

**INSTRUCTION
MANUAL
for the
TYPE 086A
and 086AS
SEMI AUTOMATIC
BAG CLOSER**

TYPE	MODEL	SERIAL NO.
<input type="text"/>	<input type="text"/>	<input type="text"/>



Kwik Lok® CORPORATION

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

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

FAX: (509) 457-6531

Internet: www.kwiklok.com

086A and 086AS CLOSER

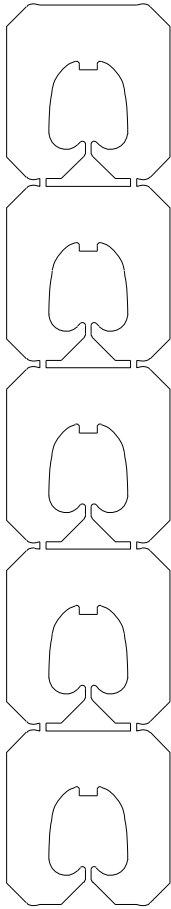
TABLE OF CONTENTS

SECTION	HEADING	PAGE
I	SPECIFICATIONS.....	1.1 - 1.2
II	OPERATION.....	2.1 - 2.2
III	ADJUSTMENTS.....	3.1 - 3.8
IV	TROUBLE SHOOTING.....	4.1 - 4.3
V	PARTS IDENTIFICATION.....	5.1 - 5.9
VI	WIRING.....	6.1
	APPENDIX	
	BAG LENGTH FORMULA.....	A
	BAGNECK TRIMMER OPERATION.....	B - E
	SUGGESTED SPARE PARTS.....	F
	RETURNED MATERIALS AUTHORIZATION.....	G

GENERAL SAFETY INFORMATION

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

1. Do not attempt to operate the closer until you understand its function. Study the manual carefully.
2. Keep all foreign material away from the drive system.
3. Keep fingers out of the closer and away from any moving parts.
4. Disconnect the power cord before making any adjustments or maintenance. All moving parts must be completely stopped before continuing. All adjustments are made with power disconnected.
5. The closer is normally operated from a counter or table. While the closer is very stable when operated from a flat a solid surface, care should be taken not use it in a way that could cause it to tip or fall from the operating surface.



**THE TYPE 086A and 086AS
MACHINE**

SEMI - AUTOMATICALLY CLOSES

PLASTIC BAGS

WITH THE STRIPLOK® CLOSURE

OR THE STRIPLOK CLOSURE LABEL

- A. The closing machine designated Type 086A can run standard R, RJ, and S series closures, and series L and U labels.
- B. The system will close a wide range of product size variations. The Striplok closures are available in many closure opening sizes to accommodate a large number of variations in bag width and film material thickness.

Upon request and upon receipt of sample bags, the factory will gladly recommend the proper closure opening sizes. Use the bag length formula found in the appendix of this manual to help determine the proper bag length needed.

- C. A suggested spare parts inventory is listed in the appendix. To save valuable time, it is recommended that an adequate supply of these parts be kept on hand for needed repairs.

SECTION I

Specifications

086A SEMI-AUTOMATIC BAG CLOSING MACHINE SPECIFICATIONS

TYPE	MODEL	CLOSURE	SPEED
086A	100	RJ	Up to 30 Bags/Min.
	200	R and S	
	300	L Labels, medium and heavy duty	
	400	U Labels, medium and heavy duty	
	500	CR and CS Labels	
086AS	100	RJ	
	200	R and S	
	300	L Labels, medium and heavy duty	
	400	U Labels, medium and heavy duty	
	500	CR and CS Labels	

1. The 086A semi-automatic closer comes standard with mounted rubber feet.
Optional suction cup feet are available.
2. The 086A is available for use with the following electrical power:

115 VAC, 60 Hz, 1amp, single phase
220 - 240VAC, 50 Hz, .38 amp, single phase
3. The model 086AS is a stainless steel version of the 086 bag closer.

SECTION II Operation

A. OPERATING SEQUENCE: (Figure 2.1)

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

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

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

1. Plug in the closer.

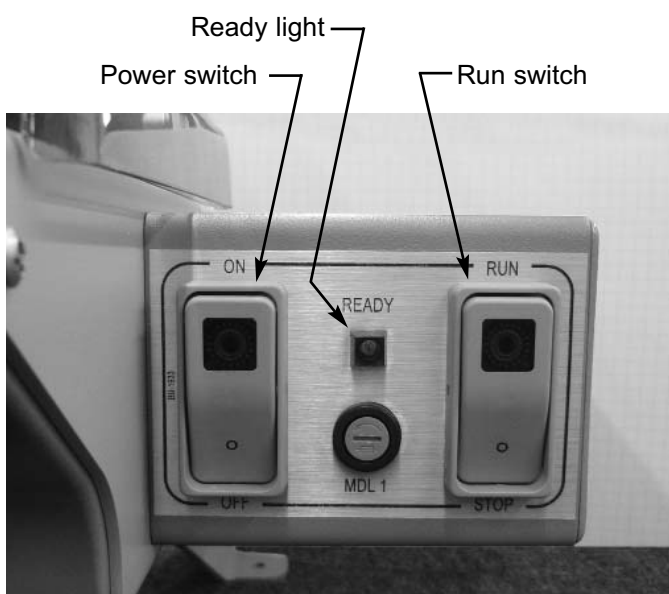


Figure 2.1

2. Press the power switch to "ON".
3. Slide the closure strip into the closure track until the strip stops (refer to part B in this section).
4. Press the run switch to "RUN" . A closure will move into the closing position, if one is not already there, and the "READY" light goes on indicating the the closer is ready to close.
5. Close the bag and remove it from the closer (refer to part C in this section).
6. The closer cycles to position a new closure into the closing position, ready for the next bag. The "READY" light will go off momentarily as the closure is loading.
7. If no closure is available to move into the closing position, the machine will cycle and the "READY" light will flash on and off repeatedly until the run switch is pressed to "STOP". The machine will then cycle back to neutral and stop. The machine at this point is again ready to close.

B. LOADING A ROLL OF CLOSURES:

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

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

4. Install the hub and roll.

SECTION II Operation

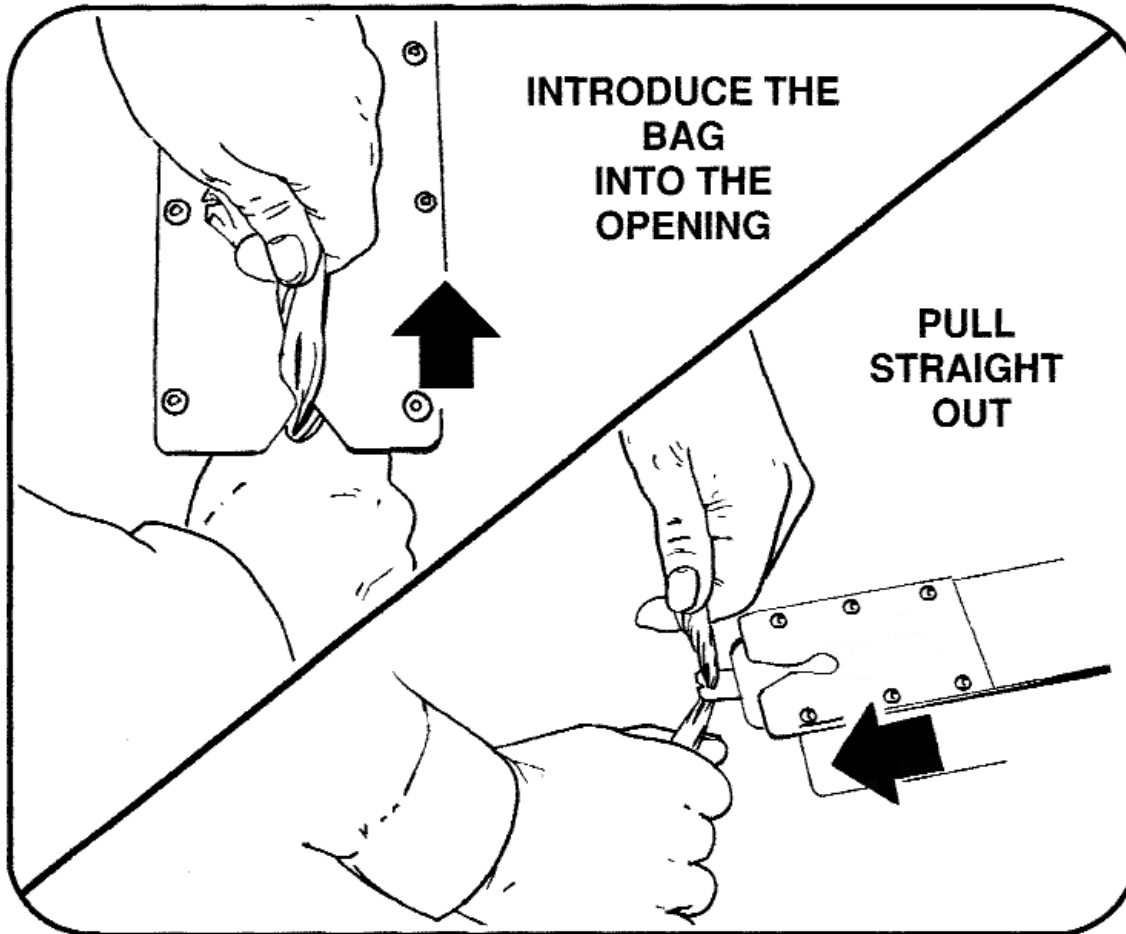


Figure 2.2

5. Remove the masking tape and feed the end of the strip into the closure track until the first closure has passed the check and is against the stop.
6. With the Power switch in the "ON" position, press the run switch to "RUN". The closer will cycle once and move a closure into the closing position. The closer is now ready to close bags.

C. CLOSING BAGS: (Figure 2.2)

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

SECTION III Adjustments

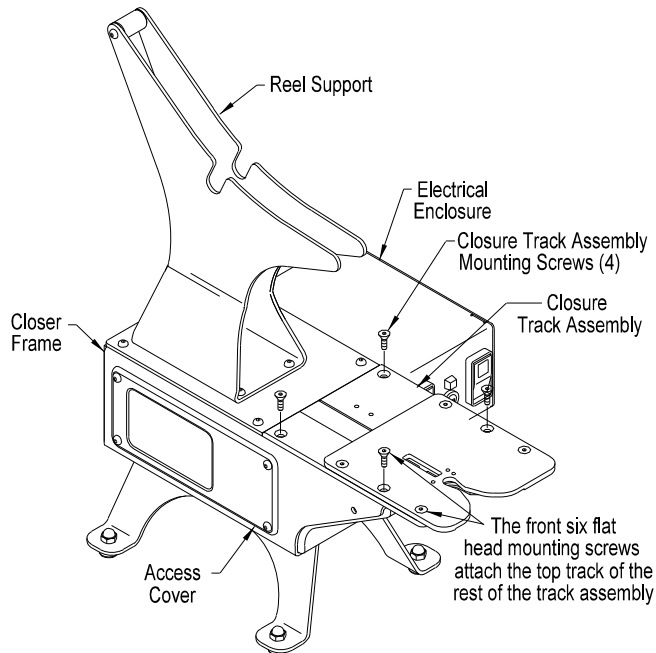


Figure 3.1

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

A. CLOSURE TRACK ASSEMBLY REMOVAL:

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

1. Remove the side access cover (Figure 3.1).
2. Disconnect the two gold colored closure stop springs (OS-012) from the lower spring anchor screw (Figure 3.2). When the springs are reattached be careful not to stretch them.
3. Remove the four flat head mounting screws which attach the closure track assembly to the closer main frame.

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

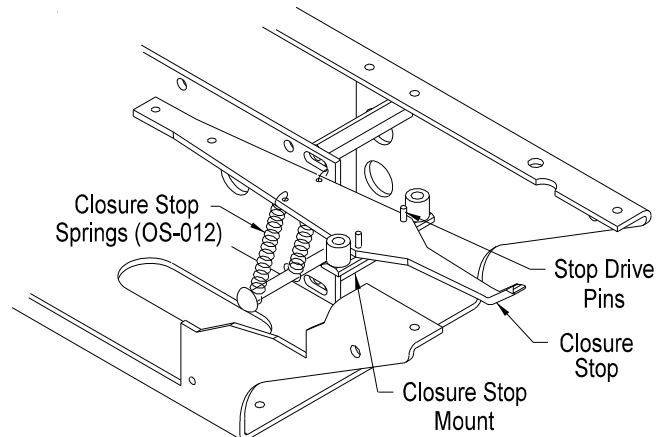


Figure 3.2

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

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

B. TOP CLOSURE TRACK REMOVAL:

The top of the closure track can be removed from the closer while the closure track assembly remains attached to the closer mainframe. This can be done to expose the slot that the closures move through. The closure track can be inspected and cleaned if needed (Figure 3.1).

1. Remove the front six flathead screws from the track top. Note the different screw lengths upon removal.
2. Remove the top of the closure track from the rest of the track assembly.

SECTION III Adjustments

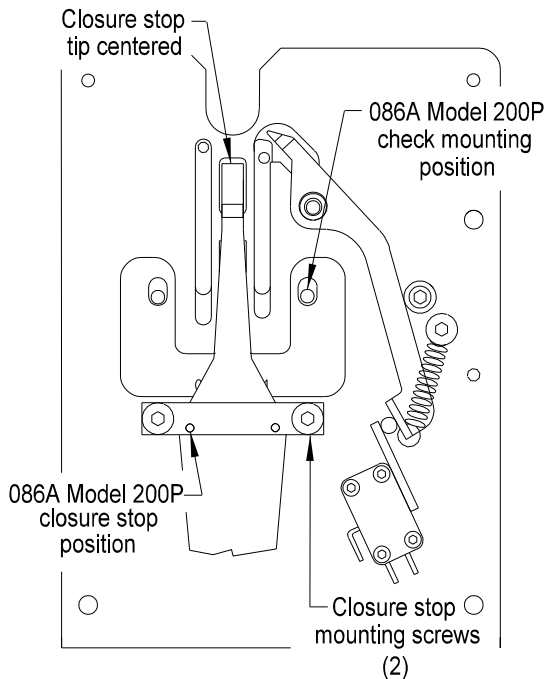


Figure 3.3

Closure track assembly as viewed from the underside.

C. REMOVE THE FRONT SHIELD:

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

DISCONNECT POWER.

1. Remove the side access cover from the closer frame.
2. Remove the two self tapping phillips screws (P23-00291) used to fasten the sides of the SHIELD from the closer frame.

3. Loosen (turn clockwise) the two SHIELD mounting screws at the bottom of the closer frame.
4. Press lightly, from inside the closer frame, on the backside of the SHIELD to remove it.

D. CHECK POSITION:

The check stops the closure strip from moving backward while the pick retracts. Depending on the model closer there are two different mounting locations for the check. Refer to Figure 3.3 to further understand the check mounting position. For this adjustment the closure track must be removed from the closer.

For 086 Model 100 the check is mounted in the forward mounting holes (the two mounting holes closest to the front of the closure track).

For 086 Models 200, 300, or 400, the check is mounted in the back mounting holes (furthest from the front of the closure track).

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

E. CLOSURE STOP POSITION:

The end closure is separated from the closure strip when the closure stop limits the travel of the second closure in the strip while the pick continues to advance the first closure.

As with the position of the check, the closure stop mount is located in a specific way depending on the closer model being adjusted.

1. For 086 Model 100 the closure stop mount is mounted as shown (Figure 3.3 upper view).

SECTION III Adjustments

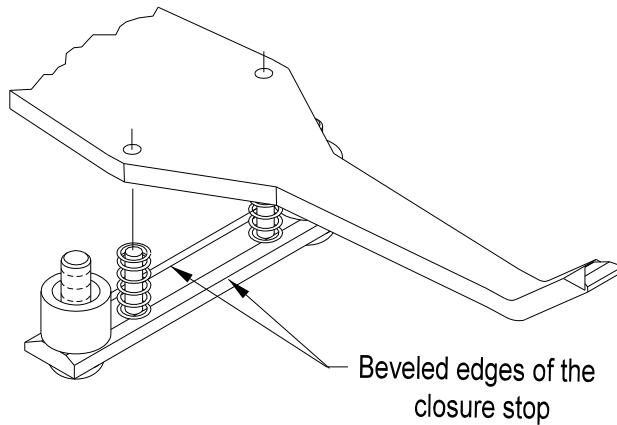


Figure 3.4

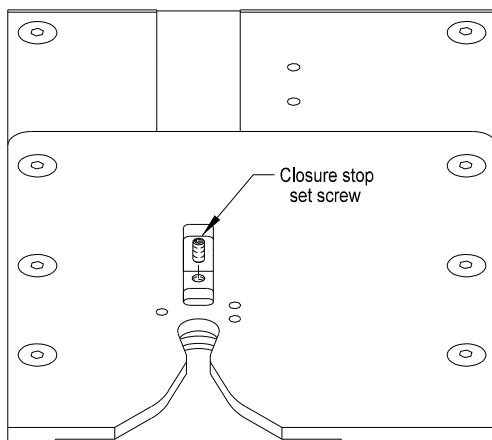


Figure 3.5

For 086 Models 200, 300, or 400, the stop mount is mounted as shown (Figure 3.3 lower view).

2. Be sure the beveled edges of the mount are against the closure stop as noted in Figure 3.4.

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

3. Slightly loosen the stop mount mounting screws.

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

F. CLOSURE STOP SET SCREW ADJUSTMENT:

When properly adjusted the closure stop setscrew sets the height of the stop so the second closure in the strip is stopped while the leading closure continues to move ahead and so is separated from the closure strip. The closure track assembly need not be removed to make this adjustment. Adjust as follows:

1. Remove any closures from the track.
2. Locate the top of the set screw (Figure 3.5).
3. Turn the set screw in or out to lower or raise the tip of the stop until it is 1/8" (3mm) below the top of the track top plate (Figure 3.6).

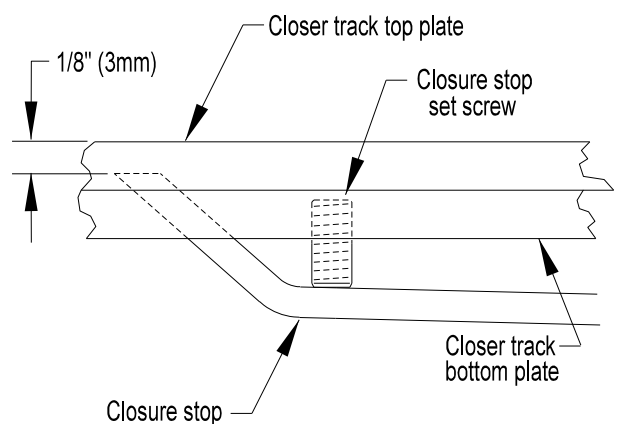


Figure 3.6

SECTION III Adjustments

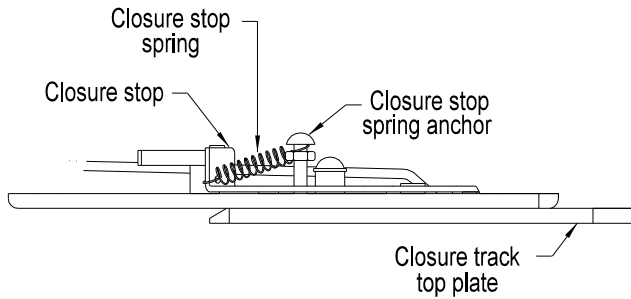


Figure 3.7

G. SENSOR LEVER SPRING:

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

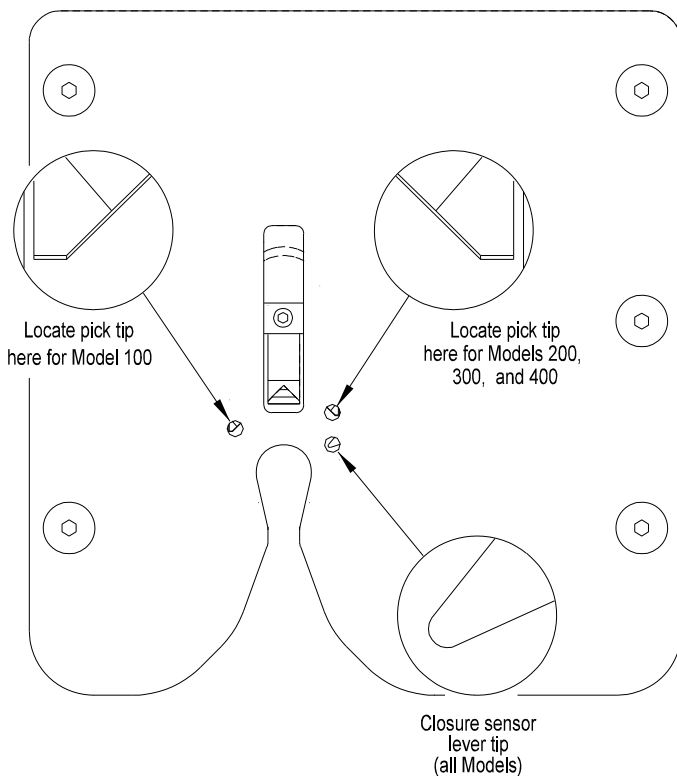


Figure 3.8

H. SENSOR LEVER STOP ADJUSTMENT (Figures 3.8 & 3.9):

The sensor lever stop is a bushing which limits the travel of the sensor lever when no closures are present. The bushing is secured under a 10-32 button head screw. There is clearance between the two so the position of the bushing can vary. When no closures are present, the sensor lever tip should be centered below the inspection hole in the top track.

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

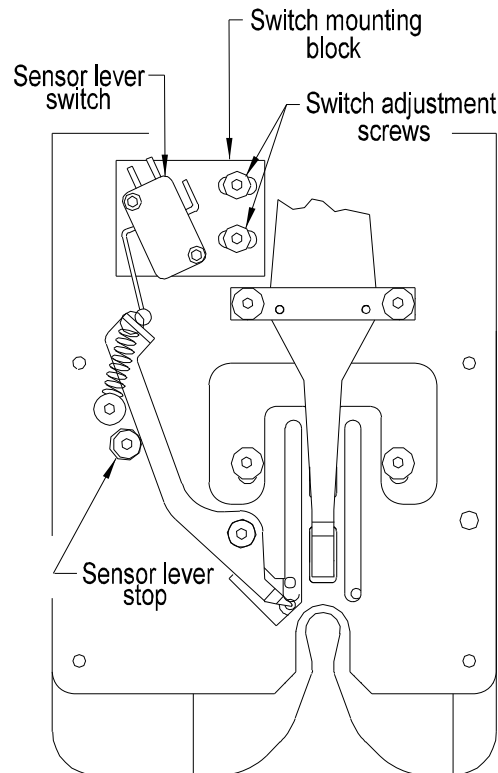


Figure 3.9

Closure track assembly as viewed from the underside.

SECTION III Adjustments

I. SENSOR SWITCH ADJUSTMENT:

The sensor switch detects whether or not there is a closure in the closing position. When a closure moves into the closing position, the sensor switch stops the motor at the end of the cycle. When the closure is removed, the switch starts the motor. The switch should turn on and off midway between the positions of the sensor lever when it is resting against the sensor lever stop and when it is resting against the side of a closure.

1. Check to see if the sensor lever stop is adjusted correctly part H above.
2. Turn the closure track upside down.
3. Feed a short strip of closures (4 or 5) through the track until the leading edge of the first closure just slides past the sensor lever then back out until the closure is free of the sensor lever. Continue to slide the strip back and forth while listening for an audible “click” indicating that the switch is turning on and off. If the strip of closures moves forward so far that it can’t back up , push it out of the front of the track and start over. Adjust if needed as follows.
4. Slightly loosen the two button head screws in the switch mounting block (Figure 3.9).
5. Move the switch assembly toward or away from the sensor lever. Listen for an audible “click” of the switch as it turns on and off.
6. Tighten the mounting screws when the switch actuates as described above.

J. MOTOR REMOVAL: (Figure 3.10):

Any time the three button head screws which are in the slots of the motor mounting plate are disturbed, the pick position must be checked. See part K this section.

The motor, motor mounting plate, cam assembly, cam switch block and accompanying limit switch can be removed and reinstalled as an assembly.

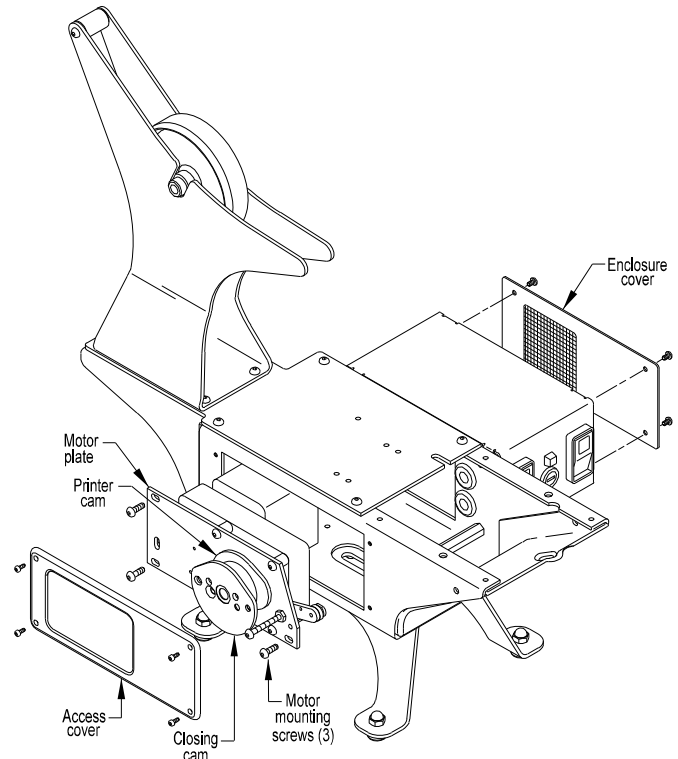


Figure 3.10

Component adjustment to this assembly can be made while the assembly is out of the frame of the closer. Remove the motor assembly as follows:

1. Disconnect power to the closer.
2. Remove the electrical enclosure cover.
3. Disconnect the two motor wires from the run switch.
4. Remove the left side access cover from the frame.
5. Remove the closure track assembly. See part A in this section.
6. Remove the top plate.
7. Disconnect the pick spring (OS-117) from the pick.

SECTION III Adjustments

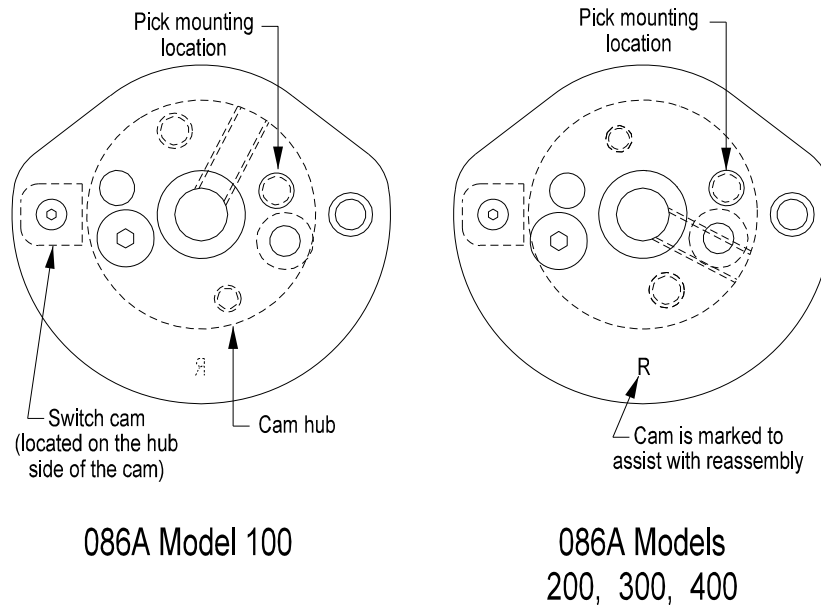


Figure 3.11

8. Disconnect the cam switch electrical leads.
9. Remove the three mounting screws from the slotted holes in the motor mounting plate. Refer to part J this section for readjustment.
10. Remove the motor assembly through the top of the closer frame.
11. To reinstall the motor assembly reverse these steps.

K. PICK / CLOSURE LOCATION:

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

1. Remove any closures from the closure track.
2. Verify that the pick is at the end of its travel. To do this plug in the closer. turn the rocker switch to "RUN" and then to "STOP". The motor will stop with the cam and pick in their proper "parked" positions.

3. With the motor stopped, disconnect the power cord.
4. Determine the correct inspection hole for the model for your closer (Figure 3.8). The tip of the pick should be visible in half of the inspection hole as shown. Reposition the pick if needed as follows:

BE SURE THE POWER IS DISCONNECTED.

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

SECTION III Adjustments

L. CAM ASSEMBLY:

The cam assembly drives the pick through its cycle and raises the closure stop at the proper time to stop the closure strip so the leading closure can be separated from the remaining strip. The closer cam fastens to the outside edge of the cam hub. The switch cam contacts the cam switch stopping the motor and cam assembly when the pick is in the parked or neutral position (Figure 3.13). The cam assembly should remain on the motor shaft with no need for adjustment. If however the cam assembly is disassembled the following information is helpful to reassemble it.

The cam is adjusted to drive either an 086A Model 100 or 086A Models 200, 300, and 400. Correct assembly of the components provide the required pick stroke so the closer functions properly. Align the cam to the hub as follows:

1. Hold the cam so the stamped letter "R" is on the correct side for your model closer as shown in the appropriate view in Figure 3.11
2. Position the hub behind the cam. Rotate the hub until one of the two 8-32 tapped holes in the hub aligns with the countersunk hole in the cam.
3. Insert the flat head screw to secure the two parts.
4. If the switch cam has been removed, remount it after the cam and hub have been connected. Square up the switch cam to the main cam hub and then tighten into place (Figure 3.12).
5. Install the cam assembly onto the motor shaft. Refer to part L below.

M. CAM ASSEMBLY LATERAL ALIGNMENT:

1. Set the lateral (side to side) position of the cam assembly so the outside edge of the closer cam measures 15/16" (24mm) from the outside edge of the motor plate (Figure 3.12).
2. Rotate the cam assembly to position the set screw over the flat on the motor shaft and tighten the set screw. The angular position of the cam assembly is not important because the motor will stop with the cam in the correct position when the switch cam contacts the limit switch.
3. Tighten the set screw.

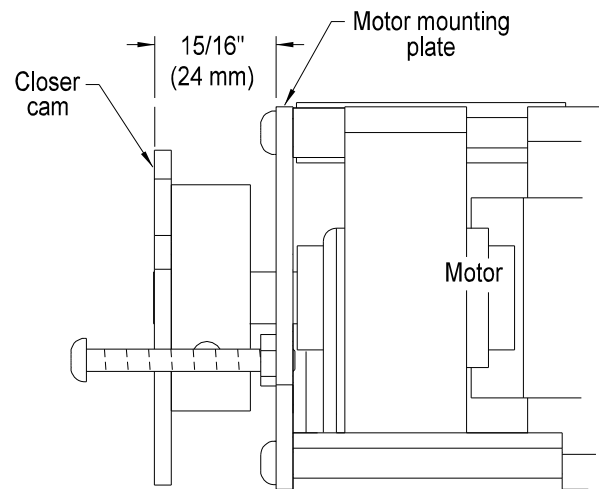


Figure 3.12

SECTION III Adjustments

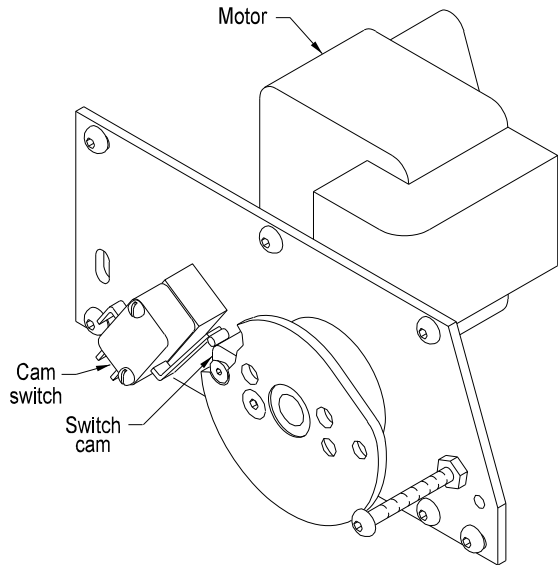


Figure 3.13

N. CAM SWITCH MOUNTING:

The cam switch allows the cam assembly to rotate and only stop when a closure reaches the bag closing position. The switch cam on the cam assembly (Figure 3.13) actuates the switch. If the rocker switch is in the "RUN" position, the "READY" light will be on while the cam switch is actuated. The cam switch should not need adjustment.

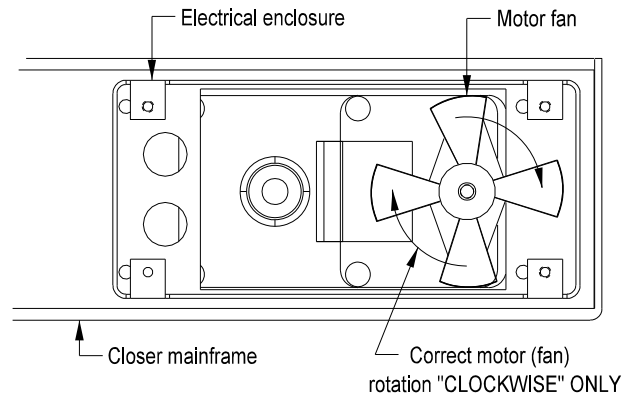


Figure 3.14

O. MOTOR ROTATION:

Inadvertently rotating the motor shaft manually can damage the cam switch (Figure 3.14). If the motor is to be manually rotated **ONLY ROTATE THE MOTOR CLOCKWISE FROM THE FAN END OF THE MOTOR**. If the motor shaft is turned in the opposite direction (counterclockwise from the fan end of the motor) the cam switch will likely be damaged.

SECTION IV Trouble Shooting

MECHANICAL TROUBLE SHOOTING

In the correction column of this section, any reference to a "part" of this manual refers to the ADJUSTMENT Section unless noted otherwise.

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

SECTION IV

Trouble Shooting

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

SECTION IV Trouble Shooting

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

PARTS ORDERING PROCEDURE

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

1) Specify on the order the **TYPE, MODEL,** and **SERIAL NUMBER** of the machine for which the parts are being ordered. This information can be found on the machine nameplate.

2) **DO NOT** order by item number. Order by **PART** or **KIT** number.

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

1) Identify the needed parts by referring to the assembly illustrations.
Each part is assigned an item number on the illustration.

2) Refer to the parts list. Locate the item number for the part to be ordered.
Opposite the item number is the part number and description for that part.

3) Again, specify on the order the **TYPE, MODEL,** and **SERIAL NUMBER** for which the parts are being ordered. This information is located on the machine nameplate.

SECTION V Parts Identification

PARTS COMMON - STANDARD

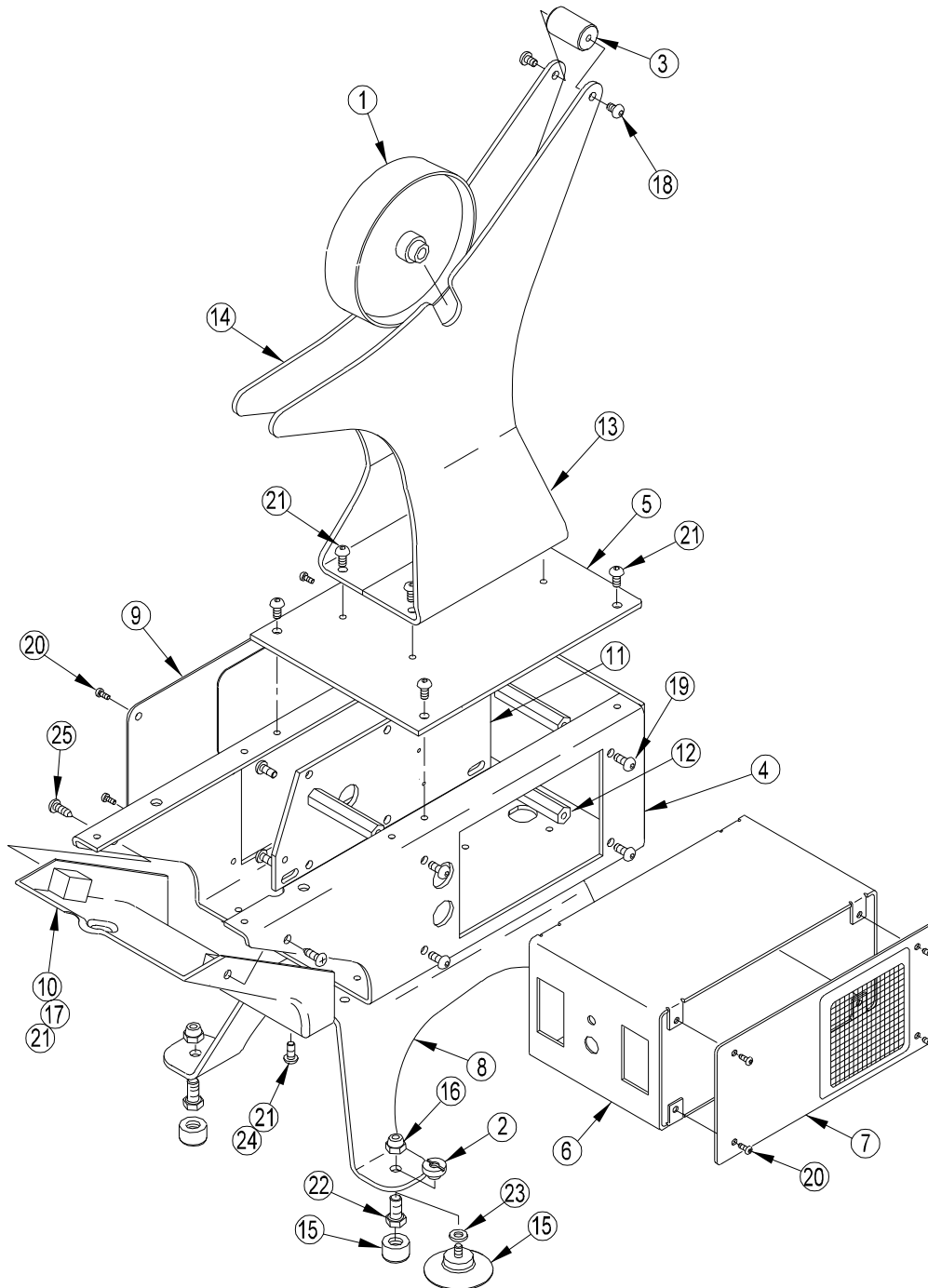


Figure 5.1

SECTION V Parts Identification

PARTS COMMON - STANDARD

(Figure 5.1)

PARTS LIST

Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	00-000594	Hub - Models 100 & 200	1	14	00-001026 L	Support - Wide - Type A	
	00-000890	Hub - Model 300	1			Model 400	1
	00-000891	Hub - Model 400	1		00-001027 L	Support - Narrow - Type A	
	00-001075	Hub - Model 500				Models 200 & 300	1
2	*00-000673	Nut	4		00-001028 L	Support - Small - Type A	
3	00-000893	Spacer - Narrow				Model 100	1
		Models 100, 200, 300	1		00-001074 L	Support - Frame - Type A	
	00-000895	Spacer - Wide - Model 400	1			Model 500	1
	00-001076	Spacer - Frame - Model 500		15	**P05-00019	Foot - Standard	4
4	00-001002	Frame - Main - Type A	1		*P05-00032	Cup - Suction	4
5	00-001006	Plate - Top - Type A	1	16	**P23-00286	Nut - Acorn	4
6	00-001304	Enclosure - Electrical - Type A	1	17	F04-190F S	Nut - 10-32UNF - Hex	2
7	00-001008	Cover - Electrical Enclosure	1	18	F11-190C06 S	Screw - 10-24UNC x 3/8 Lg	
8	00-001046	Stand - Type A	1			Skt Btn Hd	2
9	00-001010	Cover - Access	1	19	F11-190F08 S	Screw - 10-32UNF x 1/2 Lg	
10	00-001303	Shield	1			Skt Btn Hd	8
11	00-001047	Plate - Motor Mounting		20	F11-164C04S	Screw - 8-32UNC x 1/4 Lg	
		Standard	1			Skt Btn Hd	8
12	00-001017	Post - Motor Mounting	4	21	F11-190F06 S	Screw - 10-32UNF x 3/8 Lg	
13	00-001026 R	Support - Wide - Type A				Skt Btn Hd	12
		Model 400	1	22	**F13-250C06	Screw - 1/4-20UNC x 3/8 Lg	
	00-001027 R	Support - Narrow - Type A				Hex Hd	4
		Models 200 & 300	1	23	*F14-187	Washer	4
	00-001028 R	Support - Small - Type A		24	P23-00061	Nut - 10-32UNF - ESNA	2
		Model 100	1	25	P23-00291	Screw - Phillips - Self Tapping	2
	00-001074 R	Support - Frame - Type A		* These parts are available in kit Z0065004 Kit - Suction Cups and may be ordered as such.			
		Model 500	1	** These parts are available in kit Z0065006 Kit - Feet and may be ordered as such.			

SECTION V

Parts Identification

PARTS COMMON - STAINLESS STEEL

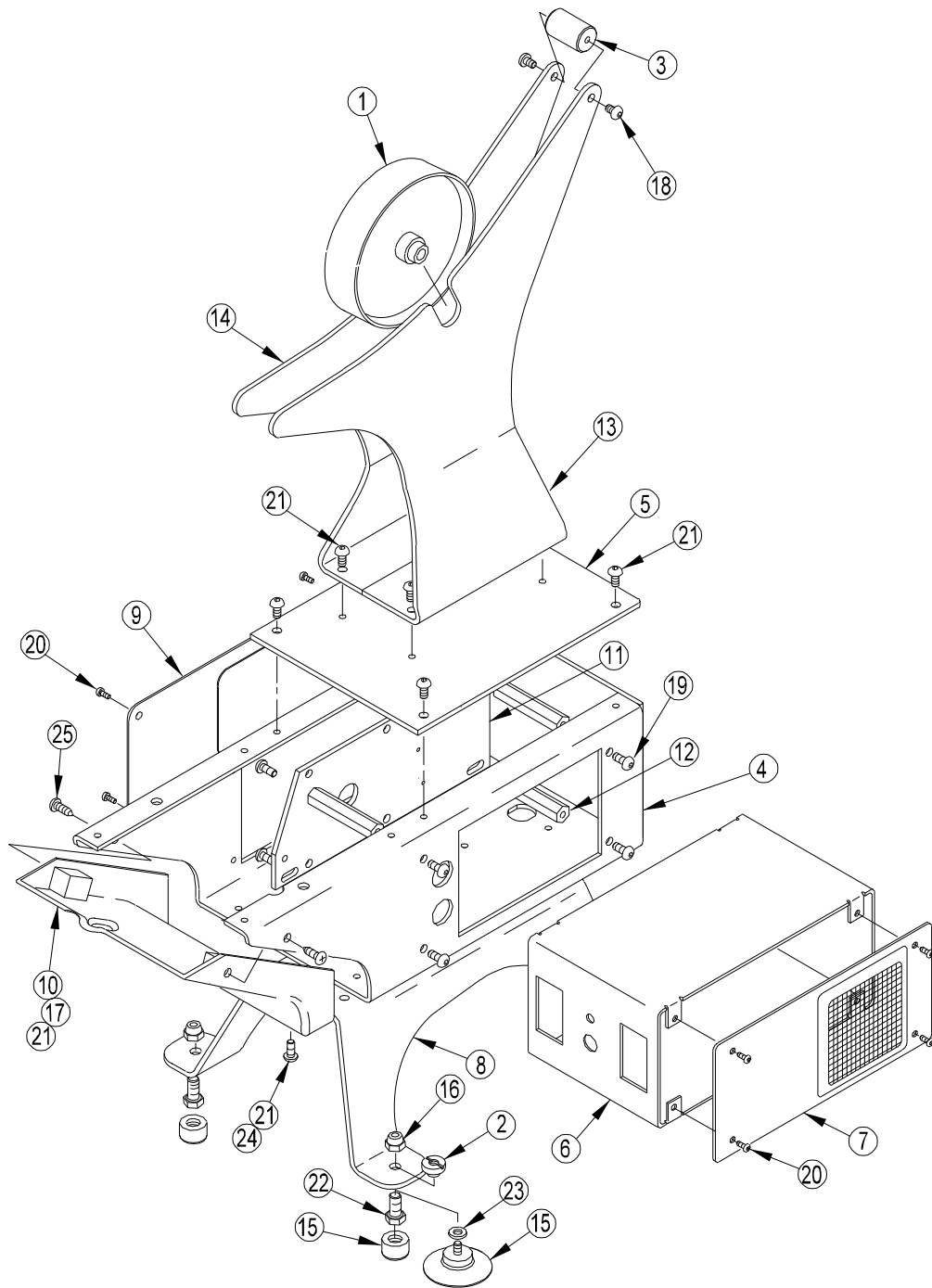


Figure 5.2

SECTION V Parts Identification

PARTS COMMON - STAINLESS STEEL

(Figure 5.2)

PARTS LIST

Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	00-000594	Hub - Models 100 & 200	1	14	00-001026SL	Support - Wide - Type AS	
	00-000890	Hub - Model 300	1			Model 400	1
	00-000891	Hub - Model 400	1		00-001027SL	Support - Narrow - Type AS	
	00-001075	Hub - Model 500				Models 200 & 300	1
2	*00-000673	Nut	4		00-001028SL	Support - Small - Type AS	
3	00-000893	Spacer - Narrow				Model 100	1
		Models 100, 200, 300	1		00-001074SL	Support - Frame - Type AS	
	00-000895	Spacer - Wide - Model 400	1			Model 500	1
	00-001076	Spacer - Frame - Model 500		15	**P05-00019	Foot - Standard	4
4	00-001002S	Frame - Main - Type AS	1		*P05-00032	Cup - Suction	4
5	00-001006S	Plate - Top - Type AS	1	16	**P23-00286	Nut - Acorn	4
6	00-001304S	Enclosure - Type AS	1	17	F04-190F S	Nut - 10-32UNF - Hex	2
7	00-001008	Cover - Electrical Enclosure	1	18	F11-190C06 S	Screw - 10-24UNC x 3/8 Lg	
8	00-001046S	Stand - Type AS	1			Skt Btn Hd	2
9	00-001010	Cover - Access	1	19	F11-190F08 S	Screw - 10-32UNF x 1/2 Lg	
10	00-001303	Shield - Gray	1			Skt Btn Hd	8
11	00-001047	Plate - Motor Mount	1	20	F11-164C04 S	Screw - 8-32UNC x 1/4 Lg	
12	00-001017	Post - Motor Mount	4			Skt Btn Hd	8
13	00-001026SR	Support - Wide - Type AS		21	F11-190F06 S	Screw - 10-32UNF x 3/8 Lg	
		Model 400	1			Skt Btn Hd	12
	00-001027SR	Support - Narrow - Type AS		22	**F13-250C06	Screw - 1/4-20UNC x 3/8 Lg	
		Models 200 & 300	1			Hex Hd	4
	00-001028SR	Support - Small - Type AS		23	*F14-187	Washer	4
		Model 100	1	24	P23-00061	Nut - 10-32UNF - ESNA	2
	00-001074SR	Support - Frame - Type AS		25	P23-00291	Screw - Phillips - Self Tapping	2
		Model 500	1				

* These parts are available in Kit Z0065004 - Suction Cups and may be ordered as such.

** These parts are available in Kit Z0065006 - Feet and may be ordered as such.

SECTION V

Parts Identification

PARTS COMMON 2

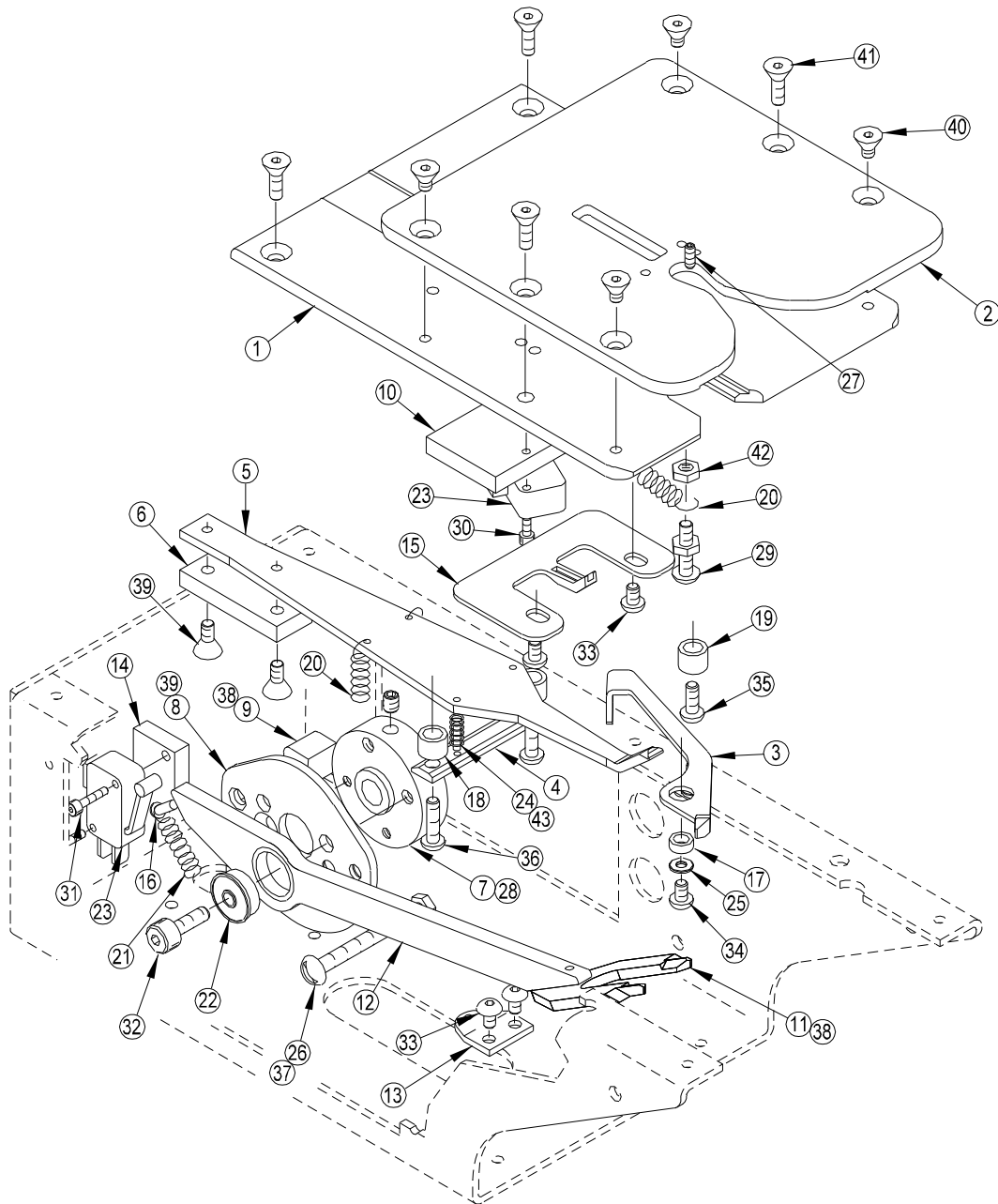


Figure 5.3

SECTION V Parts Identification

PARTS COMMON 2

(Figure 5.3)

PARTS LIST

Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	00-001041	Track - Bottom	1	28	F06-190C06	Screw - 1/4-20UNC x 3/8 Lg	
2	00-001004	Track - Top				Skt - Set	1
		Models - 300 & 400	1	29	F07-164C10S	Screw - 8-32UNC x 5/8" Lg	
	00-001005	Track - Top				Mach Hd	1
		Models 100 & 200	1	30	F10-112C10S	Screw - 4-40UNC x 5/8 Lg	
3	00-001012	Lever - Sensor	1			Skt Hd Cap	2
4	00-001013	Mount - Stop	1	31	F10-112C16S	Screw - 4-40UNC x 1" Lg	
5	00-001014	Stop - Closure	1			Skt Hd Cap	2
6	00-001015	Strip - Wear	1	32	F10-250C12	Screw - 1/4-20UNC x 3/4 Lg	
7	00-001018	Hub - Cam	1			Skt Hd Cap	1
8	00-001019	Cam	1	33	F11-190F04S	Screw - 10-32UNF x 1/4 Lg	
9	00-001020	Cam - Switch	1			Skt Btn Hd	2
10	00-001021	Block - Sensor Switch	1	34	F11-190F05S	Screw - 10-32UNF x 5/16 Lg	
11	00-001022	Pick	1			Skt - Btn Hd	1
12	00-001023	Arm - Pick	1	35	F11-190F07S	Screw - 10-32UNF x 7/16 Lg	
13	00-001024	Anchor - Pick Spring	1			Skt Btn Hd	1
14	00-001025	Block - Cam Switch	1	36	F11-190F10S	Screw - 10-32UNF x 5/8 Lg	
15	00-001029	Check	1			Skt Btn Hd	2
16	08-002026	Pin - Drive	1	37	F07-190F28S	Screw - 10-32UNF x 1 3/4	
17	BS312203125	Bushing	1			Mach Hd	1
18	BS375203375	Bushing	2	38	F12-138C06S	Screw - 6-32UNC x 3/8 Lg	
19	BS375257281	Bushing	1			Skt Flt Hd	3
20	OS-012	Spring	3	39	F12-164C06S	Screw - 8-32UNC x 3/8 Lg	
21	OS-117	Spring - Pick	1			Skt Flt Hd	3
22	P02-00064	Bearing - Pick	1	40	F12-190F06S	Screw - 10-32UNF x 3/8 Lg	
23	P12-00085	Switch - Limit	2			Skt Flt Hd	4
24	P23-00169	Pin - Drive	2	41	F12-190F10S	Screw - 10-32UNF x 5/8 Lg	
25	F01-190S	Washer - No. 10 - Flat	1			Skt Flt Hd	4
26	F03-190FS	Nut - 10-32UNF - Hex	4	42	F03-164C	Nut - 8-32UNC - Hex	2
27	F06-164C05	Screw - 8-32UNC x 5/16 lg		43	OS-118	Spring	2
		Skt Set	1				

SECTION V Parts Identification

ELECTRICAL COMPONENTS

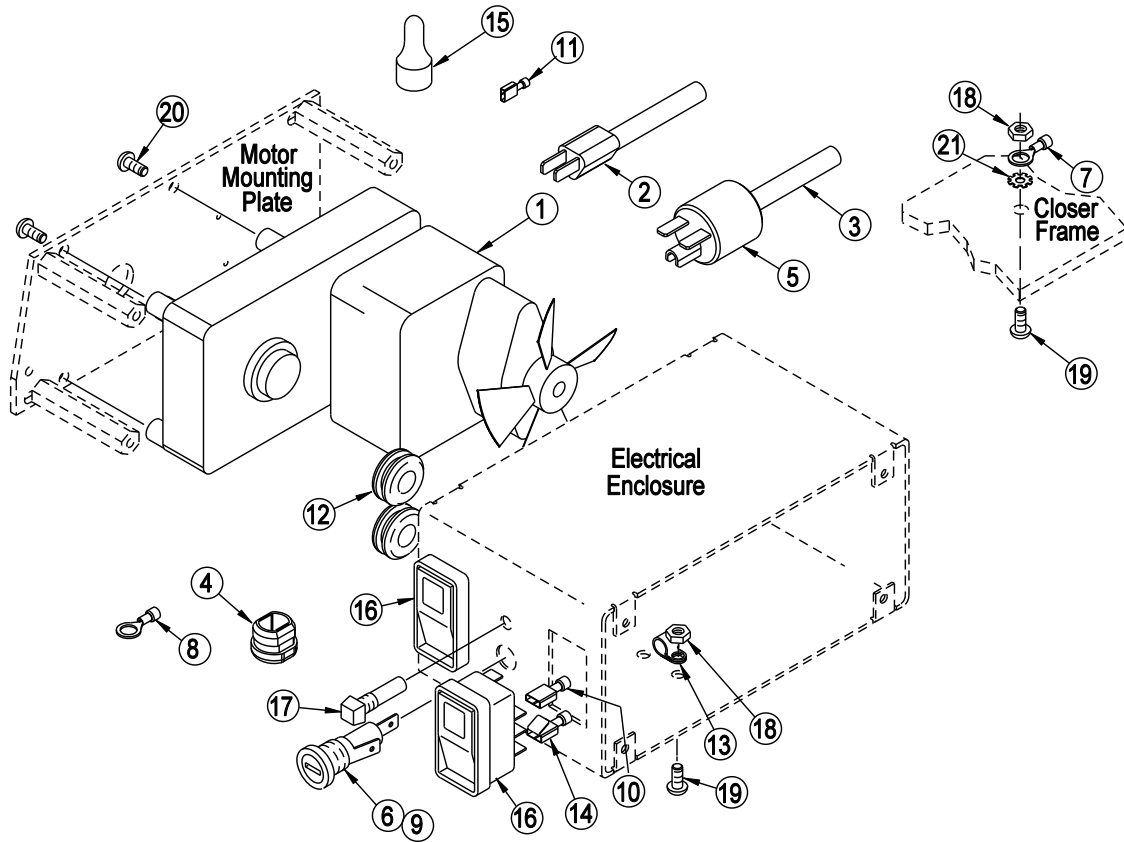
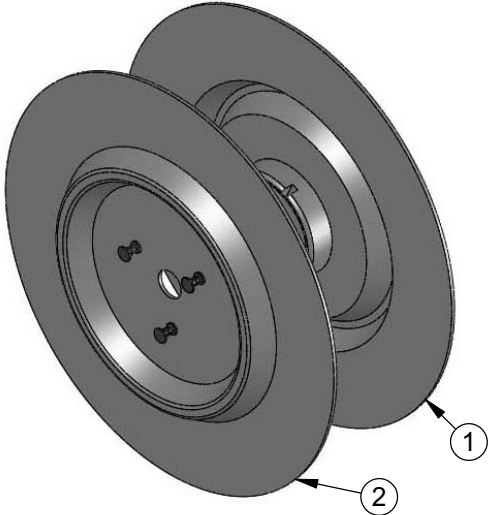
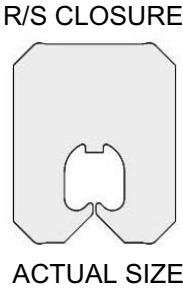


Figure 5.4

Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	00-001000	Motor - 115VAC	1	10	P11-00274	Terminal - Spade	11
	00-001001	Motor - 220-250VAC	1	11	P11-00323	Terminal - Spade	4
2	P11-00064	Cord - Motor - 115VAC	1	12	P11-00478	Grommet	2
3	P11-00019	Cord - Motor - 220-250VAC	1	13	P11-00485	Clamp - Cord	1
	P11-00736	Cord - Motor - 220-250VAC International - 72"	1	14	P11-00588	Terminal - Piggy Back	3
4	P11-00031	Strain Relief - 220-250VAC	1	15	P11-00812	Joint - Wire	1
	P11-00665	Strain Relief - 115VAC	1	16	P12-00287	Switch - Rocker - 115VAC	1
5	P11-00033	Plug - Motor - 220-250VAC	1		P12-00288	Switch - Rocker - 220-250VAC	1
6	P11-00042	Holder - Fuse	1	17	P12-00193	Light - 115VAC	1
7	P11-00144	Terminal - Closed	1		P12-00194	Light - 220-250VAC	1
8	P11-00221	Terminal - Closed Loop	1	18	F03-190FS	Nut - 10-32UNF - Hex	2
9	P11-00270	Fuse - 115VAC	1	19	F11-190F06S	Screw - 10-32UNF x 3/8 Lg	2
	P11-00616	Fuse - 220 - 250VAC	1			Skt Btn Hd	2
				20	F11-190C06S	Screw - 10-24UNC x 3/8 Lg	4
						Skt Btn Hd	4
				21	F17-190S	Washer - Star	1

SECTION V Parts Identification

Z0083003 KIT - R/S CARTRIDGE

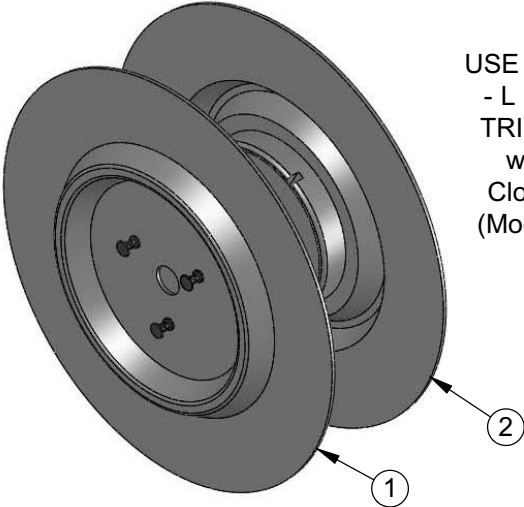
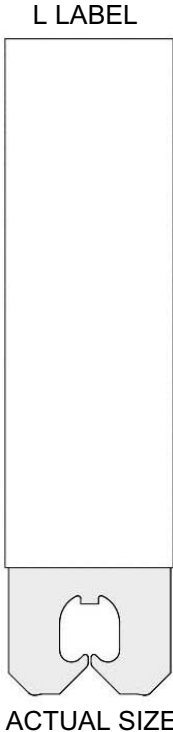


USE Z0083003 KIT - R/S Lok Cartridge and 00-001005 Track - Top - Models 100 AND 200 to close with series R or S Closures (Model 400 only).

Figure 5.5

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	00-000907	HUB UNIT - LOK CARTRIDGE	1
2	00-000908	PLATE UNIT - LOK CARTRIDGE	1

Z0083004 KIT - L LABEL CARTRIDGE



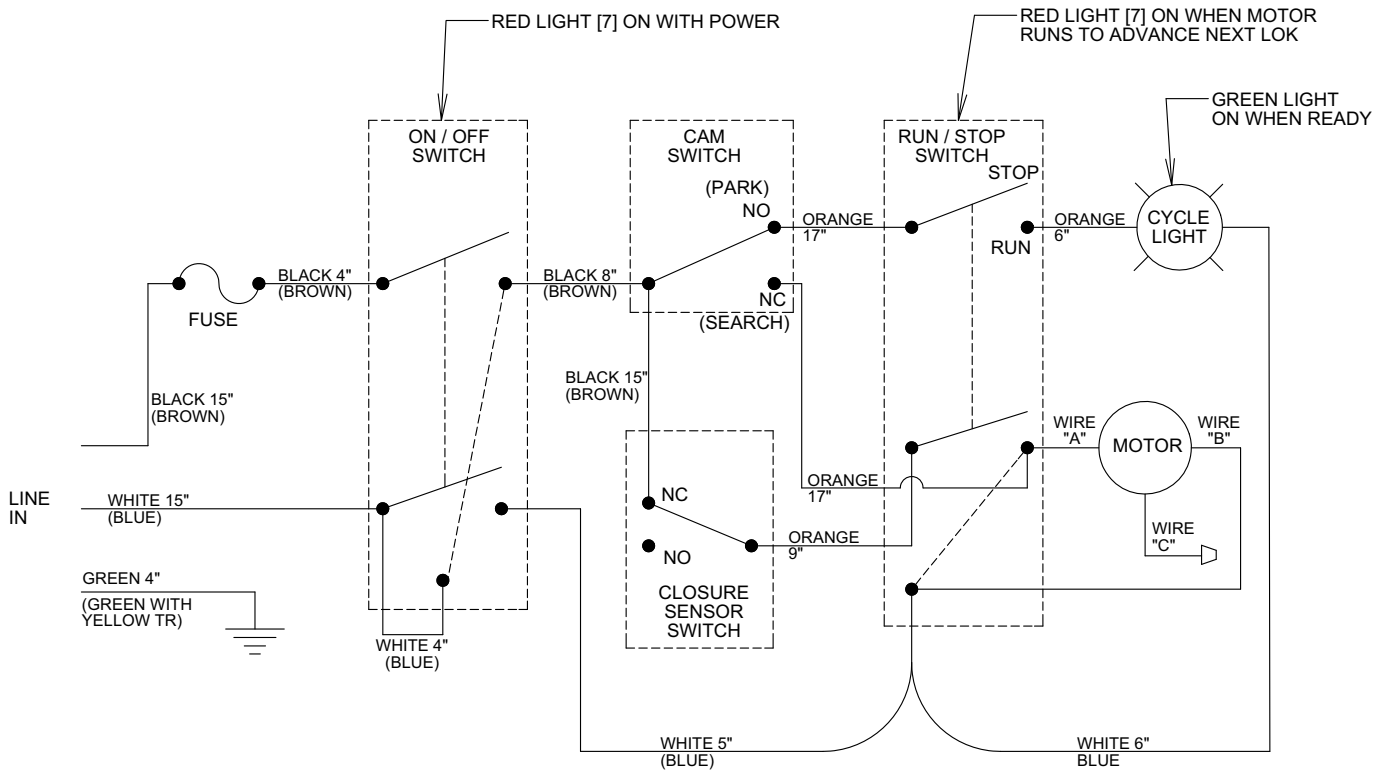
USE Z0083004 KIT - L LABEL CARTRIDGE to close with series L Closure - labels (Model 400 only).

Figure 5.6

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	00-000908	PLATE UNIT - LOK CARTRIDGE	1
2	00-000909	HUB UNIT - LABEL CARTRIDGE	1

SECTION VI Wiring Diagram

086 WIRING DIAGRAM



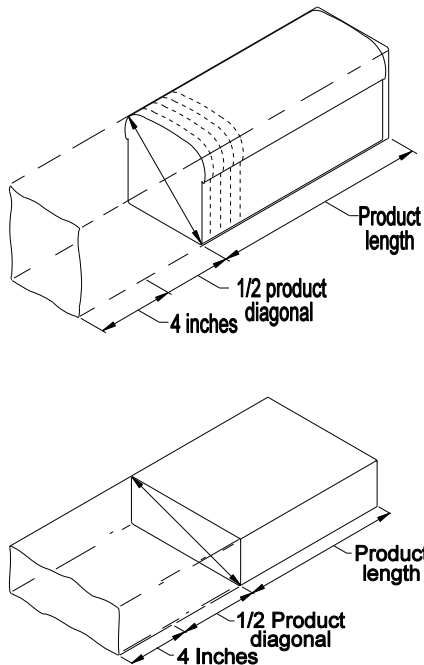
NOTES: ALL WIRE 20 GA EXCEPT
LINE IN CORD
WIRE COLOR IN ()
FOR INTERNATIONAL ONLY

MOTOR WIRING			
LINE VOLTAGE	WIRE "A"	WIRE "B"	WIRE "C"
115V	BLACK	BLACK	-----
220 - 230 V	BLACK	WHITE	RED
240 - 250 V	RED	WHITE	BLACK

Figure 6.1

APPENDIX

BAG LENGTH FORMULAS



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

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

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

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



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

APPENDIX

BAGNECK TRIMMER OPERATION AND MAINTENANCE



Figure A.1



Figure A.2

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

A. BAGNECK TRIMMER OPERATION:

To operate the trimmer follow these suggestions.

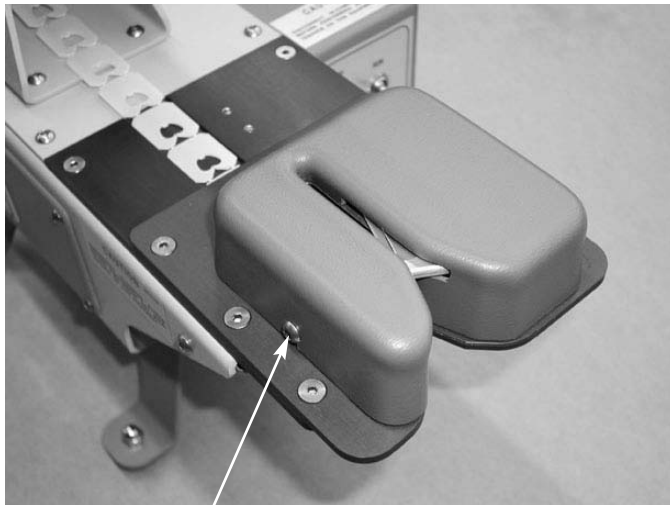
1. Grasp the product with one hand at the base of the bagneck nearest the product. Grasp the top of the bag with the other.
2. Insert the top of the bagneck into the end of the trimmer slot first slightly ahead of the lower part of the bagneck (Figure A.1). Be sure the shear blade swivels into the shearing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



Figure A.3



Figure A.4



Guard mounting screws (2)

Figure A.5

Shear blade in operating position

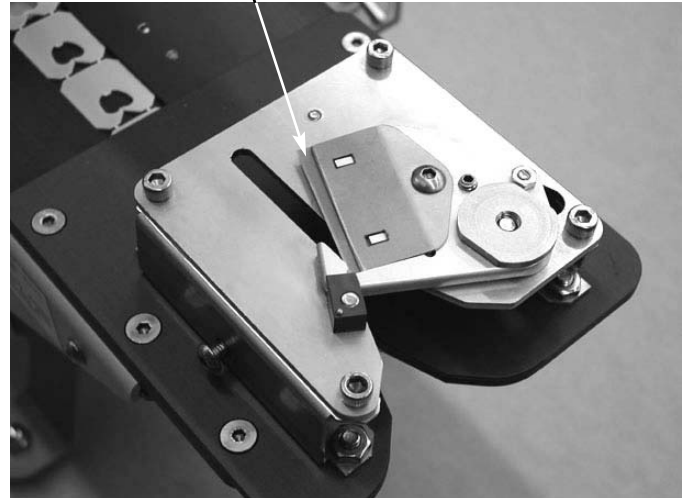


Figure A.6
(cover removed)

B. REMOVE THE TRIMMER GUARD: (Figure A.5 & A.6)

1. Loosen the two guard mounting screws located on the side of the trimmer assembly.
2. Use the end of a pencil to push the front of the carriage backward away from the front of the closer and lift the trimmer cover off. This exposes the trimmer shear blade (Figure A.6).

3. Replace the guard and tighten the mounting screws.

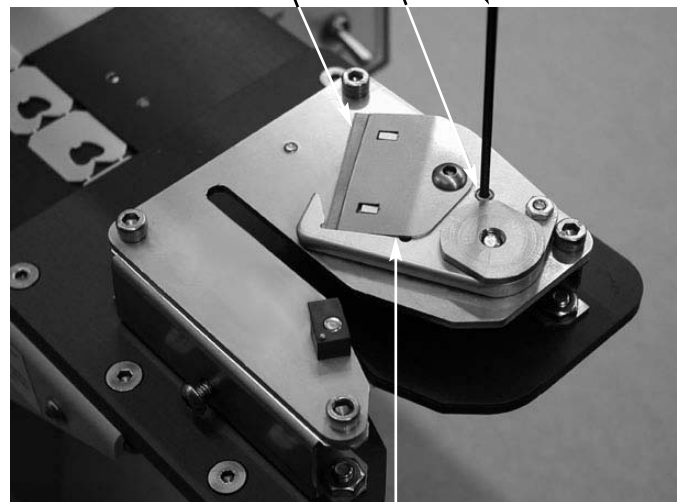
CAUTION: THE SHEAR BLADE IS MADE OF A CERAMIC MATERIAL AND IS EXTREMELY SHARP. EXTRA CARE SHOULD BE TAKEN TO ENSURE THE SAFE HANDLING OF THIS BLADE.

C. SHEAR BLADE “LOCKOUT”

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

1. Remove the trimmer guard as described in “B” above.
2. Carefully swivel the blade assembly fully open and turn the set screw into the carriage until it is flush with the top of the hole (Figure A.7). The blade assembly is now in the locked out position.

Lockout set screw
Shear blade in “lockout” position
Allen wrench



Blade retainer

Figure A.7

APPENDIX

D. REMOVING AND INSTALLING A NEW BLADE (Figures A.7 & A.8):

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

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

The shear blade is double edged. When in the operating position only one half of one edge of the blade is used to shear the bag. The shear blade can be mounted in four different positions to get the most out of a single blade. To keep track of the used blade positions use a felt pen to mark the used portion and or side of the blade being changed (Figure A.8).

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

Mark used portion of blade.



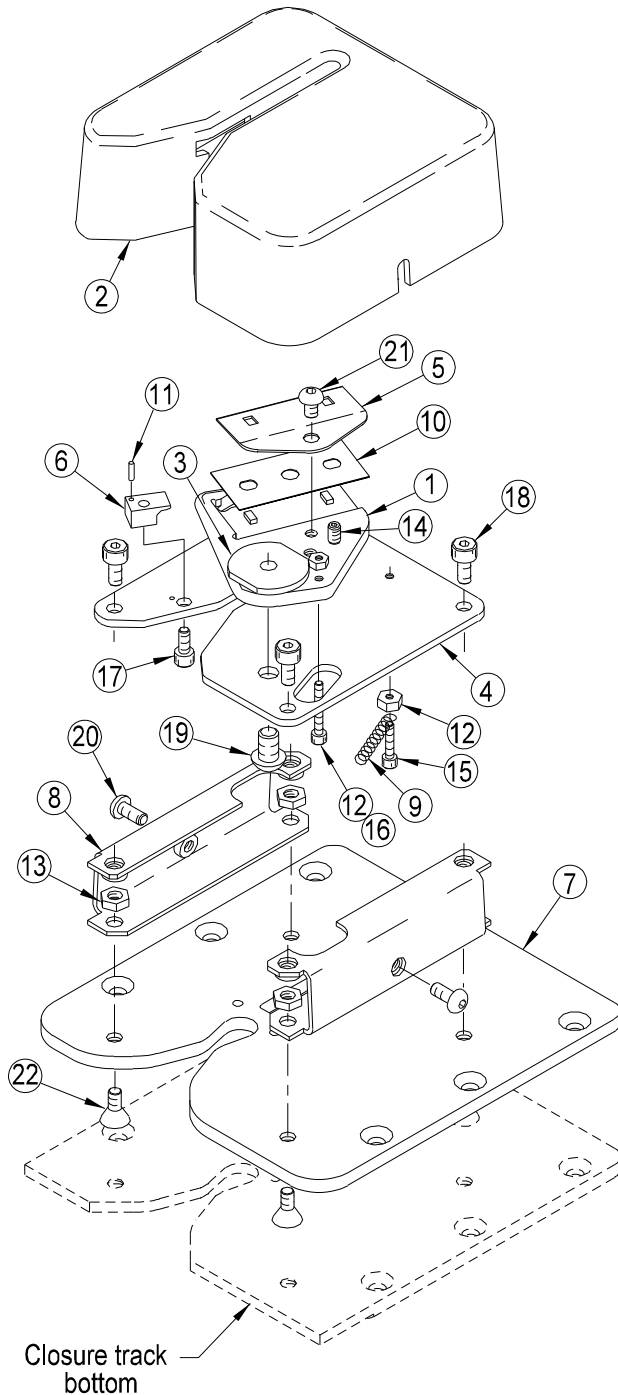
Figure A.8

Use thumb and forefinger to safely replace shear blade.

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

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

KIT Z0086007 - TRIMMER - BAG NECK LOK KIT Z0086008- TRIMMER - BAG NECK LABEL



PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-001030	Carriage - Blade	1
2	00-001031	Guard	1
3	00-001033	Pivot - Carriage	1
4	00-001034	Plate - Shear Blade	1
5	00-001035	Retainer - Blade	1
6	00-001036	Stop - Carriage	1
7	00-001037	Track - Top - Lok	1
	00-001040	Track - Top Label	1
8	00-001039	Mount	2
9	OS-082	Spring	1
10	P17-00123	Blade - Shear	1
11	P23-00216	Pin - 1/16 x 1/4	1
12	P23-00262	Nut - 6-32UNC x 1/4" Hex	2
13	F03-190FS	Nut - 10-32UNF - Hex	4
14	F06-190C04N	Screw - 10-24UNC x 1/4 Lg Skt Set	1
15	F10-138C08S	Screw - 6-32UNC x 1/2 Lg Skt Hd Cap	1
16	F10-138C12S	Screw - 6-32UNC x 3/4 Lg Skt Hd Cap	1
17	F10-164C06S	Screw - 8-32UNC x 3/8 Lg Skt Hd Cap	1
18	F10-190F06S	Screw - 10-32UNF x 3/8 Lg Skt Hd Cap	4
19	F10-250F06	Screw - 1/4-28UNF x 3/8 Lg Skt Hd Cap	1
20	F11-190F06S	Screw - 10-32UNF x 3/8 Lg Skt Btn Hd	2
21	F11-190C03S	Screw - 10-24UNC x 3/16 Lg Skt Btn Hd	1
22	F12-190F06S	Screw - 10-32UNF x 3/8 Lg Skt Flt Hd	4

APPENDIX



Kwik Lok® CORPORATION

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

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

FAX: (509) 457-6531

Internet: www.kwiklok.com

SUGGESTED SPARE PARTS INVENTORY FOR THE TYPE 086A CLOSER

Part no.	Description	Qty.
OS-012	Spring	2
OS-117	Spring	1
OS-118	Spring	2
P11-00270	Fuse - 115VAC	5
P11-00616	Fuse - 220 - 250VAC	5
P12-00085	Switch - Limit	1

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

**CONTACT THE FACTORY FOR
CURRENT PRICES.**

Kwik Lok WARRANTY POLICY

Seller warrants that the equipment shall be free of defective workmanship or materials, its obligation under this warranty to consist exclusively of repairing or replacing, free of charge f. o. b. its factory, any parts received at its factory within two years from the date of shipment of the respective equipment or parts alleged to be defective and determined by Seller upon inspection to be defective. No other warranty, expressed or implied, as to description, quality, merchantability, fitness for a particular purpose, or any other matter is given by Seller in connection with this sale. Under no circumstances shall Seller be liable for loss or profits or other consequential damages, or for any other direct or indirect costs, expenses, equipment or any part thereof. Neither shall the Seller be liable for any defects attributable to the use of any parts, supplies or service not manufactured, supplied or provided by the Seller.

Electric motors and controls carry a one year warranty in which motors or controls will be repaired and returned to the Buyer at no charge if the manufacturer determines the equipment to be defective in workmanship and / or materials.

KWIK LOK CORPORATION RETURNED MATERIALS AUTHORIZATION POLICY AND PROCEDURES

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

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

