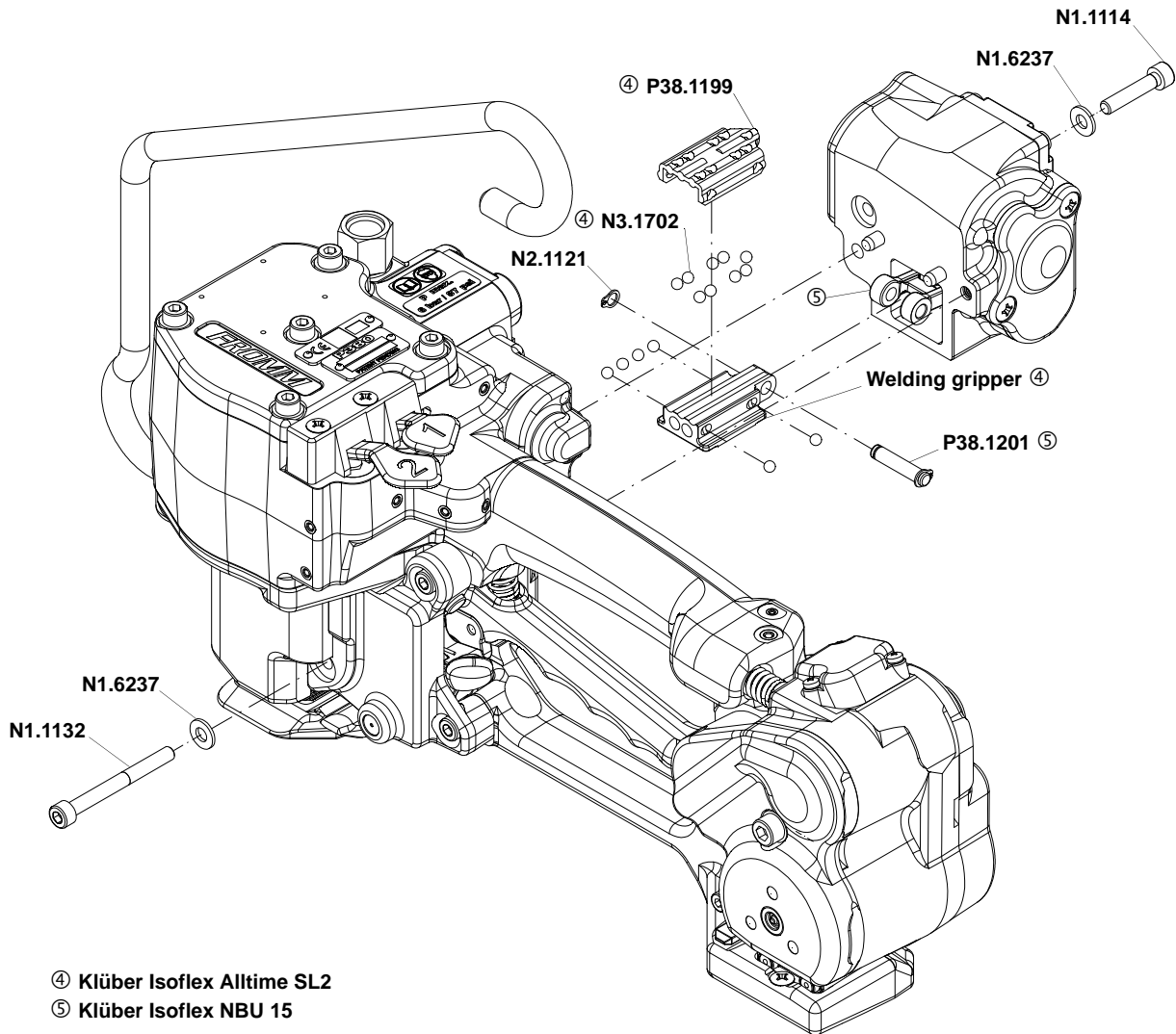


## 11.2 Exchange of welding gripper

- Disassemble the both screws N1.1114 and N1.1132 together with the conical spring washers N1.6237;
- Pull off the complete welding drive;
- Remove the ball cage P38.1199 and the balls N3.1702 from the welding gripper;
- Disassemble the security ring N2.1121;
- Remove the bolt P38.1201.



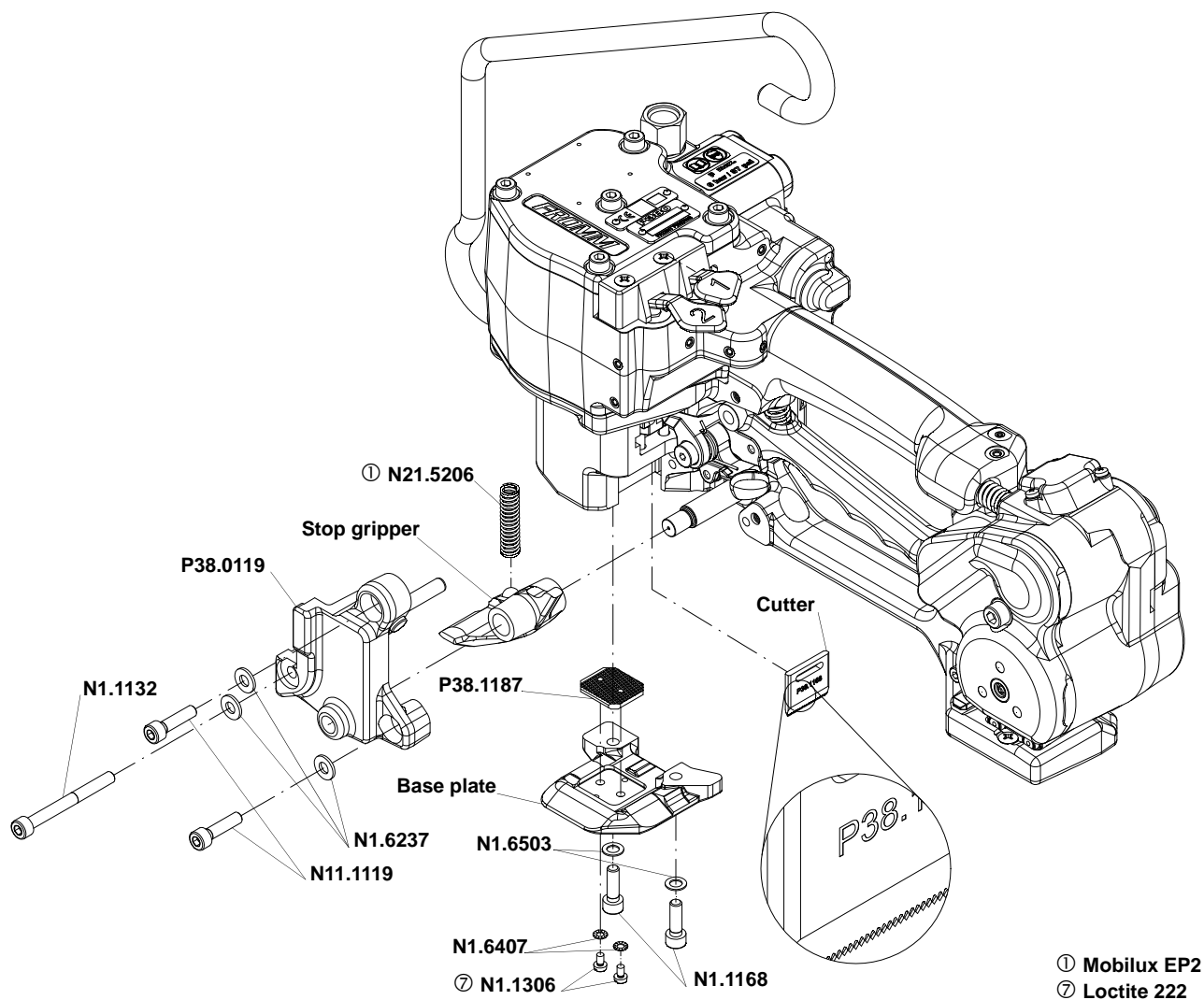
Assembling in opposite order.

### Assembly advise

- Lubricate the rocker and the bolt P38.1201 in the area of the welding jaw with Klüber Isoflex NBU 15.
- Lubricate the balls, ball cage and the running surface of the balls on the welding gripper with Klüber Isoflex Alltime SL2.

### 11.3 Exchange of welding stop gripper, stop gripper and cutter

- Put a piece of plastic strap between stop gripper and base plate;
- Screw off base plate;
- Disassemble the screws N1.1306;
- Take the welding stop gripper P38.1187 from the base plate.
  
- Disassemble the end cover P38.0119;
- Take the cutter from the tool;
- Pull off the stop gripper.



Assembling in opposite order.

#### Assembly advise

- Pay attention to the assembling position of the cutter (see drawing).
- Glue the screws N1.1306 with Loctite 222.

## 12 MAINTENANCE

Depending on the working conditions and the use of the tool the following maintenance has to be made periodically:

### 12.1 Air unit

- Checking the air-pressure daily (never exceed 6 bar / 87psi)
- Checking oil-level daily
- The water separator must be emptied before it is full (unless automatic)
- The filter has to be cleaned following the instructions of the manufacturer of the air- unit
- Check the function and proper adjustment of the lubricator daily (approximately 1-2 drops/min.)



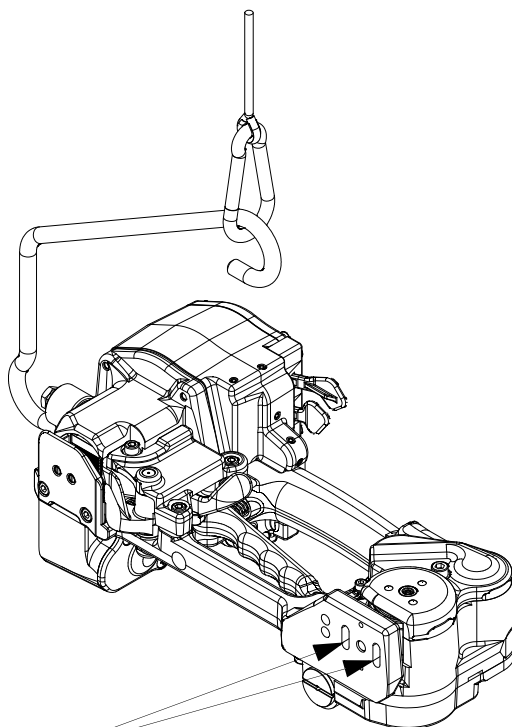
**Before any maintenance work always disconnect the tool from the air supply.**

## 13 CLEANING

Clean tension- and sealing parts from strap abrasion regularly using compressed air. For that are additional openings existent in the base plate.

Do not use any mechanical tool for cleaning.

When cleaning the surface of the tool do not use water or aggressive solvents!



Openings for blowing  
out the tensioning elements

## 14 SERVICE / REPAIR

Servicing and repair work must only be carried out by authorized service centres.

If the tool breaks down or does no longer operate do not disassemble it. Send it fully assembled to the local service centre (see name and address on the rear page of this manual). Use original packing.

The pneumatic plastic strapping tool P380 is a high performance tool. We strongly recommend you to have it serviced by an authorized service shop after 12 months at the latest if used one shift per day. If used two or more shifts per day the tool has to be serviced after a shorter period of time.