

PLAS-TIES[®]
TWIST-TYING MACHINES & MATERIALS

OPERATING MANUAL

FOR THE

TIE-MATIC

HD38, HD58 & HD78 MACHINES
110V



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GENERAL INFORMATION

Thank you for purchasing the Tie-Matic HD from Plas-Ties, manufacturers of high quality twist-tying equipment.

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

The HD38, 58 and 78 machines are designed to wrap and twist tie material to close bags, bundle products and secure wire and cables. PLAS-TIES twist tie material and service should be ordered from your dealer, distributor, or:

PLAS-TIES
14272 Chambers Road
Tustin, CA 92780 USA

Telephone: (714) 542-4487
(800) 854-0137
Fax: (714) 972-2978
Email: info@plasties.com

When contacting Plas-Ties, please have the following information handy:

1. Model Number and Serial Number (see Name Plate)
2. Date of purchase
3. Number of cycles on Counter
4. Type of tie material in use
5. Part Name or description (for replacement parts - see Appendix as reference guide)

CAUTION!

**DO NOT ATTEMPT TO OPERATE YOUR TIE-MATIC HD BEFORE
 READING THE OPERATING INSTRUCTIONS.**

The efficiency and convenience of the Tie-Matic HD equipment reduces costly labor hours, while increasing output of securely tied products. Semi-automatic operation can deliver more than 60 tied bags or bundles per minute with minimal effort. Insert the bundle at the throat to trigger the tying mechanism and get a twist-tie. All bundles and bags are secured with 2-1/2 full twists of tie material.

EXPLANATION OF SYMBOLS



Circle with line through hands facing gears on COVER: CAUTION! Do not put your fingers or hands inside the throat of the machine as this could result in serious injury.

SAFETY INSTRUCTIONS

CAUTION:

DO NOT ATTEMPT TO OPERATE YOUR TIE-MATIC MACHINE BEFORE READING THE OPERATING INSTRUCTIONS

The operating procedures outlined in this manual are prepared to facilitate the TIE-MATIC machine.

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

WARRANTY

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

PLAS-TIES warrants the Tie-Matic HD to be free from defects in materials and workmanship at time of delivery. Liability under this warranty is limited to the repair or exchange of any defective part or parts of the unit providing the same is returned to **PLAS-TIES**, transportation prepaid, within 1 year or 300,000 ties (*whichever comes first and based on machine counter*). **THE WARRANTY BEGINS FROM THE DATE OF INSTALLATION AT CUSTOMER SITE AND NOT DATE OF PURCHASE. IN ORDER TO ACTIVATE THE WARRANTY, THE COMPANY NAME, CONTACT, CITY/STATE, AND SERIAL NUMBER MUST BE REGISTERED WITH PLAS-TIES or PROOF OF PURCHASE MUST BE PROVIDED. FAILURE TO DO SO WILL RESULT IN LIMITATION OF THE FULL WARRANTY. THIS IS TO INSURE TOTAL QUALITY ASSURANCE AND 800 TOLL FREE TECHNICAL SUPPORT.**

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

This warranty is void if the Tie-Matic HD is used with anything other than genuine **PLAS-TIES** twist-tie material.

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

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

SPECIFICATIONS

Model Designation

This manual covers all models of the Tie-Matic HD Series. The models are identical in their operation.

Models HD38, HD58 and HD78 are equipped with a 2 amp circuit breaker for overload protection U.L. approved for the United States.

Performance*

- Up to 60 ties per minute
- 2-1/2 full twists on product tied

*Production speeds vary depending on tying diameter, tightness of tie, operator and processing/production requirements.

Specifications

HD38-Maximum Tying Diameter Capacity - 3/8"

HD58-Maximum Tying Diameter Capacity - 5/8"

HD78-Maximum Tying Diameter Capacity - 7/8"

Power Requirements

- 110-120 VAC, 60Hz
- 60 cycle

Dimensions / Weight *(approximate)*

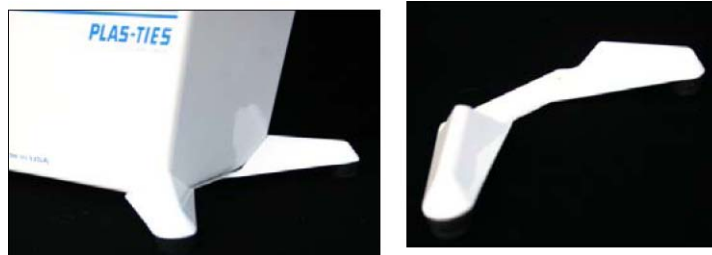
Length:	22"
Height:	11"
Width at top:	5-1/2"
Width at front feet:	9-1/2"
Weight:	16 pounds / 19 pounds with shipping container (no spools)

OPERATION: MOUNTING & START UP

The Tie-Matic HD should be secured to your work table by:

1. Installing the front stabilizer on the unit. (Figure III-1)
2. Rubber suction cup feet are available for complete stability on a stainless steel table or flat surface area (Figure III-2).
3. Also for a permanent position, you can bolt the Tie-Matic to a work table with 10-32 screws to the bottom of the unit.
4. To start the machine, plug the machine into a power source and flip the “ON/OFF” switch to “ON” position.
5. Cover must be closed to activate machine.

Front Stabilizer



(Figure III-1)

Suction Cup Feet

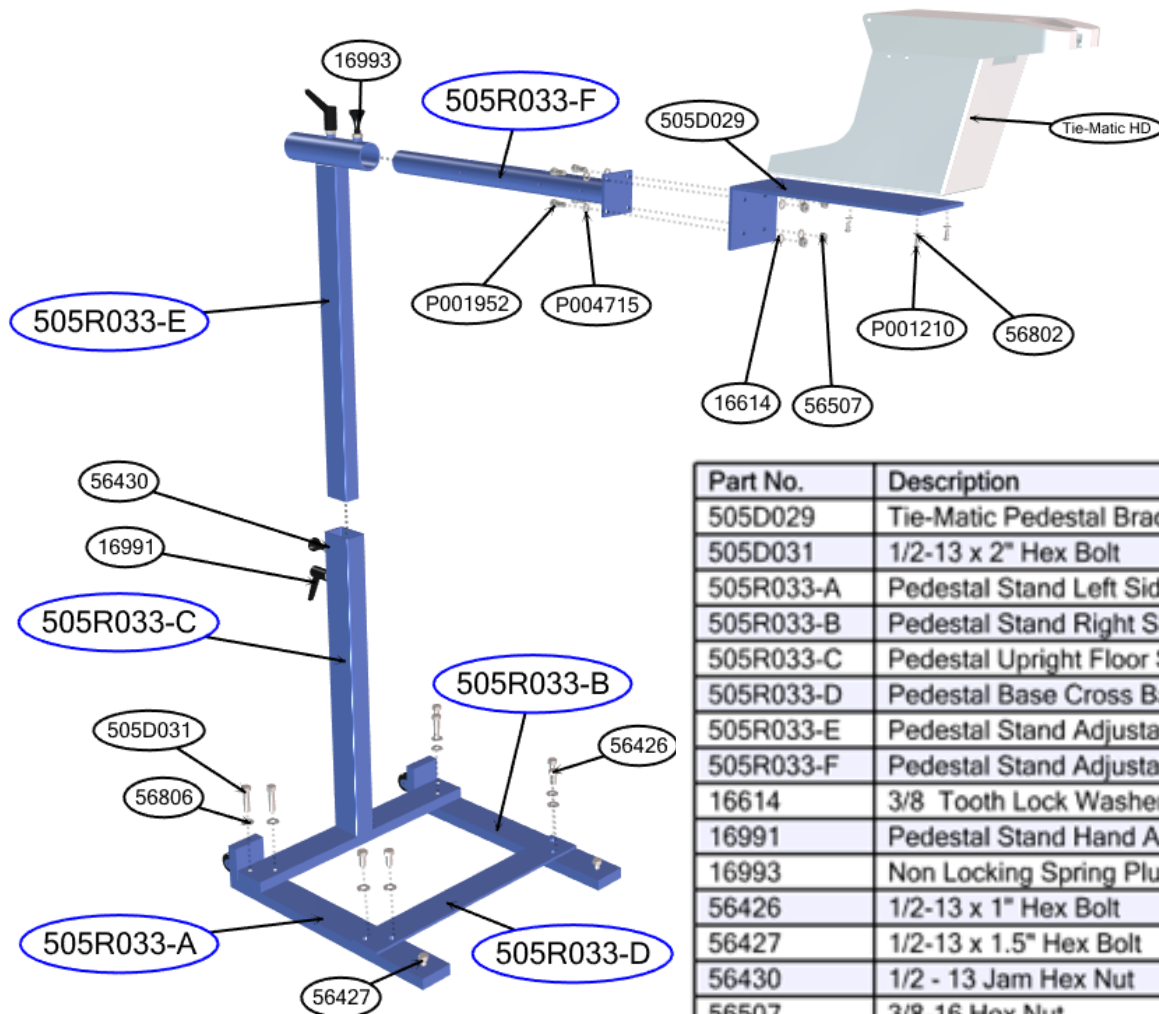


(Figure III-2)

OPERATION: PEDESTAL STAND ASSEMBLY

Lay out all the parts on the floor. Place legs (A&B) with the wheels, parallel to each other as shown

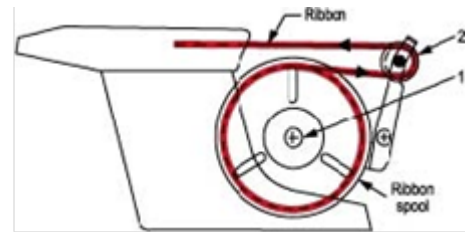
1. Attach the upright (C) to the legs (A&B) using 4 bolts (505D031)
2. Attach cross bar (D) to the legs using 4 bolts (56426) to the front of the legs
3. Place the adjustment upright (E) inside the stationary upright (C). The adjustment upright is held in place by the non-locking spring plunger and secured by the lever clamp.
4. Place the support plate tube (F) inside the tube on the adjustment upright and secure the lever clamp
5. Mount the pedestal stand bracket (505D029) to the support plate (F).
6. Add the pedestal stand bracket (505D029) to (F) using 4 screws (P001952) and 4 washers (P004715)
7. Screw 4 washers (16614) and 4 Hex Nuts (56507) to secure the bracket to (F)
8. Add HD machine to bracket with 3 washers (56802) and 3 screws (P001210).



Part No.	Description	Qty
505D029	Tie-Matic Pedestal Bracket	1
505D031	1/2-13 x 2" Hex Bolt	4
505R033-A	Pedestal Stand Left Side Base	1
505R033-B	Pedestal Stand Right Side Base	1
505R033-C	Pedestal Upright Floor Stand	1
505R033-D	Pedestal Base Cross Bar	1
505R033-E	Pedestal Stand Adjustable Upright	1
505R033-F	Pedestal Stand Adjustable Gooseneck	1
16614	3/8 Tooth Lock Washer	4
16991	Pedestal Stand Hand Assembly	2
16993	Non Locking Spring Plunger	2
56426	1/2-13 x 1" Hex Bolt	4
56427	1/2-13 x 1.5" Hex Bolt	2
56430	1/2 - 13 Jam Hex Nut	4
56507	3/8-16 Hex Nut	4
56802	#10 Flat Washer	3
56806	1/2" Flat Washer	8
Tie-Matic HD		1
P001210	10-32 X 1/2 For Foot Stabilizers	3
P001952	3/8-16 x 7/8" Socket Head Cap Screw	4
P004715	3/8 Split Lock Washer	4

OPERATION: LOADING MATERIAL (HD38 / HD58 / HD78)

Loading Material



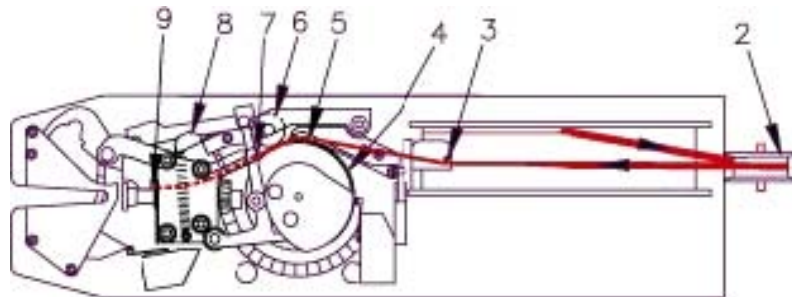
1. Turn OFF machine before loading material. Place spool with label facing out onto Spindle (1). Then tighten Knurled Nut snugly onto the spindle to secure spool.
2. Feed tie material under, then over small roller (2) on Brake Arm and pull toward machine. **(Make sure the ribbon is not twisted)**

VERY IMPORTANT (SEE IMAGE—>)

Check tie material and look for the flat side and the wire side
MAKE SURE THE FLAT SIDE OF THE MATERIAL IS POSITIONED TOWARD THE INSIDE OF THE MACHINE THROUGHOUT THE LOADING PROCESS.



3. Feed material through the Pin on Brake Arm (3), and pull approx 4 inches. Then pull the Idler Wheel (6) out using lever (8) and guide material into the Pinion Support Channel (7). (The entry is marked in bright orange with a black stripe over the opening.) Continue slowly inserting the ribbon into Pinion Support Channel (7) (for approx 2 inches) until the ribbon appears just beyond the cutter (9). **Make sure that the ribbon is under the lip of the white plastic ribbon guide at (5).** Close cover and machine is now set and ready to operate.



Note: Make sure material is straight or curved slightly towards machine (11) when inserted into Pinion Support Channel (7), not kinked or curved as per (10).



OPERATION: LOADING MATERIAL (PICTURE SEQUENCE)

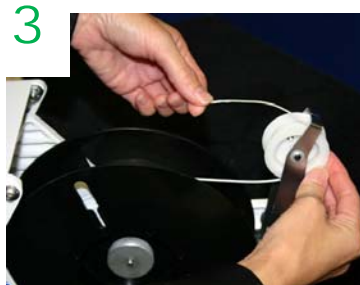
LOADING MATERIAL (MODELS HD38/HD58/HD78)



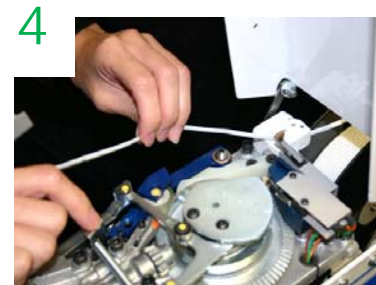
Unscrew Knurled Nut, then place spool of tie material in right hand with label facing palm



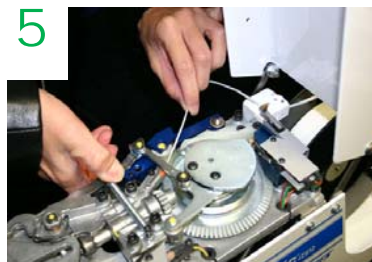
Place spool on spindle & tighten Knurled Nut snugly onto the spindle to secure spool



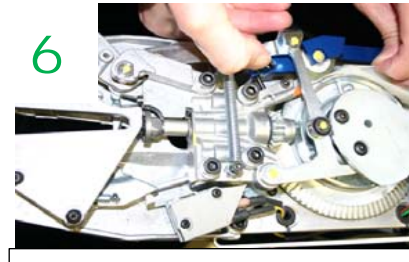
Feed material under small roller on Brake Arm, then over top of roller & pull towards machine



Feed material through the Pin on Brake Arm & pull approximately 4 inches.



Pull the Idler Wheel out, using Lever & guide material into the Pinion Support Channel



Continue slowly inserting the material into Pinion Support Channel until the material appears just beyond the Cutter. Make sure material is under the lip of the Ribbon Guide

[Click for video demonstration](#)



OPERATION: FUNCTIONAL INFORMATION

FUNCTIONAL INFORMATION FOR THE TIE-MATIC MACHINE

HOW IT WORKS

When a product is inserted into the throat of the machine, it depresses a trigger which activates solid state timer, starting the drive gear motor. The gear motor causes the gear segment to operate through one revolution. This one revolution feeds tie material, wraps it around the product, cuts material to required length and twists ends together.

The product has now been tied and is removed by pulling toward the operator. The Tie-Matic HD will repeat tying cycle **ONLY** after tied product is removed and another product inserted into the throat.

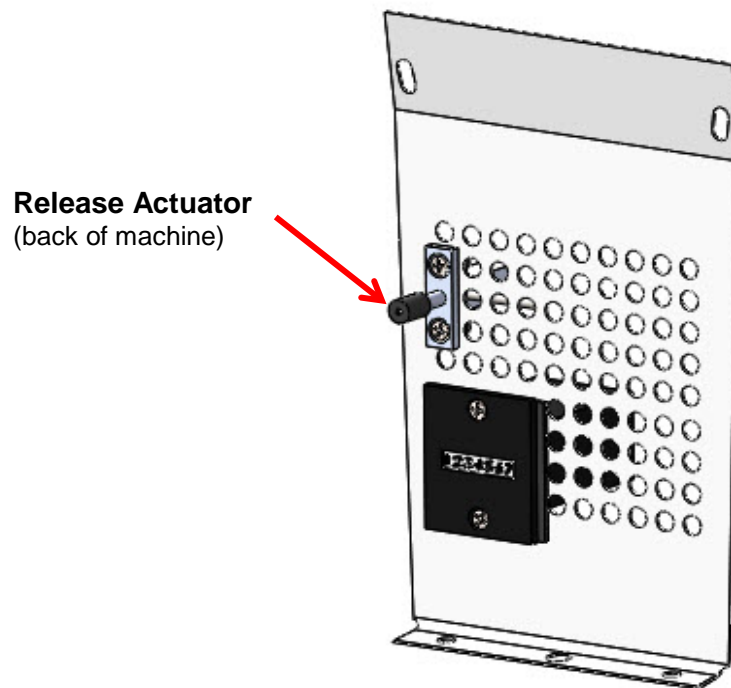
MANUAL RESET TO START POSITION

As a safety precaution, the power switch should **ALWAYS** be turned to the OFF position when inspecting the mechanism for any reason, such as: unloading or reloading twist tie material, cleaning the machine, removing material or performing adjustments.

To manually turn mechanism, you will need to push the Release Actuator in and hold as you manually turn mechanism.

REMOVING JAMS

Pull Idler Wheel lever (blue arm) out and then remove material.



(Figure III-10)

MAINTENANCE

GENERAL

The Tie-Matic HD machine is designed for simple operation and, with reasonable care and maintenance, will provide long service.

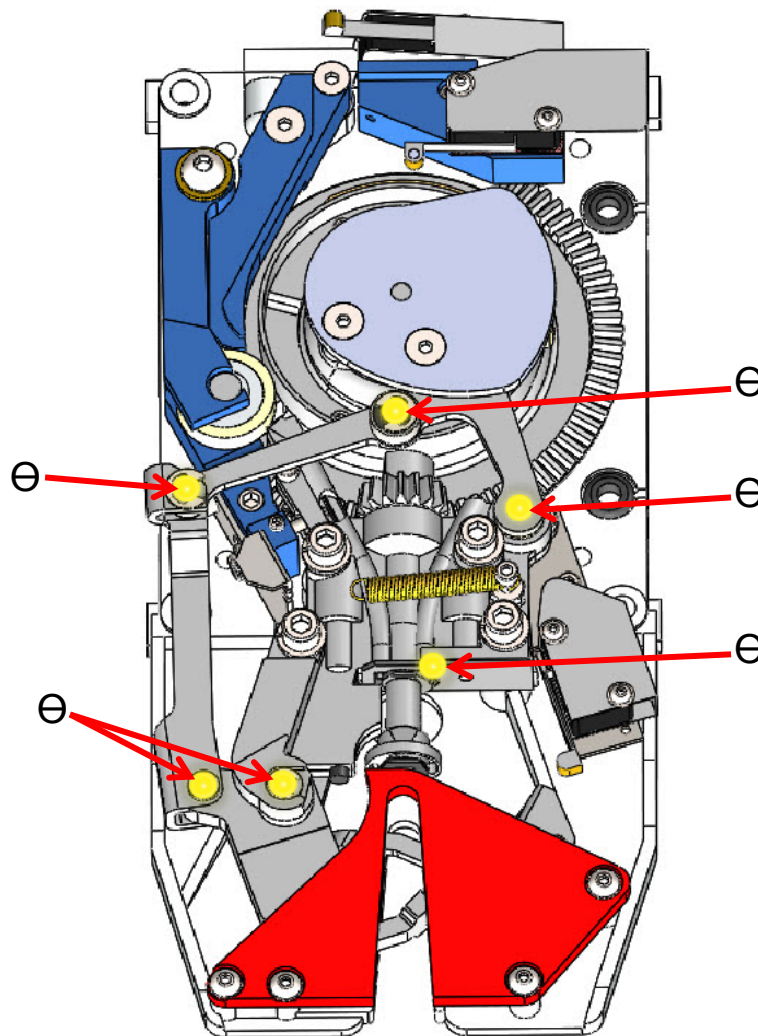
CAUTION

DO NOT OVER-OIL OR OVER-LUBRICATE MACHINE

It is important that the material feed drum and idler pressure wheel be kept free of lubricants. Excess lubrication to the drum will result in an improper tie due to material slippage, requiring a thorough cleaning of the material feed drum and idler wheel before reuse. Excess oil lubrication could damage the motor.

LUBRICATION

1. Turn OFF the machine
2. Air hose the dust from the machine
3. Lubricate the machine with 1 to 2 drops of 3-in-one multi-purpose oil every 50,000 ties.
4. Apply to areas marked with yellow dots or \ominus as shown in Figure IV-1 (6 locations).
5. Lubricate gear segment with food machinery lubricant (Bel Ray).

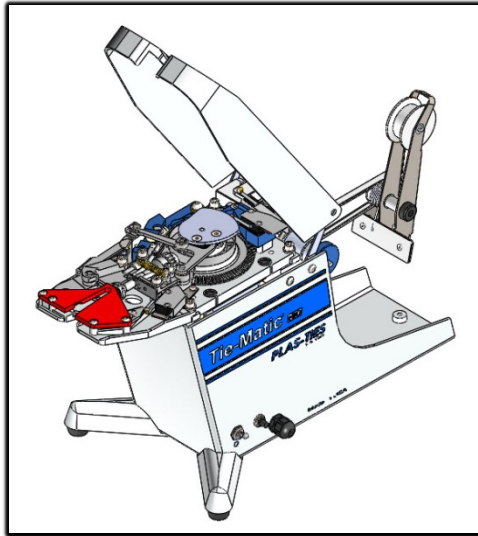


(Figure IV-1)

TROUBLESHOOTING

<u>Condition</u>	<u>Cause</u>	<u>Correction</u>
A. Machine jammed	<ul style="list-style-type: none"> a. Using non-Plas-Ties material b. Improper threading of material c. Oversized bundle to be tied d. Material jammed at throat of machine 	<ul style="list-style-type: none"> a. Use Plas-Ties material only b. Check spool & ribbon threading c. Do not exceed capacity diameter of the machine d. Press Release Actuator (See figure III-10 on page 12) to allow the motor to rotate, then remove the jammed material.
B. Machine circuit breaker trips	<ul style="list-style-type: none"> a. Motor locked due to jamming 	<ul style="list-style-type: none"> a. Press circuit breaker (#90 on Appendix A) and remove material causing the jam
C. Material end crushed	<ul style="list-style-type: none"> a. Cutters dull or worn out b. Improperly installed movable cutter 	<ul style="list-style-type: none"> a. Replace worn cutter b. Install properly
D. Machine won't start	<ul style="list-style-type: none"> a. Power cord not connected b. Circuit breaker tripped c. Motor malfunction d. Machine switched off e. Cover micro switch not activated. 	<ul style="list-style-type: none"> a. Connect to outlet b. Reset circuit breaker c. Replace motor d. Check ON/OFF switch e. Check switch connection
E. Missing Ties	<ul style="list-style-type: none"> a. Loosely wound ribbon on spool b. Oil or grease on material or feed drum c. Defective spool brake spring d. Pinion channel obstructed e. Package too big 	<ul style="list-style-type: none"> a. Rethread material taut b. Clean material feed drum c. Replace spring d. Clean channel f. Use larger model of machine
F. Tie length short	<ul style="list-style-type: none"> a. Oil or grease on material feed drum b. Brake arm binding c. Material snag in spool 	<ul style="list-style-type: none"> a. Clean with appropriate solvent b. Check material alignment on spool c. Take out snag and rethread
G. Machine won't stop at end of cycle	<ul style="list-style-type: none"> a. Defective limit switch b. Defective motor 	<ul style="list-style-type: none"> a. Replace switch b. Replace motor

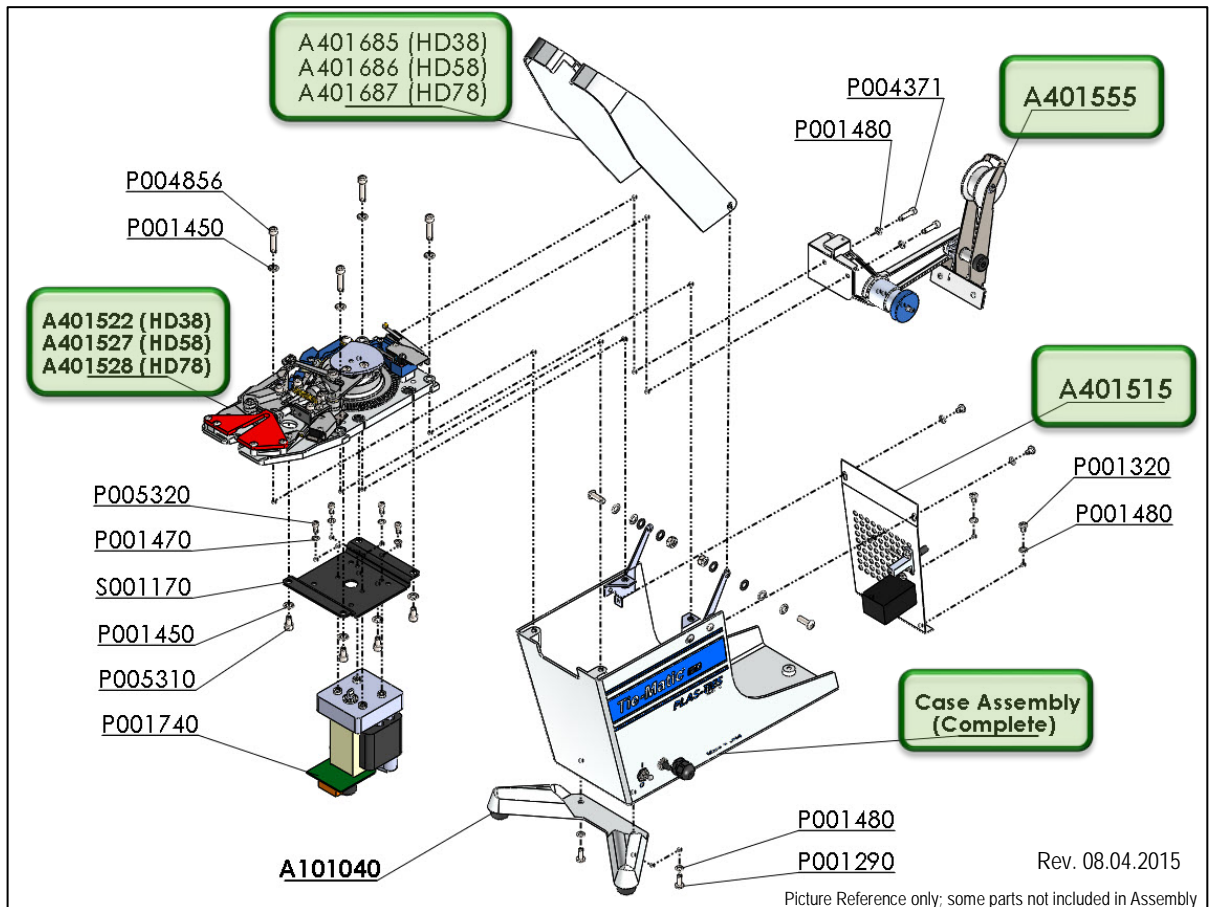
TIE-MATIC HD ASSEMBLIES



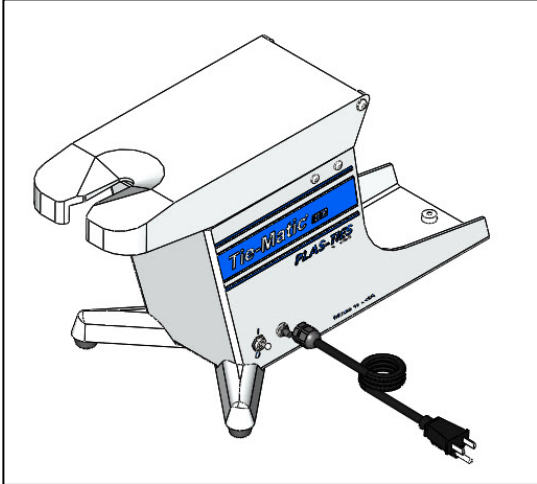
Part #	Description	Qty
A101040	HD Foot Stabilizer Assembly	1
A401515	Case Divider Assembly	1
A401522	HD38 Complete Frame Assembly	1
A401527	HD58 Complete Frame Assembly	
A401528	HD78 Complete Frame Assembly	
A401555	Complete HD Brake Assembly	1
Case Assembly	Complete HD Case Assembly	1
A401685	Cover Assembly HD38	1
A401686	Cover Assembly HD58	
A401687	Cover Assembly HD78	
P001290	10-32 X 1/2 Phillips Screw	2
P001320	10-32 X 1/4 Phillips Pan Head SS	4
P001450	1/4" Lockwasher - Internal Tooth	8
P001470	Lockwasher - Internal Tooth # 8	4
P001480	#10 Lockwasher - Internal Tooth	8
P001740	Motor - Gear	1
P004371	10-32 X 3/4 SHCS	2
P004856	1/4-20 X 1 Socket Head Cap Screw Stainless	4
P005310	1/4-20 X 3/8 SHCS	4
P005320	8-32 X 5/16 SHCS Stainless	4
S001170	Plate - Motor Mount	1

Not shown in explosion:

A701060	Top Limit Switch	1
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TIE-MATIC CASE ASSEMBLY (COMPLETE)

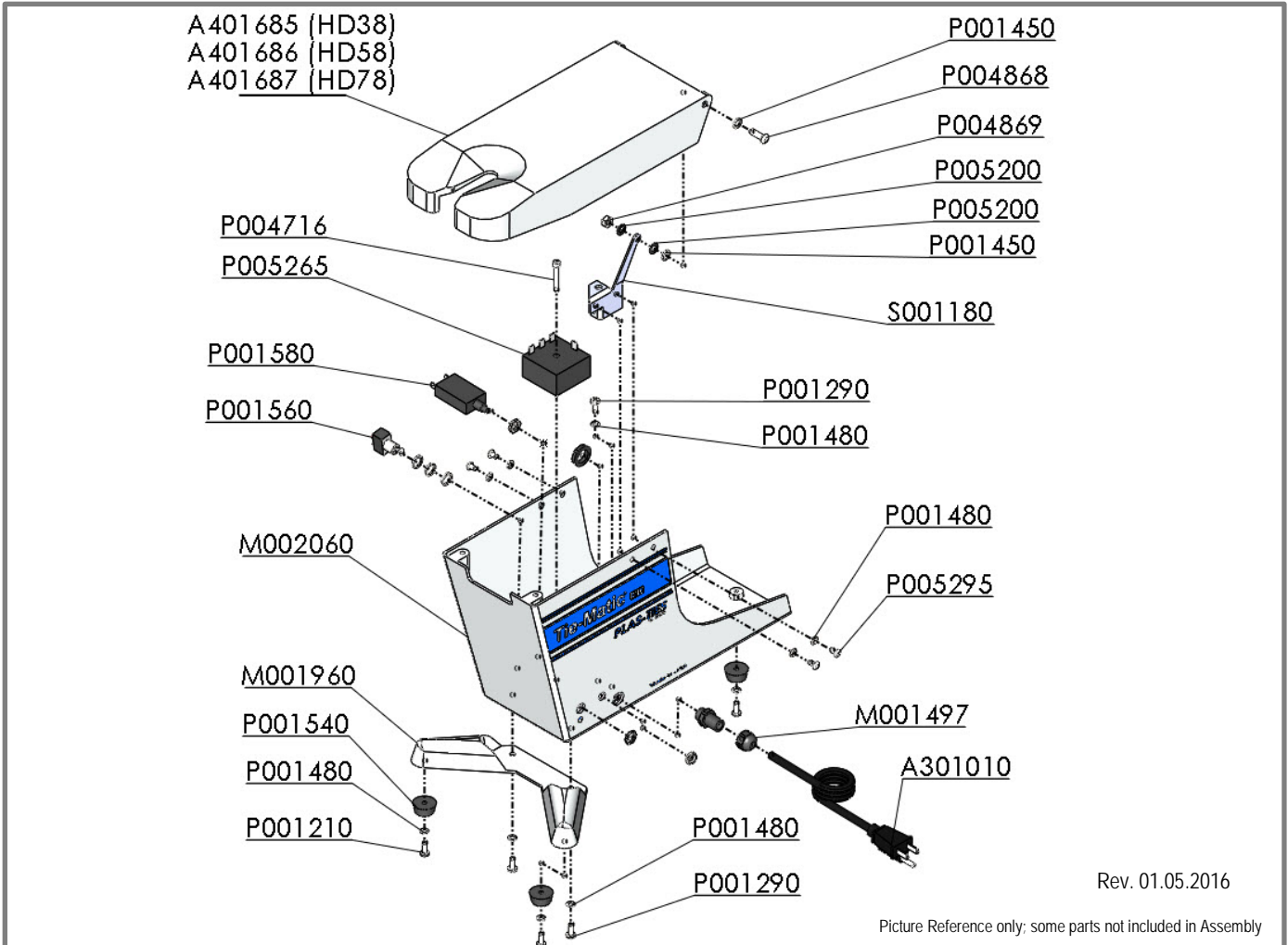


PART #	DESCRIPTION	QTY.
A401685	HD38 Cover Assembly	1
A401686	HD58 Cover Assembly	
A401687	HD78 Cover Assembly	
A301010	Power Cord	1
M001497	Strain Relief Connector	1
M001960	Foot Stabilizer	1
M002060	HD Tie-Matic Case	1
P001210	10-32 X 1/2 For Foot Stabilizers	3
P001290	10-32 x 1/2" Philips Screw	3
P001450	1/4 Internal Lock washer	4
P001480	#10 Tooth Lock Washer	10
P001540	Rubber Foot	3
P001560	Switch - On/Off	1
P001580	Circuit Breaker - 115v 2 amp	1
P004716	10-32 X1-1/4 Socket Head CapScrew	1
P004868	1/4-20 x 3/4" Button Head Cap Screw SS	2
P004869	1/4-20 Nylon Insert Locknut	2
P005200	Wave Disc Washer	4
P005265	Abb Solid State Timer	1
P005295	10-32 x 5/16 Button Cap Screw	4
S001180*	Support Bracket Hinge	2

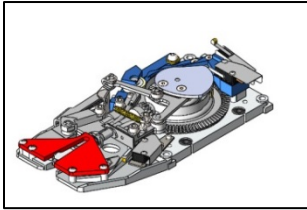
* Support Bracket Hinge sold as pair, left and right ship together.

Not shown in explosion:

A601020	Wire Harness (includes P005265)	1
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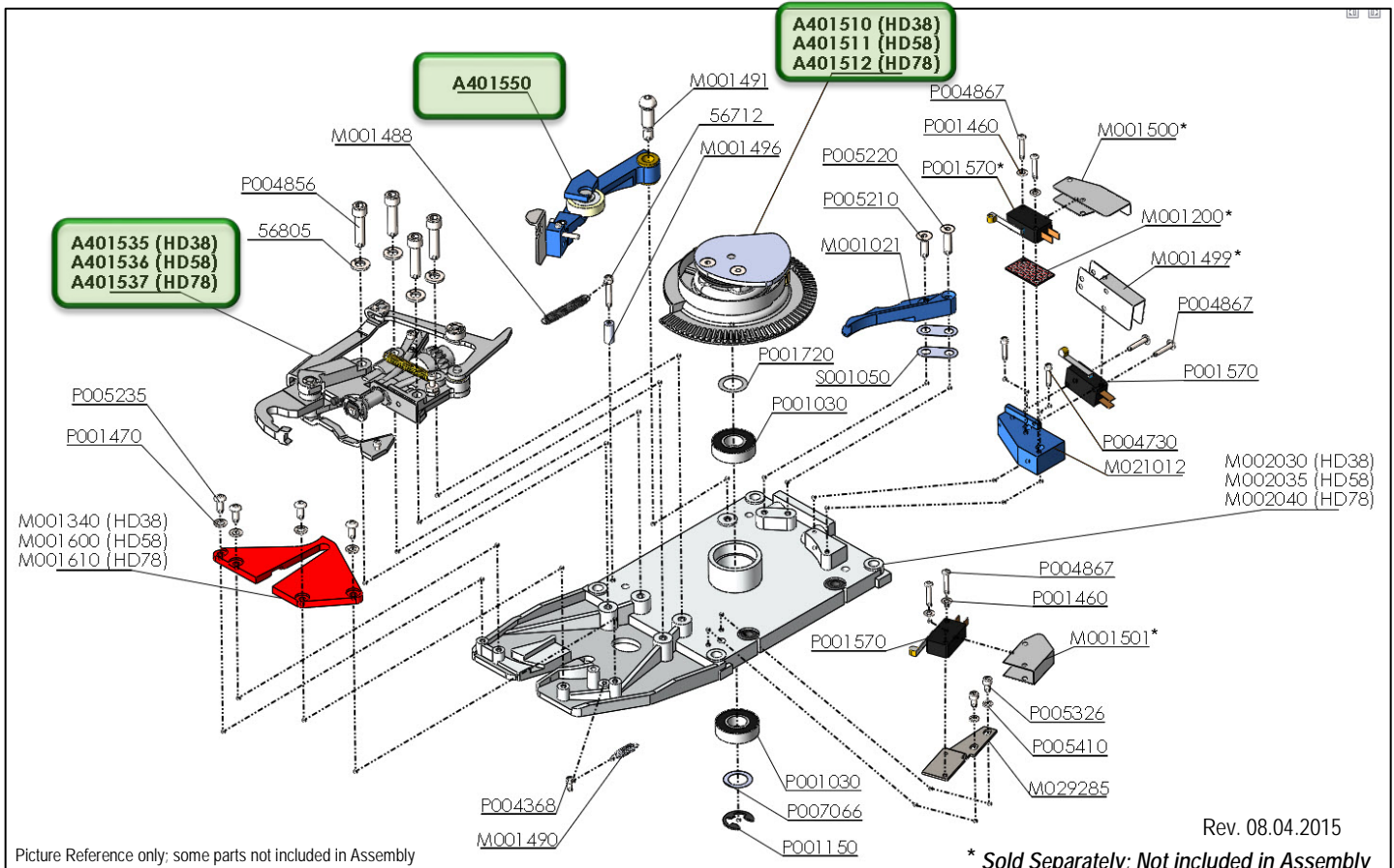
TIE-MATIC COMPLETE FRAME ASSEMBLY



A401522 (HD38)
A401527 (HD58)
A401528 (HD78)

PART #	DESCRIPTION	QTY.
56712	6-32 x 3/4" Socket Head Cap Screw	1
56805	1/4 Split Lock Washer	4
A401510	HD 38 Complete Gear Segment Assembly	1
A401511	HD 58 Complete Gear Segment Assembly	
A401512	HD78 Complete Gear Segment Assembly	
A401535	HD38 Master Pinion Support Assembly	1
A401536	HD58 Master Pinion Support Assembly	
A401537	HD78 Master Pinion Support Assembly	
A401550	Idler Wheel Assembly	1
M001021	Tape Feed Guide	1
M001200*	Switch Insulator Spacer	1
M001340	HD38 Trigger Cover	1
M001600	HD58 Trigger Cover	
M001610	HD78 Trigger Cover	
M001488	Needle Return Spring	1
M001490	HD Trigger Return Spring	1
M001491	Modified Shoulder Bolt 5/16 - 5/8	1
M001496	Needle Return Spring Spacer	1
M001499*	Cover Limit Switch Insulator	1
M001500*	Cam Limit Switch Insulator	1

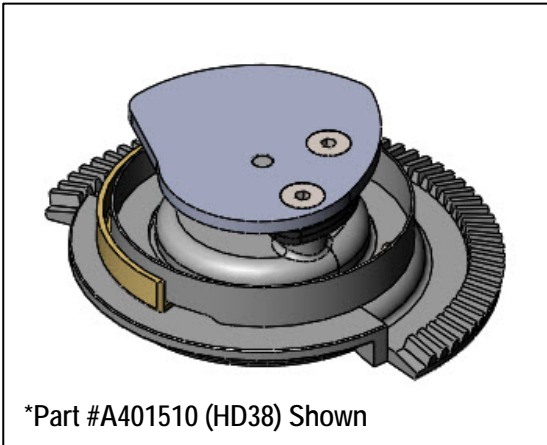
PART #	DESCRIPTION	QTY.
M001501*	Trigger Limit Switch Insulator	1
M002030	HD38 Gear Support Frame	1
M002035	HD58 Gear Support Frame	
M002040	HD78 Gear Support Frame	
M021012	Switch Mount	1
P001150	E Ring	1
P001460	Lockwasher - Internal Tooth #4	6
P001470	#8 Tooth Lock Washer	4
P001550	Grommet	2
P001570*	Micro Switch	3
P001720	Shim	1
P004730	4-40 x 1/2 Socket Head Cap Screw	2
P004856	1/4-20 X 1" Socket Head Cap Screw	4
P004867	4-40 x 5/8" Button Head Cap Screw	6
P005210	10-32 x 5/8 Flat Head Socket Screw	1
P005220	10-32 x 3/4 Flat Head Socket Screw	1
P005235	8-32 X 3/8" Button Head Cap Screw	4
P007066	Shim - 1/2" x 3/4" x 0.012	1
S001050	Tape Guide Shim	2



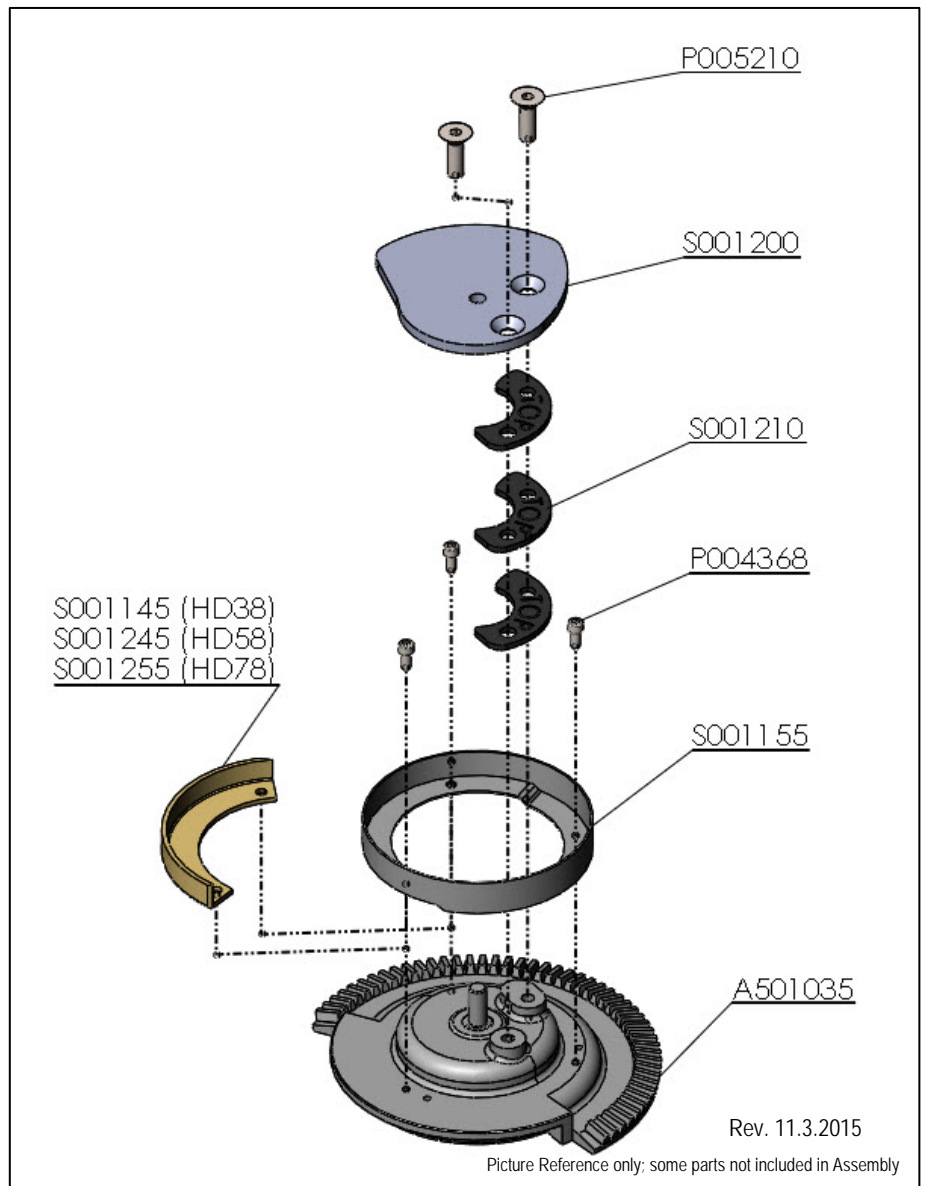
Picture Reference only; some parts not included in Assembly

TIE-MATIC MASTER GEAR SEGMENT ASSEMBLY

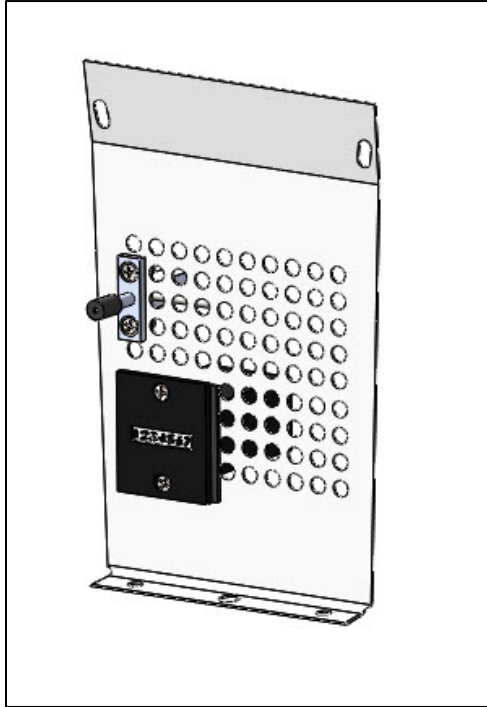
A401510 (HD38)
A401511 (HD58)
A401512 (HD78)



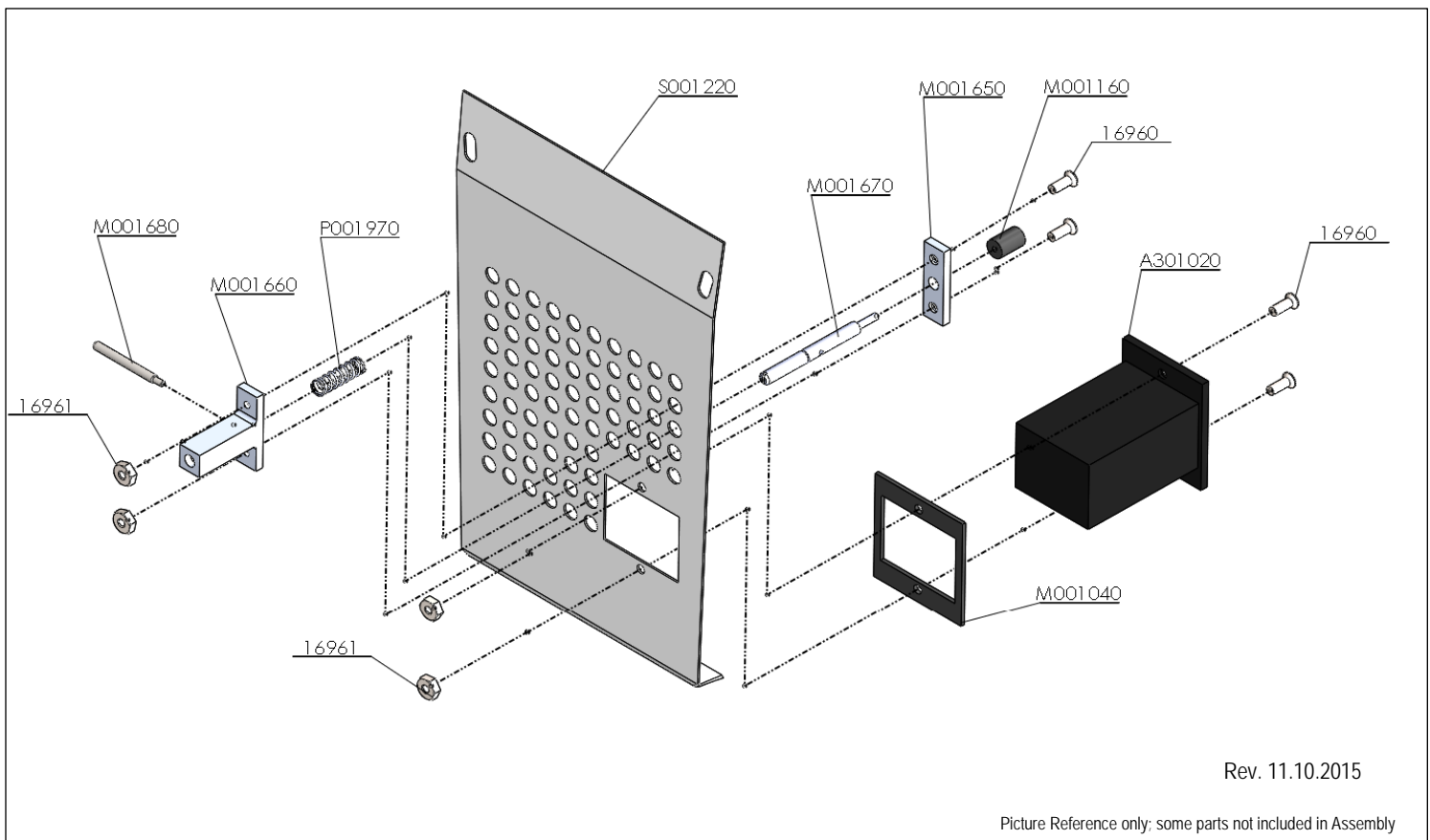
PART #	DESCRIPTION	QTY.
A501035	HD Series Gear Segment	1
P004368	4-40 X 1/4 Socket Head Cap Screw	3
P005210	10-32 x 5/8 Flat Head Socket Screw	2
S001145	HD38 Drum Material Feed (GOLD)	1
S001245	HD 58 Drum Material Feed (SILVER)	
S001255	HD 78 Drum Material Feed (BLACK)	
S001155	Cam Return Guard	1
S001200	Cam Needle	1
S001210	Cam Needle Opening	3



CASE DIVIDER ASSEMBLY (A401515)

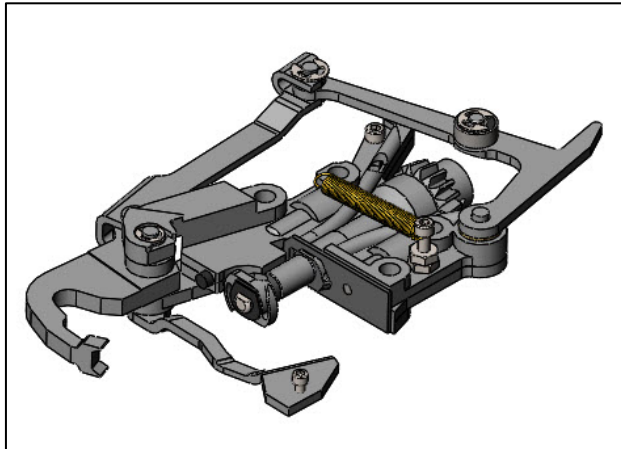


PART #	DESCRIPTION	QTY.
16960	6-32 x 3/8 Philips Flat Head Screw	4
16961	6-32 Nut	4
M001040	Counter Seal	1
M001160	Needle Stop Cushion	1
M001650	Plate	1
M001660	Motor Release Actuator Housing	1
M001670	Motor Release Actuator Shaft	1
M001680	Release Actuator Bar	1
A301020	Counter Assembly	1
P001970	Motor Release Actuator Spring	1
S001220	Case Divider	1

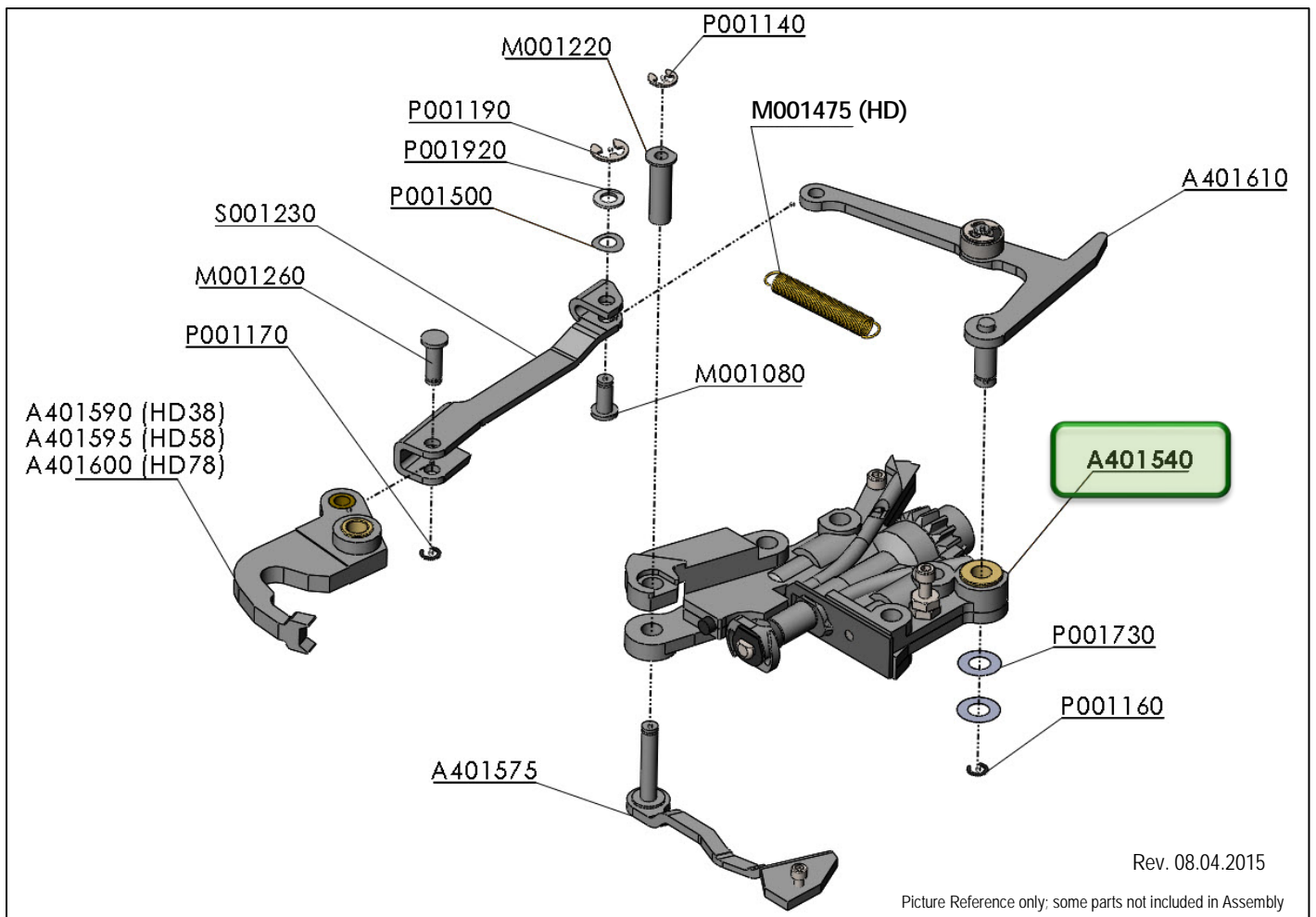


TIE-MATIC MASTER PINION SUPPORT ASSEMBLY

A401535 (HD38)
A401536 (HD58)
A401537 (HD78)



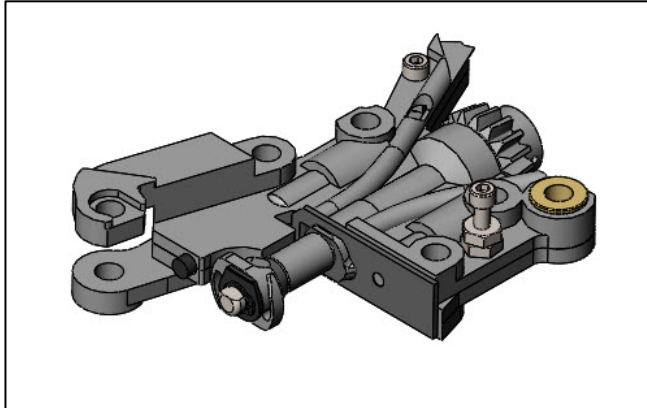
PART #	DESCRIPTION	QTY.
A401540	Pinion Support Assembly	1
A401575	Trigger Lever Assembly HD	1
A401590	HD 38 Needle Assembly	1
A401595	HD 58 Needle Assembly	
A401600	HD 78 Needle Assembly	
A401610	Actuating Lever-Needle Assembly	1
M001080	Needle Lever Clevis Pin	1
M001220	Sleeve	1
M001260	Idler wheel Pin	1
M001475	HD Tension Idler Arm Spring	1
P001140	E-Ring	1
P001160	Snap Ring	1
P001170	Retaining Ring	1
P001190	0.188 "E" Retaining Ring	1
P001500	Curved Spring Washer #10	1
P001730	Pinion Support Shim - 0.26 x 0.5 x 0.005	2
P001920	Nylon Washer #8	1
S001230	Needle Operating Link	1



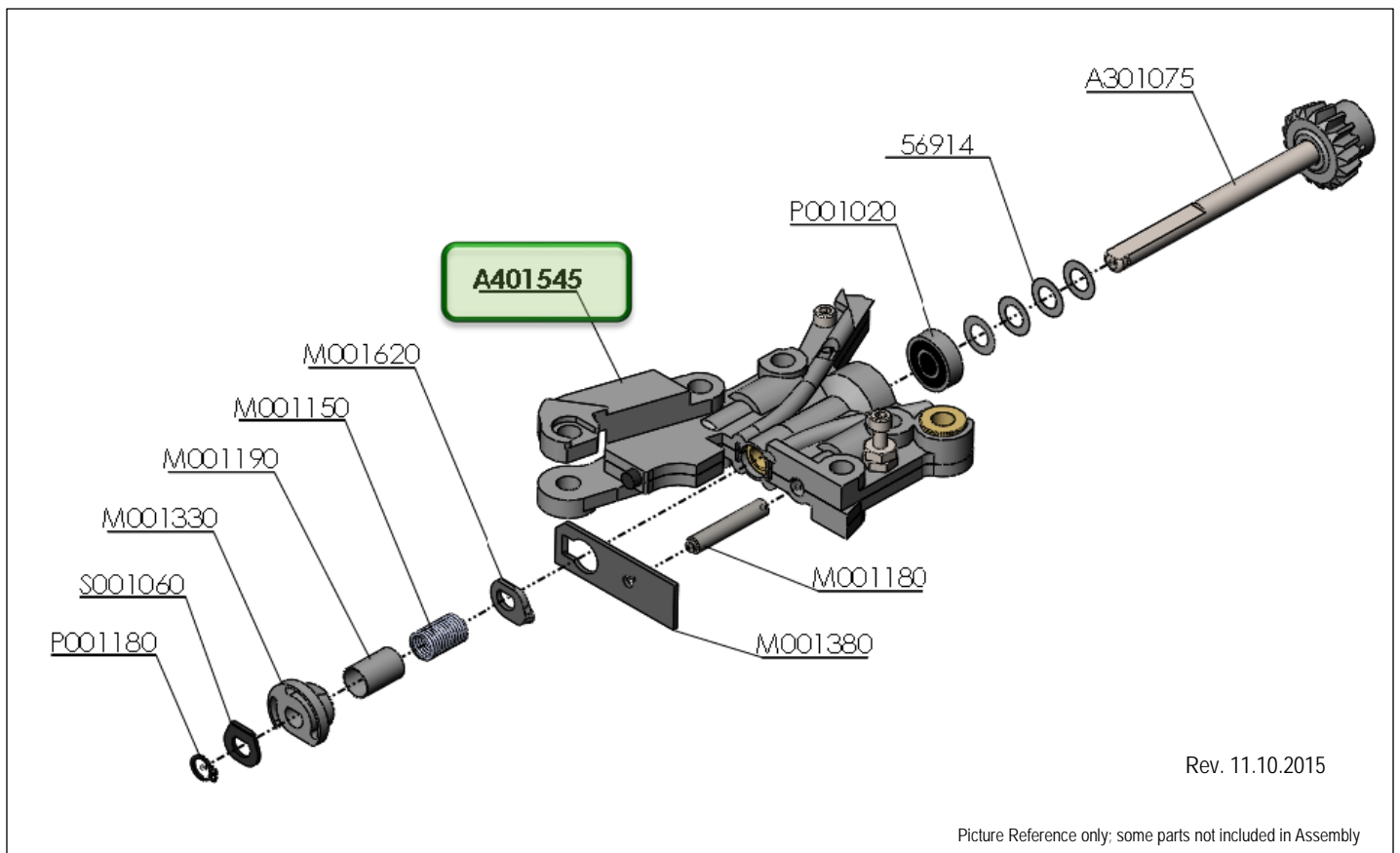
Rev. 08.04.2015

Picture Reference only; some parts not included in Assembly

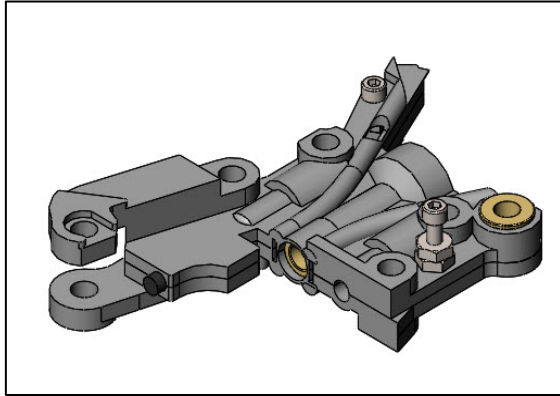
TIE-MATIC PINION SUPPORT ASSEMBLY (A401540)



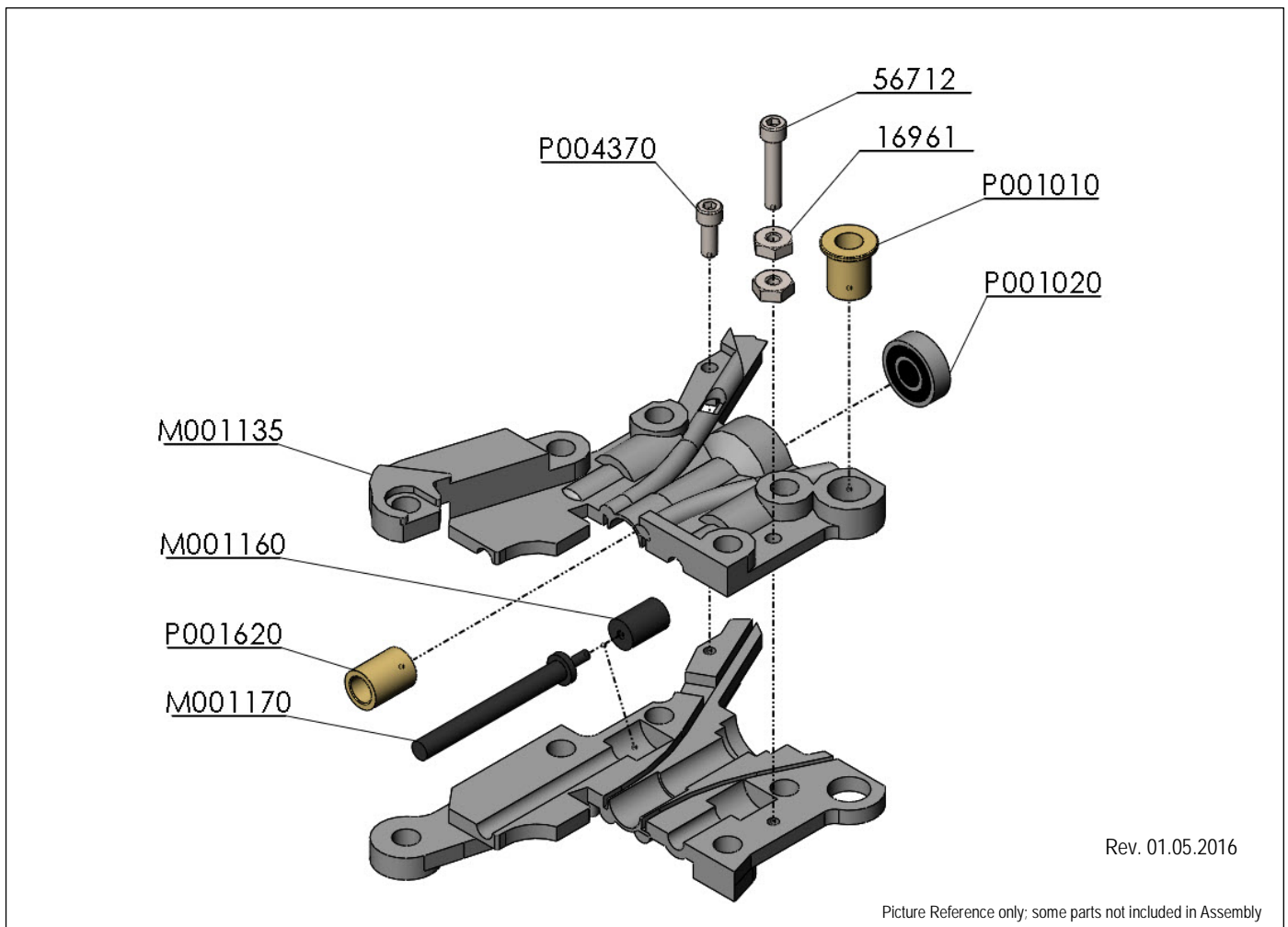
PART #	DESCRIPTION	QTY.
56914	Shim .250 x .437 x .005	4
A301075	HD Pinion/ Shaft Assembly	1
A401545	HD Pinion Support Sub Assembly	1
M001150	Cutter Spring	1
M001180	Locating Cutter Pin	1
M001190	Spring Cover	1
M001330	Twister Ribbon	1
M001380	Cutter Plate	1
M001620	Moveable Cutter	1
P001020	Bearing - Radial Ball <i>(Internal part of #A401545)</i>	1
P001180	1/4 External Retaining Ring	1
S001060	Ribbon Deflector	1



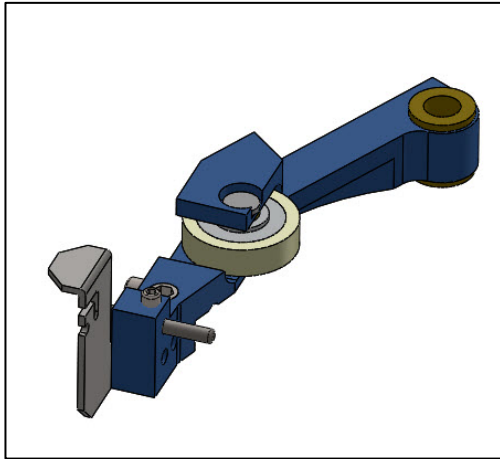
TIE-MATIC PINION SUPPORT SUB ASSEMBLY (A401545)



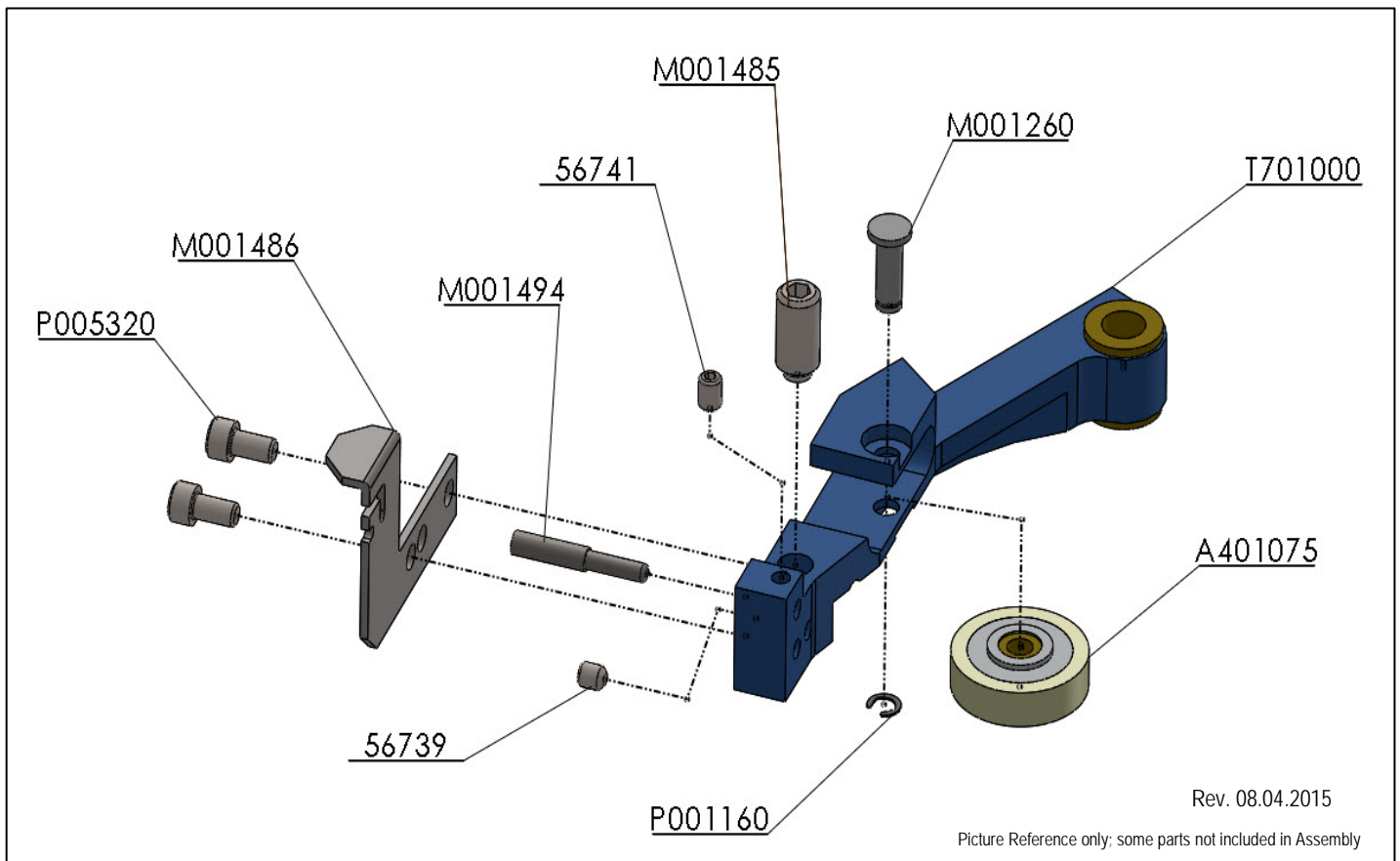
PART #	DESCRIPTION	QTY.
16961	6-32 Nut	2
56712	6-32 x 3/4" Socket Head Cap Screw	1
M001135	Pinion Support (2 pieces)	1
M001160	Needle Stop Cushion	1
M001170	Needle Stop	1
P001010	Bushing	1
P001020	Bearing	1
P001620	Bushing	1
P004370	6-32 X 3/8 Socket Head Cap Screw	1



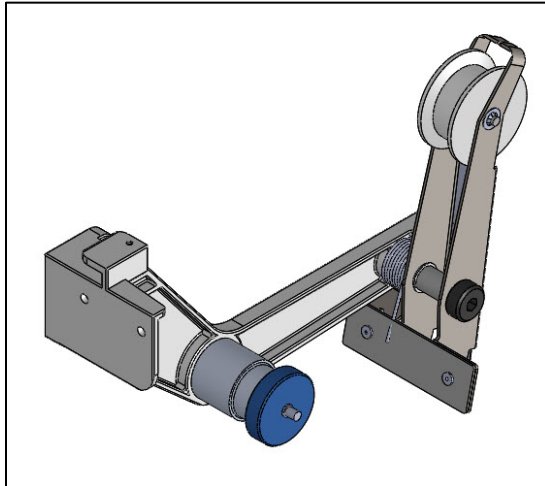
TIE-MATIC HD IDLER ARM ASSEMBLY (A401550)



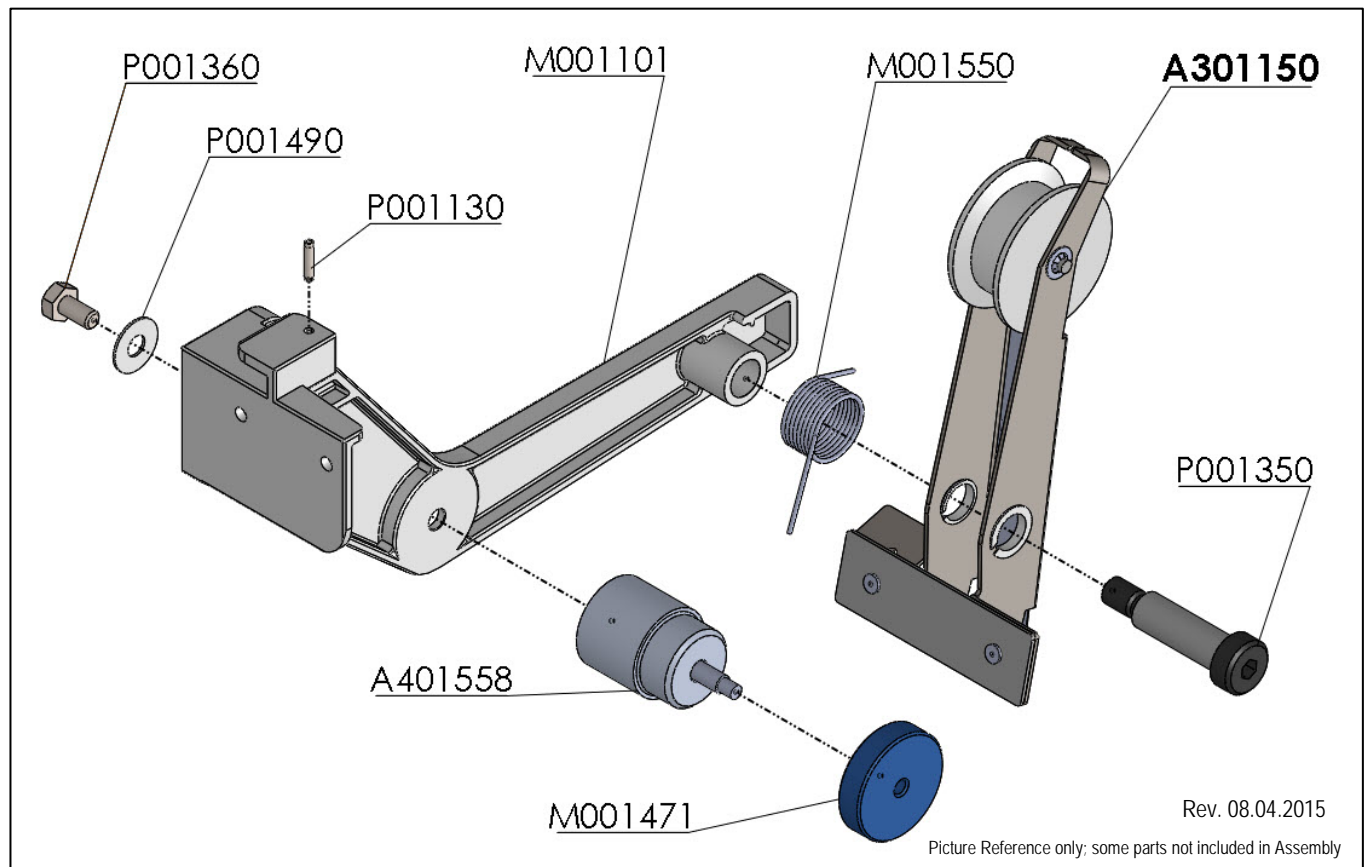
PART #	DESCRIPTION	QTY.
56739	8-32 X 3/16 Hex Socket Set Screw	1
56741	8-32 x 1/4 Socket Set Screw	1
A401075	Wheel Complete Assembly	1
M001260	Idler wheel Pin	1
M001485	Modified Set Screw	1
M001486	Pivot Bracket	1
M001494	Modified Set Screw	1
P001160	Snap Ring	1
P005320	8-32 x 5/16" Socket Head Cap Screw Stainless	2
T701000	Pivot Arm with Bushings	1



TIE-MATIC COMPLETE HD BRAKE ASSEMBLY (A401555)



PART #	DESCRIPTION	QTY.
A301150	Brake Arm Spool Assembly	1
A401558	Spindle Assembly	1
M001101	Spool Brake Beam Support	1
M001471	Knurled Knob	1
M001550	Brake Arm Spring	1
P001130	0.125 x 0.563 Roll Pin	1
P001350	3/8-16 X 1/2 X 1-1/2 Socket Head Shoulder Screw	1
P001360	1/4-20 X 1/2" Hex Bolt	1
P001490	Nylon Washer	1



TIE-MATIC HD38 SPARE PARTS KIT (K004038)							
PART	QTY	DESCRIPTION		PART	QTY	DESCRIPTION	
56805	4		1/4 Split Lock Washer	P001160	4		External Snap Ring
56914	4		Shim 0.250 x 0.437 x 0.005	P001170	4		Crescent External Ring
A301075	1		HD Pinion Gear Assembly	P001190	4		Snap Ring
A501035	1		Gear Segment Assembly For HD Series	P001500	2		#10 Curved Spring Washer
M001080	1		Pin - Clevis	P001730	2		Pinion Support Shim 0.26 x 0.5 x 0.005
M001160	1		Needle Stop Cushion	P001150	4		E-Ring - Bowed
M001200	1		Spacer - Switch (505)	P001450	8		1/4" Lockwasher - Internal Tooth
M001220	1		Sleeve - Needle Pivot	P001460	6		#4 Lockwasher Internal Tooth
M001260	1		Pin - Idler Wheel	P001470	4		#8 Internal Tooth Washer
M001488	1		Spring - Needle Return	P001480	8		#10 Lockwasher - Internal Tooth
M001475	1		HD38/58/78 Idler Arm Tension Spring	P001570	3		Micro Switch - 110v
M001490	1		Spring - Trigger Return	P001720	2		Shim: 0.503 X 0.748 X 0.004
M001499	1		Insulator Switch - 1	P001740	1		Motor - Gear
M001500	1		Insulator Switch - 2	P001920	2		Washer - Nylon No.8
M001501	1		Switch Insulator	P005320	1		8-32 X 5/16 Socket Head Cap Screw
M001620	1		Cutter For All Tie-Matic's & HD's	P007066	1		Shim 0.012 x 0.5 ID x 0.75 OD
P001010	1		Bushing Flanged FB46-4	S001145	1		Drum Material Feed HD38
P001140	4		E-Ring				

Parts for reference only; not scaled to size

TIE-MATIC HD58 SPARE PARTS KIT (K004058)							
PART	QTY		DESCRIPTION	PART	QTY		DESCRIPTION
56805	4		1/4 Split Lock Washer	P001160	4		External Snap Ring
56914	4		Shim 0.250 x 0.437 x 0.005	P001170	4		Crescent External Ring
A301075	1		HD Pinion Gear Assembly	P001190	4		Snap Ring
A501035	1		Gear Segment Assembly For HD Series	P001500	2		#10 Curved Spring Washer
M001080	1		Pin - Clevis	P001730	2		Pinion Support Shim 0.26 x 0.5 x 0.005
M001160	1		Needle Stop Cushion	P001150	4		E-Ring - Bowed
M001200	1		Spacer - Switch (505)	P001450	8		1/4" Lockwasher - Internal Tooth
M001220	1		Sleeve - Needle Pivot	P001460	6		#4 Lockwasher Internal Tooth
M001260	1		Pin - Idler Wheel	P001470	4		#8 Internal Tooth Washer
M001488	1		Spring - Needle Return	P001480	8		#10 Lockwasher - Internal Tooth
M001475	1		HD38/58/78 Idler Arm Tension Spring	P001570	3		Micro Switch - 110v
M001490	1		Spring - Trigger Return	P001720	2		Shim: 0.503 X 0.748 X 0.004
M001499	1		Insulator Switch - 1	P001740	1		Motor - Gear
M001500	1		Insulator Switch - 2	P001920	2		Washer - Nylon No.8
M001501	1		Switch Insulator	P005320	1		8-32 X 5/16 Socket Head Cap Screw
M001620	1		Cutter For All Tie-Matic's & HD's	P007066	1		Shim 0.012 x 0.5 ID x 0.75 OD
P001010	1		Bushing Flanged FB46-4	S001245	1		Drum Material Feed HD58
P001140	4		E-Ring				

Parts for reference only; not scaled to size

TIE-MATIC HD78 SPARE PARTS KIT (K004078)							
PART	QTY	DESCRIPTION	PART	QTY	DESCRIPTION		
56805	4	 1/4 Split Lock Washer	P001160	4	 External Snap Ring		
56914	4	 Shim 0.250 x 0.437 x 0.005	P001170	4	 Crescent External Ring		
A301075	1	 HD Pinion Gear Assembly	P001190	4	 Snap Ring		
A501035	1	 Gear Segment Assembly For HD Series	P001500	2	 #10 Curved Spring Washer		
M001080	1	 Pin - Clevis	P001730	2	 Pinion Support Shim 0.26 x 0.5 x 0.005		
M001160	1	 Needle Stop Cushion	P001150	4	 E-Ring - Bowed		
M001200	1	 Spacer - Switch {505}	P001450	8	 1/4" Lockwasher - Internal Tooth		
M001220	1	 Sleeve - Needle Pivot	P001460	6	 #4 Lockwasher Internal Tooth		
M001260	1	 Pin - Idler Wheel	P001470	4	 #8 Internal Tooth Washer		
M001488	1	 Spring - Needle Return	P001480	8	 #10 Lockwasher - Internal Tooth		
M001475	1	 HD 38/58/78 Idler Arm Tension Spring	P001570	3	 Micro Switch - 110v		
M001490	1	 Spring - Trigger Return	P001720	2	 Shim: 0.503 X 0.748 X 0.004		
M001499	1	 Insulator Switch - 1	P001740	1	 Motor - Gear		
M001500	1	 Insulator Switch - 2	P001920	2	 Washer - Nylon No.8		
M001501	1	 Switch Insulator	P005320	1	 8-32 X 5/16 Socket Head Cap Screw		
M001620	1	 Cutter For All Tie-Matic's & HD's	P007066	1	 Shim 0.012 x 0.5 ID x 0.75 OD		
P001010	1	 Bushing Flanged FB46-4	S001255	1	 Drum Material Feed HD78		
P001140	4	 E-Ring					

Parts for reference only; not scaled to size

TIE-MATIC

HD38, HD58 & HD78 MACHINES

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