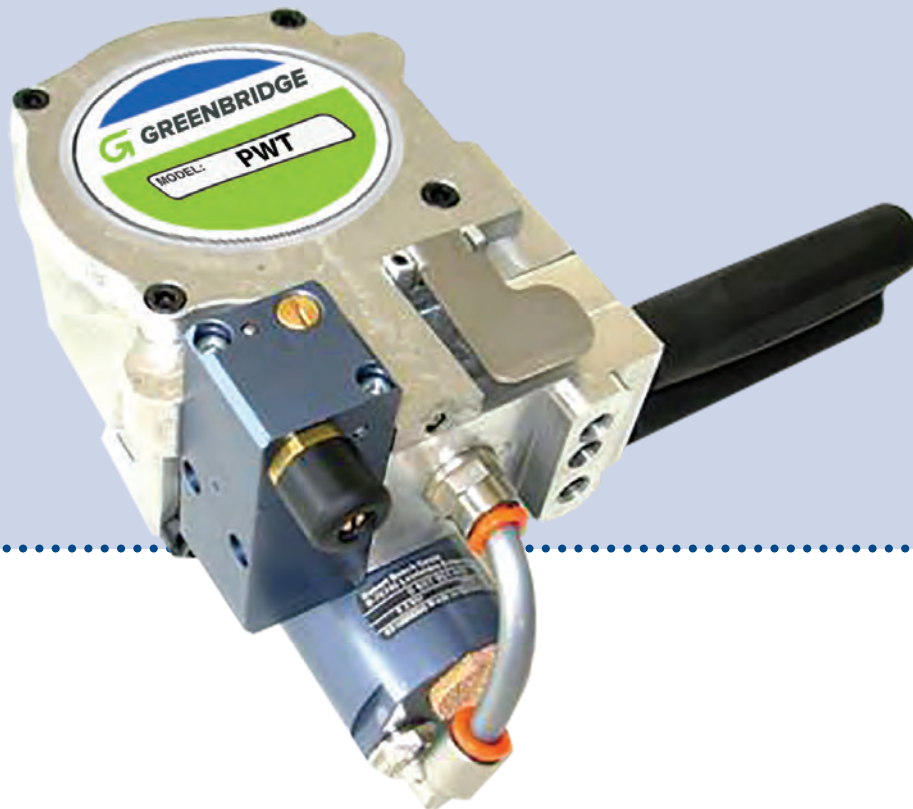




PWT

OPERATION MANUAL | SPARE PARTS LIST

PNEUMATIC PLASTIC STRAPPING TOOL



CE

READ ALL INSTRUCTIONS BEFORE OPERATING THE TOOL

GREENBRIDGE
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ED. 12/21

TABLE OF CONTENTS

- 1) Safety instructions
- 2) Technical data
- 3) Warranty and liability
- 4) Installation
- 5) Operating elements
- 6) Operation
- 7) Servicing and cleaning
- 8) Troubleshooting
- 9) Layout – spare parts list

1) SAFETY INSTRUCTIONS



READ THE OPERATING INSTRUCTION CAREFULLY



WHEN OPERATING THE TOOL, WEAR EYE, FACE AND HAND SAFETY PROTECTION



GENERAL SAFETY INSTRUCTIONS :

The tool must be used by properly trained people. Failure to follow the operating instructions or improper use could cause strap breakage, injuries, or package damages.

Check tool daily, do not use tool with worn or damaged parts. Use original spare parts for replacement. Never modify any tool part.

Do not put fingers, hands or other body parts between the strap and package during the cycle.

It is your responsibility to check the seal joints made by your tool. Training about the weld time adjustment will be useful to check the seal quality in order to avoid severe injury. Never move goods with bad quality seals. Only use specific strap dispenser to dispense the strap. Keep your working area clean and always use the tool in good balance and safety conditions. Never use straps as a means of pulling or lifting goods.

Always use a proper safety strap cutter and keep other people and yourself at a safe distance from strap, always stand to side of strap, away from direction of strap trajectory once cut. Hold the upper strap portion and pay attention that the lower strap will snap forward away from you.

Improper operation, excessive tensioning, use of non recommended strap, or sharp corners on the package could cause a loss of strap tension and/or strap breakage that could lead to packaging failure or injury. The following is recommended; use edge protectors if package has sharp corners, place the strap correctly around a properly positioned package, stand in safety position (on one side of strap) during strapping cycle, and use the correct strap quality, width, thickness, and break strength as recommended in this manual.

Please save this manual, as it is a part of the tool. This tool is manufactured without any substances which could be dangerous to health. National instructions must be observed for disposal of all the parts.



GENERAL SAFETY INSTRUCTIONS FOR COMPRESSED AIR:

Never operate this tool using bottled air or other gas source. Do not exceed the air pressure range as shown in this operation manual. For all adjustments, repairs or cleaning of the tool, always disconnect air supply. Always use dry, clean and lubricated compressed air.

2) TECHNICAL DATA

TOOL SIZE				
Length:				250 mm – 9.8”
Width:				130 mm – 5.1”
Height:				120mm – 4.7”
Weight:				2.6 kgs – 5.7 lbs
REQUIRED AIR				
Pressure range:				4.5-7 bar / 64-99 psi
PERFORMANCE				
Sealing:				Friction seal
Joint strength:				80% plastic strap strength*

- depends on strap quality

CHART OF TYPES

ITEM	MODEL	STRAP	THICKNESS
T189901 T182501	PWT	PP-PET 16-19mm / 5/8”- 3/4” PET 25mm – 1”	>0.016” – 0.055”<

3) WARRANTY

GREENBRIDGE warrants all its tools during a period of 4 months from the shipping date document. Warranty includes free replacement of faulty parts ex works. The warranty is not valid in case of improper use, lack of maintenance, tampering, arbitrary modifications and reparations, use of non original parts, disregard of instructions of the operation manual, and missing serial number. The warranty excludes the wearing parts shown on spare parts list.

No compensation can be claimed for production shutdowns and for damages to people and objects due to tools defects. GREENBRIDGE reserves the right to modify the tools and documentation without any obligation to update previous ones.

4) INSTALLATION

It is recommended to always use a dryer unit near the compressor and a filter-regulator-lubricator unit with pressure gauge (Greenbridge part # 200-0025) close to the tool air connection to avoid water and dirt in the valves or in the pneumatic motors. Connect the tool to air with quick connector ¼” and use minimum 8mm or 3/8” internal diameter pipe; max length for flexible pipe 10 m between tool and regulator group. Check that your compressor / air distribution plant is able to supply the right air quantity as shown in the operation manual without losing pressure.

TOOL AIR CONNECTION

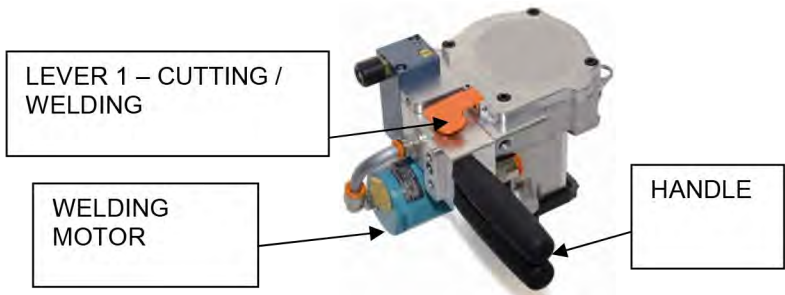


200-0025



5) OPERATING ELEMENTS-ADJUSTMENTS

- **DO NOT OPERATE THE TOOL WITHOUT STRAP, YOU COULD DAMAGE THE WELDING / CUTTING GROUP**



Handle rotation

It is possible to change the handle position 90°. To change the position you unscrew the handle and move it as pictured.

Welding time adjustment

The welding time can be adjusted with a screwdriver as shown in pic.A; turning clockwise will increase the time, and counter clockwise will decrease the time.



Strap size conversion

(B1)



Front strap guide (1)

(B2)



Rear strap guide (2)

To set the tool for 16mm 5/8" and 19mm 3/4" strap sizes follow the instructions below:

19 > 16 3/4" > 5/8"	Turn the strap guides 1 and 2 in 16mm 5/8" position (pic.B1-B2)
16 > 19 5/8" > 3/4"	Turn the strap guides 1 and 2 in 19mm 3/4" position (pic.B1-B2)

6) OPERATION

Wrap the parcel to be bound with the strap, as shown in **(pic.C1)**, (make sure that the strap is clean, and oil and grease free); align the two straps and insert them between the body and bottom plate, against the front / rear strap guides **(pic.C2)**, push lever 1 one time to cut and weld the strap. **(pic.C3)**. Remove the tool.

(C1)



(C2)



(C3)



WARNING : Wait 2-3 seconds after the welding cycle to cool the strap before releasing it

Seal check

A regular seal quality control is very important and it can be checked visually as follows:

(D1)



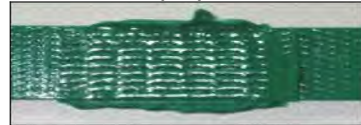
NO – seal strength insufficient
Weld time too short

(D2)



YES -- right

(D3)



NO – seal strength affected
Weld time too long

7) SERVICING

DISCONNECT TOOL FROM COMPRESSED AIR LINE BEFORE PERFORMING ANY SERVICE

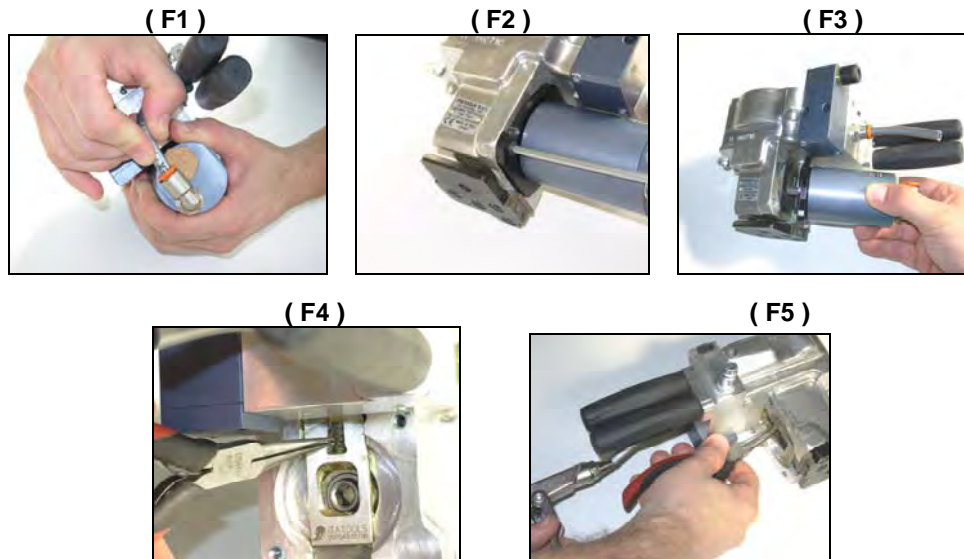
Periodically clean the tool from strap dust, particularly the gripper plates and the cutter using compressed air.
(Do not use other tools or keys) **(pic. E)**

(E)

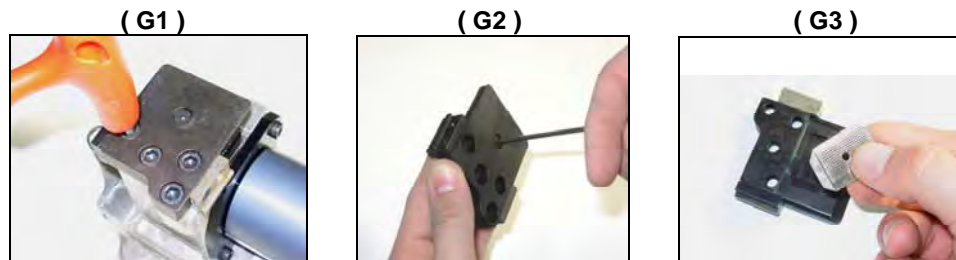


Cutter replacement

Disconnect the air pipe from welding motor (**pic.F1**), remove the 2 locking motor screws (**pic.F2**), remove the motor (**pic.F3**). Pull out the cutter spring with pliers (**pic.F4**), remove the cutter by inserting air into the disconnected pipe to push the piston down to free the cutter and then remove it from its seat with pliers (**pic.F5**). Replace it and reassemble in reverse order putting grease on spring and cutter seat.



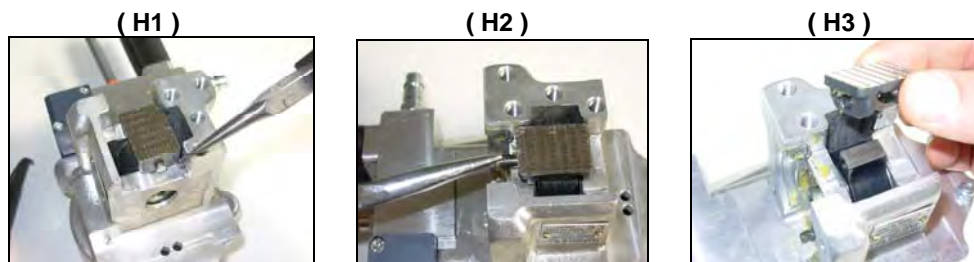
Grippers replacement



Remove the 4 bottom plate screws (**pic.G1**), unscrew the gripper screw (**pic.G2**), replace the parts (**pic.G3**), and reassemble in reverse order.

Welding gripper replacement

Remove the cutter as shown in **F1 to F5** sequence, remove the bottom plate as point **G1**, remove the safety circlip from welding gripper pin (**pic.H1**), remove the pin from welding gripper (**pic.H2**), and replace the worn out part(**pic.H3**) . Reassemble all parts in reverse order. It is advised to replace the safety circlip with a new one.



8) TROUBLESHOOTING

PROBLEM

REMEDY

Air leaking

Check the air connection. May need to replace the gaskets (contact the after sale service)

The seal is weak; the upper strap isn't completely cut; the cutting is inconsistent

Improper weld time adjustment set it properly. Check if the sealing foot and the cutter are damaged or worn out. Check if the sealing foot is dirty or slides on strap. Check the air pressure value. Check if the strap qualities are right for the strapping tool and application. Check if the sealing motor or the pneumatic valve is locked or dirty (contact the after sale service), try to clean the timer valve, check the air circuit.

The strap is breaking while sealing

Improper weld time adjustment, may be too long, set it properly.

Both straps are cut while sealing

Check if the gripper plate is dirty or damaged (clean or replace it). Improper weld time adjustment, may be too long.

The sealing time is inconsistent

Timer valve problem, try to clean, lubricate or replace it (contact the after sale service)

9) SPARE PARTS LIST

Ed. 06/08

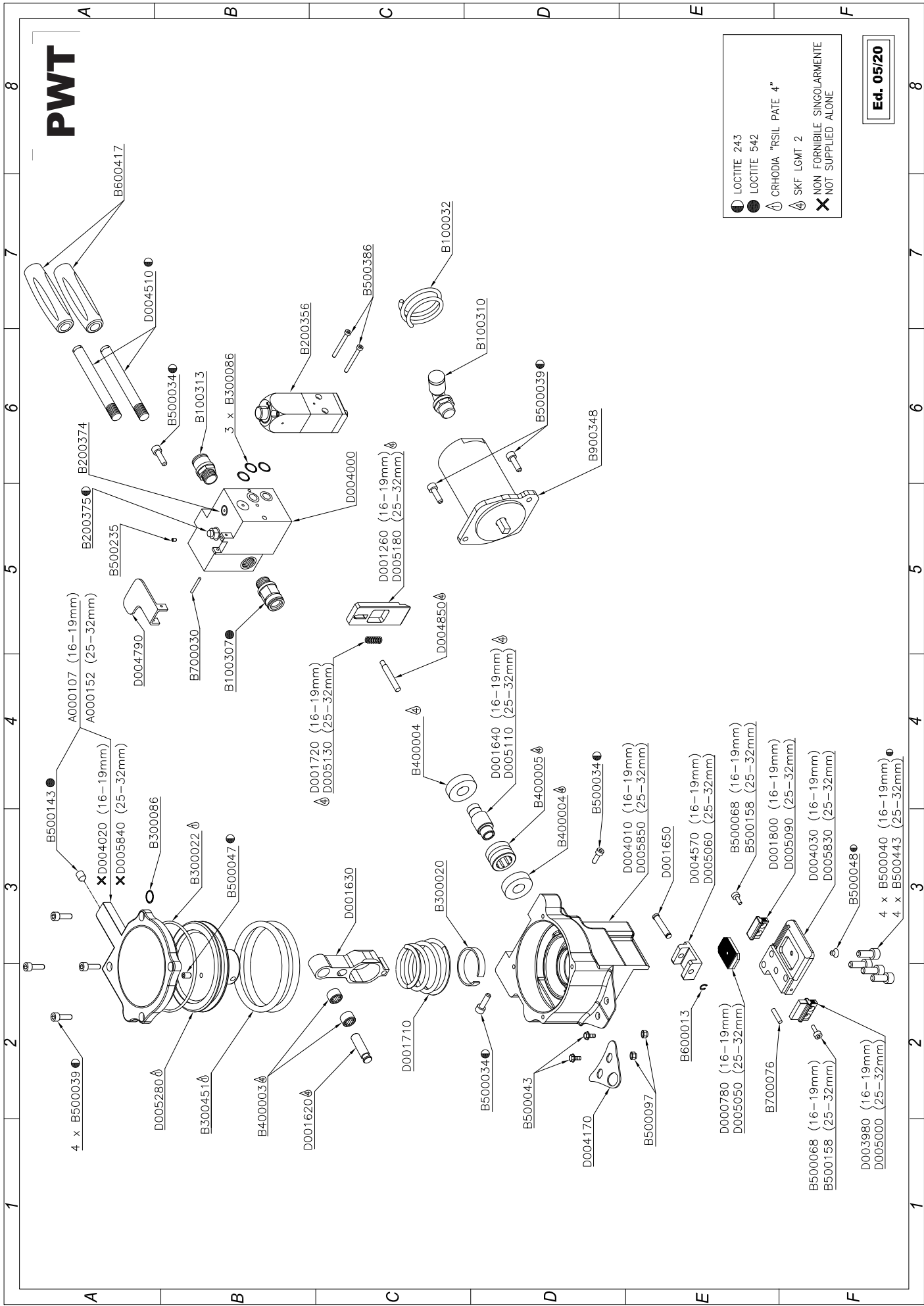
GREENBRIDGE PART NUMBER	ITEM	DESCRIPTION	QTY		
401-0279	A000107	ASSEMBLED COVER	1		
200-0027	B100032	PIPE 6x8	0,08 mt		*
401-0149	B100307	CONN. DIR 10 1/4 RL1 (2L01012)	1		
400-0039	B100310	SWING ELBOW RL31 8 1/4 (2L31011)	1		*
400-0094	B100313	CONNECTION RL1 08 1/4 (2L01010)	1		*
400-0060	B200356	VALV 2VIE TEMP AZ10.017.4	1		*
401-0146	B200374	KIT AIR STOPPER 1/8"F0.5 AZ 11.005.2	1		
400-0025	B200375	KIT MICROVALVE NC AZ 08.022.2	1		
400-0014	B300022	O-RING 3300 (D85)	1		
400-8004	B300019	GASKET RING RP6287.85	1		
400-0019	B300020	GASKET TEFLON + BRONZE 1.5x6.1 IN MTS	0,11		
401-0109	B300086	O-RING OR108 (D9)	4		
400-0049	B400003	ROLLER BEARING HK0808 INA	2		
400-0085	B400004	BEARING 6001 2Z	2		
400-0054	B400005	ROLLER BEARING NK1616	1		
401-0141	B500034	SCREW UNC 10-24x5/8" ANSI B18.3	3		
400-0038	B500039	SCREW UNC10-24x1/2"	6		*
400-0044	B500040	SCREW M6x16 UNI5931	4		*
400-0088	B500043	SCREW M5x12	2		
401-0140	B500047	SCREW M5x8 UNI5925	1		
400-7135	B500048	SCREW M4x6 UNI5933	1		*
401-2149	B500068	SCREW M3X8 UNI 5931	2		
401-0142	B500097	SELFLOCK M5 DIN985 5S	2		
401-0273	B500143	SCREW M6X6 UNI5927	1		
401-0145	B500235	SCREW M3X4 UNI5929	1		
401-0205	B500386	SCREW M4x30 DIN7984	2		
400-0059	B600013	CIRCLIP H5	1		
401-0147	B600417	RUBBER GRIP	2		
400-8033	B700030	PIN 3x24 DIN6325	1		
401-2047	B700076	PIN 4x12 DIN6325 R220	1		
400-0036	B900348	PNEUMATIC BOSCH MOTOR 0607951449	1		
401-0274	B900406	PNEUMATIC MOTOR AM-004	1		
400-0063	D000780	LOCKING STRAP PLATE	1	§	*
400-0035	D001260	CUTTER	1	§	*
400-0205	D001620	CONNECTING ROD PIN	1		
400-0055	D001630	CONNECTING ROD	1		
400-8014	D001640	EXCENTRIC SHAFT	1		
400-0058	D001650	WELDING FOOT PIN	1		
400-0067	D001700	COVER	1		
400-0020	D001710	PISTON SPRING	1		
400-0149	D001720	STRONG CUTTER SPRING	1		
401-0024	D001800	REAR STRAP GUIDE	1		
401-0275	D003000	CUTTER (1"STRAP)	1	§	*
401-0276	D003010	WELDING FOOT (1"STRAP)	1	§	*
401-0277	D003040	LOCKING STRAP PLATE (1"STRAP)	1	§	*
401-0036	D003980	FRONT STRAP GUIDE	1		
401-0278	D004000	PNEUMATIC VALVE	1		
401-0150	D004010	MAIN FRAME	1		
401-0143	D004030	BOTTOM PLATE	1		
401-0280	D004170	HOOK SUPPORT PLATE	1		
401-0148	D004510	GRIP PIN	2		
401-0208	D004570	WELDING FOOT	1	§	*
401-0144	D004790	WELDING START LEVER	1		
401-0209	D004850	CUTTER PIN	1		
401-0210	D004860	PISTON	1		
401-0281	D004920	BOTTOM PLATE (1"STRAP)	1		
401-0282	D004930	MAIN FRAME (1"STRAP)	1		

GREENBRIDGE PART NUMBER	ITEM	DESCRIPTION	QTY	
	§	WEARING PART		
	*	PART THAT SHOULD BE STOCKED		

PWT

- LOCTITE 243
- LOCTITE 542
- ⚙ CRHODIA "RSIL PATE 4"
- ⚙ SKF LGMT 2
- ✘ NON FORNIBILE SINGOLARMENTE
- ✘ NOT SUPPLIED ALONE

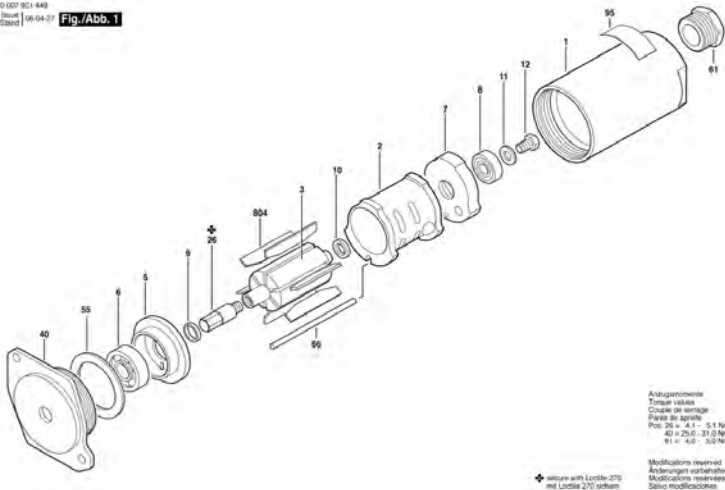
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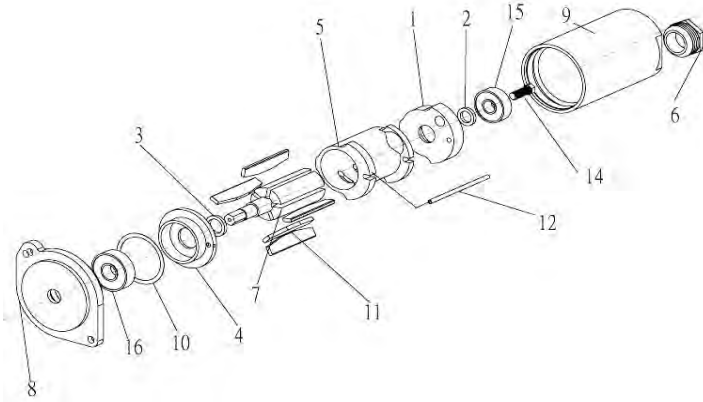
**BOSCH 0 607 951 449 – POLYCHEM 400-0036
WELDING MOTOR**

0 607 951 449
Standard | 04-04-07 | Fig./Abb. 1



REF.	ITEM	DESCRIPTION	Q.TY
1	3 605 125 063	Housing	1
2	3 604 090 009	Cylinder	1
3	3 604 220 005	Roller	1
5	3 605 700 167	Front plate	1
6	1 900 905 127	Bearing	1
7	3 605 700 010	End plate	1
8	1 900 905 029	Bearing	1
9	2 600 202 007	Washer	1
10	3 600 202 004	Washer	1
11	2 916 011 012	Washer	1
12	2 911 061 150	Screw	1
26	3 606 337 209	Pin	1
40	3 600 390 040	Cap	1
55	3 600 100 048	Kasher	2
61	3 603 462 017	Silencer	1
66	3 604 710 032	Roll pin	1
95	3 601 108 047	Label	1
804	3 607 030 280	Blade	1

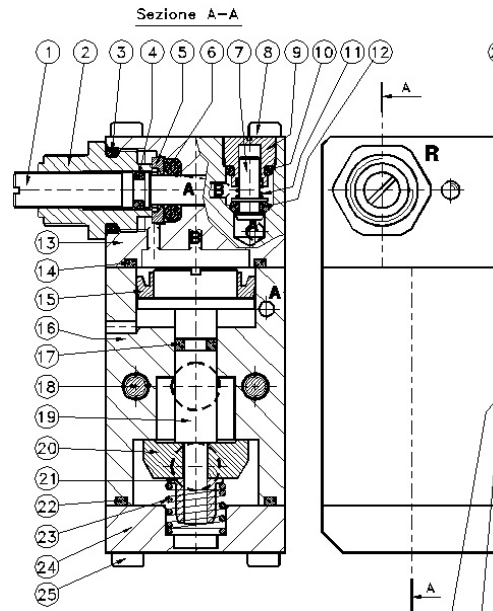
**AM-0004-P-0703B-MI– POLYCHEM 401-0274
WELDING MOTOR**



REF.	ITEM	DESCRIPTION	Q.TY
1	AM0004-01	End Plate	1
2	AM0004-02	End Washer	1
3	AM0004-03	Front Washer	1
4	AM0004-04	Front Plate	1
5	AM0004-05	Cylinder	1
6	AM0004-06	Silencer	1
7	AM0004-07	Roller	1
8	AM0004-08	Cap	1
9	AM0004-09	Housing	1
10	AM0004-10	Washer	1
11	AM0004-11	Blade	5
12	AM0004-12	Roll Pin	1
14	AM0004-14	Screw	1
15	AM0004-15	Bearing	1
16	AM0004-16	Bearing	1

400-0060 (B200356) – TIMER VALVE

REF.	ITEM	DESCRIPTION	QNTY
1	10.077.0	SPILLO 1/8.1 TAGLIO CACC RIBASS	1
2	12.002.1	NIPPLO REGOLATORE 1814	1
3	OR 2043	OR 2043	1
4	OR 102	OR 102 DA LUBRIFICARE	1
5	12.103.1	PREMIGUARNIZIONE REG. 908	1
6	5*3*11	OR NBR 70 5*3*11	1
7	12.104.0	OTTURATORE REG. 908	1
8	M4*20	VITE TCCE M4*20 UNI 5931 8G	2
9	12.101.0	GUIDA OTTURATORE PER REG.908	1
10	OR 103	OR 103	1
11	12.102.0	MOLLA 908	1
12	OR 101	OR 101	1
13	10.089.1	COMAND 2 VIE OTTURAT+RFU+VNR	1
14	OR 2081	OR 2081	2
15	01.014.0	GUARNIZ LABBRO DE20	1
16	10.040.1	CORPO VALV 2 VIE OTTUR CON TEMP	1
17	OR 102	OR 102	3
18	M4*30	VITE TCCE M4*30 UNI 5931 ZINC.BIANCO	2
19	10.043.0/S	PISTONE D.20 CON SPOLA	1
20	03.032.0	OTTURATORE VERDE	1
21	03.025.0	GUIDA MOLLA	1
22	OR 2093	OR 2093	1
23	11.040.0	MOLLA RSW 1/8	1
24	10.042.1	FONDELLO VALV 2 VIE OTTUR	1
25	M4*10	VITE TCCE M4*10 UNI 5931 8G	2



CE DECLARATION OF CONFORMITY

Greenbridge declares under own responsibility that the under mentioned machinery, to which this declarations refers, is in conformity with **2006/42/CE** Directive and successive modifications, as well as with standards **EN12100-1 / EN12100-2**

MODEL :
series PWT



MACHINE TYPE

PNEUMATIC PLASTIC STRAPPING TOOL

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Manufactured in Italy

