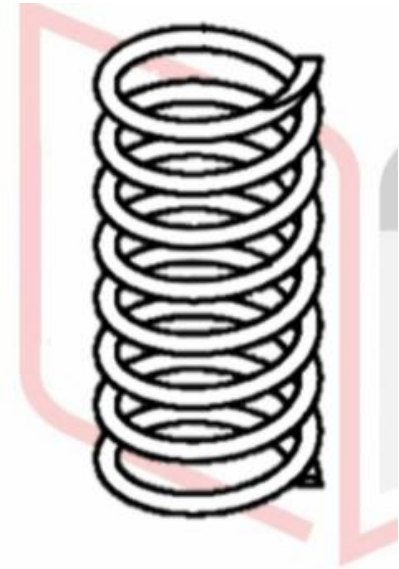
Hallbrookcomponents.com
Salbæk Technology Group
support@sal-tech.com
Skype: easy.packaging

Item: **H44-10940 Spring**

Document: **Installation Guide**

In connection with: **Combination Tools (Tensioning and Sealing P.P. and PET Strap) Automatic Strapping Machine**

Edition/date/Initials: A 261021 CZA





Part images:

Support 24/7: Hallbrookcomponents.com support team is ready 24/7, use online Zendesk, phone or email. Details later in this guide.

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1. General Information

This document is a guide for H44-10940 Spring. Listed below are the machines/tools which are compatible to the H44-10940 Spring spare part:

- STEP H-44-12 (12mm strap width) Part no.: 41212010
- STEP H-44-16 (16mm strap width) Part no.: 41213010
- STEP TP-702-59 Part no.: 41190125
- STEP TP-702-12 Part no.: 41192222





2. Maintenance Instructions

- Keep tool clean by brushing or periodically blowing dust or dirt off with clean, dry compressed air.
- Periodically lubricate all moving parts with one or two drops of light machine oil.

3. Requirements to do the repair and assembly of part(s)

Any electrical work performed on the equipment/tool must be conducted by a skilled electrician or under the supervision of a skilled electrician. All work must be observed good electrical engineering practice and follow safety rules and local wiring standards. You can contact our support team for further guidance and advice.

For STEP TP-702

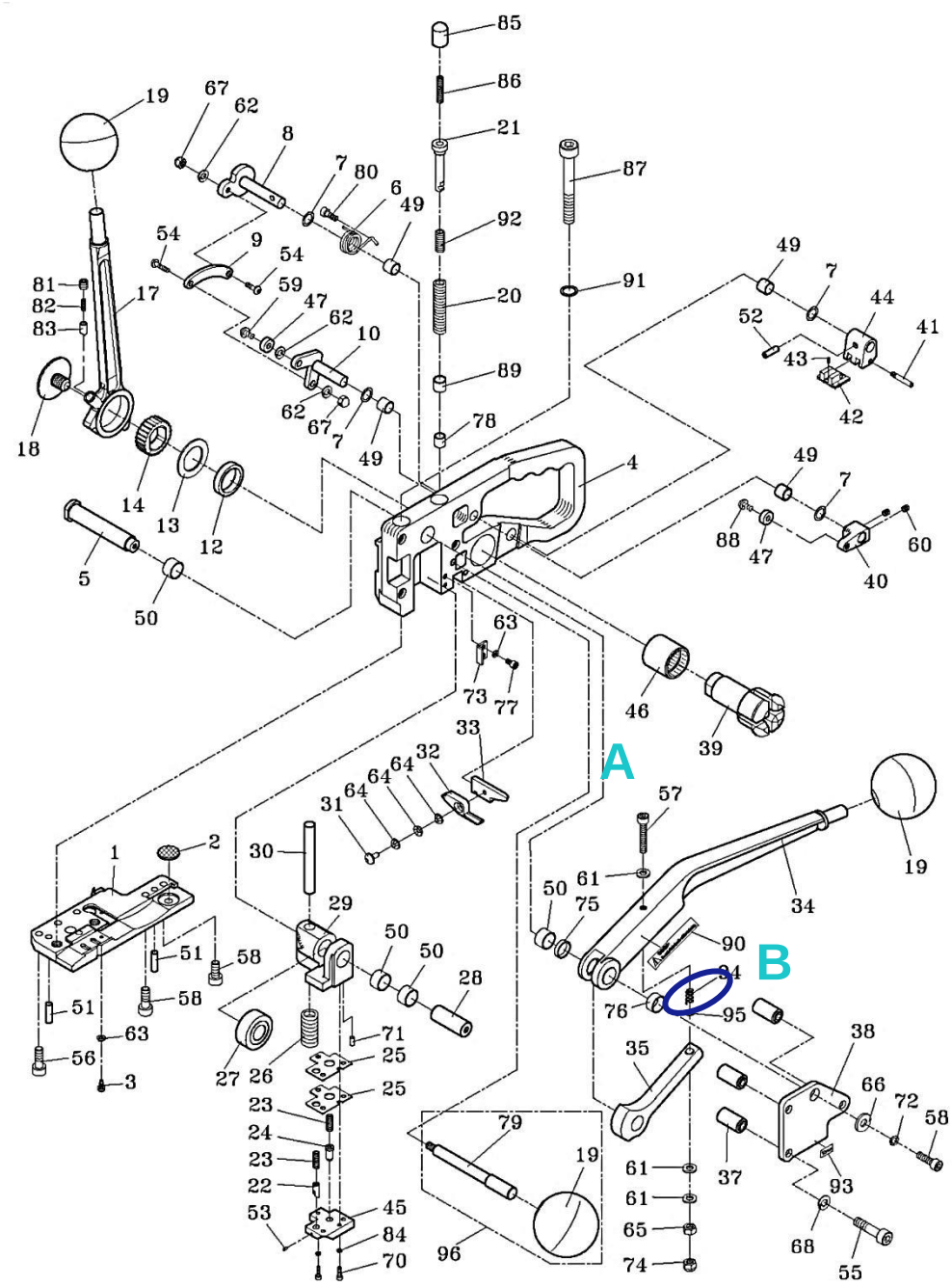
”Warning: Before any maintenance or repairs on the machine, set the Main Power Switch to "O" (OFF). Wait about 5 minutes for cooling down the heater to avoid burns with this area.”

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4. Spare Parts dismantling and assembly of H44-10940 Spring on H-44 Combination Tool

Following installation on B – The H44-10940 Spring is installed to the Sealing Lever (H44-10340), connected to Washer (H44-10950), Cam (H44-10350), 2 pcs of PW, M6 (A) (PW06A), HN, M6 (HN06), CAP, M6 (CAP06) secured by PW, M6 (A) (PW06A) and HBS, M6x50 (H)(N) (HBS0620N) from the Sealing Lever (H44-10340).

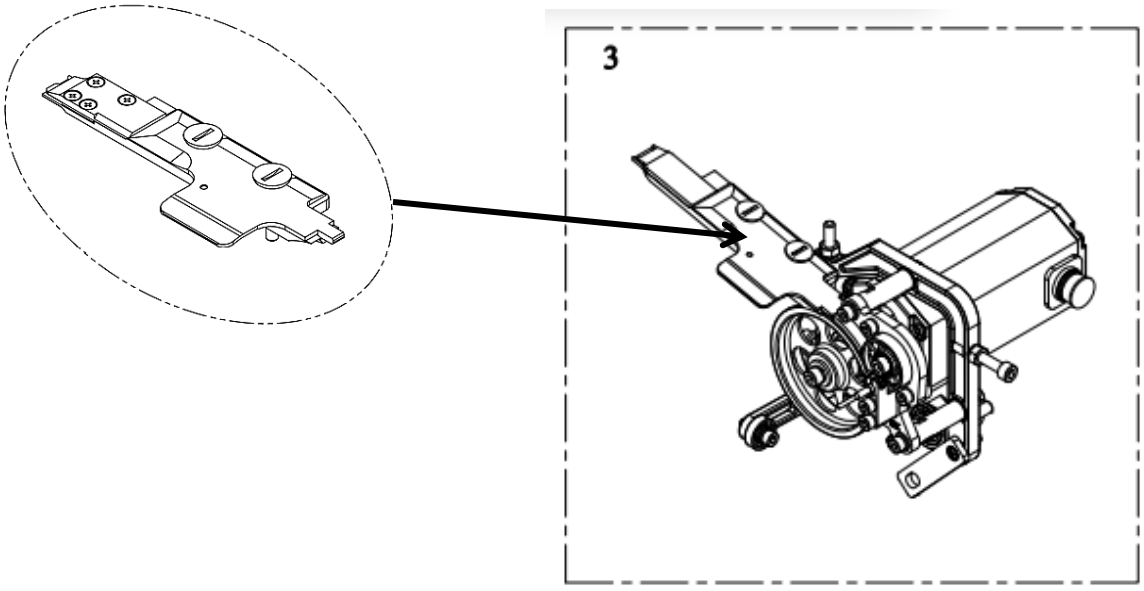
The H44-10940 Spring position 94, with the full assembly of the H-44 Combination Tool consists of:



Position	Parts no.	Description	Qty
34	H44-10340	Sealing Lever	1
57	HBS0650HN	HBS, M6x50 (H)(N)	1
61	PW06A	PW, M6 (A)	3
94	H44-10940	Spring	1
95	H44-10950	Washer	1
35	H44-10350	Cam	1
65	HN06	HN, M6	1
74	CAP06	CAP, M6	1

5. Spare Parts dismantling and assembly of H44-10940 Spring on TP-702 Automatic Strapping Machine

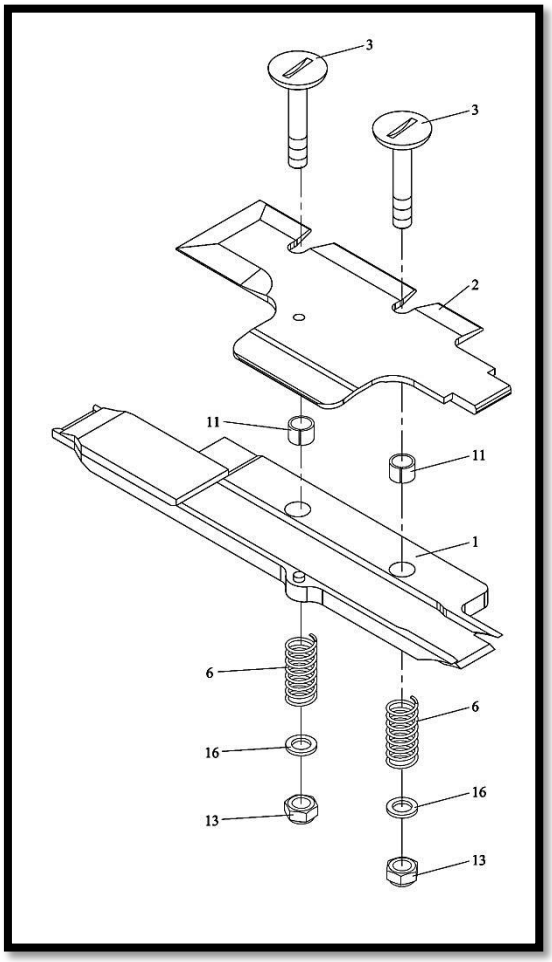
The H44-10940 Spring is installed to the Upper Guide Ass'y in the Feed Group (M7-1-300002/ M7-1-300012/ M7-1-300012) of TP-702.



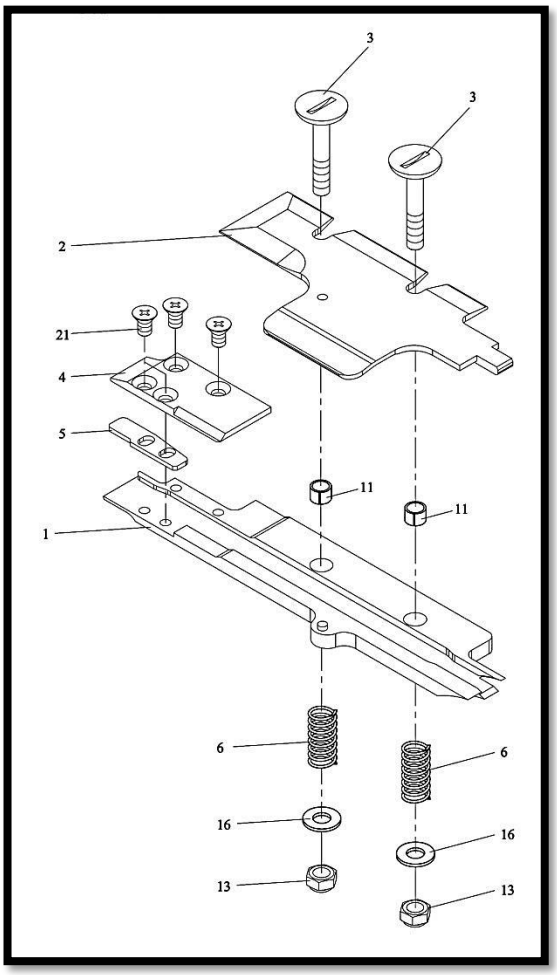
The H44-10940 Spring is installed to Upper Guide (M7-1-311103/ M7-1-311103S/ M7-1-311113/ M7-1-311113S/ M7-1-311122/M7-1-311122EN) with PW, M5 (PW05) and NTE, M5 (NTE05), secured by Metal Bushing, 0505 (MB0505) and Bolt (M7-1-311300/ M7-1-311300S) securing also the Cover (M7-1-311201/M7-311211).

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The H44-10940 Spring position 6, with the full assembly of the Upper Guide Ass'y consists of:



STEP TP-702-12



STEP TP-702-59

Position	Parts no.	Description	Qty
		STEP TP-702-59	
	M7-1-310001	Upper Guide Ass'y (For 5-6mm)	1
	M7-1-310001S	Upper Guide Ass'y (Stainless Steel Model) (For 5-6mm)(Option)	1
	M7-1-310011	Upper Guide Ass'y (For 9mm)	1
	M7-1-310011S	Upper Guide Ass'y (Stainless Steel Model) (For 9mm)(Option)	1
		STEP TP-702-12	
	M7-1-310021	Upper Guide Ass'y	1
	M7-1-310021S	Upper Guide Ass'y (Stainless Steel Model) (Option)	1

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1		**STEP TP-702-59**	1
	M7-1-311103	Upper Guide (For 5-6mm)	1
	M7-1-311103S	Upper Guide (Stainless Steel Model) (For 5-6 mm)(Option)	1
	M7-1-311113	Upper Guide (For 9 mm)	1
	M7-1-311113S	Upper Guide (Stainless Steel Model) (For 9 mm)(Option)	
		STEP TP-702-12	
	M7-1-311122	Upper Guide	1
	M7-1-311122EN	Upper Guide (Stainless Steel Model)(Option)	1
2		**STEP TP-702-59**	
	M7-1-311201	Cover (For 5-6mm)	1
	M7-1-311211	Cover (For 9mm)	1
		STEP TP-702-12	
	M7-1-311221	Cover	1
	M7-1-311221EN	Cover (Stainless Steel Model)(Option)	1
3	M7-1-311300	Bolt	2
	M7-1-311300S	Bolt (Stainless Steel Model)(Option)	2
6	H44-10940	Spring	2
11	MB0505	Metal Bushing, 0505	2
13	NTE05	NTE, M5	2
16	PW05	PW, M5	2

6. Test of machine/tool installation of new parts with old parts

On H-44 Combination Tool: Once the machine is assembled secure the machine/tool is clean, oiled and is ready to use.

On TP-702 Strapping Machine:

The LCD display would flash and show failure message when machine is not working due to malfunction.

Message shown on the LCD could be follows:

1. Reminder message:

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a. Push Start: Please press the Start Switch to make machine function. This is especially necessary after the Safety Switch is released or after you just turn on the machine.

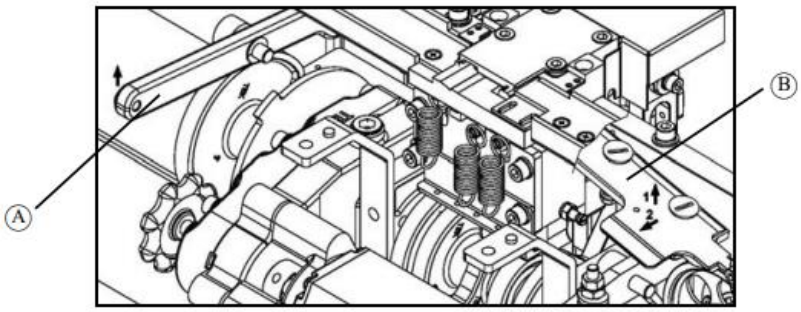
b. Load Strap: Load a new roll of strap or re-do the Auto Strap feeding again.

c. B6 open; K1 open: When it shows this message after you press the Start Switch, it means the Safety Switch might not be closed or the K1 in the control box is abnormal.

2. Malfunction from switches:
   a. S1 Error: This means the Start Switch or the Foot Pedal is continuously triggered before activating them. Please check if any of these 2 Switches is defective.
   b. S5 Error: This means the Reel Release Switch is continuously triggered before activating it. Try to press it by hand to see if it's defective.
   c. SQ1 on Error: The SQ1 is triggered when doing Auto Strap Feeding. Check if the SQ1 or the Switch lever is defective.
   d. SQ9 failure: Foot bar is not able to function properly and cause it not able to go back to home position.
3. Malfunction from procedures:

   a. ASF failed: Auto Strap Feeding failed. It might be caused by wrong inserting direction or inserting too much strap. Please re-do the Auto Strap Feeding.

   b. Feed jam: Resulting from not being able to feed strap to the sealing position. When Feed jam occurs, press the Start Switch or Foot bar first to let the arch open and strap comes out of the arch. Hold the strap by left hand and then press the Start Switch or Foot bar again. Machine would reverse the strap a little bit and cut it, and then machine would go back to home position and feed again. If this does not solve the problem, please take out the jammed strap by following steps:



b-1. Open Upper Table Front Ass'y M7-5-210001/M7-5-220001.

b-2. Lift up the Lever ○A (M7-2-101400/M7-2-101410) with left hand and take out the Cover ○B (M7-1-311201/M7-1-311211) for the Upper Guide with right hand at the same time.

b-3. Take out the jammed strap and cut it.

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b-4. Put the cover (M7-1-311201/M7-1-311211) for the Upper Guide back to its position and put the Upper Table Front Ass'y back as well. Push START switch in the control panel to RESTART machine.

If problem still cannot be solved double check the manual for the following causes that have to be checked as well. You can also contact our support team for further guidance and advice.

7. Ordering spare parts:

Purchase planning when exchanging the H44-10940 Spring.

Link to order H44-10940 Spring:
https://hallbrookcomponents.com/tp-702-automatic-strapping-machine/303-h44-10940-spring.html?search_query=H44-10940&results=1

8. Hallbrookcomponents.com 24/7 support and contact information

Hallbrookcomponents.com part of Salbæk Technology Group that operates worldwide with office in Many countries. Our 24/7 support and hotline via these channels:

- Email: support@hallbrookcomponents.com
- Zendesk: On our websites https:\\hallbrookcomponents.com
- Skype. Easy.packaging
- Denmark phone: +45 – 7027 2220 or 3695 9804
- USA phone: +1 – 310 773 3423
- Spain phone: +34 – 699 900 987
- Italy phone: +39 – 351 988 0682
- Sweden phone: +46 – 31 799 5398
- Philippines phone: +63 - 916 777 5299
- Hong Kong phone: +852 - 8170 1025



Always check the web for latest or updated phone numbers.

Easy Packaging since 1995.

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9. Hallbrookcomponents.com – Your packaging solution partner

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10. Disclaimer

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