

FROMM

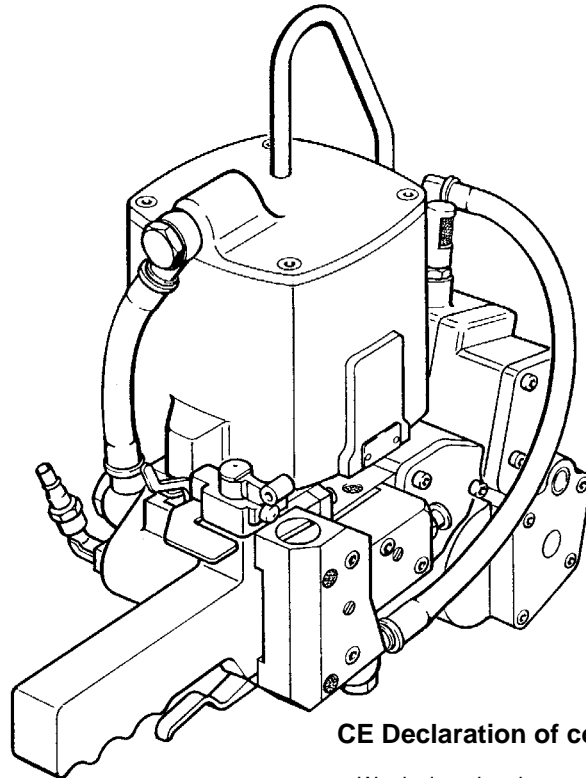
OPERATION MANUAL / SPARE PARTS LIST

PNEUMATIC STEEL STRAPPING TOOL

AUTOMATIC

MODEL A380.0003

13.6285.01



CE Declaration of conformity

We declare that the machine A380
is in conformity with the following standard or
standardised documents:
98/37/EEC

FROMM Holding AG
Hinterbergstrasse 26
CH - 6330 Cham
13.07 2004



R.Fromm
Director



13628501_en/DS/©06.05

S joint system®

handling & packaging
joint system®

via volvera 123

10090 bruino torino italy

t +39 011 957 29 54

f +39 011 908 42 94

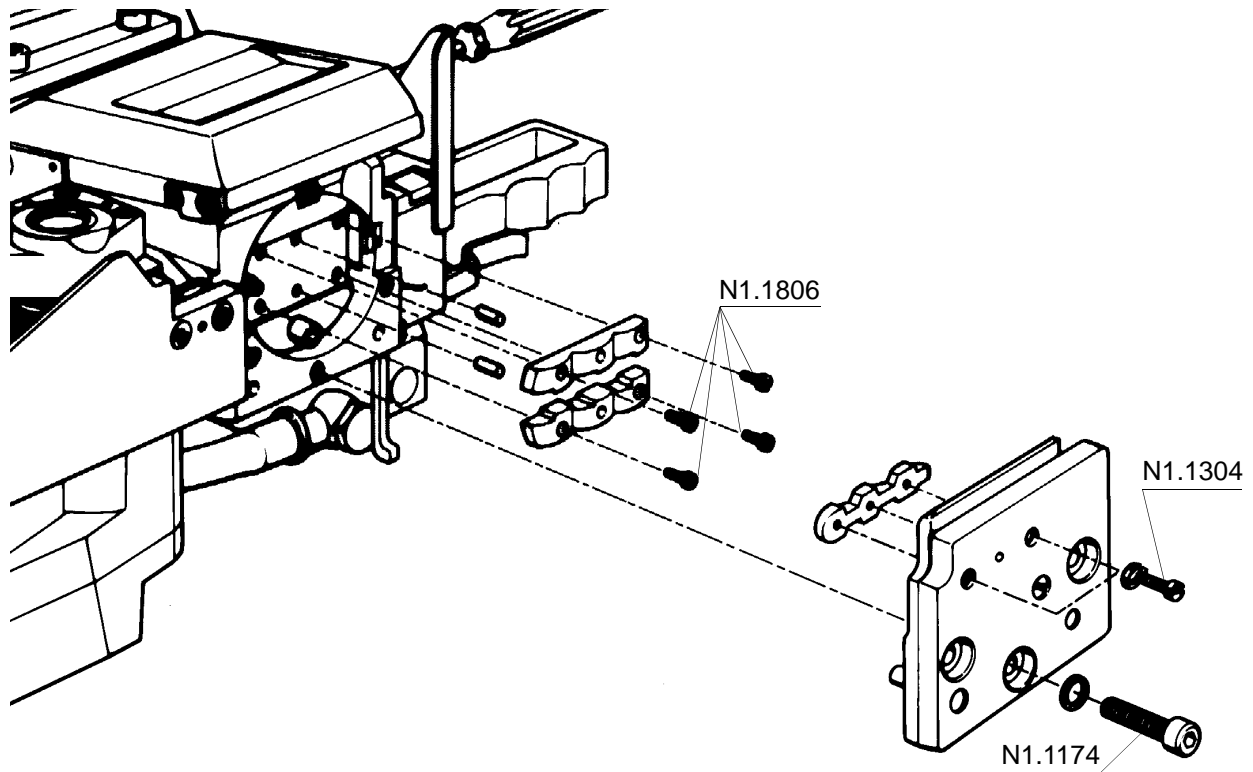
p.iva / c.f. 07028380017

info@jointssystem.com

13 EXCHANGE OF WEARING PARTS

13.1 Exchange of punch and die halves

If in spite of a correct adjustment of the adjusting screw it is no longer possible to make a proper seal (see seal control) the base plate must be removed and the wear of punch and die halves must be examined. If the cutting edges are destroyed or heavily worn (Attention! The cutting edges of new punches and dies are also rounded slightly) the equivalent parts must be replaced.



Important!

Make sure that the mounting surfaces are completely free from dirt before the new parts are installed.

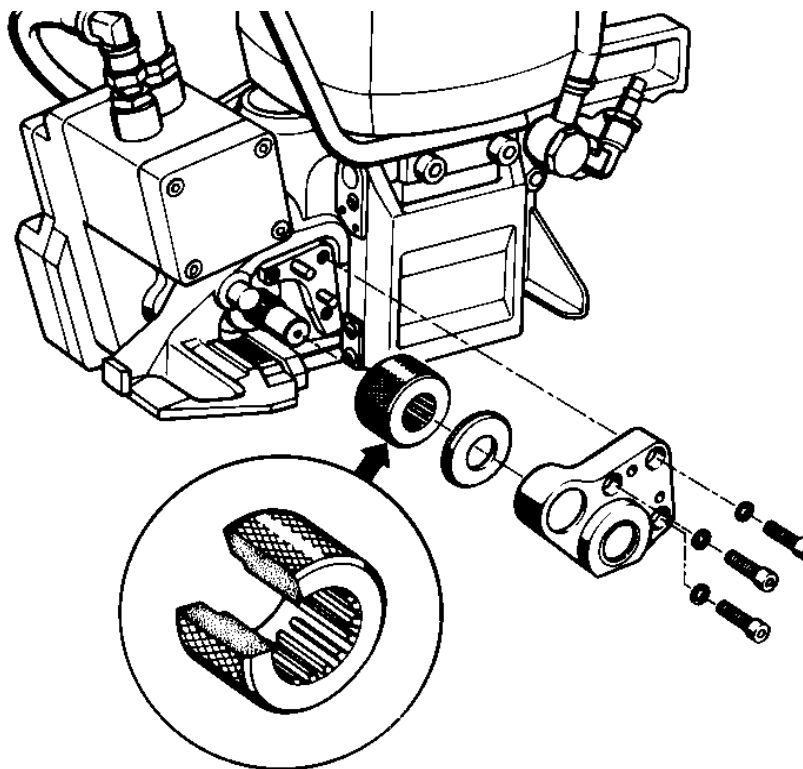
After assembling the base plate, the base plate screws must be tightened using a torque wrench with a torque of 90 Nm/66.6 ft lbs

Safe the screws N1.1304 and N1.1806 with Loctite 222.

13.2 Exchange of the feed wheel

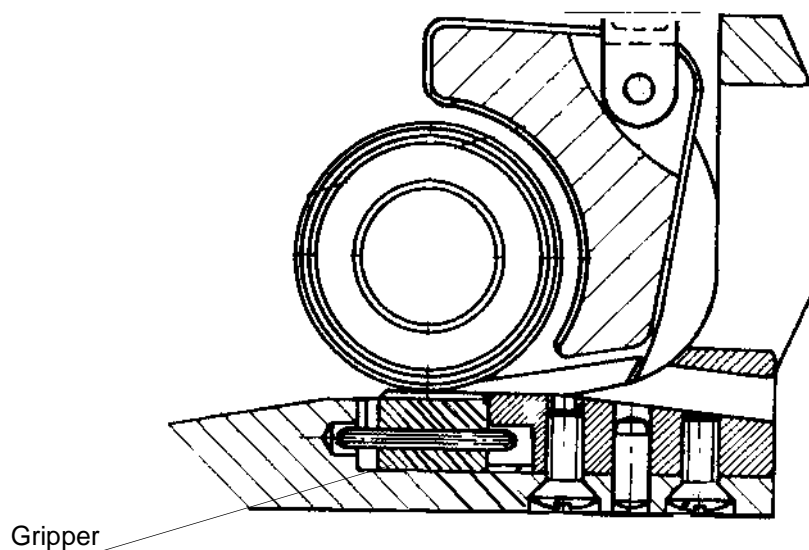
- Remove the three screws and the bearing cover.
- Remove the front distance ring and the feed wheel from the feed wheel shaft.
- Assemble in opposite order.

Important!
Consider assembling position of the feed wheel



13.3 Exchange of the gripper

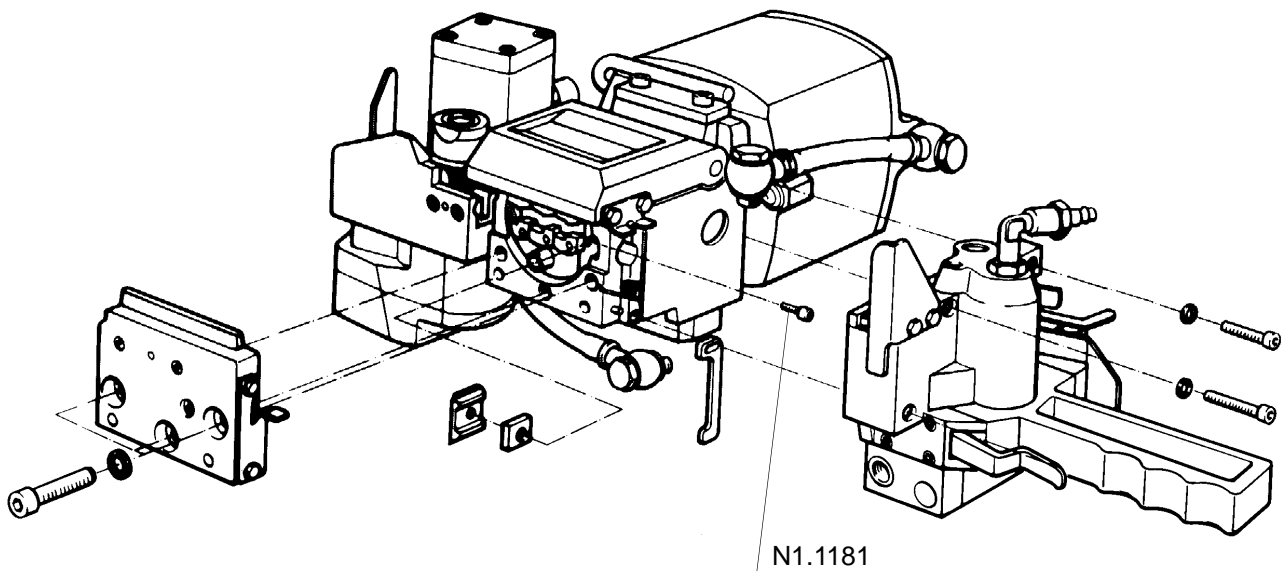
- Loosen both cross-head screws in the tension body and lift the holder so that the gripper can be removed.
- Clean the groove and firmly retighten the holder after insertion of the new gripper.



13.4 Exchange of cutter

- Remove base plate and valve body
- Loosen and remove piston screw N1.1181 through the provided boring in the sealer body using a hexagon socket spinner wrench.
- Exchange cutter.
- Assembling in opposite order.

When valve body is mounted, make sure that bending spring N2.5805 is in its correct position.



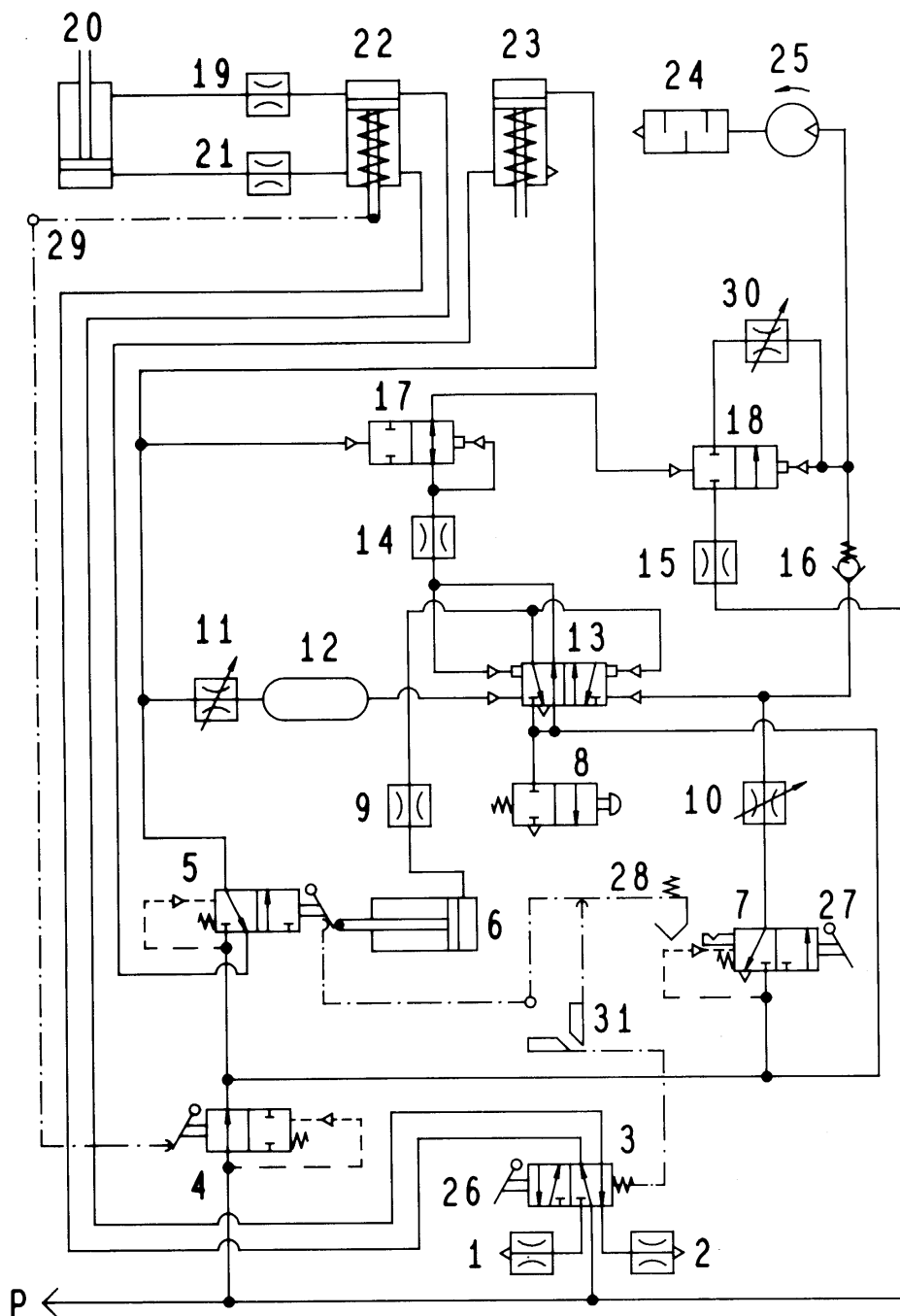
Important!

Safe screw N1.1181 with Loctite 222

14 CONTROL SYSTEM

14.1 Pneumatic schematic A380.0003

POS.	DESCRIPTION
1	Throttle 1,2
2	Throttle 1,2
3	Flapper valve
4	Flapper security valve
5	Sealing valve
6	Release piston
7	Motor valve
8	Emergency aeration
9	Throttle 0,3
10	Throttle screw
11	Sealing time throttle
12	Volume
13	Pilot valve
14	Throttle 1,8
15	Holding air throttle 2,0
16	Nonreturn valve
17	Diaphragm
18	Holding air valve
19	Throttle 1,2
20	Feed wheel cylinder
21	Throttle 1,2
22	Flapper cylinder
23	Sealing cylinder
24	Muffler
25	Air motor
26	Flapper valve lever
27	Motor valve lever
28	Catch
29	Flapper
30	Holding air throttle
31	Ejector bolt



16 SPARE PARTS LIST 13.6285.01

13.6285.01	A380/13/0.50-0.63/4.5/A		A380.0003.01		15.07.99	
Item-No.		in group	Pcs.	Description	Dimension	Field
A3H.1110			1	FILTER NETTING		B9
A3H.1111			1	NETTING FRAME		B9
A3H.1112			1	PROTECTION NETTING		B9
A3H.1709			1	ADJUSTING SCREW		D6
[A38.0101]			1	TENSIONING UNIT	1/2"-20.0/4,5KN	A22
[A38.0108]			1	VALVE HANDLE		C15
[A38.0110]			1	CONTROL VALVE		A17
[A38.0117]		A38.0101	1	AIR MOTOR	EXC. 2,5	B22
[A38.0131]		A38.0117	1	MOTOR CELL	EXC. 2,5	B21
A38.1104	*		1	DIE HALF		D3
A38.1105	*		1	DIE HALF		D4
A38.1111			1	GUIDE KEY		B3
[A38.1112]			1	SPRING PACKAGE		B6
A38.1113		A38.1112	1	SPINDLE		B5
A38.1114		A38.1112	1	BUSH		B5
A38.1115			1	BASE PLATE		C6
A38.1117	*		1	PUNCH		C5
A38.1120			1	STRAP CLAMP		B4
A38.1122			1	STRAP STOP		C6
A38.1126			1	FLAPPER		C2
A38.1128			1	STRAP GUIDE		C2
A38.1133			1	STRAP GUIDE		B1
A38.1137			1	FLAP PIVOT PIN		B3
A38.1138			1	SOCKET SET SCREW		A3
A38.1140			1	PISTON ROD		C9
A38.1141			1	HINGE		C9
A38.1142			1	BOLT		C9
A38.1143			1	BOLT		B1
A38.1144			1	HINGE PLATE		B1
A38.1145			1	CYLINDER COVER		A9
A38.1146			1	PISTON ROD		C7
A38.1147			1	FORK		C23
A38.1148			1	SHAFT		C23
A38.1149			1	COVER		B7
A38.1150			1	GUIDE RING		C8
A38.1151			1	COVER DISK		C8
A38.1152			3	BLIND PLUG		B9+
[A38.1154]			1	PISTON PLATE		B11
A38.1155			1	PLUNGER		C11
A38.1156			1	DISK		B11
A38.1157			1	CYLINDER COVER		A10
A38.1158	*		1	CUTTER		C4
[A38.1178]			1	SEALING HOUSING		A4
[A38.1180]			1	SEALING CYLINDER		B8
A38.1186		A38.1189	1	EJECTOR SPINDLE		C3
A38.1187		A38.1189	1	EJECTING BUSH		C3
[A38.1189]			1	EJECTOR		C4
A38.1190		A38.1189	1	CAP		C3
A38.1191			1	DIE AND CUTTER SUPPORT		B4
A38.1202		A38.0108	1	SECURITY VALVE SHELL		D14
A38.1203		A38.0108	1	VALVE BOLT		D13

* = Wearing parts

[] = Group

13.6285.01	A380/13/0.50-0.63/4.5/A		A380.0003.01			15.07.99
Item-No.		in group	Pcs.	Description	Dimension	Field
A38.1204		A38.0108	1	SHAFT		D13
A38.1205		A38.0108	1	SECURITY LEVER		D14
A38.1206		A38.0108	1	LEVER BODY		D13
A38.1208		A38.0108	1	SEALER VALVE SHELL		B14
A38.1209		A38.0108	2	VALVE BOLT		A14
A38.1210		A38.0108	1	TENSIONER VALVE LEVER		A15
A38.1212		A38.0108	1	SHAFT		A14
A38.1214		A38.0108	1	CATCH PIN		B15
A38.1215		A38.0108	1	GUIDE RING		C16
A38.1216		A38.0108	5	SUSTAINING RING		B17+
A38.1216		A38.0110	4	SUSTAINING RING		B18
A38.1217		A38.0108	1	GUIDE RING		C17
A38.1218		A38.0108	1	VALVE PISTON		C17
A38.1220		A38.0108	1	VALVE LEVER		D17
A38.1221		A38.0108	1	SHAFT		D17
A38.1222		A38.0108	1	LEVER BODY		D17
A38.1226		A38.0110	1	CYLINDER CAP		C18
A38.1227		A38.0110	1	CYLINDER RING		C18
A38.1228		A38.0110	1	PISTON BAR		C18
A38.1229		A38.0110	1	THRUST PIECE		A18
A38.1230		A38.0110	1	SEALING SCREW		A18
A38.1231			1	SEAL PLATE		B17
[A38.1236]			1	MOTOR TUBE		A16
[A38.1237]			1	CYLINDER HOSE		C12
A38.1238		A38.0108	1	GUARD-PLATE		D14
[A38.1241]		A38.0108	1	VALVE HOUSING		C15
A38.1242		A38.0108	1	TENSIONER VALVE SHELL		B15
A38.1243			1	SEAL PLATE		C14
[A38.1244]		A38.0110	1	CONTROL VALVE BODY		A17
A38.1253		A38.0108	1	THROTTLE SCREW		C14
A38.1257		A38.0108	1	SEALING VALVE LEVER		B15
A38.1258		A38.0108	1	LEVER BODY		A14
A38.1259			1	CONTROL PISTON		C9
A38.1260			1	GUIDE RING		C9
[A38.1261]			1	VALVE HEAD		D10
A38.1263			1	COUPLER		D9
A38.1264			1	INTERMEDIATE WASHER		D9
A38.1265			5	SUSTAINING RING		C9+
A38.1266			1	COMPENSATOR RING		D10
A38.1267			2	PISTON		D9+
A38.1268			1	SEAL		D10
A38.1269			1	ADJUSTING SCREW		D11
A38.1270		A38.1261	1	VALVE FACE		D9
A38.1271		A38.1261	1	TOUCH BOLT		D9
A38.1272			1	JOINT CONE		B16
A38.1274		A38.1244	1	HOLDING AIR THROTTLE		A17
A38.1275		A38.0108	1	SLIDE BOLT		C16
A38.1276		A38.0108	1	RING		B15
A38.1277		A38.0108	1	SCREW		A15
A38.1278		A38.0108	1	EJECTION HEAD		A15
A38.1279		A38.0108	1	EJECTING BOLT		A15
A38.1310			1	TENSIONING BODY		C22
[A38.1311]	*		1	GRIPPER		C22

* = Wearing parts

[] = Group

13.6285.01	A380/13/0.50-0.63/4.5/A		A380.0003.01		15.07.99	
Item-No.		in group	Pcs.	Description	Dimension	Field
A38.1313			1	RETAINER		D22
A38.1314			1	PIVOT PIN		C21
A38.1315			1	BOLT		D21
A38.1316			1	SPACER RING		C21
A38.1317	*		1	TENSIONING WHEEL		D21
A38.1320			1	SPACER RING		D21
A38.1322			1	STRAP HOLDER		D21
A38.1326			1	END COVER		D21
A38.1328			1	STRAP STOP		C21
A38.1349		A38.0131	1	END PLATE		C20
A38.1350		A38.0131	1	JACKET		B21
A38.1351	*	A38.0131	8	VANE		C20
A38.1352		A38.0131	1	END PLATE		B21
[A38.1353]		A38.0117	1	AIR MOTOR HOUSING		B21
A38.1354		A38.0117	1	COVER		A20
[A38.1355]		A38.0101	1	HOUSING		C22
A38.1362		A38.0101	1	PINION		A23
A38.1363		A38.0101	1	INTERMEDIATE WHEEL	2-3	B23
A38.1367		A38.0101	1	INTERMEDIATE WHEEL	1-2	A22
A38.1368		A38.0101	1	TENSION SHAFT		C23
A38.1370		A38.0101	1	BEARING PLATE		C24
A38.1371		A38.0101	1	INTERMEDIATE WHEEL		B23
[A38.1372]		A38.0101	1	BODY COVER		B24
A38.1374		A38.0131	16	FELT		B20+
A38.1376		A38.0131	1	ROTOR		C20
A38.1377		A38.0131	1	COUPLING		B20
A38.1378		A38.0131	1	DOWEL		B20
[A38.1431]			1	SUSPENSION		--
[A38.1432]		A38.1431	1	SUSPENSION BRACKET		--
A38.1513			1	CLAMPING PIECE		C4
[A38.2155]			1	PISTON PLATE		C9
A38.2156			1	STOP DISK		C9
A38.2157			1	SUPPORTING DISK		B10
A38.2158			1	HEXACON NUT		B9
A48.1234		A38.0108	1	CATCH		B15
A48.1237		A38.0108	1	SIEVE		C13
N1.1104		A38.1431	2	SCREW	M8 X 20	--
N1.1106			5	SCREW	M6 X 20	A8+
N1.1113		A38.0101	4	SCREW	M5 X 20	A24
N1.1114			4	SCREW	M5 X 25	C24+
N1.1125			4	SCREW	M6 X 16	B8
N1.1130		A38.0101	4	SCREW	M5 X 35	B24
N1.1133			2	SCREW	M5 X 40	D10
N1.1141			1	SCREW	M6 X 40	D15
N1.1143			4	SCREW	M6 X 35	A17+
N1.1168			1	SCREW	M5 X 16	A10
N1.1174			3	SCREW	M10 X 1 X 40	D5
N1.1175			2	SCREW	M5 X 55	A10
N1.1180		A38.0117	4	SCREW	M6 X 90	B19
N1.1181			1	SCREW	M5 X 12	C4
N1.1304			2	SCREW	M3 X 8	D5
N1.1560		A38.0108	2	HEXAGON SCREW	M5 X 10	D14
N1.1560			7	HEXAGON SCREW	M5 X 10	B1+

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13.6285.01	A380/13/0.50-0.63/4.5/A		A380.0003.01			15.07.99
Item-No.		in group	Pcs.	Description	Dimension	Field
N1.1806			4	SCREW	M4 X 10	D4
N1.1807			3	SCREW	M5 X 12	C21+
N1.2101			1	COUNTERSUNK SCREW	M8 X 25	B11
N1.2102			4	COUNTERSUNK SCREW	M6 X 20	A10
N1.2106			4	COUNTERSUNK SCREW	M4 X 8	C9+
N1.2212		A38.0108	7	COUNTERSUNK SCREW	M4 X 25	A14+
N1.2212			1	COUNTERSUNK SCREW	M4 X 25	B3
N1.5608			1	SLOTTED ROUND NUT	M8 X 1	B7
N1.6203			2	SPRING LOCK WASHER	M3	C5
N1.6207		A38.0101	8	SPRING LOCK WASHER	M5	A24+
N1.6207			9	SPRING LOCK WASHER	M5	A10+
N1.6220		A38.0117	4	SPRING LOCK WASHER	M6	A20
N1.6220			14	SPRING LOCK WASHER	M6	B8+
N1.6310		A38.0101	2	SPACER WASHER	14 X 26 X 0,5	B23+
N1.6501		A38.1431	2	SAFETY WASHER	M8	--
N1.6502			3	SAFETY WASHER	M10	D6
N2.1125			2	SECURITY RING	E3.2	C22
N2.1215		A38.0108	1	SECURITY RING	J22	B15
N2.1301		A38.1112	1	CIRCLIP	6 MM	A6
N2.1701			1	SECURITY RING	17 MM	C7
N2.1702			1	SECURITY RING	26 MM	D9
N2.2101			1	PARALLEL PIN	5 M6 X 12	B1
N2.2107			2	PARALLEL PIN	5 M6 X 40	D21
N2.2109			2	PARALLEL PIN	8 M6 X 30	B6
N2.2112			1	PARALLEL PIN	3 M6 X 12	C5
N2.2114		A38.0108	1	PARALLEL PIN	4 M6 X 24	C14
N2.2138			3	PARALLEL PIN	4 M6 X 12	D4+
N2.2143		A38.0101	2	PARALLEL PIN	5 H6 X 16	A23
N2.2144		A38.0101	1	PARALLEL PIN	14 H6 X 75	C23
N2.2413		A38.0131	1	DOWEL PIN	4 X 20 MM	B21
N2.2440			1	DOWEL PIN	4 X 12 MM	B4
N2.2441			2	DOWEL PIN	6 X 20 MM	C23
N2.2445		A38.0131	1	DOWEL PIN	2,5 X 6 MM	C20
N2.2449			2	DOWEL PIN	3,5 X 20 MM	C24
N2.4407		A38.0101	4	RIVET	2 X 3	A23+
N2.4902			4	HAMMER HEAD BOLT	1,85 X 4,76	B9
N2.5102		A38.0108	1	PRESSURE SPRING	0.6 X 8 X 14/6	D14
N2.5151		A38.0108	1	PRESSURE SPRING	0.3 X 2.8 X 11	C15
N2.5159		A38.0108	2	PRESSURE SPRING	0.5 X 7 X 18	B14
N2.5160		A38.0108	1	PRESSURE SPRING	1 X 12 X 26	C16
N2.5161		A38.0108	2	PRESSURE SPRING	1 X 12 X 20	B14
N2.5162			1	PRESSURE SPRING	2 X 42 X 22	C8
N2.5163			1	PRESSURE SPRING	5.5 X 74 X 155	A8
N2.5168			1	PRESSURE SPRING	0.5 X 10 X 22	B16
N2.5178		A38.1261	1	PRESSURE SPRING	0.32X2.82X20.5	D9
N2.5601		A38.1112	52	CUP SPRING	12.5X6.2X0.7	B5
N2.5609		A38.0117	2	CUP SPRING	45X22.5X1.75	A20
N2.5610		A38.1189	60	CUP SPRING	8X3.2X0.5	C3
N2.5616			2	CUP SPRING	50 X 25.4 X 2.5	C10
N2.5805			1	BENDING SPRING		A4
N3.1109		A38.1355	1	BALL BEARING		B22
N3.1109		A38.1372	1	BALL BEARING		A23
N3.1123		A38.0131	1	BALL BEARING		B21

* = Wearing parts

[] = Group

13.6285.01	A380/13/0.50-0.63/4.5/A		A380.0003.01		15.07.99	
Item-No.		in group	Pcs.	Description	Dimension	Field
N3.1133		A38.0131	1	BALL BEARING		C19
N3.1703		A38.0101	1	BALL	5 MM.	C24
N3.1706		A38.0108	2	BALL	15 MM	B14
N3.1708		A38.0108	1	BALL	10 MM	D14
N3.2319			1	NEEDLE CASE		D21
N3.2322		A38.1355	1	NEEDLE CASE		B22
N3.2322		A38.1372	1	NEEDLE CASE		A23
N3.2323		A38.1355	1	NEEDLE CASE		B22
N3.2323		A38.1372	1	NEEDLE CASE		B24
N3.2602			1	PACKING RING		D21
N3.2603		A38.0101	1	PACKING RING		C22
N3.3119			1	SLIDE-BEARING		B2
N3.3124			1	SLIDE-BEARING		B2
N3.3128		A38.0101	1	HEADED PRESS FIT BUSH		C23
N3.3129		A38.0101	2	SLIDE-BEARING		B23+
N3.3130		A38.0101	1	HEADED PRESS FIT BUSH		C24
N41.9128			1	ADHESIVE LABEL		A11
N41.9129			1	ADHESIVE LABEL		A11
N4.5110		A38.0108	1	CAP		B15
N4.5110			1	CAP		A15
N4.9131			1	LABEL	<<A380>>	B9
N4.9159			1	LABEL	<<CE>>	B8
[N6.3404]			1	PISTON		B7
N6.3501		A38.1154	1	INNER PACKING	12.31X24.1X6.5	B11
N6.3504		N6.3404	1	INNER PACKING	8.3X12.1X4	B7
N6.3505		A38.1154	1	EXTERNAL PACKING RING	125X12	C11
N6.3507		A38.2155	1	EXTERNAL PACKING RING		B10
N6.3508		N6.3404	1	EXTERNAL PACKING RING		B7
N6.5133		A38.0108	1	REDUCING COUPLING		C13
N6.5508		A38.0117	1	EXHAUST SILENCER	R 1/2"	A22
N6.5624		A38.0108	1	ANGLE		C13
N6.5627			1	HOLLOW SCREW		B17
N6.5628			2	HOLLOW SCREW		C12+
N6.5634			2	PACKING RING		B17
N6.5635			4	PACKING RING		C12+
N6.5637		A38.0117	1	ADAPTER		A21
N6.6107			1	SEAL	56 X 46 X 10	B4
N6.6108			1	SEAL	16 X 24 X 5	D8
N6.6113			1	PACKING RING	10 X 16 X 4.5	C7
N6.6114		A38.0110	1	LIP SEAL	12 X 6 X 4	C18
N6.6115		A38.0110	1	LIP SEAL	16 X 10 X 4	C18
N6.6116			1	SEAL	18 X 28 X 17.5	C8
N6.6117		A38.0108	5	SEAL	6 X 13 X 2.3	B16+
N6.6117		A38.0110	4	SEAL	6 X 13 X 2.3	A18+
N6.6121			6	SEAL	8 X 15 X 2.3	C10+
N6.6122			3	SEAL	20 X 13 X 2.3	C9+
N6.6145			1	DIAPHRAGM		C14
N6.6204		A38.0108	4	O-RING	18 X 2	B14
N6.6207		A38.1244	1	O-RING	3,1 X 1,6	A17
N6.6207			1	O-RING	3,1 X 1,6	D11
N6.6209			6	O-RING	17 X 2	C9+
N6.6216			1	O-RING	125 X 2	A11
N6.6217		A38.0108	8	O-RING	15 X 2	B16+

* = Wearing parts

[] = Group

13.6285.01	A380/13/0.50-0.63/4.5/A			A380.0003.01		15.07.99
Item-No.		in group	Pcs.	Description	Dimension	Field
N6.6217		A38.0110	6	O-RING	15 X 2	A18+
N6.6223		A38.0117	1	O-RING	50 X 2	B21
N6.6229		A38.0101	1	O-RING	14 X 1	B24
N6.6230		A38.0108	1	O-RING	8 X 1,5	D14
N6.6233		A38.0108	1	O-RING	6 X 2	B15
N6.6235		A38.0108	2	O-RING	12 X 2	B15
N6.6237			1	O-RING	33 X 1,5	B7
N6.6238			1	O-RING	60 X 2	B9
N6.6241		A38.0131	2	O-RING	46 X 2	B20+
N6.6247		A38.1261	1	O-RING	5 X 2,5	D10
N6.6247			1	O-RING	5 X 2,5	B16
N6.6251			1	O-RING	18 X 1.5	C9
N6.6252			1	O-RING	12 X 1.5	B9
N6.6501		A38.1261	1	FLAT SEAL	18 X 13 X 2	D10
N6.6803		A38.0101	1	PACKING RING	10 X 19 X 9.8	C22
N7.1104			1	BUSH		D20
N7.1202			1	SEALING DISK		D20

