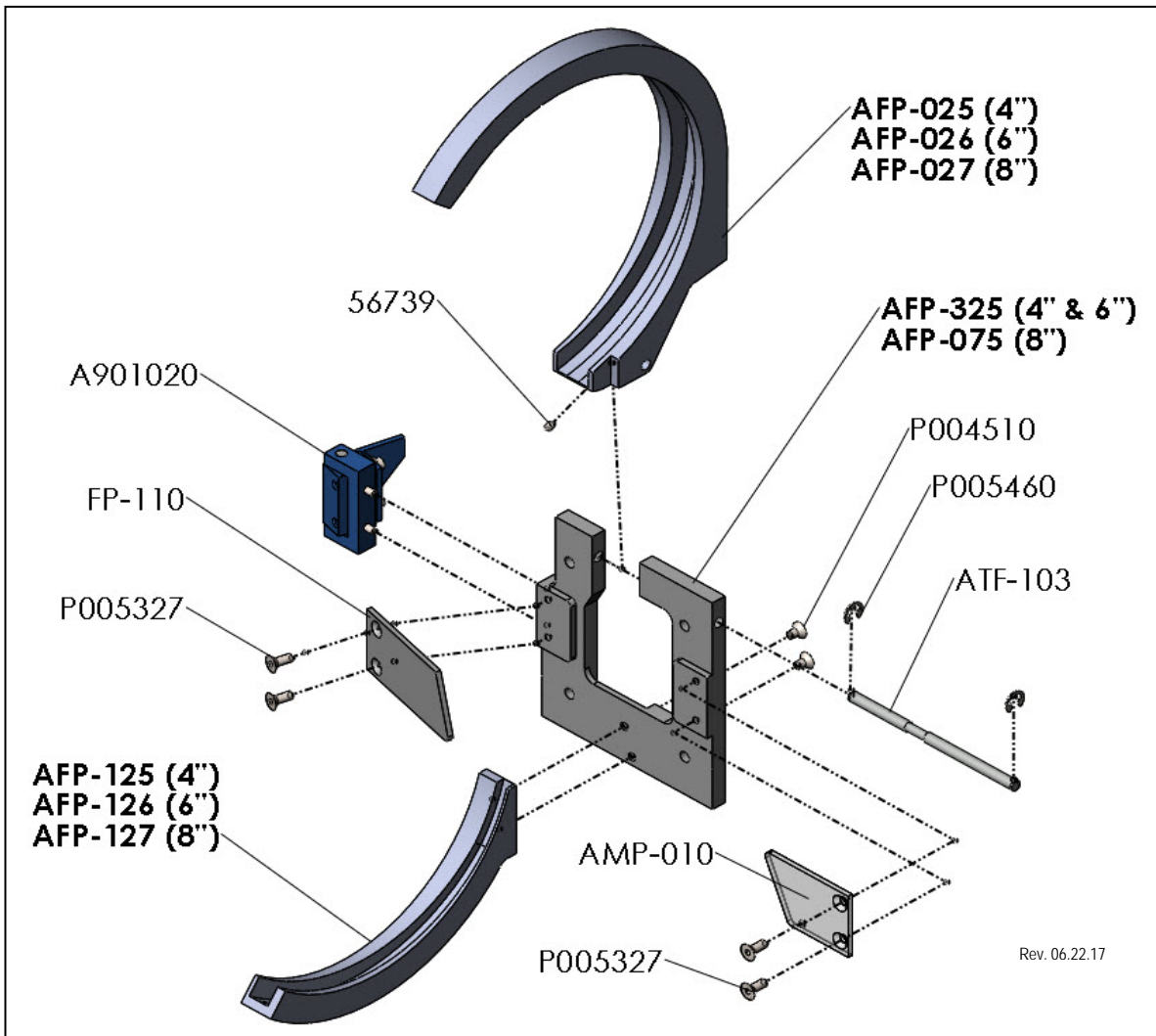
PART #	DESCRIPTION	QTY.
56503	XL8 1/4 - 28 Hex Nut Steel	1
56730	XL8 10-32 x 3/8 Cup Point Set Screw	1
56805	XL8 1/4 Split Lock Washer	1
56810	XL8 1/4 Flat Washer	4
A902054 A902055	XL8 4" Cylinder #1 with Fittings XL8 6" & 8" Cylinder #1 with Fittings	1
ACC-051	XL8 Clevis - 1/4-28 Thread	1
AFP-330	XL8 Ribbon Stop Mounting Plate	1
AMP-025	XL8 Ring Actuator Guide	1
AMP-030	XL8 Rod Actuator for 6 in & 8 in Ring	1
AMP-400 AMP-600 AMP-800	XL8 4" Ring Mounting Bracket XL8 6" Ring Mounting Bracket XL8 8" Ring Mounting Bracket	1
ARF-038	XL8 Valve Actuator For 6" & 8" Rings	1
ATF-101	XL8 Clevis Pin	1
ATF-102	XL8 Clevis Pin 1/6"	1
P004600	XL8 8-32 x 1 Socket Head Cap Screw	2
P005460	XL8 1/4 Side Mount External Retaining Ring	4
P008060	XL8 #8 Split Lock Washer	2



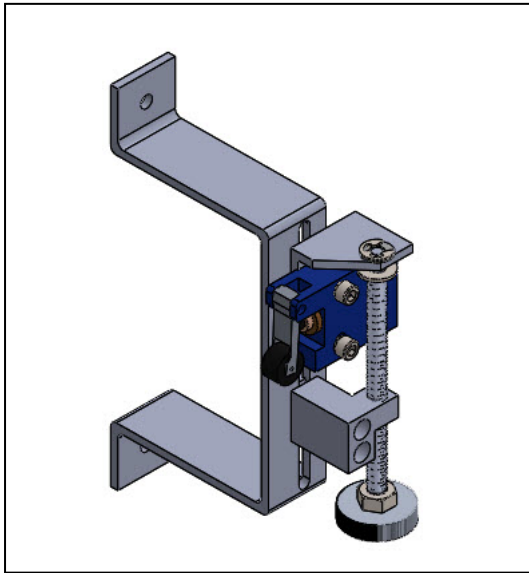
XL8 RING ASSEMBLY (A901062: 4" / A901000: 6" / A901055: 8")



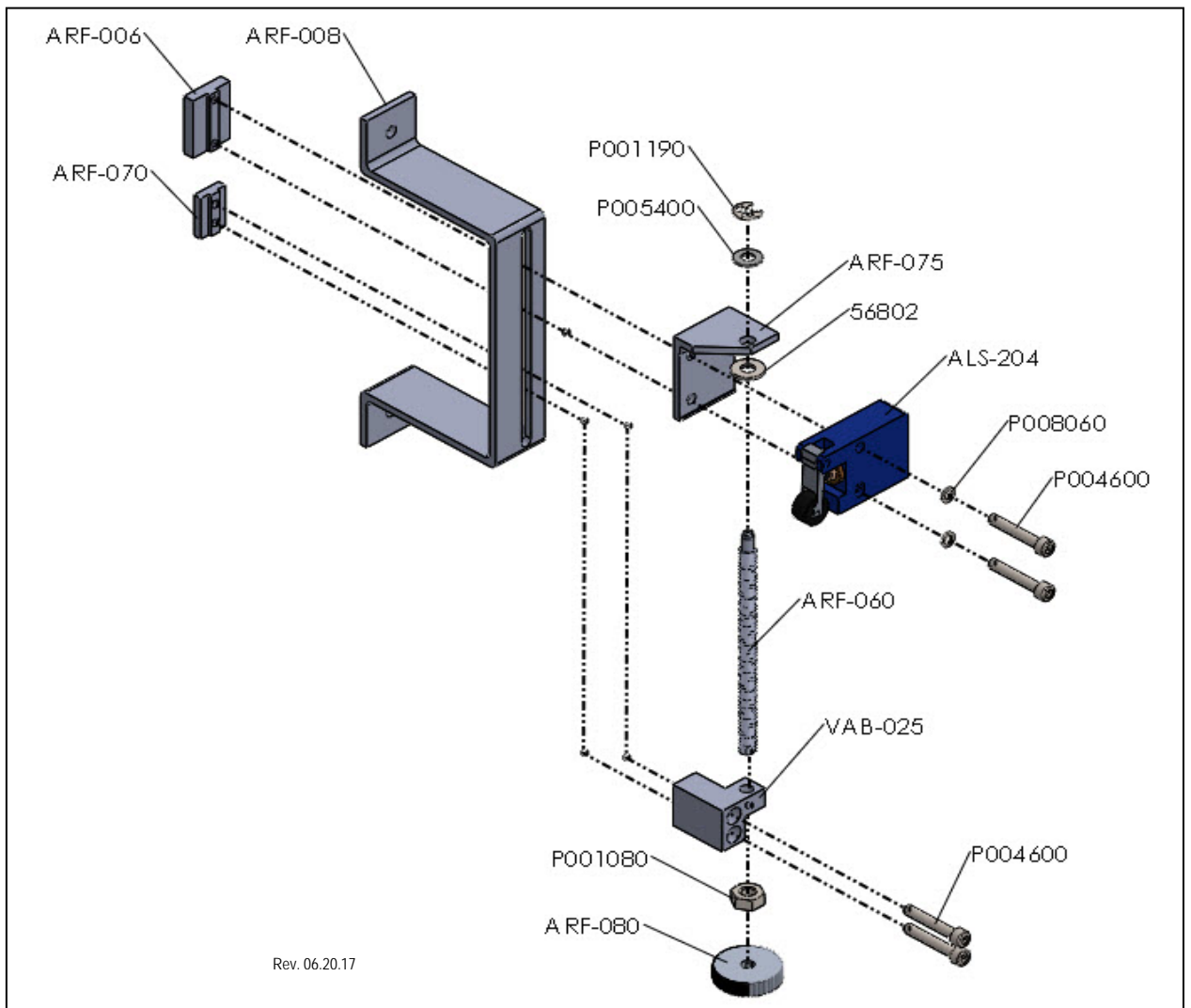
PART #	DESCRIPTION	QTY.
56739	XL8 8-32 X 3/16 Hex Socket Set Screw	1
A901020	XL8 Trigger Assembly	1
AFP-025 AFP-026 AFP-027	XL8 4" Ring Top XL8 6" Ring Top XL8 8" Ring Top	1
AFP-325 AFP-075	XL8 4" & 6" Face Plate XL8 8" Face Plate	1
AFP-125 AFP-126 AFP-127	XL8 4" Ring Bottom XL8 6" Ring Bottom XL8 8" Ring Bottom	1
AMP-010	XL8 Shield Guard	1
ATF-103	XL8 Clevis Pin	1
FP-110	XL8 Trigger Arm Shell	1
P005327	XL8 10-32 X 1/2 Flat Head Socket Screw	4
P005460	XL8 1/4" External "E" Retaining Ring	2
P004510	XL8 10-32 x 3/8 Flat Head Cap Screw	2



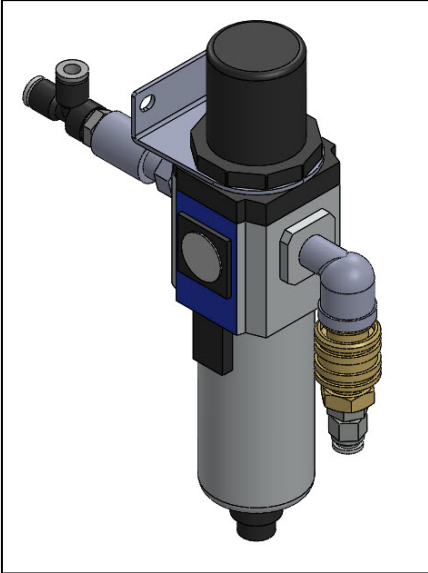
XL8 SWITCH "A" ASSEMBLY 4" AND 6" (A901025)



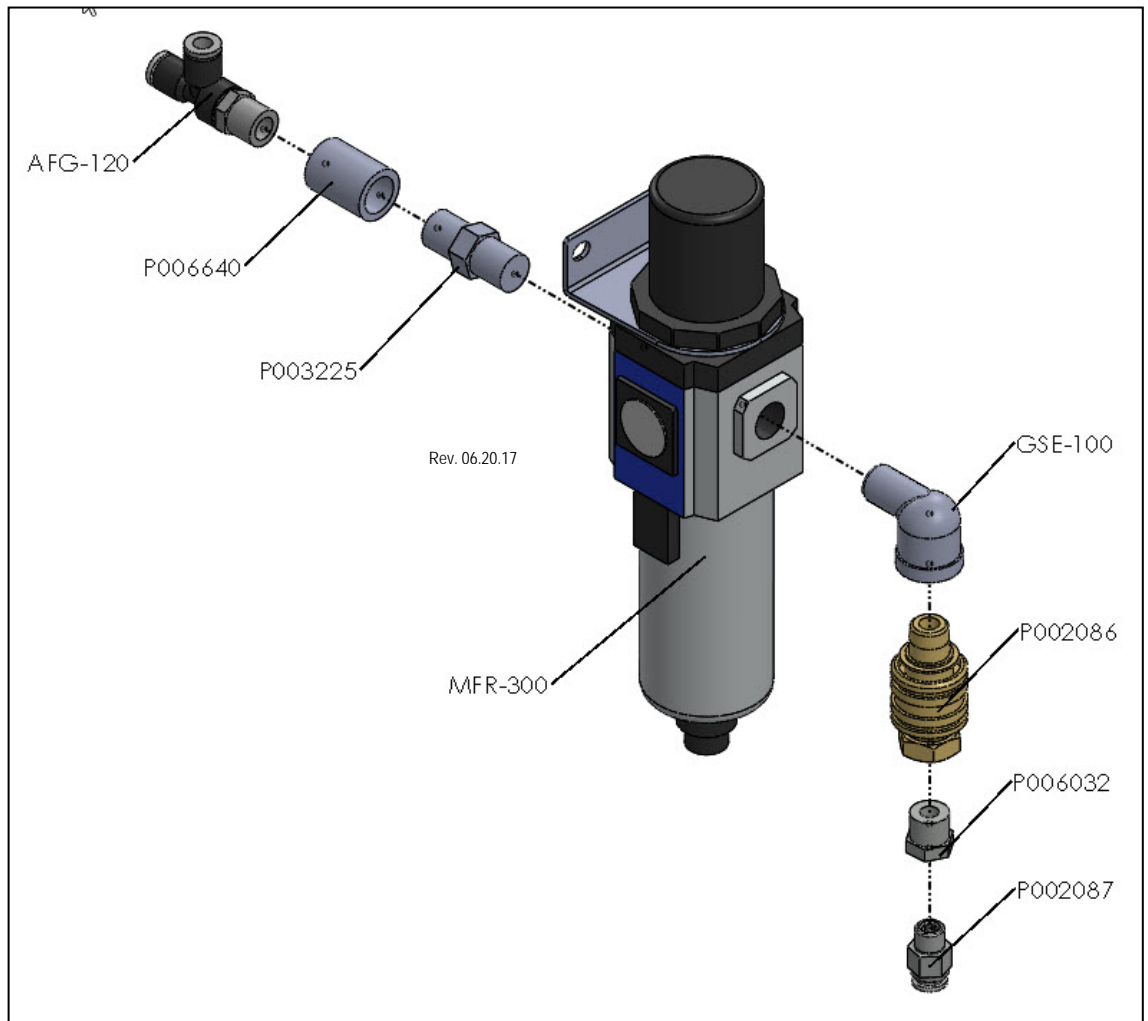
PART #	DESCRIPTION	QTY.
56802	XL8 #10 Flat Washer	1
ALS-204	XL8 Limit Switch	1
ARF-006	XL8 Switch "A" Mounting Plate	1
ARF-008	XL8 Extended Limit Switch Bracket	1
ARF-060	XL8 Switch "A" Rod - Adjust	1
ARF-070	XL8 Nut Plate - Adjust	1
ARF-075	XL8 Angle Bracket	1
ARF-080	XL8 Switch "A" Adjust Wheel	1
P001080	XL8 1/4 - 20 Hex Nut	1
P001190	XL8 0.188 "E" Retaining Ring	1
P004600	XL8 8-32 X 1" Socket Head Cap Screw	4
P005400	XL8 Flat Washer .203 X .433 X .032	1
P008060	XL8 #8 Split Washer	2
VAB-025	XL8 Valve Adjustment Bracket	1



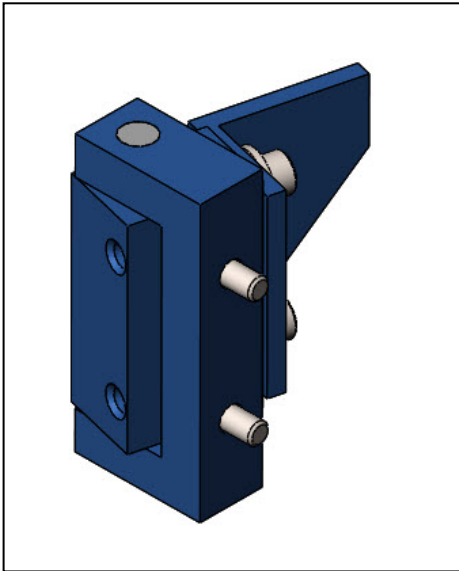
XL8 MAIN FILTER REGULATOR ASSEMBLY (A901080)



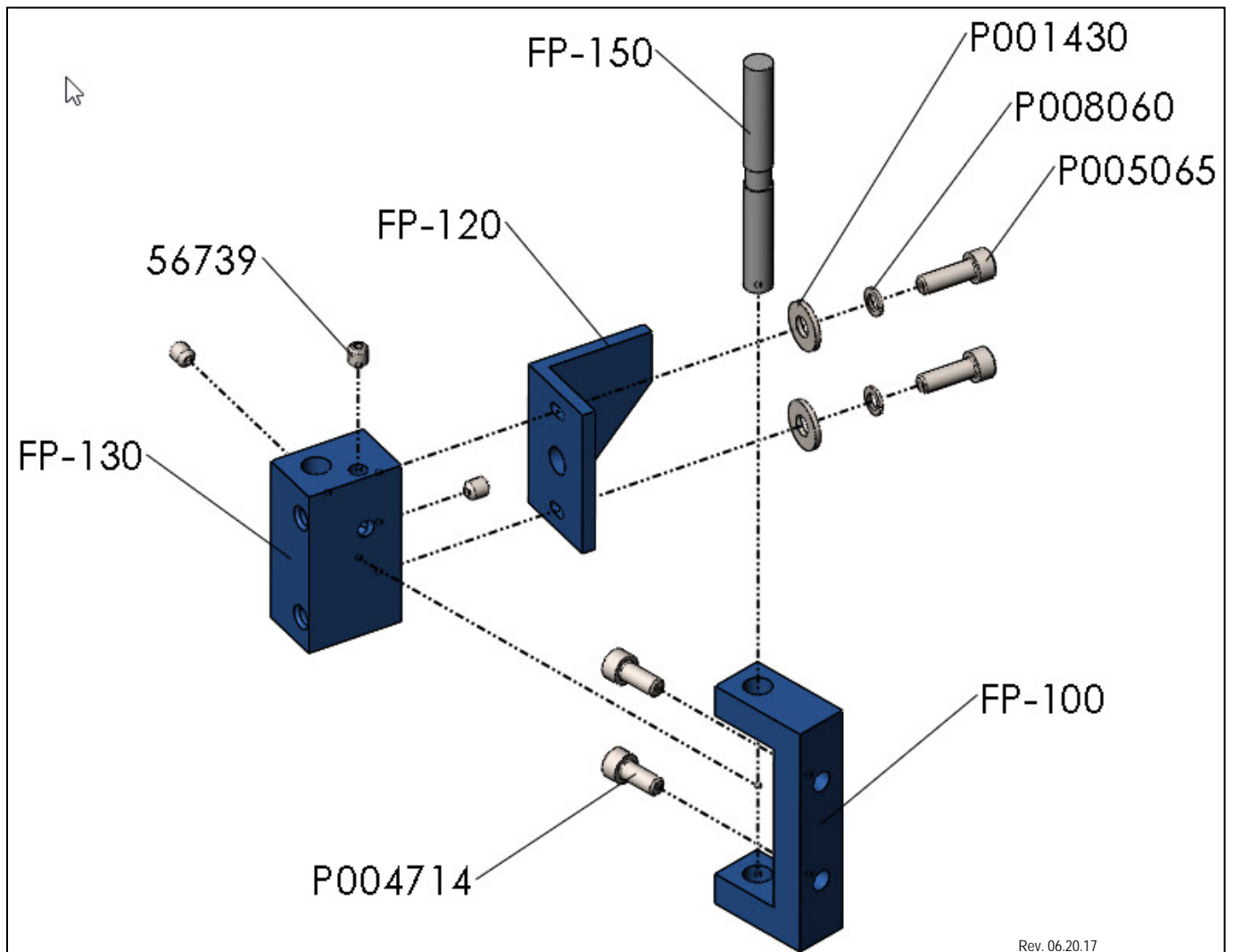
PART #	DESCRIPTION	QTY.
AFG-120	XL8 Large Straight Tube Fitting	1
GSE-100	XL8 1/8 Street Elbow 90'	1
MFR-300	XL8 Main Regulator	1
P002086	XL8 Valve, Hand Slide	1
P002087	XL8 Fitting, Straight, 1/4-U Qs-1/8-1/4-U	1
P003225	XL8 Hex Pipe Nipple	1
P006032	XL8 1/4m X 1/8f Pipe	1
P006640	XL8 1/4 x 1 Pipe Coupling	1



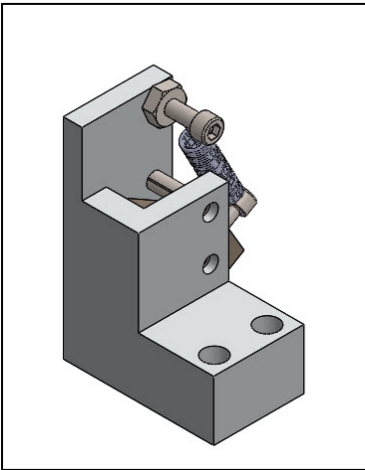
XL8 TRIGGER ASSEMBLY (A901020)



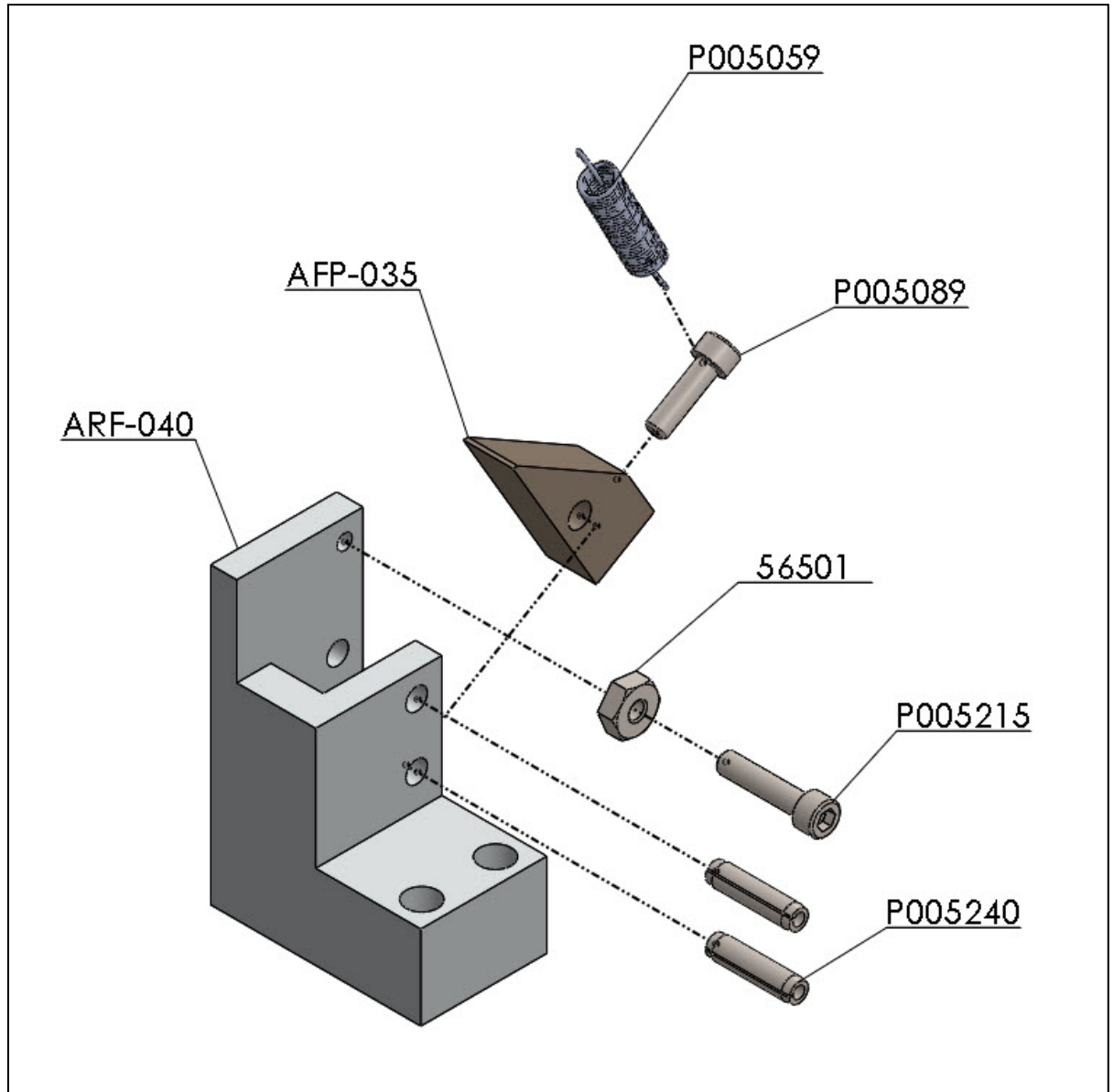
PART #	DESCRIPTION	QTY.
56739	XL8 8-32 X 3/16 Hex Socket Set Screw	3
FP-100	XL8 Trigger Mount	1
FP-120	XL8 Trigger Bracket	1
FP-130	XL8 Trigger Pivot	1
FP-150	XL8 Trigger Pin	1
P001430	XL8 #8 Flat Washer	2
P004714	XL8 8-32 X 3/8 Socket Head Cap Screw	2
P005065	XL8 8-32 X 1/2" Socket Head Cap Screw	2
P008060	XL8 #8 Split Washer	2



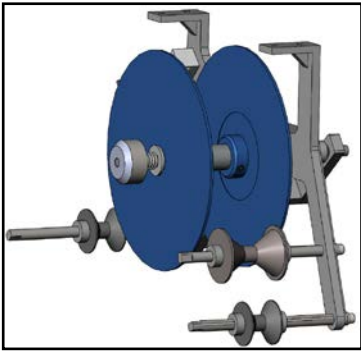
NO BACK ASSEMBLY (A901063)



PART #	DESCRIPTION	QTY.
56501	4-40 Hex Nut	1
AFP-035	No Back Knife	1
ARF-040	No Back Block	1
P005059	No Back Spring	1
P005089	4 - 40 X 3/8" Socket Head Cap Screw	1
P005215	4-40 X 1/2" Socket Head Cap Screw	1
P005240	1/8 X 1/2 Roll Pin	2



XL8 FULL BRAKE ASSEMBLY (A903045)



PART #	DESCRIPTION	Qty
56976	5/16 Split Lock Washer	7
A900045	Tape Reel Assembly Mount	1
A901095	Brake Arm Eye Bolt Assembly	1
A902010	Brake Arm Eye Bolt w/ Holder	1
A903080	Brake Yoke Assembly	1
AFW-030	Compression Spring	1
ARB-101	Brake Arm Pad Plate	1
ARB-106	Brake Washer	1
ASC-500	1/2" Collar Shaft	7
ATF-090	Clevis Pin	2
ATH-029	Plastic Spacer	1
ATR-005	XL-8 Brake Extension	1
ATR-006	XL-8 Brake Return Spring	1
ATR-013	Brake Spooler Shaft	3
ATR-016	XL-8 Brake Arm Guide	1
ATR-018	Brake Arm	1

PART #	DESCRIPTION	Qty
ATR-030	Roller	1
ATR-032	Small Roller	2
ATR-036-1	Precision Wound Spool Brake Pad	1
ATR-038	XL-8 Brake Spacer	1
ATR-039	3/8" x 1" Socket Shoulder Screw	1
DT-610	Spacer	1
M004005	Knurled Hand Nut	1
P001180	1/4 External Retaining Ring	4
P005380	5/16-18 X 1" Socket Head Cap Screw	3
P005385	5/16-18 x 1 1/4" Socket Head Cap Screw	2
P008025	5/16-18 X 3/4 Socket Head Cap Screw	2
PWS-100	Mounting Plate	1
PWS-150	1/4-20 Set Screw/ Pin	1
PWS-160	3/8-16 x 3/4" Set Screw	1
PWS-200	Mounting Plate	1
PWS-300	Precision Wound Spool Shaft	1

