



# PARTS CHART

FOR THE

## TIE-MATIC

HD38, HD58 & HD78 MACHINES  
110V



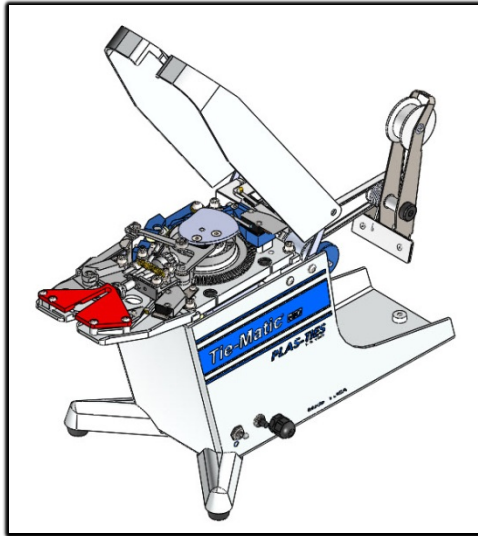
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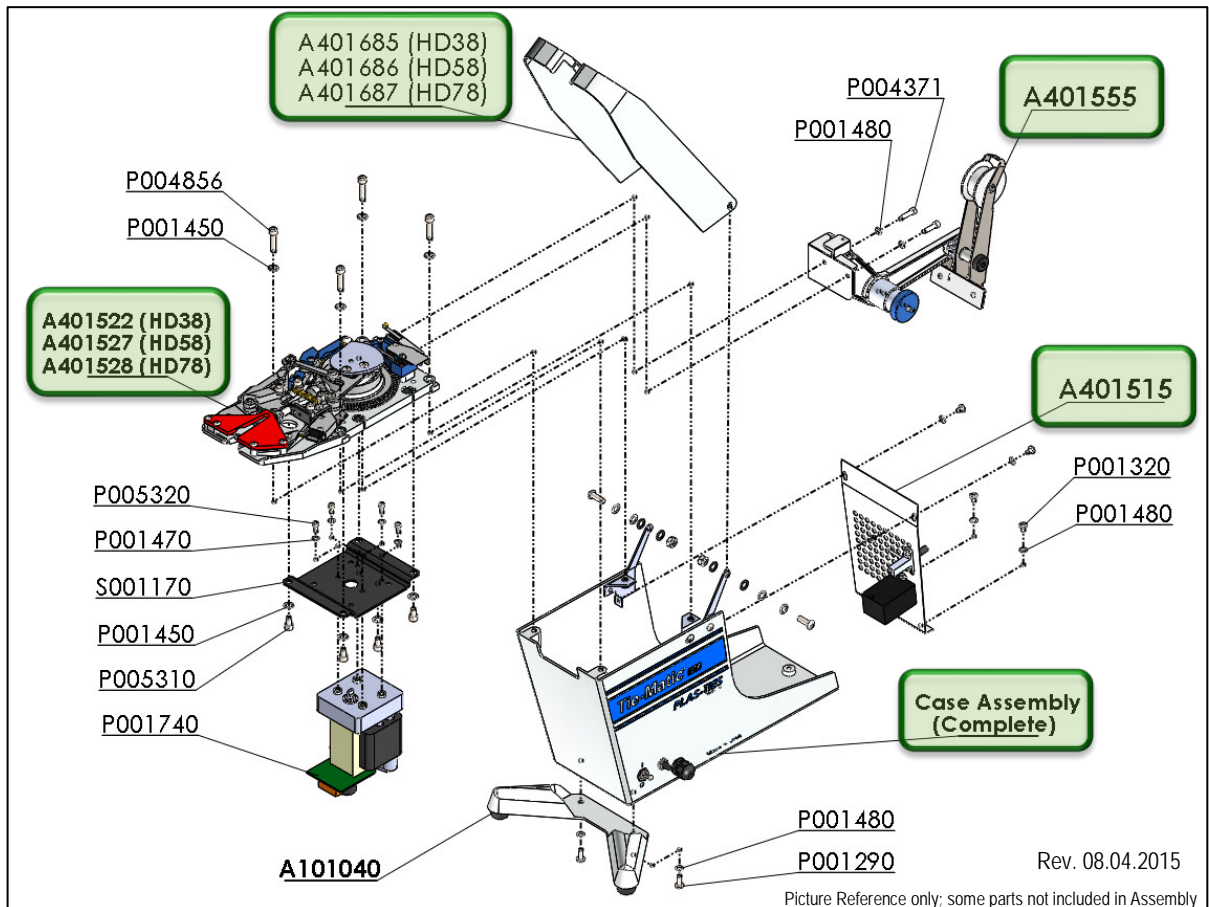
### TIE-MATIC HD ASSEMBLIES



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:

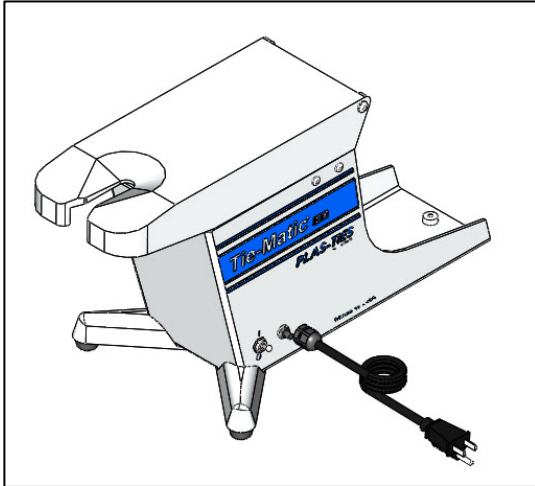
A701060	Top Limit Switch	1
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Rev. 08.04.2015

Picture Reference only; some parts not included in Assembly

## TIE-MATIC CASE ASSEMBLY (COMPLETE)

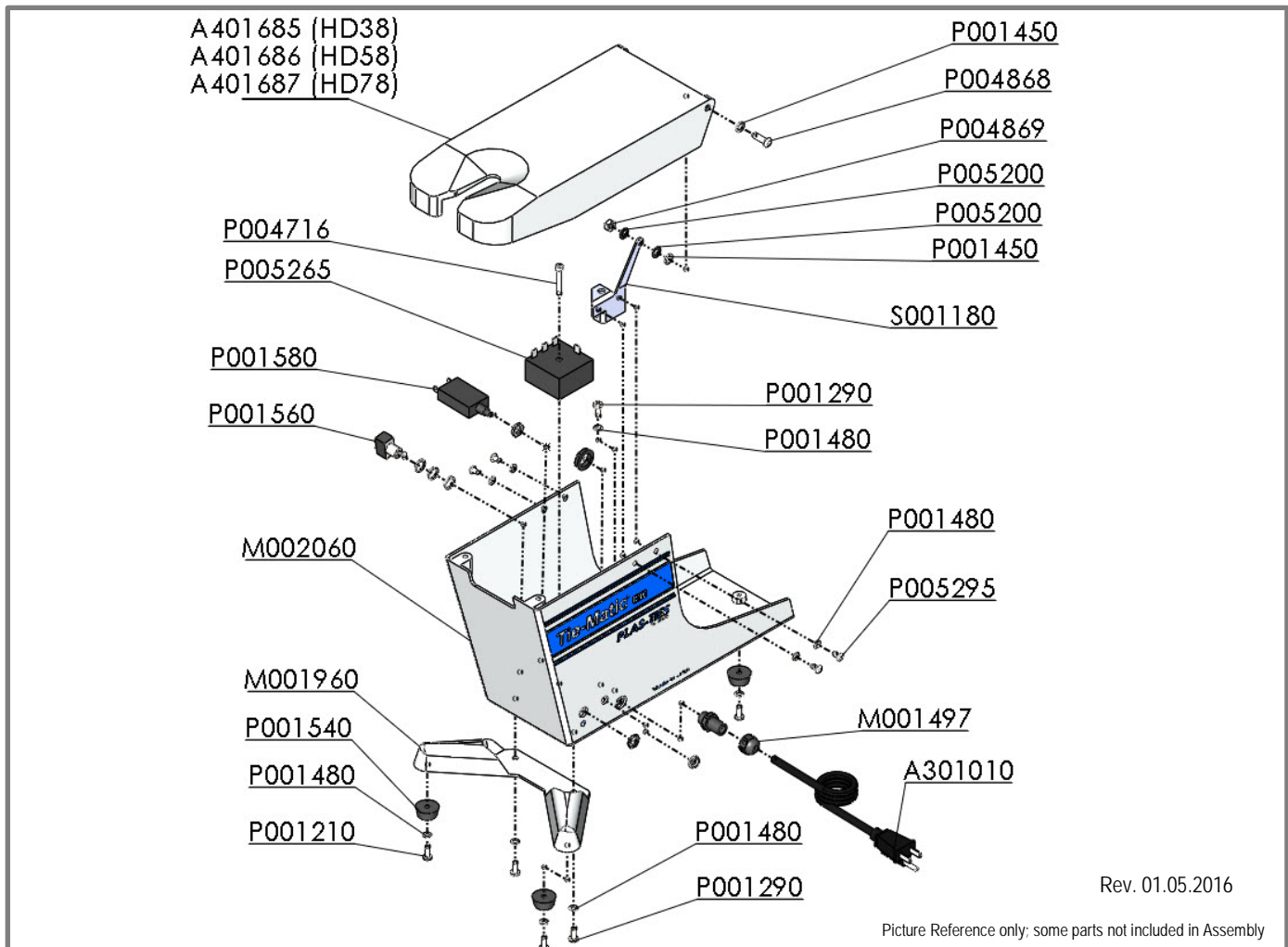


PART #	DESCRIPTION	QTY.
A401685	HD38 Cover Assembly	1
A401686	HD58 Cover Assembly	
A401687	HD78 Cover Assembly	
A301010	Power Cord	1
M001497	Strain Relief Connector	1
M001960	Foot Stabilizer	1
M002060	HD Tie-Matic Case	1
P001210	10-32 X 1/2 For Foot Stabilizers	3
P001290	10-32 x 1/2" Philips Screw	3
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:*

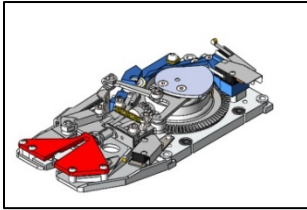
A601020	Wire Harness (includes P005265)	1
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Rev. 01.05.2016

Picture Reference only; some parts not included in Assembly

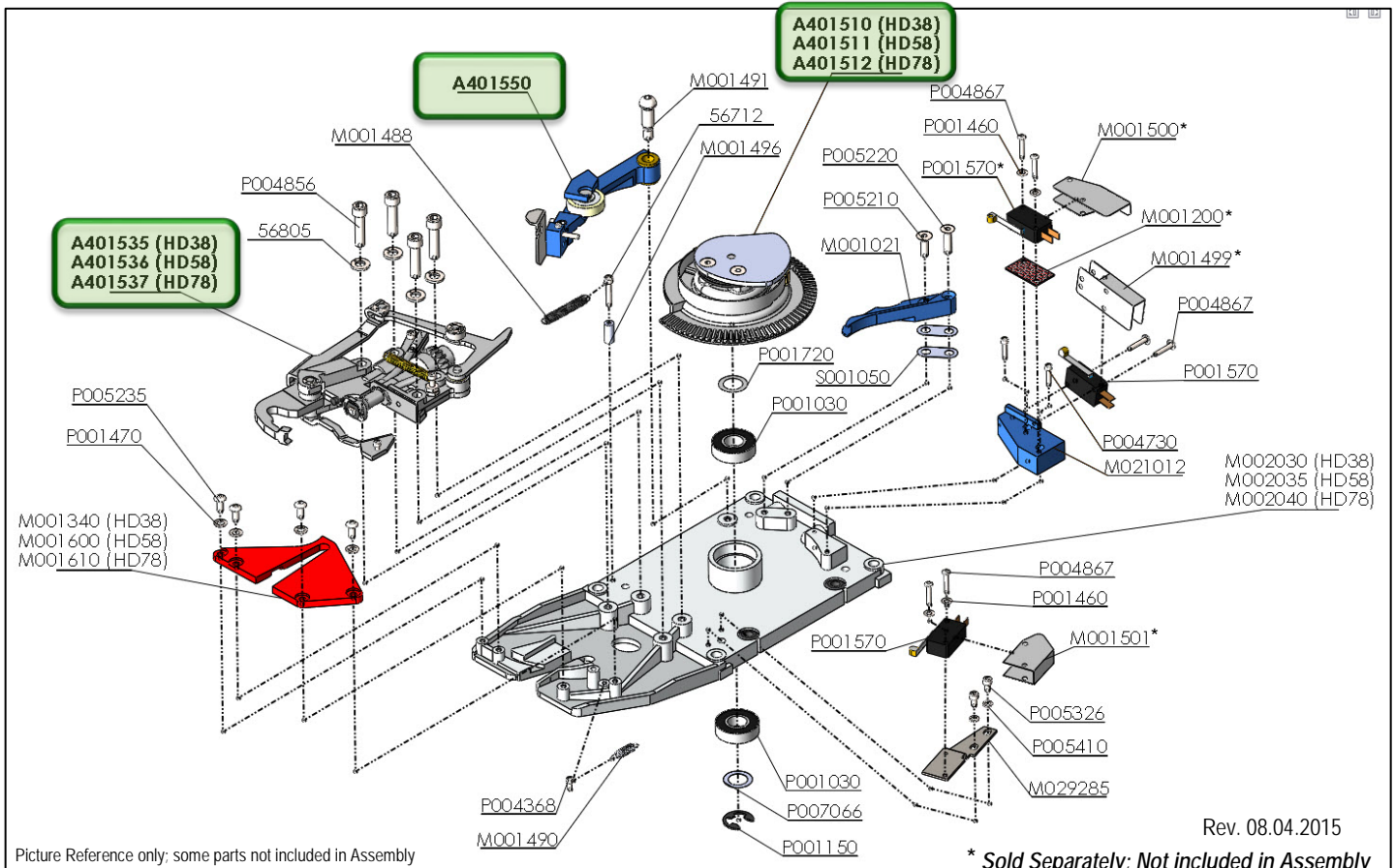
## TIE-MATIC COMPLETE FRAME ASSEMBLY



**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



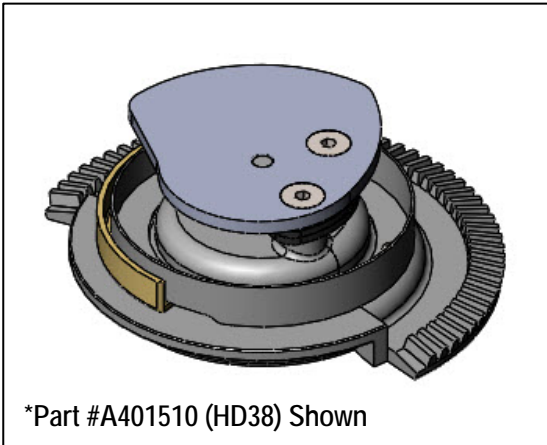
Picture Reference only; some parts not included in Assembly

Rev. 08.04.2015

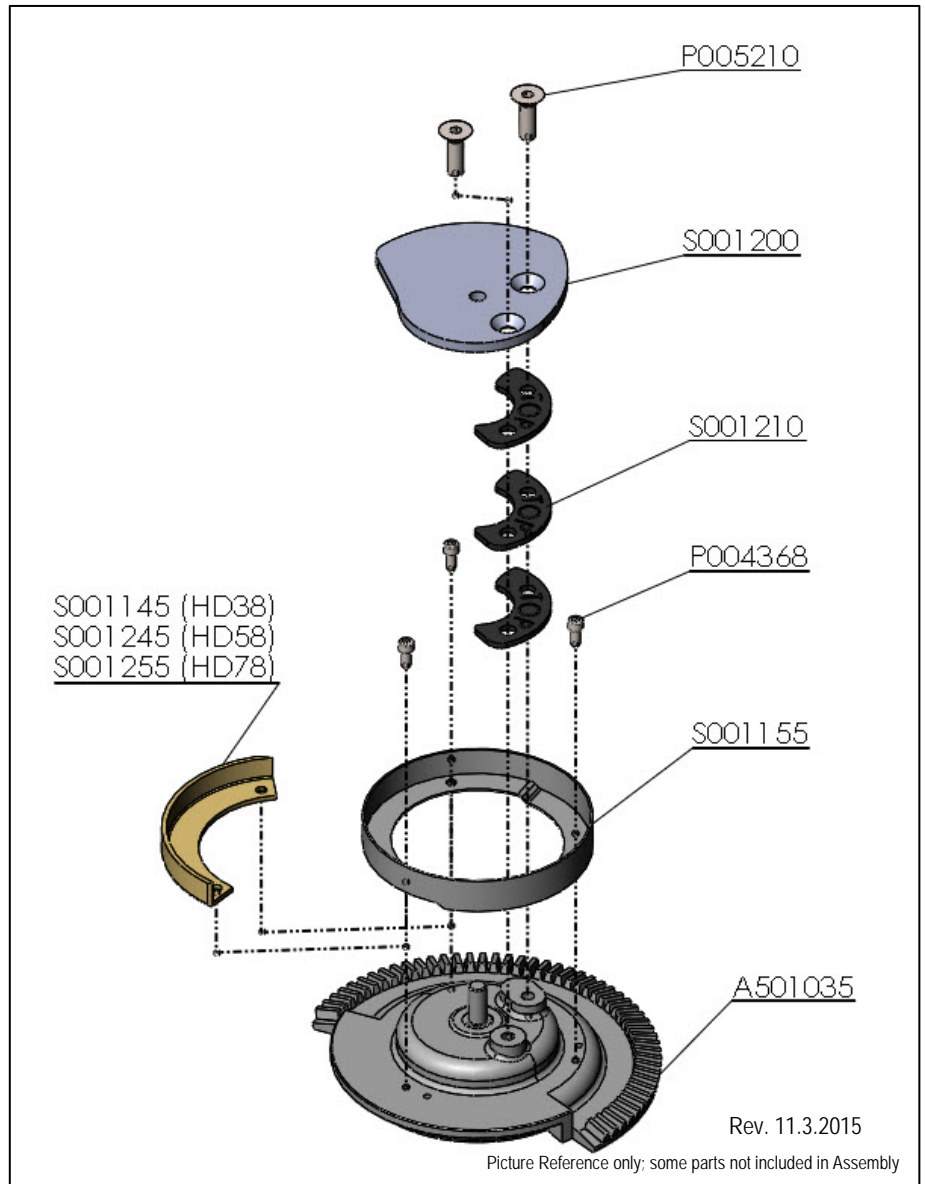
\* Sold Separately; Not included in Assembly

## TIE-MATIC MASTER GEAR SEGMENT ASSEMBLY

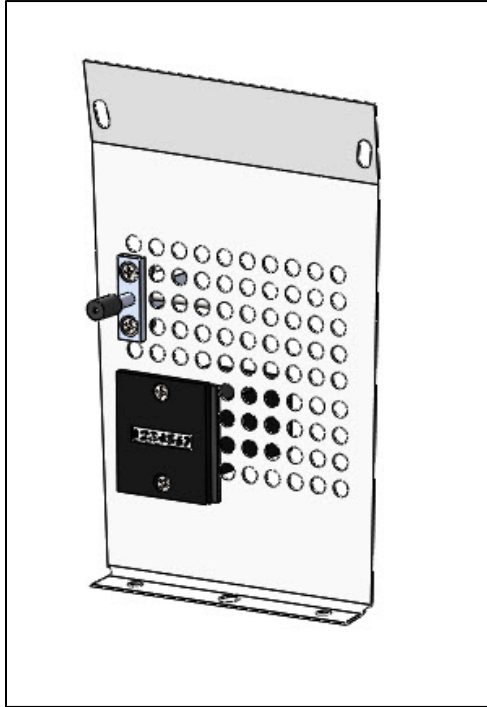
**A401510 (HD38)**  
**A401511 (HD58)**  
**A401512 (HD78)**



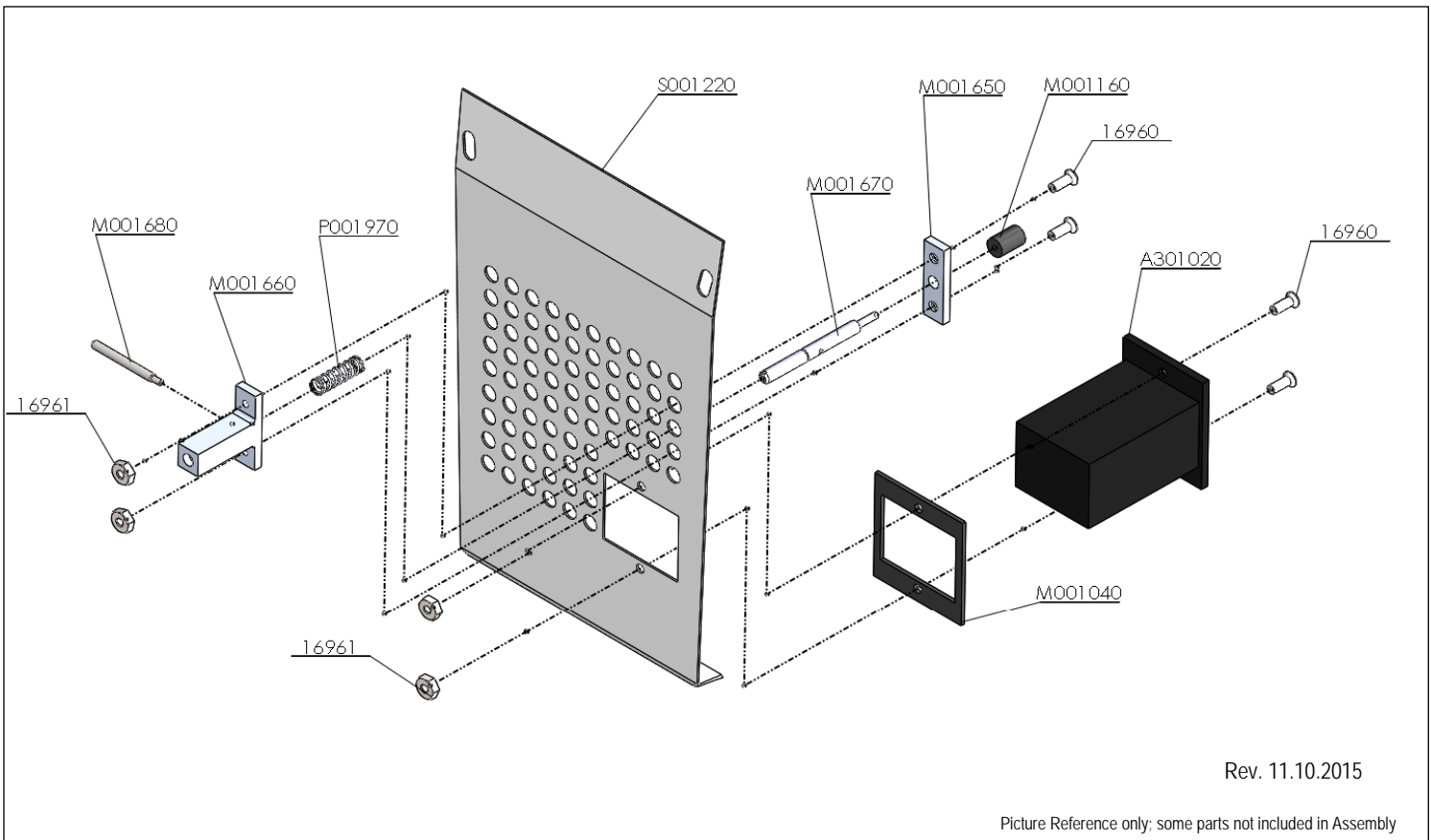
PART #	DESCRIPTION	QTY.
A501035	HD Series Gear Segment	1
P004368	4-40 X 1/4 Socket Head Cap Screw	3
P005210	10-32 x 5/8 Flat Head Socket Screw	2
S001145	HD38 Drum Material Feed (GOLD)	1
S001245	HD 58 Drum Material Feed (SILVER)	
S001255	HD 78 Drum Material Feed (BLACK)	
S001155	Cam Return Guard	1
S001200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

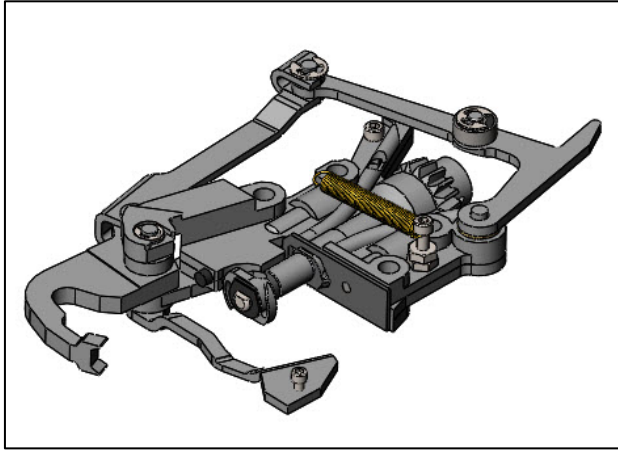


Rev. 11.10.2015

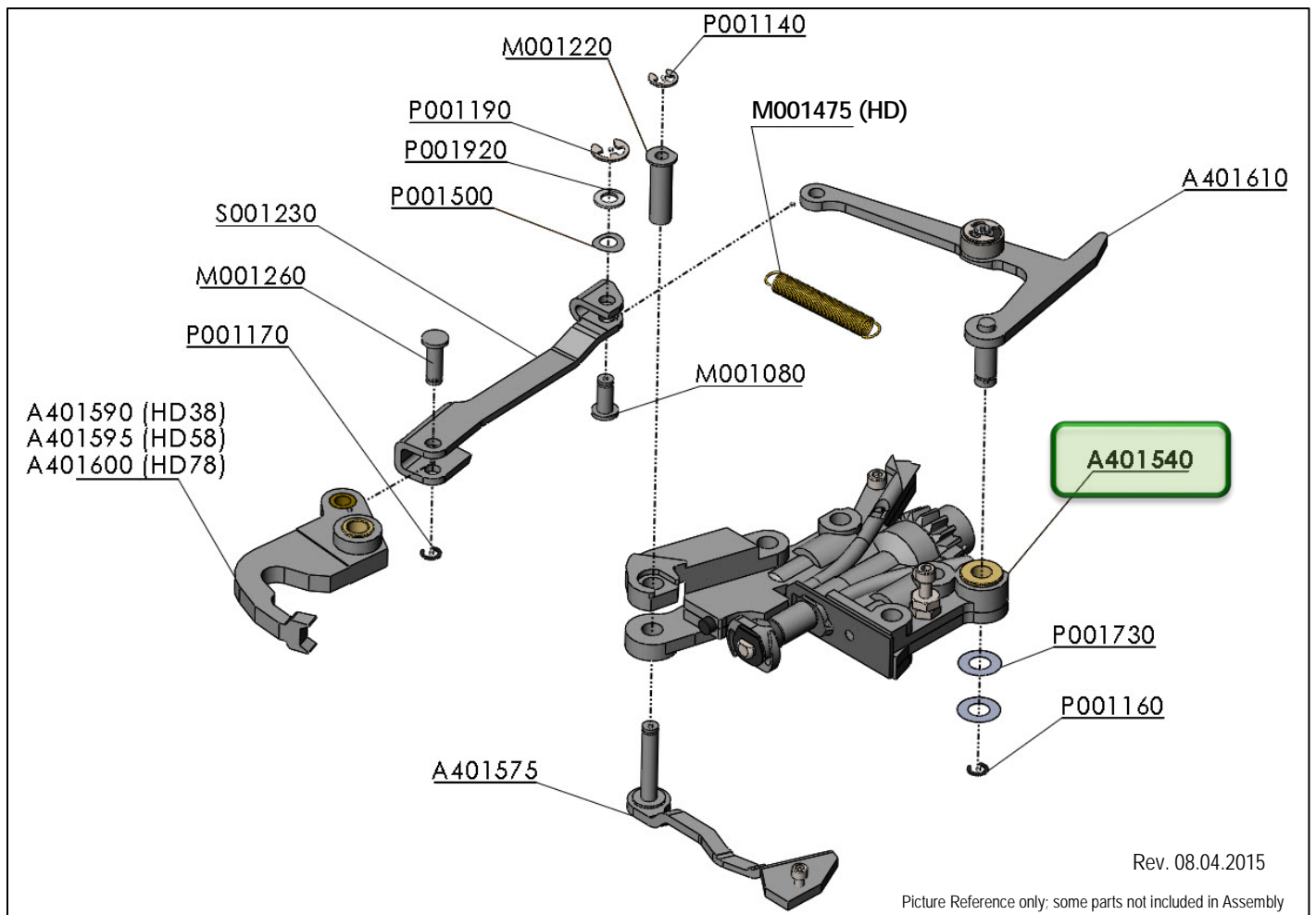
Picture Reference only; some parts not included in Assembly

## 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

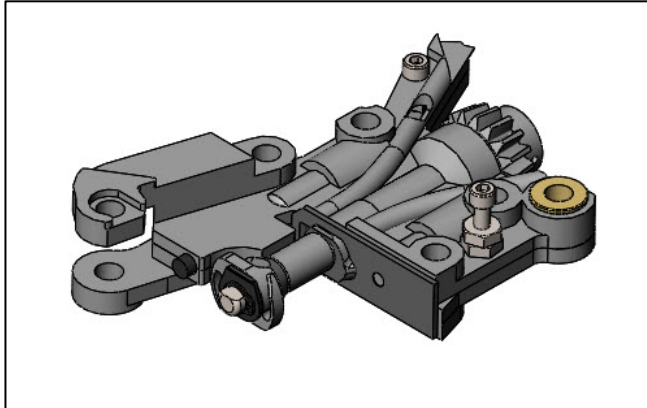


Rev. 08.04.2015

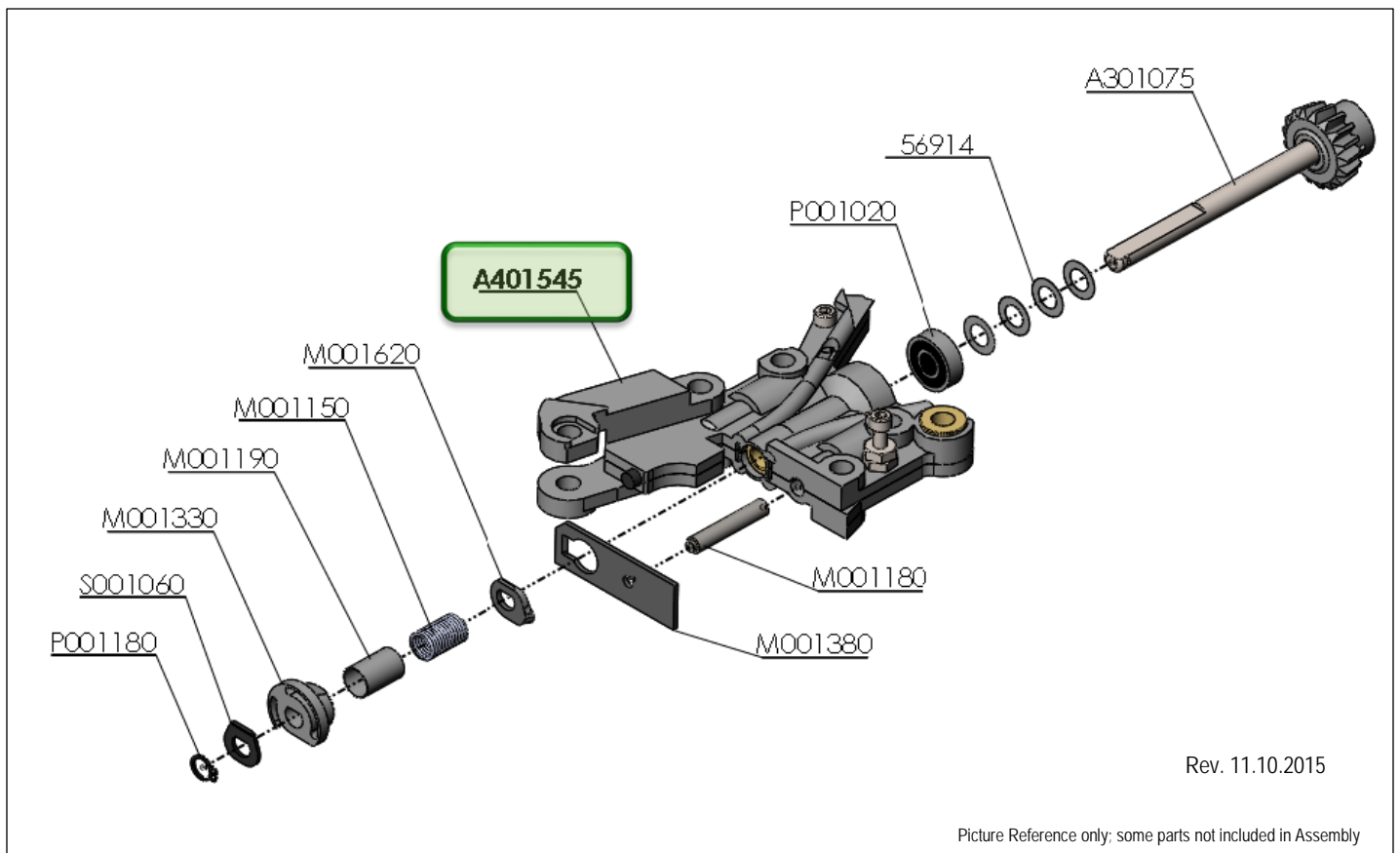
Picture Reference only; some parts not included in Assembly



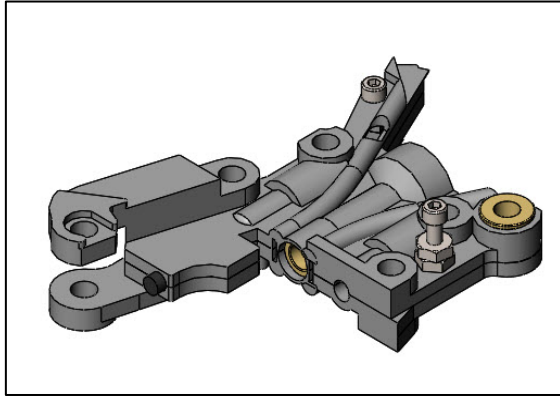
## TIE-MATIC PINION SUPPORT ASSEMBLY (A401540)



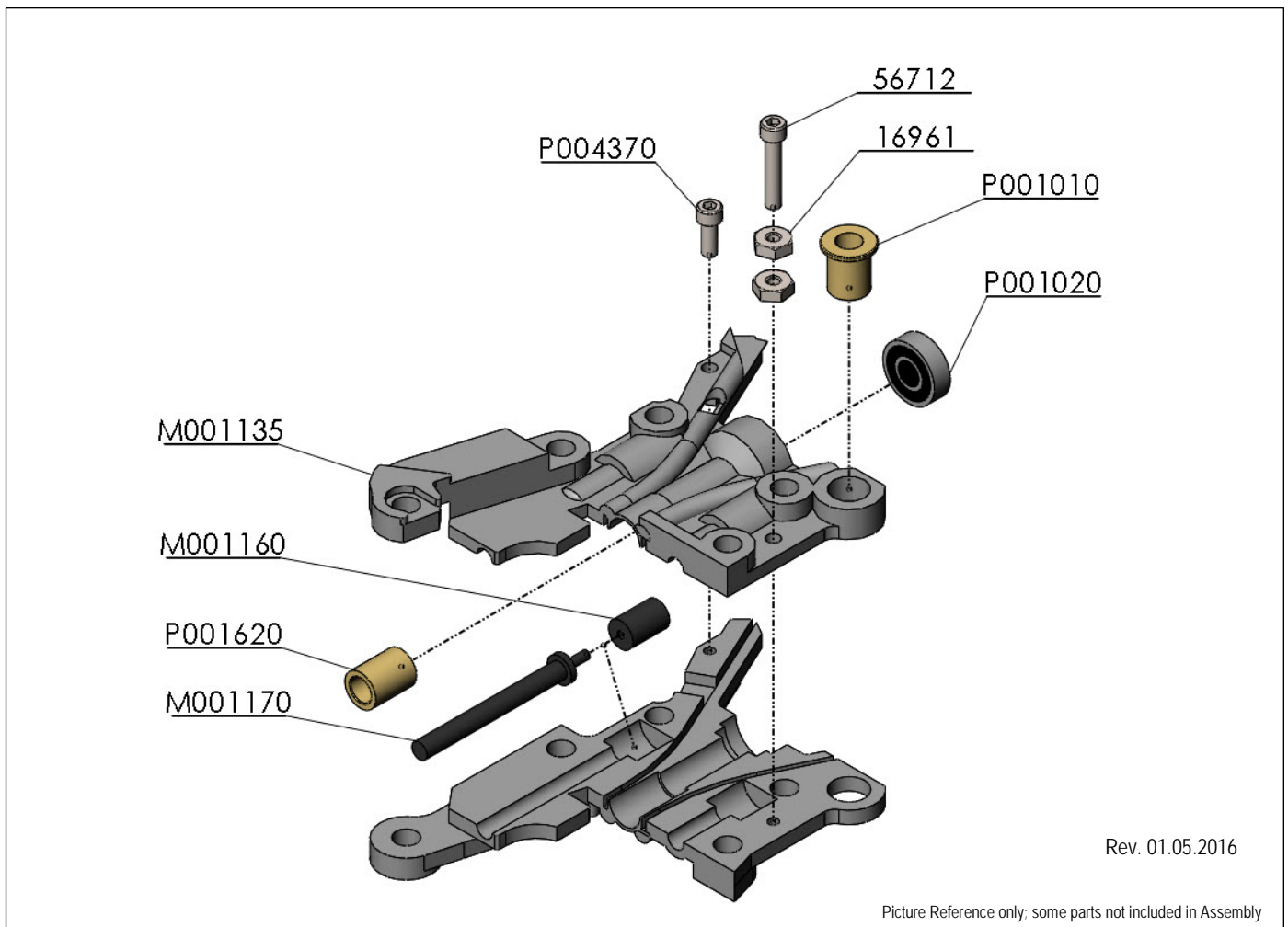
PART #	DESCRIPTION	QTY.
56914	Shim .250 x .437 x .005	4
A301075	HD Pinion/ Shaft Assembly	1
A401545	HD Pinion Support Sub Assembly	1
M001150	Cutter Spring	1
M001180	Locating Cutter Pin	1
M001190	Spring Cover	1
M001330	Twister Ribbon	1
M001380	Cutter Plate	1
M001620	Moveable Cutter	1
P001020	Bearing -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



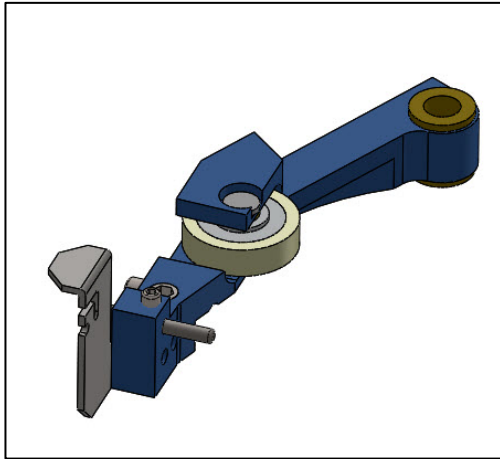
## TIE-MATIC PINION SUPPORT SUB ASSEMBLY (A401545)



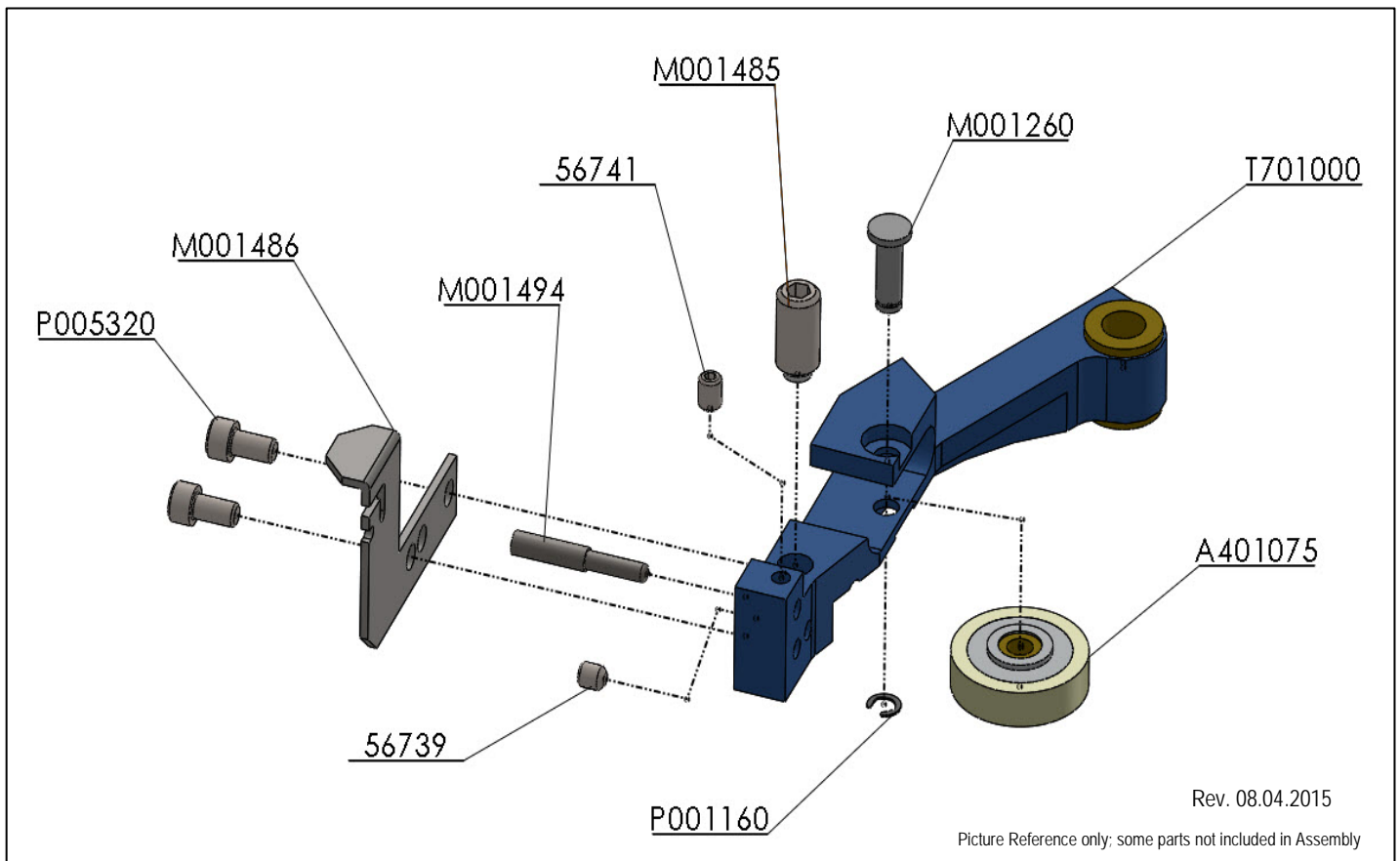
PART #	DESCRIPTION	QTY.
16961	6-32 Nut	2
56712	6-32 x 3/4" Socket Head Cap Screw	1
M001135	Pinion Support (2 pieces)	1
M001160	Needle Stop Cushion	1
M001170	Needle Stop	1
P001010	Bushing	1
P001020	Bearing	1
P001620	Bushing	1
P004370	6-32 X 3/8 Socket Head Cap Screw	1



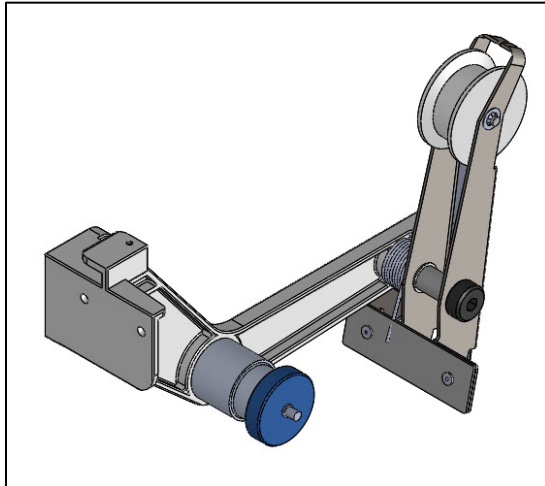
## TIE-MATIC HD IDLER ARM ASSEMBLY (A401550)



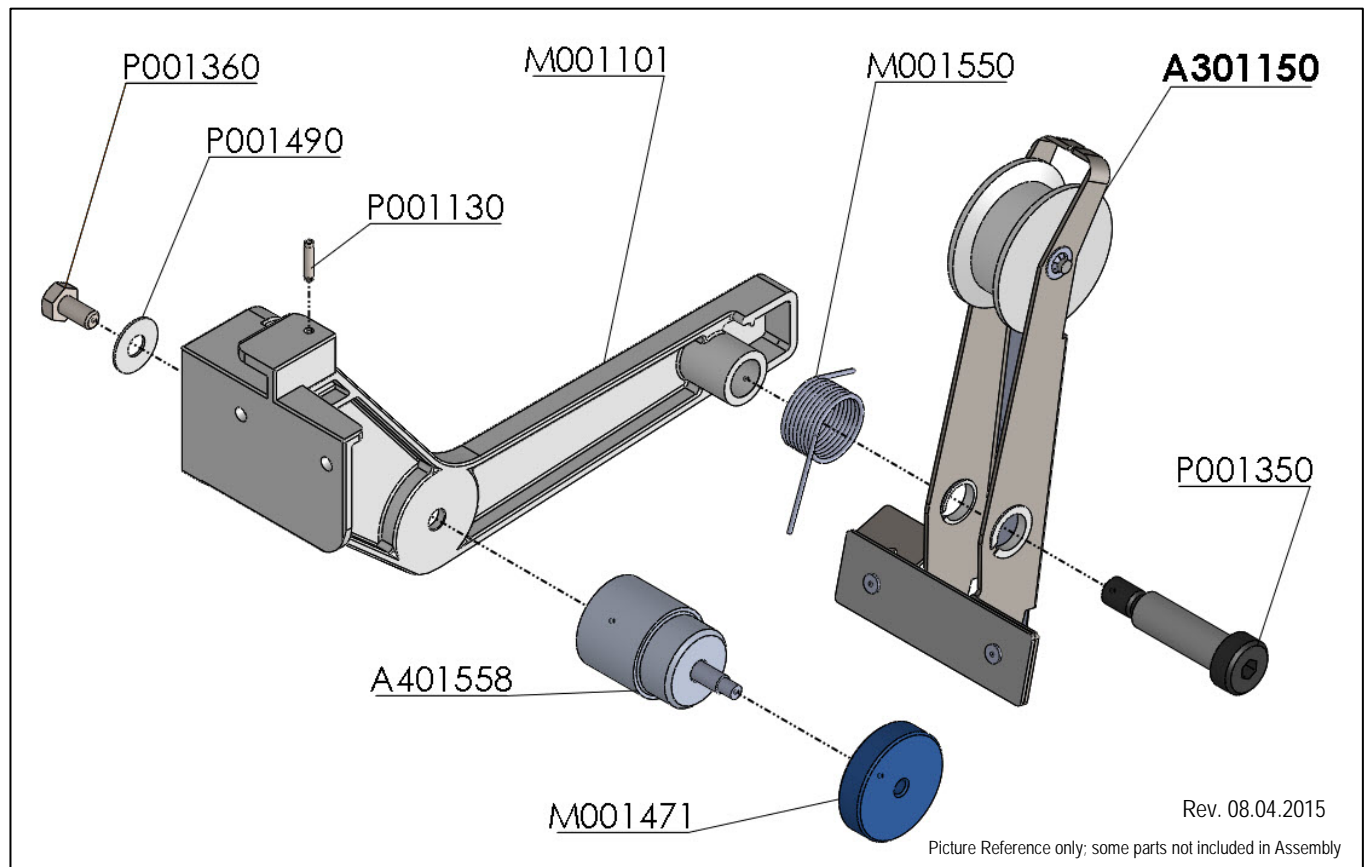
PART #	DESCRIPTION	QTY.
56739	8-32 X 3/16 Hex Socket Set Screw	1
56741	8-32 x 1/4 Socket Set Screw	1
A401075	Wheel Complete Assembly	1
M001260	Idler wheel Pin	1
M001485	Modified Set Screw	1
M001486	Pivot Bracket	1
M001494	Modified Set Screw	1
P001160	Snap Ring	1
P005320	8-32 x 5/16" Socket Head Cap Screw 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	<b>S001245</b>	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**

### **110V**

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REV 07.11.2018