

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

TYPE	MODEL	SERIAL NO.
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086A and 086AS CLOSER

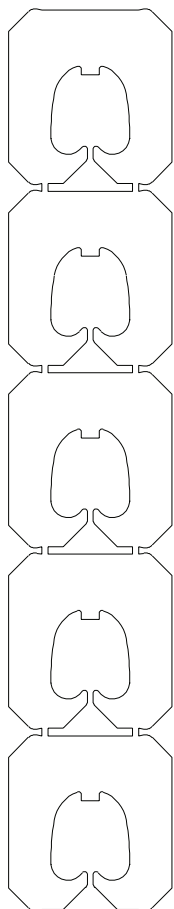
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GENERAL SAFETY INFORMATION

Be sure the following safety instructions are read, understood and become a part of daily practice when operating or maintaining the 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, 1.2 amp, single phase
220 - 240VAC, 50 Hz, .38 amp, single phase
3. The model 086AS is a stainless steel version of the 086 bag closer.

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.

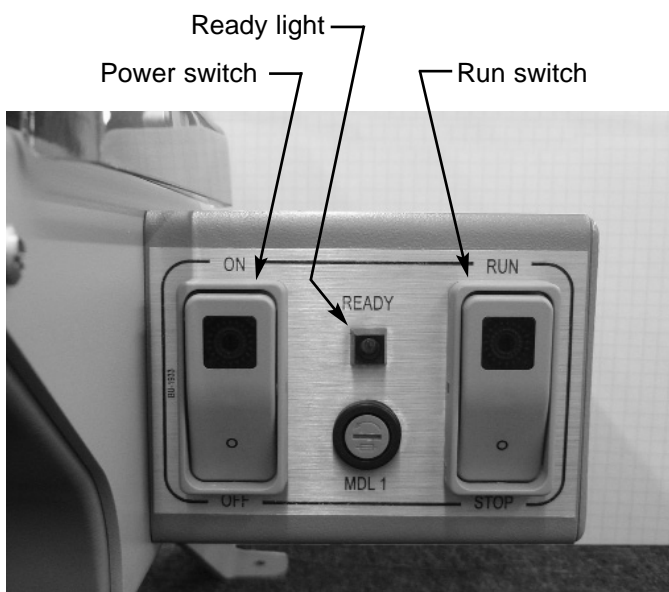


Figure 2.1

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 load.

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

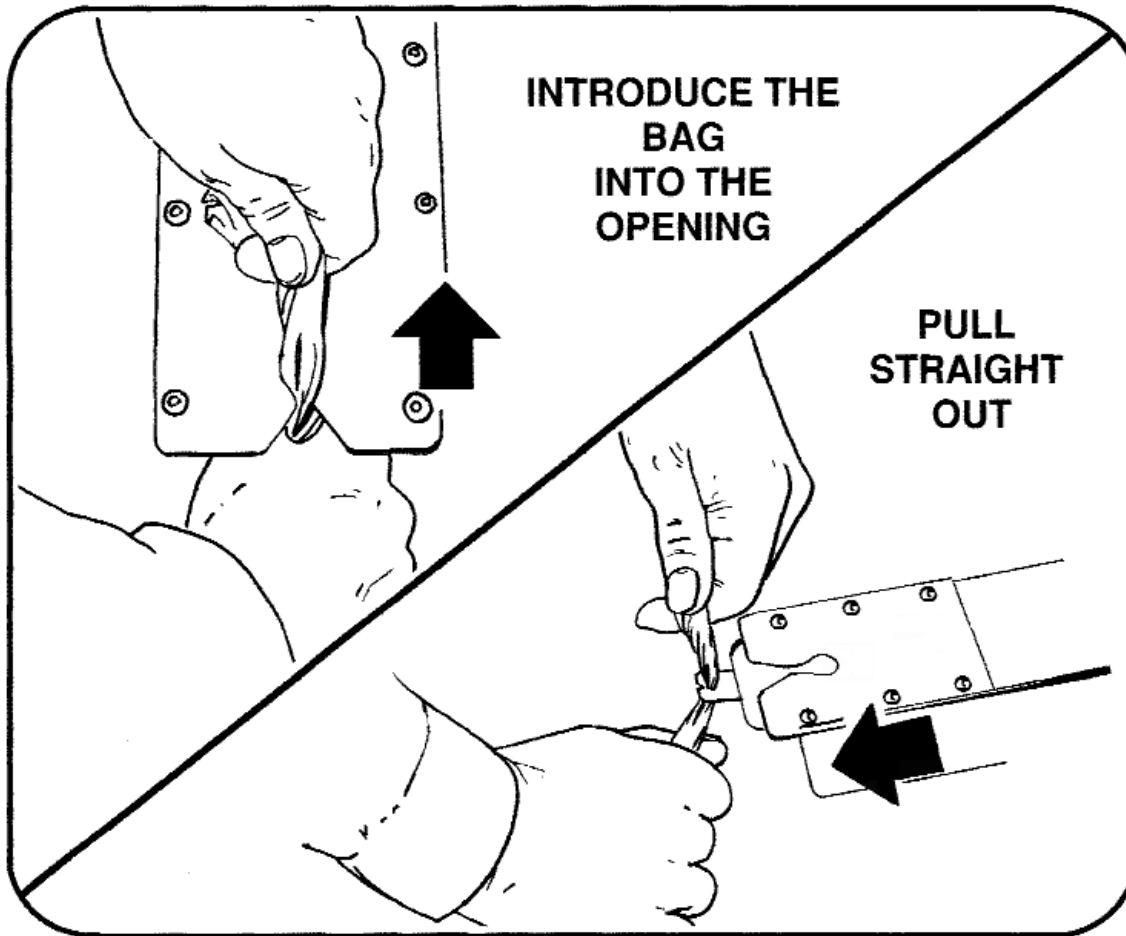


Figure 2.2

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.

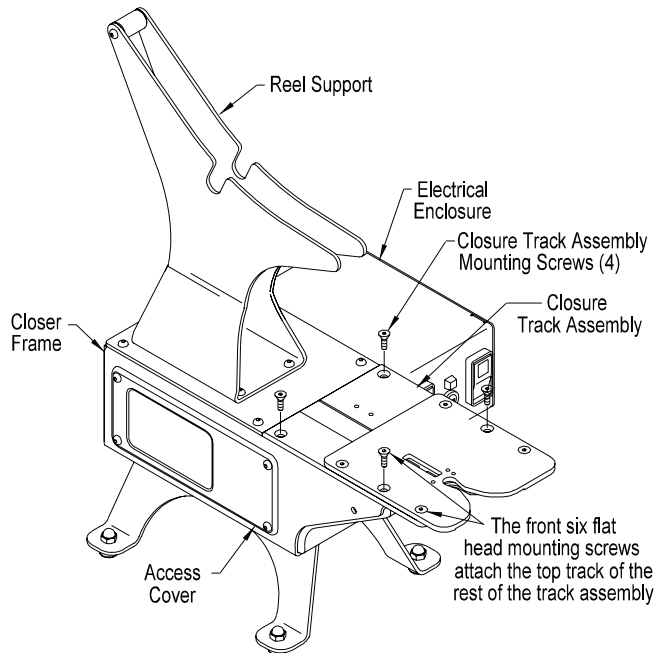


Figure 3.1

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.

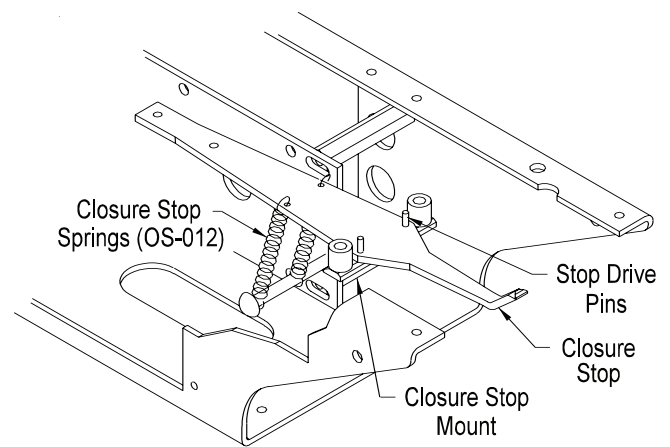


Figure 3.2

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 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.	A. The wrong closures are being used.	The 086A is available in four models. Refer to the Section I Specifications to determine the correct closure for your model closer.
	B. The check is not adjusted properly.	See Part C. REMOVE THE FRONT SHEILD and Part D. CHECK POSITION.
	C. The pick does not advance the closure.	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.
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

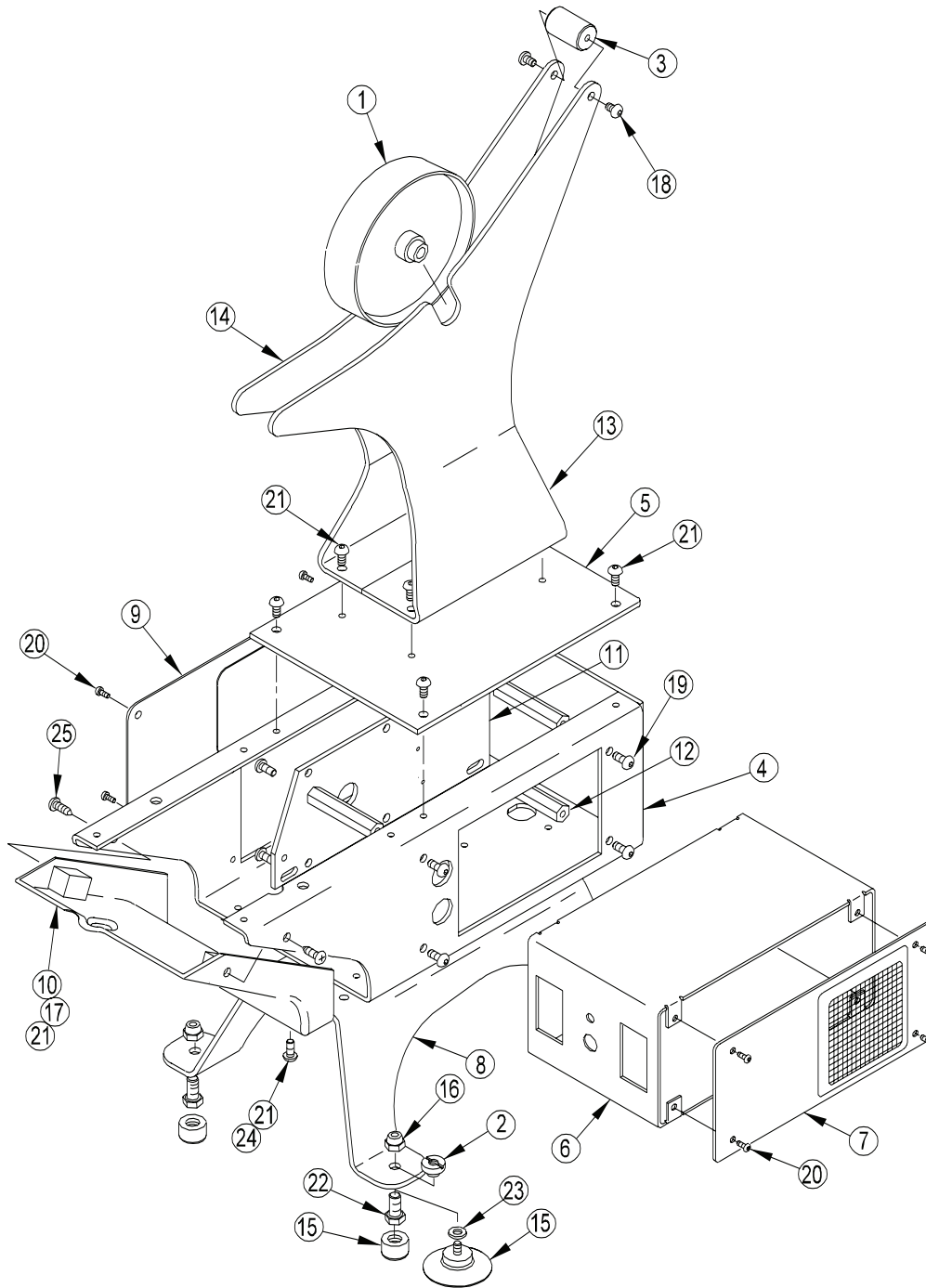


Figure 5.1

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 Model 400	1
	00-000890	Hub - Model 300	1		00-001027 L	Support - Narrow - Type A Models 200 & 300	1
	00-000891	Hub - Model 400	1		00-001028 L	Support - Small - Type A Model 100	1
	00-001075	Hub - Model 500	1		00-001074 L	Support - Frame - Type A Model 500	1
2	*00-000673	Nut	4	15	**P05-00019	Foot - Standard	4
3	00-000893	Spacer - Narrow Models 100, 200, 300	1		*P05-00032	Cup - Suction	4
	00-000895	Spacer - Wide - Model 400	1	16	**P23-00286	Nut - Acorn	4
	00-001076	Spacer - Frame - Model 500	1		17	F04-190F S	Nut - 10-32UNF - Hex
4	00-001002	Frame - Main - Type A	1	18	F11-190C06 S	Screw - 10-24UNC x 3/8 Lg Skt Btn Hd	2
5	00-001006	Plate - Top - Type A	1		19	F11-190F08 S	Screw - 10-32UNF x 1/2 Lg Skt Btn Hd
6	00-001304	Enclosure - Electrical - Type A	1	20	F11-164C04S	Screw - 8-32UNC x 1/4 Lg Skt Btn Hd	8
7	00-001008	Cover - Electrical Enclosure	1		21	F11-190F06 S	Screw - 10-32UNF x 3/8 Lg Skt Btn Hd
8	00-001046	Stand - Type A	1	22	**F13-250C06	Screw - 1/4-20UNC x 3/8 Lg Hex Hd	4
9	00-001010	Cover - Access	1		23	*F14-187	Washer
10	00-001303	Shield	1	24	P23-00061	Nut - 10-32UNF - ESNA	2
11	00-001047	Plate - Motor Mounting Standard	1	25	P23-00291	Screw - Phillips - Self Tapping	2
		Post - Motor Mounting	4				
13	00-001026 R	Support - Wide - Type A Model 400	1	<p>* These parts are available in kit Z0065004 Kit - Suction Cups and may be ordered as such.</p> <p>** These parts are available in kit Z0065006 Kit - Feet and may be ordered as such.</p>			
	00-001027 R	Support - Narrow - Type A Models 200 & 300	1				
	00-001028 R	Support - Small - Type A Model 100	1				
	00-001074 R	Support - Frame - Type A Model 500	1				

SECTION V

Parts Identification

PARTS COMMON - STAINLESS STEEL

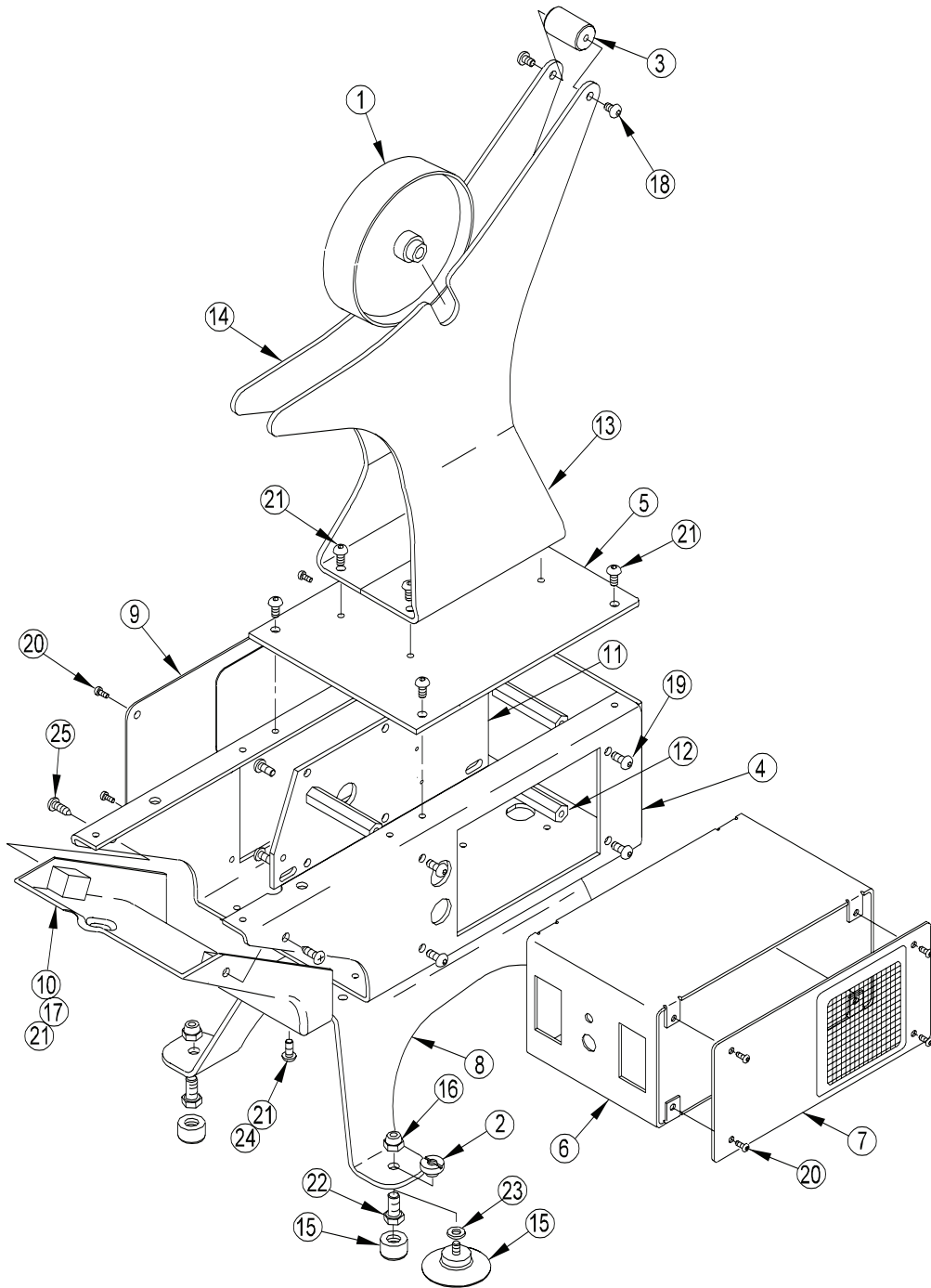


Figure 5.2

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 Model 400	1	
	00-000890	Hub - Model 300	1		00-001027SL	Support - Narrow - Type AS Models 200 & 300	1	
	00-000891	Hub - Model 400	1			00-001028SL	Support - Small - Type AS Model 100	1
	00-001075	Hub - Model 500	1		00-001074SL		Support - Frame - Type AS Model 500	1
2	*00-000673	Nut	4	15		**P05-00019	Foot - Standard	4
	3	00-000893	Spacer - Narrow Models 100, 200, 300		1	*P05-00032	Cup - Suction	4
00-000895		Spacer - Wide - Model 400	1	16	**P23-00286	Nut - Acorn	4	
00-001076		Spacer - Frame - Model 500	1		17	F04-190F S	Nut - 10-32UNF - Hex	2
4	00-001002S	Frame - Main - Type AS	1	18		F11-190C06 S	Screw - 10-24UNC x 3/8 Lg Skt Btn Hd	2
5	00-001006S	Plate - Top - Type AS	1		19	F11-190F08 S	Screw - 10-32UNF x 1/2 Lg Skt Btn Hd	8
6	00-001304S	Enclosure - Type AS	1	20		F11-164C04 S	Screw - 8-32UNC x 1/4 Lg Skt Btn Hd	8
7	00-001008	Cover - Electrical Enclosure	1		21	F11-190F06 S	Screw - 10-32UNF x 3/8 Lg Skt Btn Hd	12
8	00-001046S	Stand - Type AS	1	22		**F13-250C06	Screw - 1/4-20UNC x 3/8 Lg Hex Hd	4
9	00-001010	Cover - Access	1		23	*F14-187	Washer	4
10	00-001303	Shield - Gray	1	24		P23-00061	Nut - 10-32UNF - ESNA	2
11	00-001047	Plate - Motor Mount	1		25	P23-00291	Screw - Phillips - Self Tapping	2
12	00-001017	Post - Motor Mount	4					
	13	00-001026SR	Support - Wide - Type AS Model 400	1				
		00-001027SR	Support - Narrow - Type AS Models 200 & 300	1				
		00-001028SR	Support - Small - Type AS Model 100	1				
00-001074SR		Support - Frame - Type AS 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

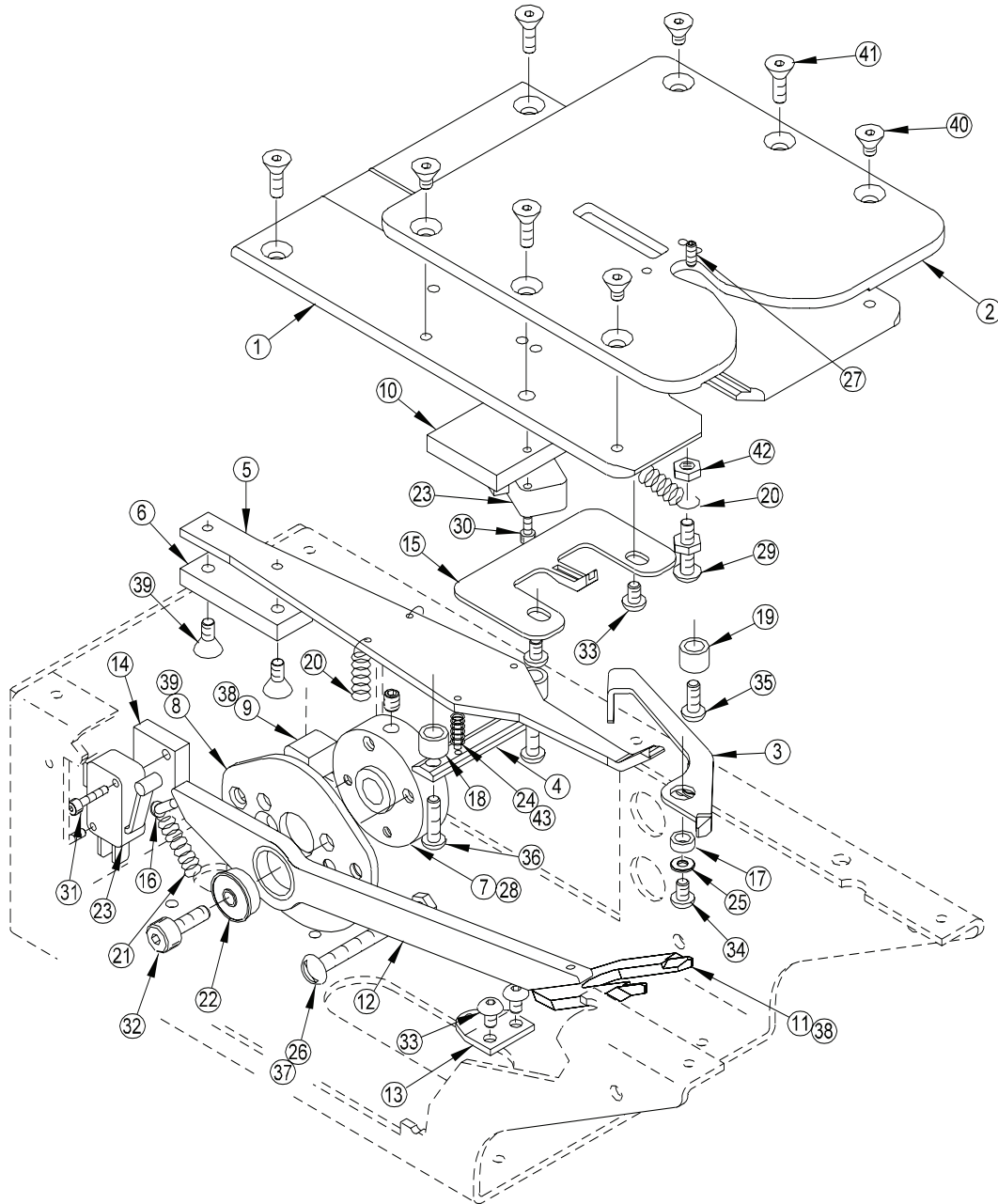


Figure 5.3

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	00-001003	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

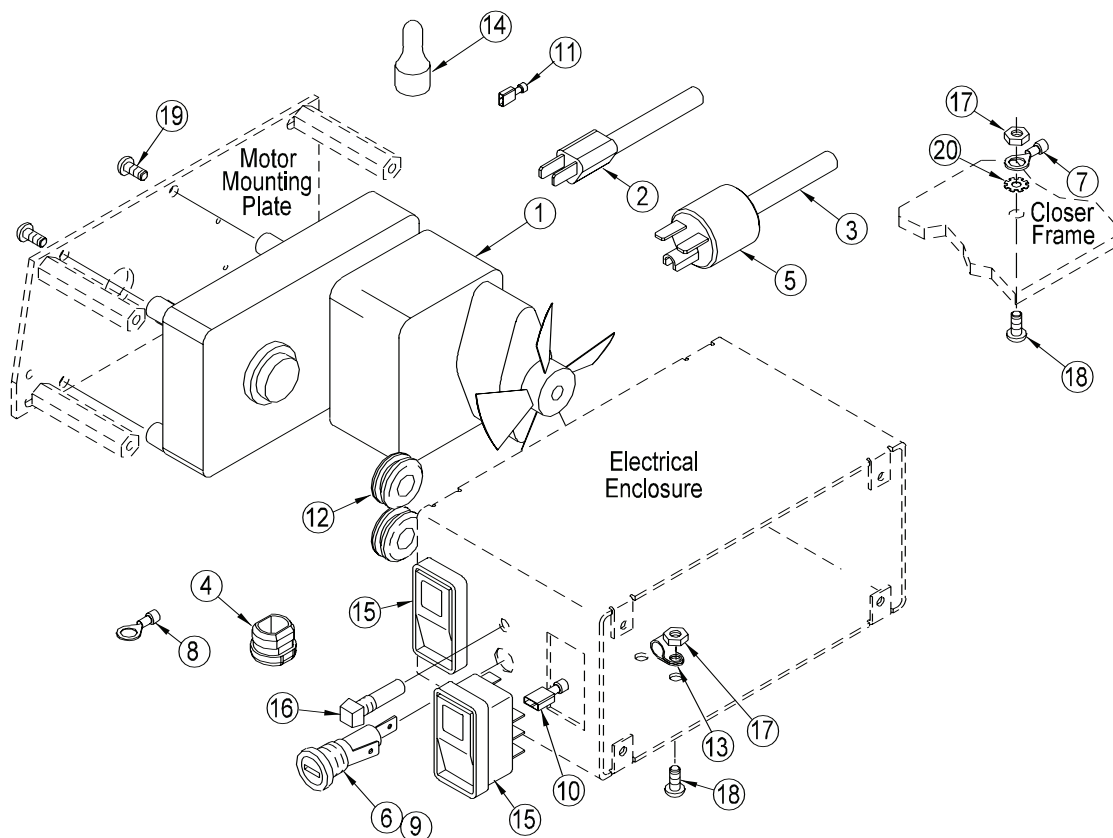


Figure 5.4

Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	00-001000	Motor - 115VAC	1	11	P11-00323	Terminal - Spade	4
	00-001001	Motor - 230VAC	1	12	P11-00478	Grommet	2
2	P11-00064	Cord - Motor - 115VAC	1	13	P11-00485	Clamp - Cord	1
3	P11-00019	Cord - Motor - 230VAC	72"	14	P11-00812	Joint - Wire	1
	P11-00736	Cord - Motor - 230VAC International	72"	15	P12-00287	Switch - Rocker - 115VAC	1
4	P11-00031	Strain Relief - 220-250VAC	1		P12-00288	Switch - Rocker - 220-250VAC	1
	P11-00665	Strain Relief - 115VAC	1	16	P12-00193	Light - 115VAC	1
5	P11-00033	Plug - Motor - 230VAC	1		P12-00194	Light - 230VAC	1
6	P11-00042	Holder - Fuse	1	17	F03-190FS	Nut - 10-32UNF - Hex	2
7	P11-00144	Terminal - Closed	1	18	F11-190F06S	Screw - 10-32UNF x 3/8 Lg	2
8	P11-00221	Terminal - Closed Loop	1			Skt Btn Hd	2
9	P11-00270	Fuse - 115VAC	1	19	F11-190C06S	Screw - 10-24UNC x 3/8 Lg	4
	P11-00616	Fuse - 220 - 240VAC	1			Skt Btn Hd	4
10	P11-00274	Terminal - Spade	11	20	F17-190S	Washer - Star	1

SECTION VI Wiring Diagram

086 WIRING DIAGRAM

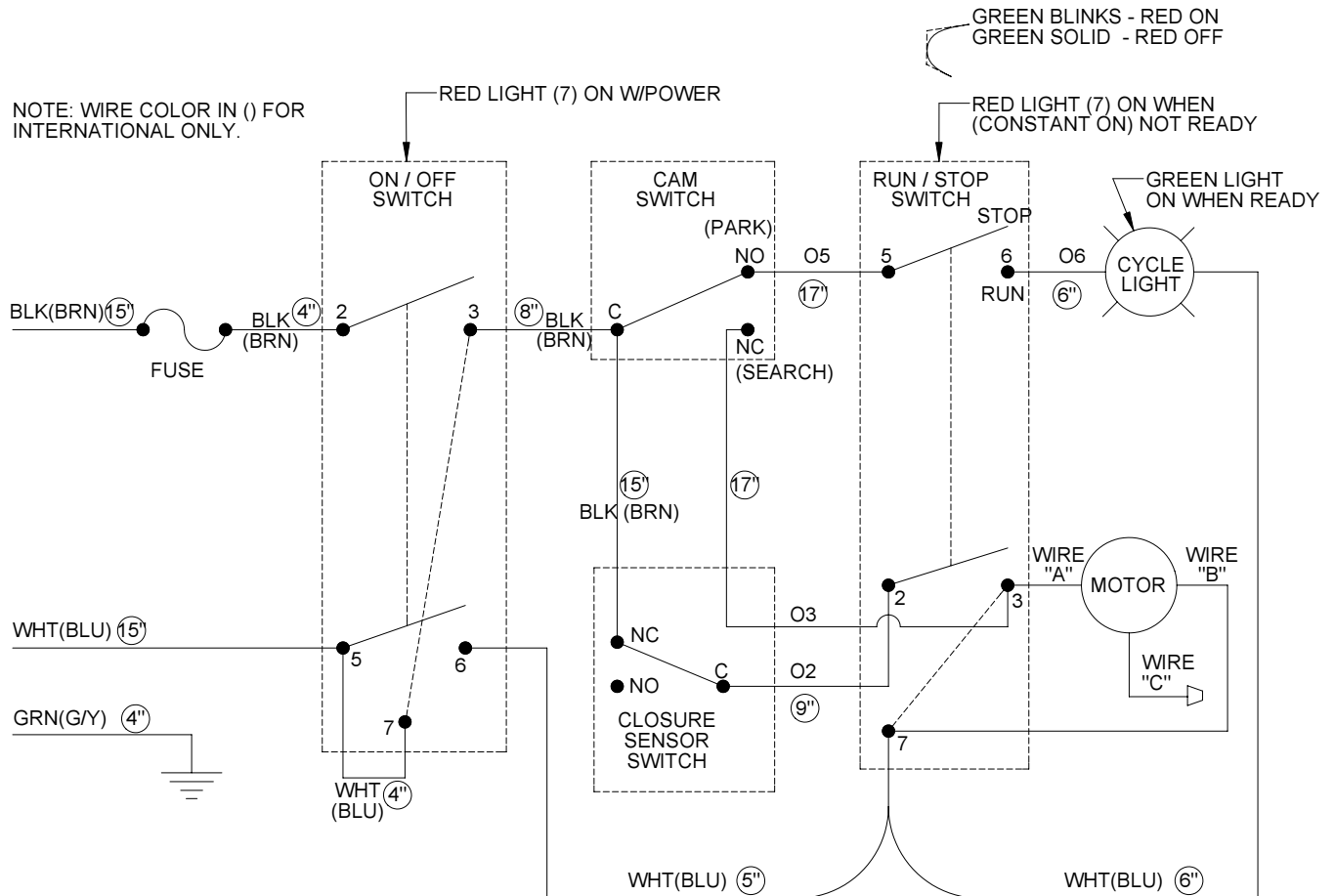
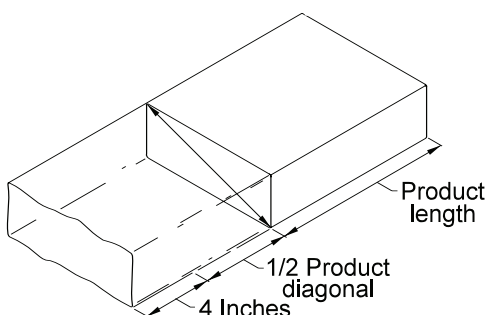
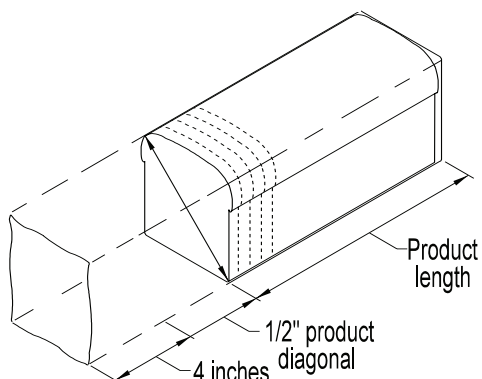


Figure 6.1

<u>USA (DOMESTIC) WIRE COLOR CODE</u>	
BLACK (BLK)	115VAC / 230VAC (16GA.)
WHITE (WHT)	115VAC / 230VAC (16GA.)
GREEN (GRN)	115VAC (18GA.) 230VAC (16GA.)
ORANGE (02, 03, 05, 06)	115VAC (20GA.)
<u>INTERNATIONAL WIRE COLOR CODE</u>	
BROWN (BRN)	220VAC - 240VAC (18GA.)
BLUE (BLU)	220VAC - 240VAC (18GA.)
GREEN (GRN)	220VAC - 240VAC (16GA.)
ORANGE (02, 03, 05, 06)	220VAC - 240VAC (20GA.)

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.

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. It's 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.

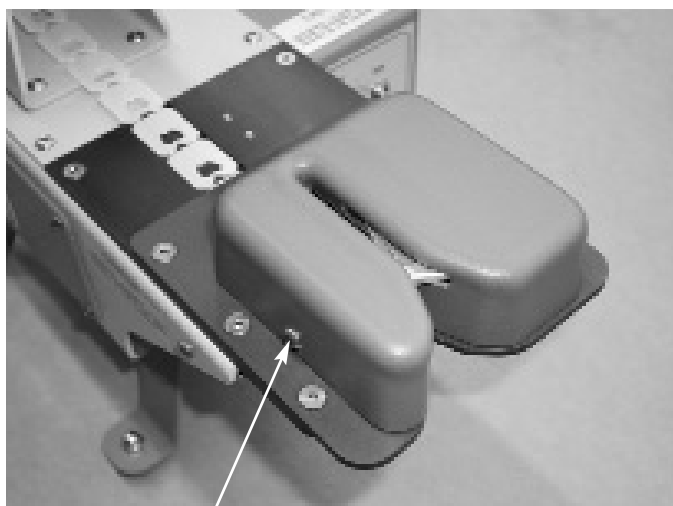
1. Grasp the product with one hand at the base of the bagneck nearest the product. Grasp the top of the bag with the other.
2. Insert the top of the bagneck into the end of the trimmer slot first slightly ahead of the lower part of the bagneck (Figure A.1). Be sure the shear blade swivels into the shearing 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

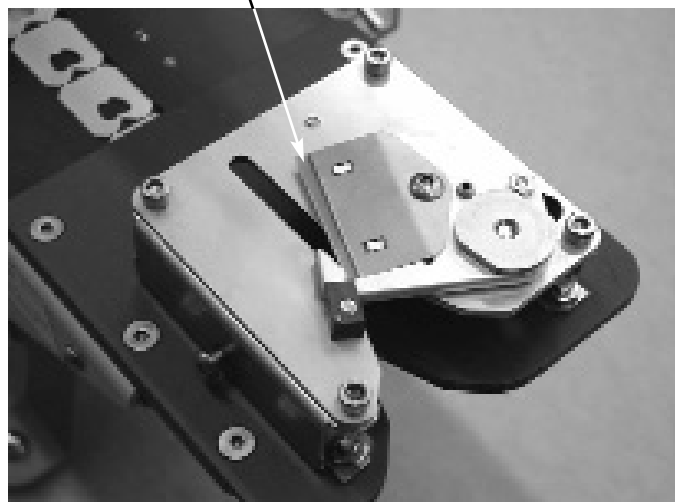


Figure A.6
(cover removed)

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.

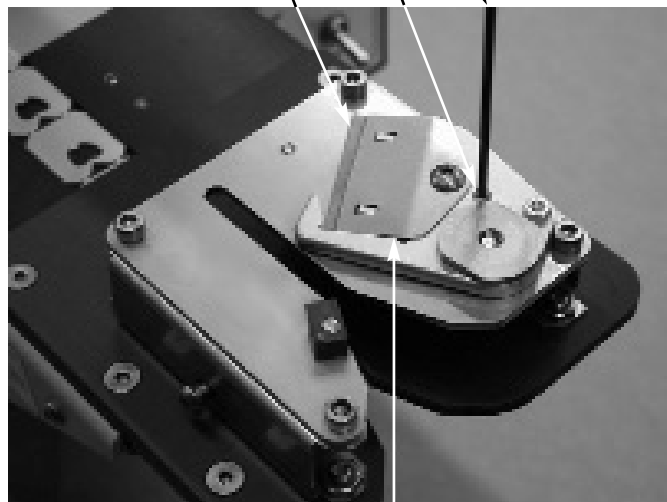
CAUTION: THE SHEAR BLADE IS MADE OF A CERAMIC MATERIAL AND IS EXTREMELY SHARP. EXTRA CARE SHOULD BE TAKEN TO ENSURE THE SAFE HANDLING OF THIS BLADE.

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.



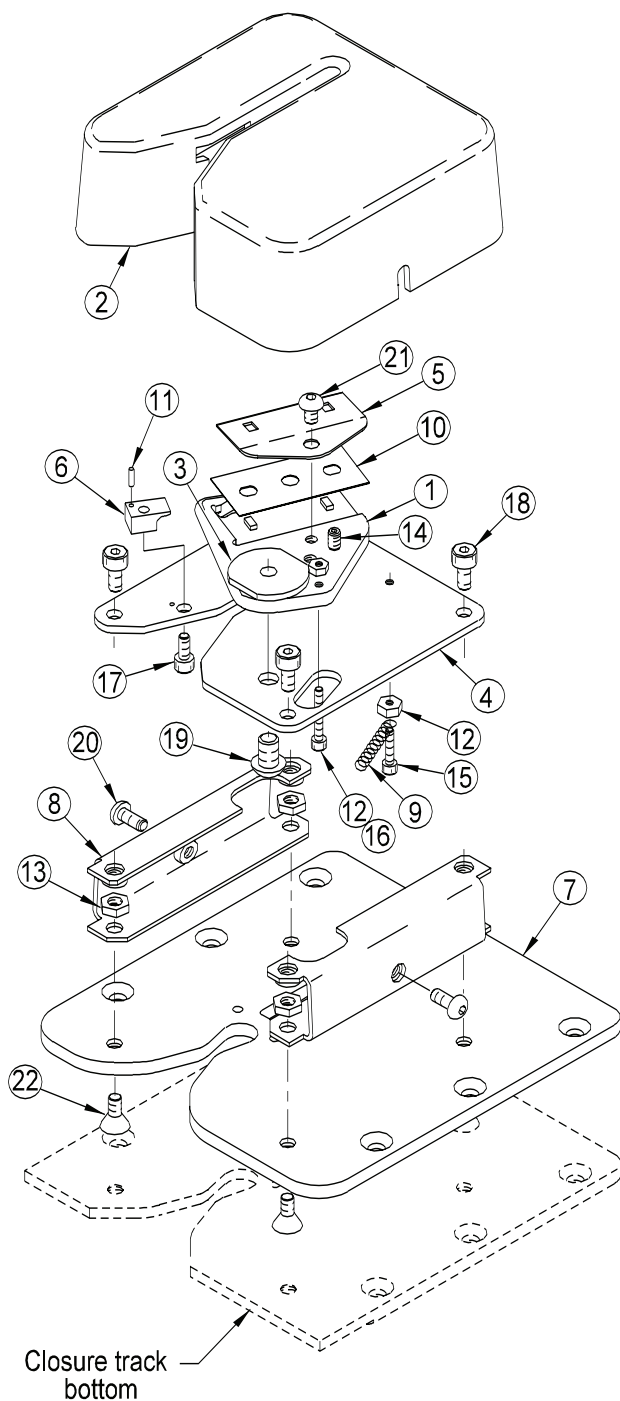
Figure A.8

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	1
		Skt Set	
15	F10-138C08S	Screw - 6-32UNC x 1/2 Lg	1
		Skt Hd Cap	
16	F10-138C12S	Screw - 6-32UNC x 3/4 Lg	1
		Skt Hd Cap	
17	F10-164C06S	Screw - 8-32UNC x 3/8 Lg	1
		Skt Hd Cap	
18	F10-190F06S	Screw - 10-32UNF x 3/8 Lg	4
		Skt Hd Cap	
19	F10-250F06	Screw - 1/4-28UNF x 3/8 Lg	1
		Skt Hd Cap	
20	F11-190F06S	Screw - 10-32UNF x 3/8 Lg	2
		Skt Btn Hd	
21	F11-190C03S	Screw - 10-24UNC x 3/16 Lg	1
		Skt Btn Hd	
22	F12-190F06S	Screw - 10-32UNF x 3/8 Lg	4
		Skt Flt Hd	



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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 - 200 - 240VAC	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.