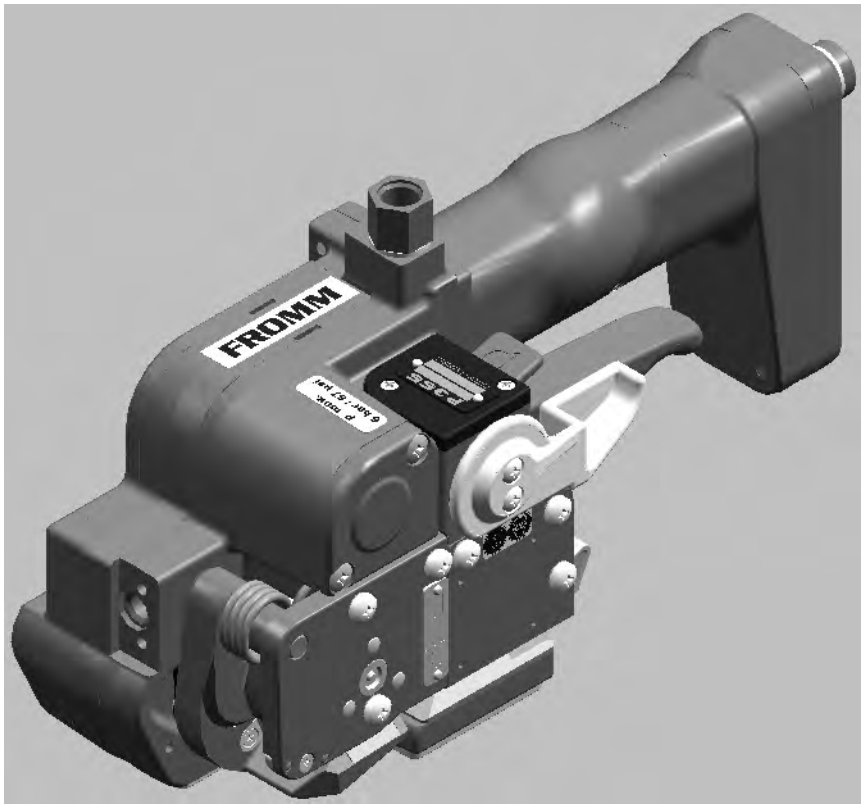
FROMM

SERVICE MANUAL

PNEUMATIC PLASTIC STRAPPING TOOL

MODEL P355.0001.01



Manual for autorized dealers and service points

P355.0001.01se.en.fm/MAS/© 11.03

1.2 CONVERSION PARTS

When changing strap thickness or strap width following parts must be exchanged.

1.2.1 Conversion parts: strap width

	10mm	11.1mm	12mm	12.7mm	13mm	15mm	15.5mm	16mm
Guide pin	P30.1156	P30.1158	P30.1156	P30.1157	P30.1158	P30.1159	P30.1160	P30.1161
Guide pin	P30.1162	P30.1164	P30.1162	P30.1163	P30.1164	P30.1165	P30.1166	P30.1167
Guide case	P32.1205	P32.1205	P32.1206	P32.1206	P32.1206	P32.1206	P32.1206	P32.1206
Strap stop	P32.1230	P32.1231	P32.1232	P32.1233	P32.1234	P32.1235	P32.1236	P32.1237
Strap guide	P32.1239	P32.1240	P32.1241	P32.1242	P32.1243	P32.1244	P32.1245	P32.1246

1.2.2 Conversion parts: strap thickness

	0.4-0.64mm	0.65-1.05mm
Steel insert	P32.1201	P32.1202
Tensioning wheel	P32.1219	P32.1220
Gripper	P32.1222	P32.1225
Gripper	P32.1223	P32.1226
Gripper	P32.1224	P32.1227



Attention!
When converting tools always change the item number on the type label

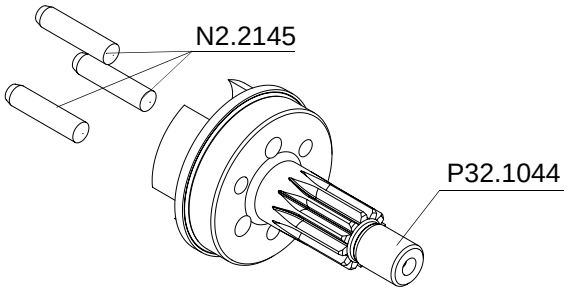
Replace following parts:
Type label N41.9143
2 x hammer head bolts N2.4902

Enclose the suitable operation manual with the tool after each conversion
(see paragraph Ordering manuals)

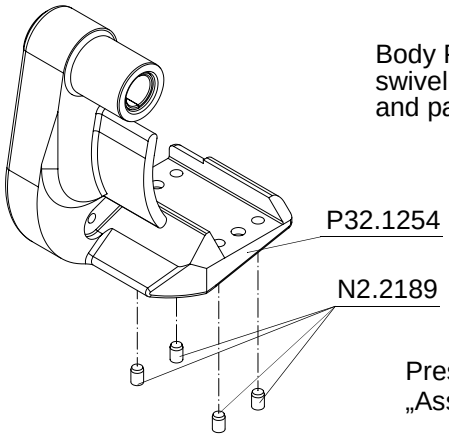
1.3.4 Glueing rules

Following parts have to be glued with **LOCTITE 603**:

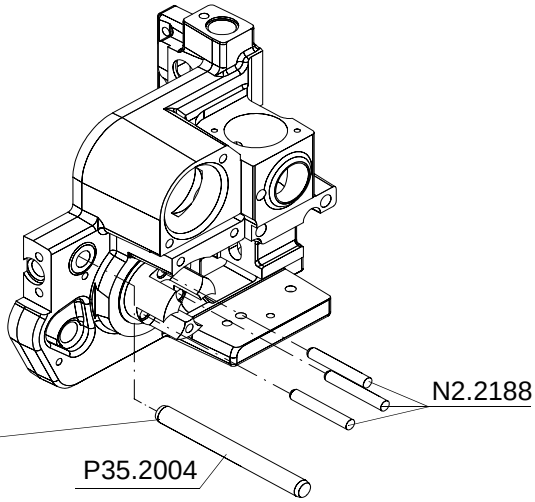
Planet shaft P32.1044
with the parallel pins N2.2145.



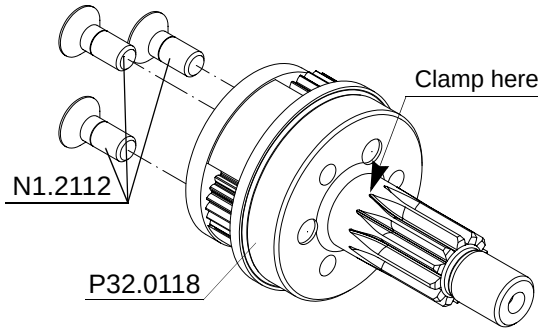
Tensioning body P32.1254
with the parallel pins N2.2189



Body P35.2002 with
swivel shaft P35.2004
and parallel pins N2.2188



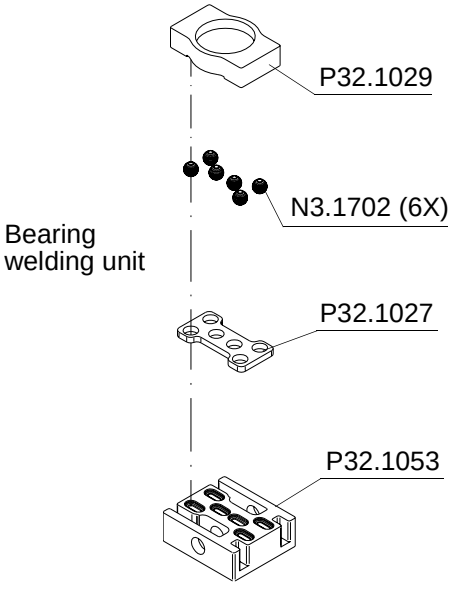
Additional the screws N1.2112 have to be glued in the planetary gear stage P32.0118 using **LOCTITE 222.**
Don’t clamp the planet shaft directly on the teeth when loosening or tightening the screws N1.2112.



1.3.5 Lubrication rules

All bearing parts of the welding unit have to be cleaned and lubricated with **Klueber Isoflex Alltime SL2** grease during each maintenance.

Lubrication interval:
At each maintenance or after 12 months at the latest.



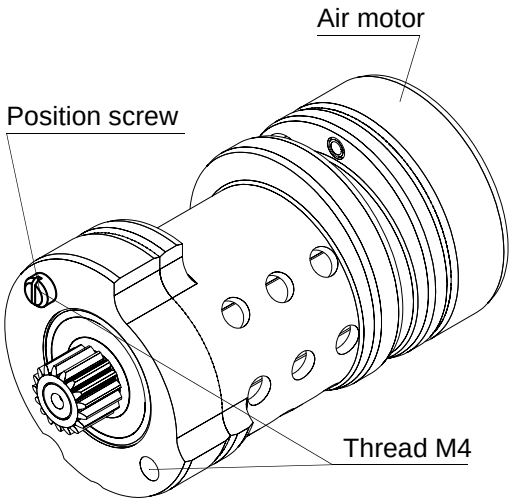
All movable gear parts have to be lubricated with **MOLYKOTE BR 2 PLUS** grease.
Lubrication interval: At each maintenance or after 12 months at the latest.

All other parts have to be greased according to the explosion drawing.
Lubrication interval: At each maintenance or after 12 months at the latest.

1.3.6 Assembly information

Air motors

Installation:
When installing the air motors pay attention to the correct position of the position screw.
(see picture)

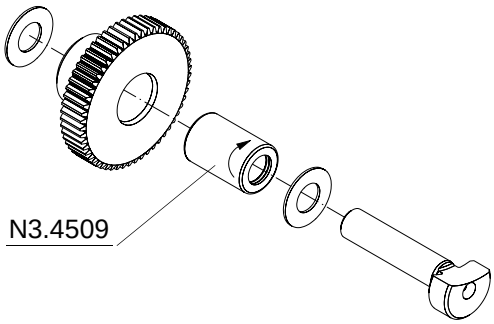


Removing welding motor:

- Remove positioning screw and screw in two screws M4 (e.g. N1.1936) in the two existing thread holes.
- Pull out welding motor.

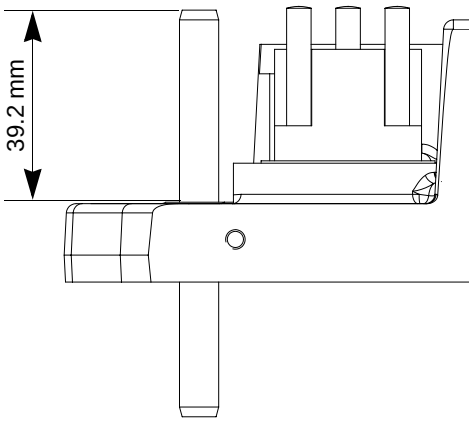
Needle free wheeling:

Pay attention to the assembling direction of the needle free wheeling N3.4509.
The sense of rotation is stamped in the front of the free wheeling.



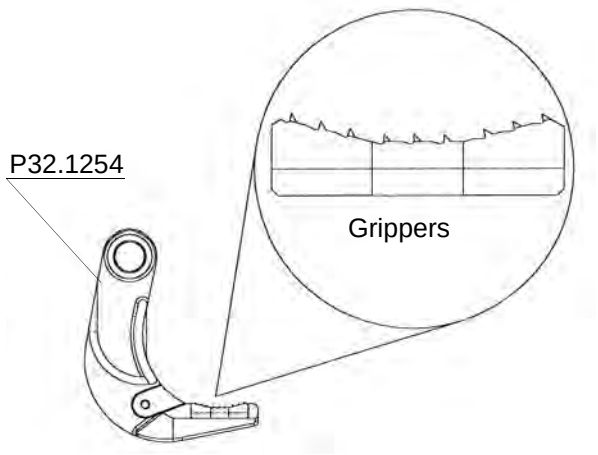
Swivel shaft:

When pressing in the swivel shaft P35.2004 the dimension 39.2 mm must be observed (see drawing)



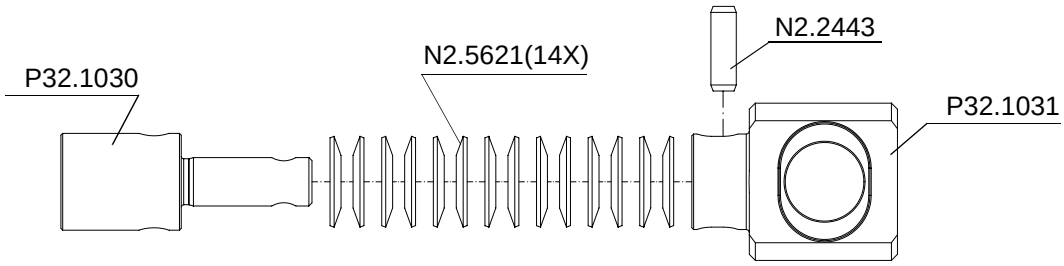
Grippers:

When installing the grippers into the tensioning body P32.1254 pay attention to the direction of the teeth.(see picture)



Cup springs:

Assemble the cup springs N2.5621 as shown in the picture.

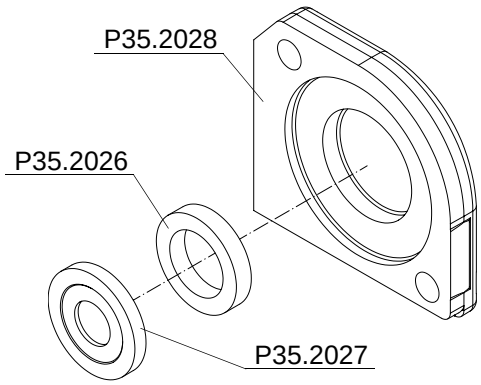


Motor cover:

When assembling the motor cover P35.2028, pay attention to the assembling direction of the spring P35.2026 and the thrust piece P35.2027. (See drawing)

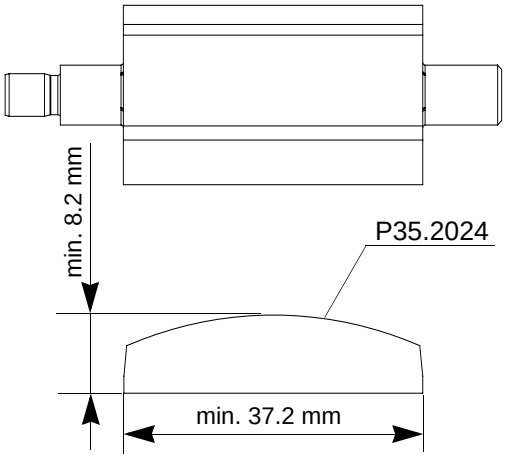
Attach parts with grease (ESSO BEACON 2) !

The same assembling position is valid for the welding motor too!



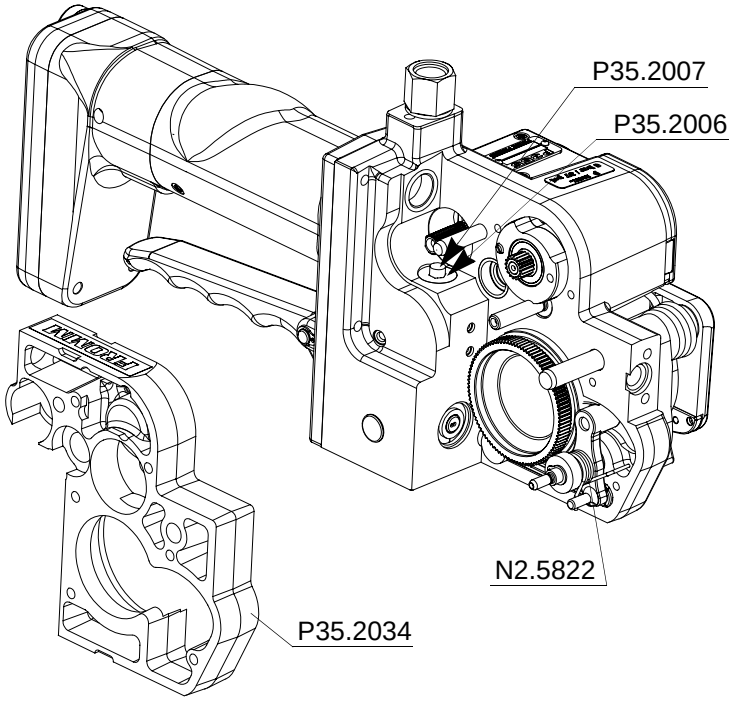
Vane:

If the minimum diameters (see drawing) are not reached anymore, the vanes P35.2024 must be exchanged.



Gear body:

When assembling or disassembling the gear body (P35.2034) the touch bolt (P35.2007) and the guide (P35.2006) of the welding valve must be pressed down. The spring N2.5822 must be slightly lifted up. (see drawing)



1.4 RECOMMENDED SPARE PARTS

Following spare parts are recommended for stock keeping:

Item-No.	Description	Pieces per tool
N1.1305	Screw	2
N1.1813	Screw	6
N1.1820	Screw	1
N1.1904	Screw	5
N1.1909	Flat head screw	2
N1.1915	Screw	2
N1.1929	Screw	1
N1.1932	Flat head screw	2
N1.1935	Flat head screw	4
N1.1936	Flat head screw	2
N1.6205	Spring lock washer	2
N1.6503	Safety washer	6
N1.6504	Safety washer	9
N1.6505	Safety washer	4
N2.1107	Security ring	1
N2.1118	Security ring	1
N2.1121	Security ring	5
N3.1174	Ball bearing	2
N3.1702	Ball	6
N3.1703	Ball	1
N5.2702	Cover	2
P32.1034	Lever	1
P32.0110	End cover	1

Besides should be stocked the wearing parts of the different Types.
Stock only parts from tools that are in sale.

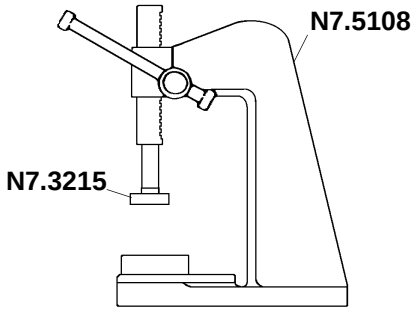
1.5 ACCESSORY TOOLS

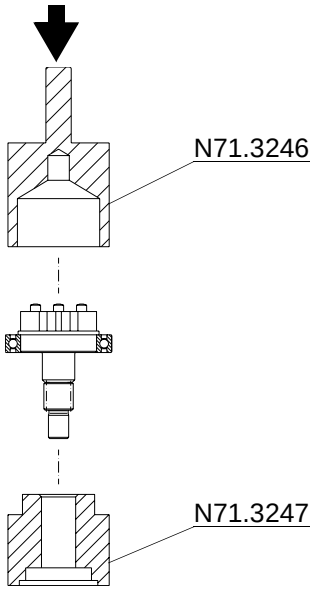
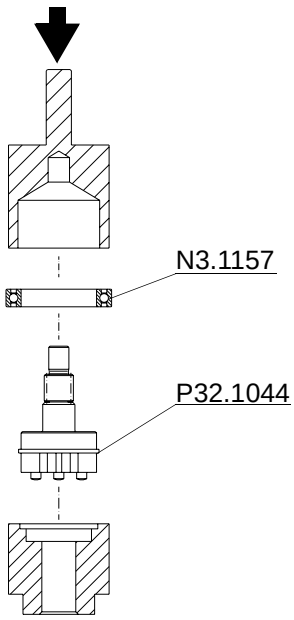
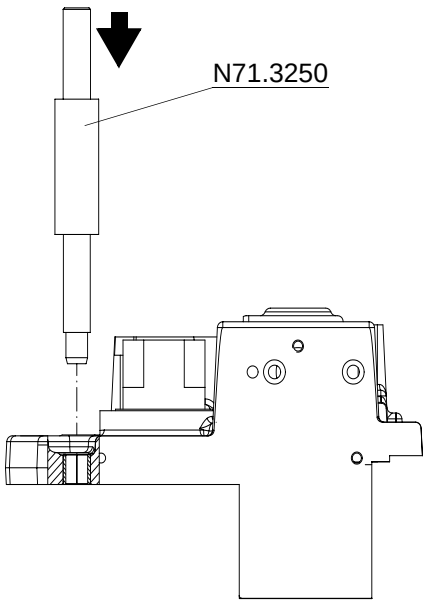
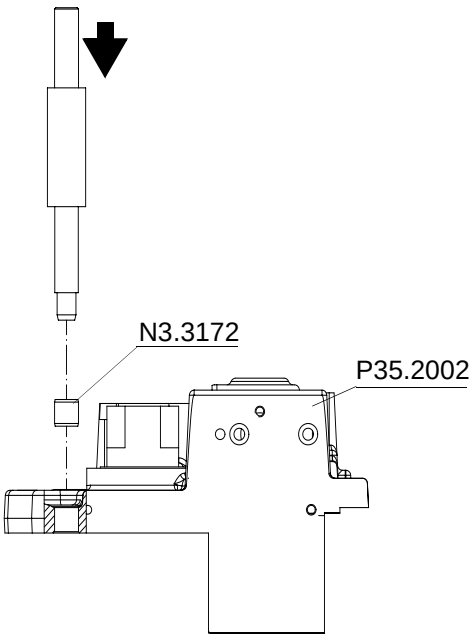
Item number		Field	Use
N7.3219	**	F10	Press in and press out pressure pad for N3.3173/P35.2002
N71.3235	*	F5	Press in and press out arbor for N3.4509/P35.2036
N71.3237	*	F3	Press in and press out arbor for N3.1159/P32.1037
N71.3238	*	F3	Press in and press out pressure pad for N3.1159/P32.1037
N71.3239	*	F7	Press in arbor for N3.2347/P32.1024
N71.3240	*	F7	Press out arbor for N3.2347/P32.1024
N71.3241	*	F7	Press in and press out pressure pad for N3.2347/P32.1024
N71.3242	*	F8	Press in and press out arbor for N3.2346/P32.1238
N71.3243	*	F6	Press in arbor for N3.1134, P32.1023/P32.1022
N71.3244	*	F6, F9	Press out arbor for N3.1134, P32.1023/P32.1022; P35.0123/P32.1123; P35.0124/P32.1023
N71.3245	*	F6, F8	Pressure pad for N3.1134, P32.1023/P32.1022; N3.2346/P32.1238
N71.3246	*	F1	Press in and press out arbor for N3.1157/P32.1044
N71.3247	*	F1	Press in and press out pressure pad for N3.1157/P32.1044
N71.3248	*	F4	Press in arbor for N3.3172/P32.1254
N71.3249	*	F4	Press out pressure pad for N3.3172/P32.1254
N71.3250	*	F2, F4	Press in and press out arbor for N3.3172/P35.2002; N3.3172/P32.1254
N71.3253	*	F10	Press in and press out arbor for N3.3173/P35.2002
N71.3254	*	F10, F9	Press out arbor for N3.3173/P35.2002; Press on arbor for P32.1123/ P35.0123 and P32.1023/P35.0124
N71.3273		F5	Press in and press out pressure pad for N3.4509/P35.2036
N71.3274		F12	Hook for exhaust ring P35.2005/P35.2002
N71.3275		F9	Press on pressure pad for P32.1123/P35.0123, P32.1023/P35.0124
N71.3276		F11	Pressure pad for P35.2021/P35.2023, N3.1174
N71.3277		F11	Thrust piece for P35.2021/P35.2023, N3.1174
N71.3280		F9	Press out pressure pad for P32.1123/P35.0123, P32.1023/P35.0124

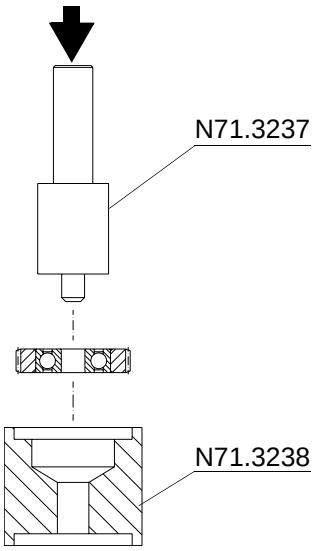
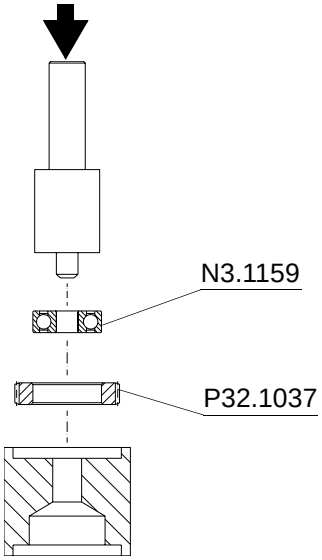
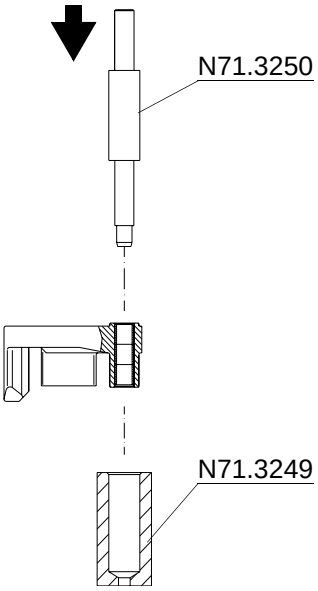
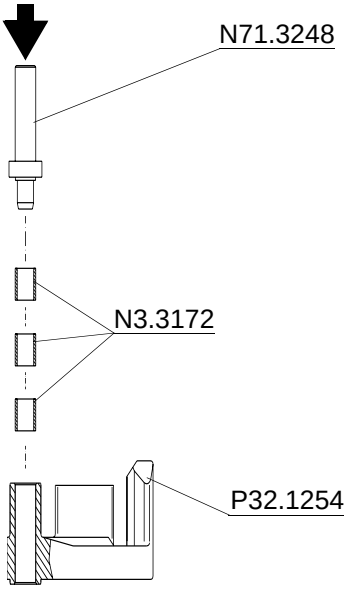
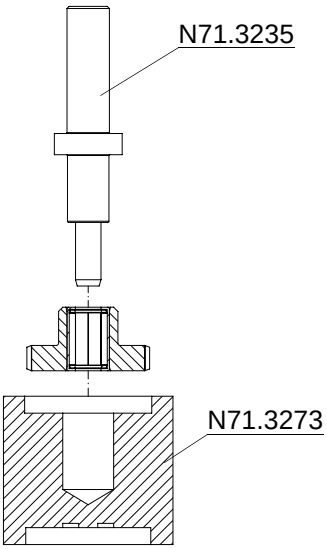
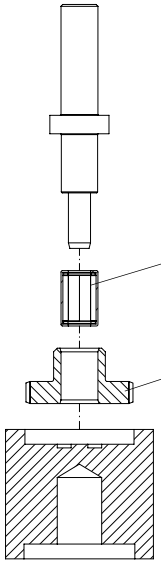
*These tools are also included in the P320 tool set.
**These tools are also included in the P300 tool set.

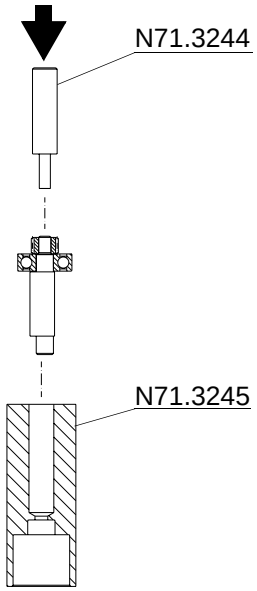
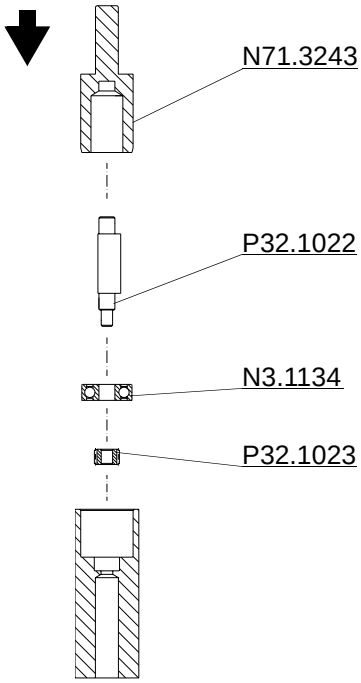
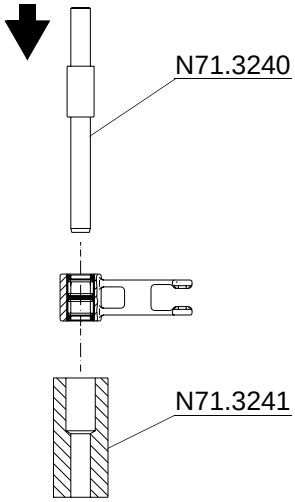
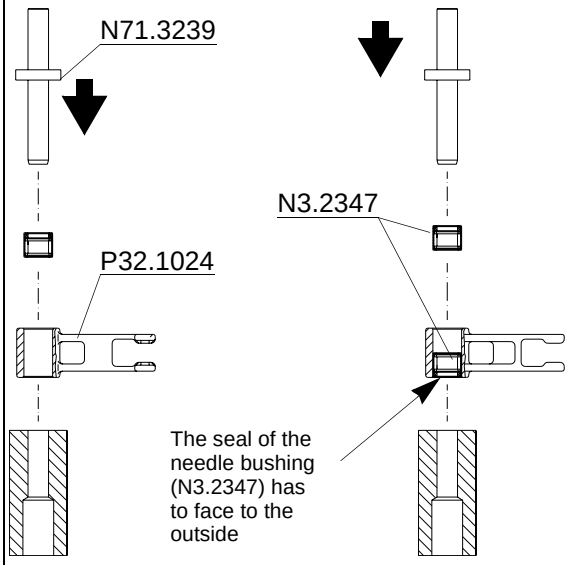
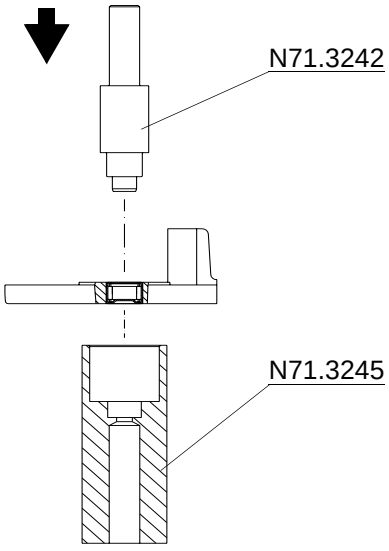
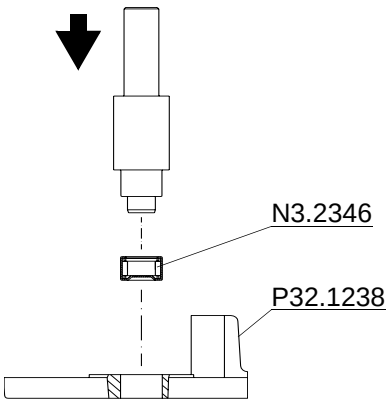
1.5.1 Use of accessory tools

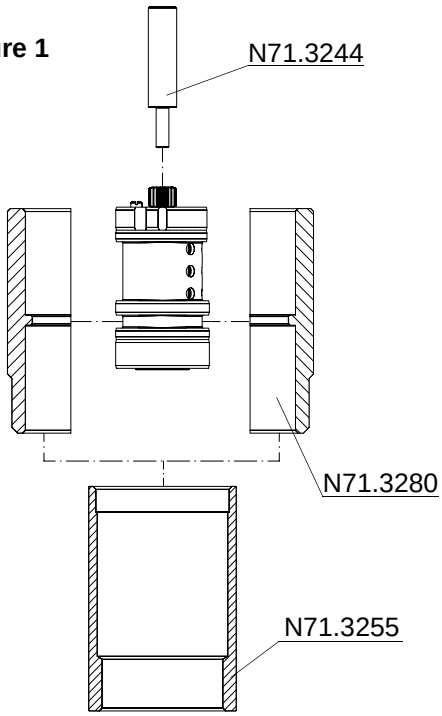
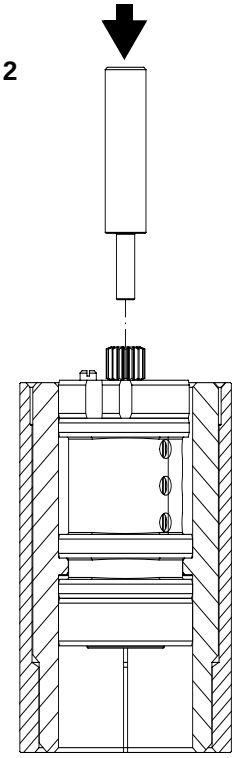
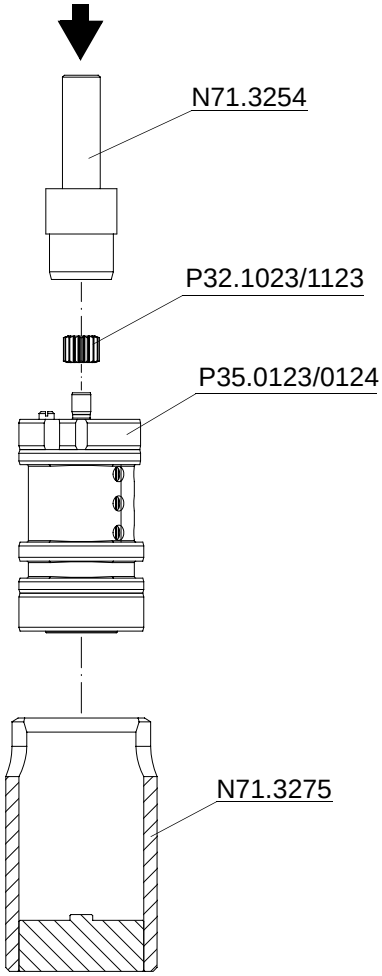
Accessory tools should only be used with the suitable arbor press N7.5108 in order to avoid a tilt of the pressed in parts.
Additional a retainer (N7.3215) is necessary.

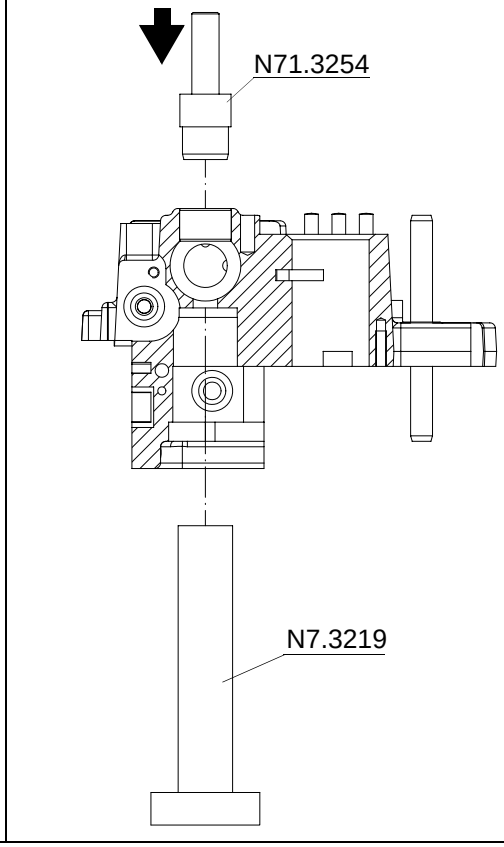
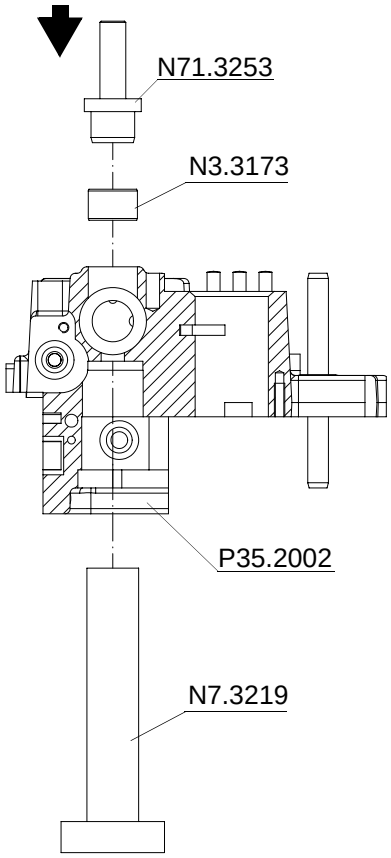


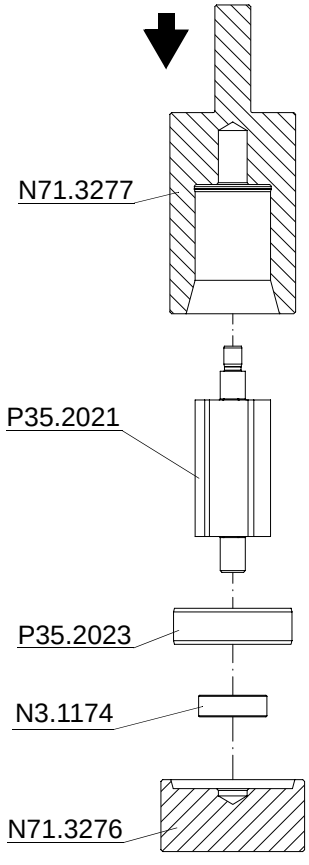
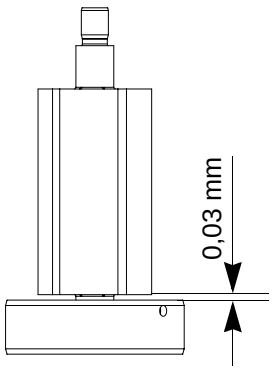
Part	Disassembly	Assembly
N3.1157/ P32.1044 **F1**		
N3.3172/ P35.2002 **F2**		

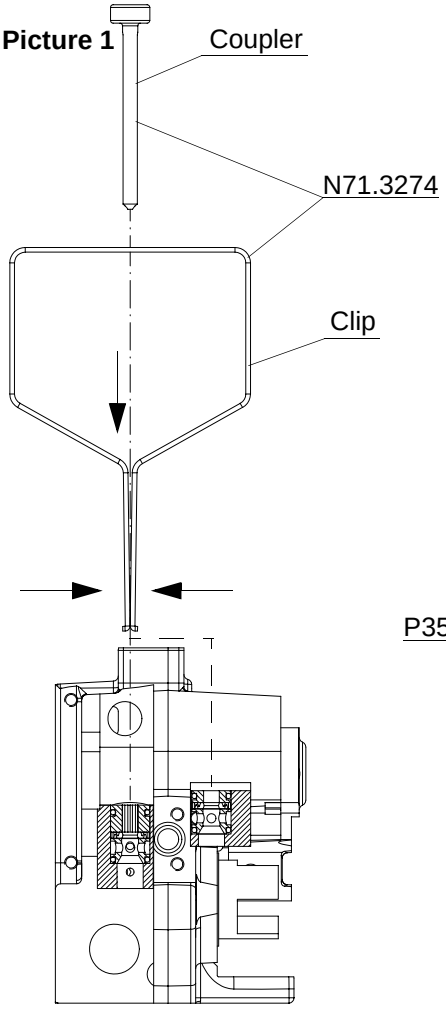
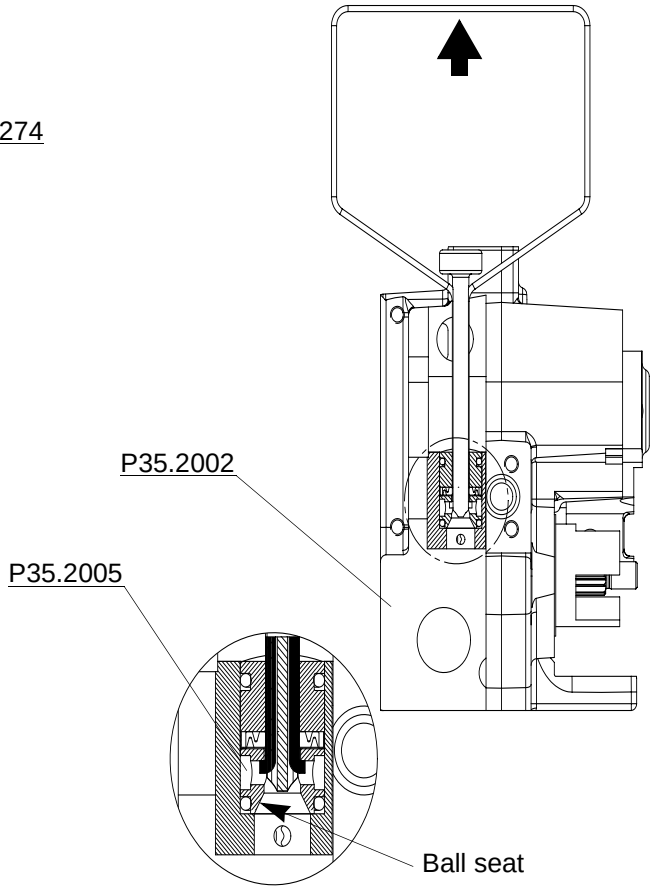
Part	Disassembly	Assembly
N3.1159/ P32.1037 **F3**		
N3.3172/ P32.1254 **F4**		
N3.4509/ P35.2036 **F5**		 *Assembling position see „Assembly information“

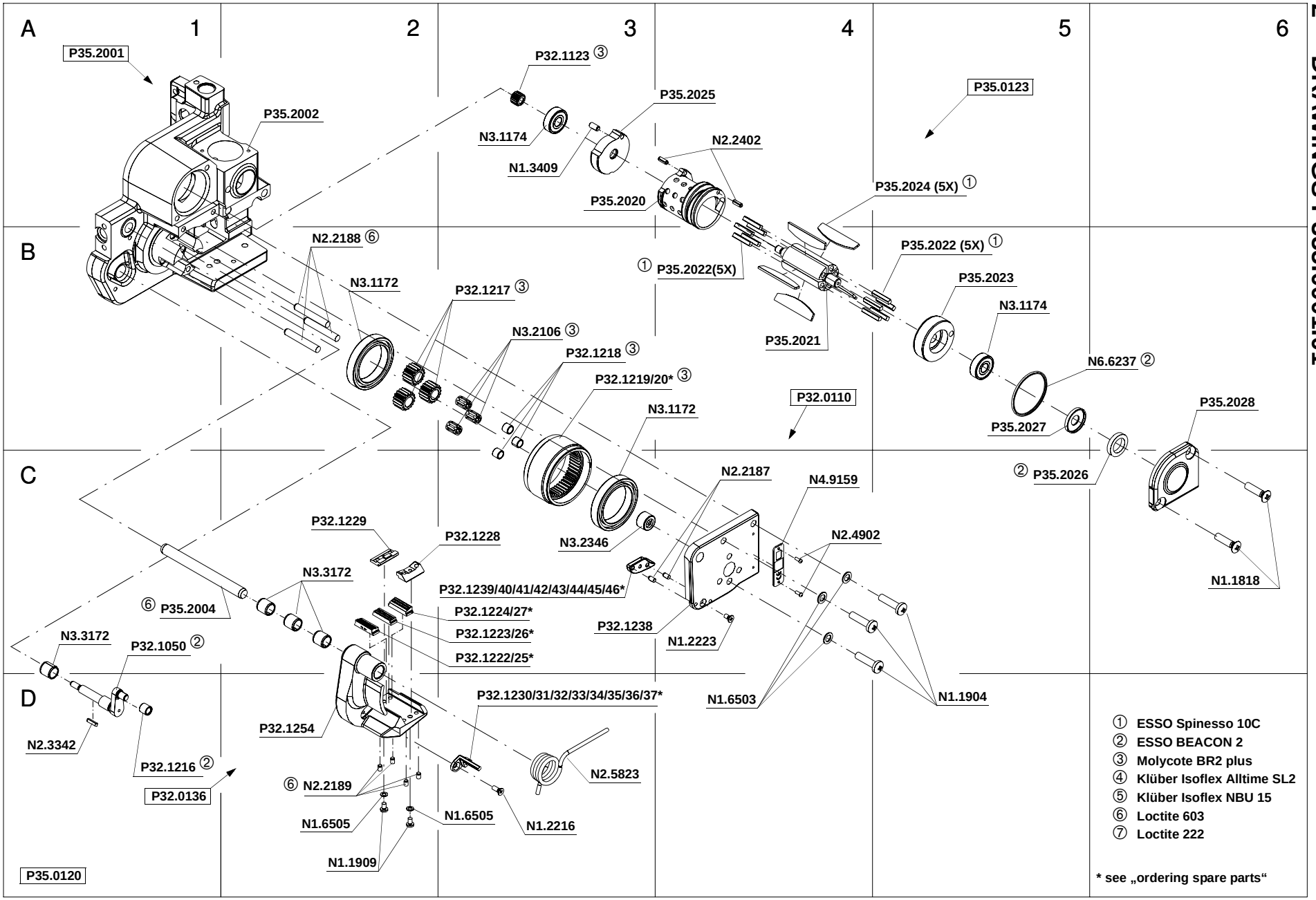
Part	Disassembly	Assembly
P32.1023/ N3.1134/ P32.1022 **F6**		
N3.2347/ P32.1024 **F7**		
N3.2346/ P32.1238 **F8**		

Part	Disassembly	Assembly
P32.1123/ P35.0123 and P32.1023/ P35.0124 **F9**	**Picture 1**  **Picture 2** 	

Part	Disassembly	Assembly
N3.3173/ P35.2002 **F10**		

Part	Disassembly	Assembly
P35.2023/ N3.1174/ P35.2021 **F11**	**Commercially available Puller.**	 The distance between rotor (P35.2021) and end plate (P35.2023) should be 0,03 mm 

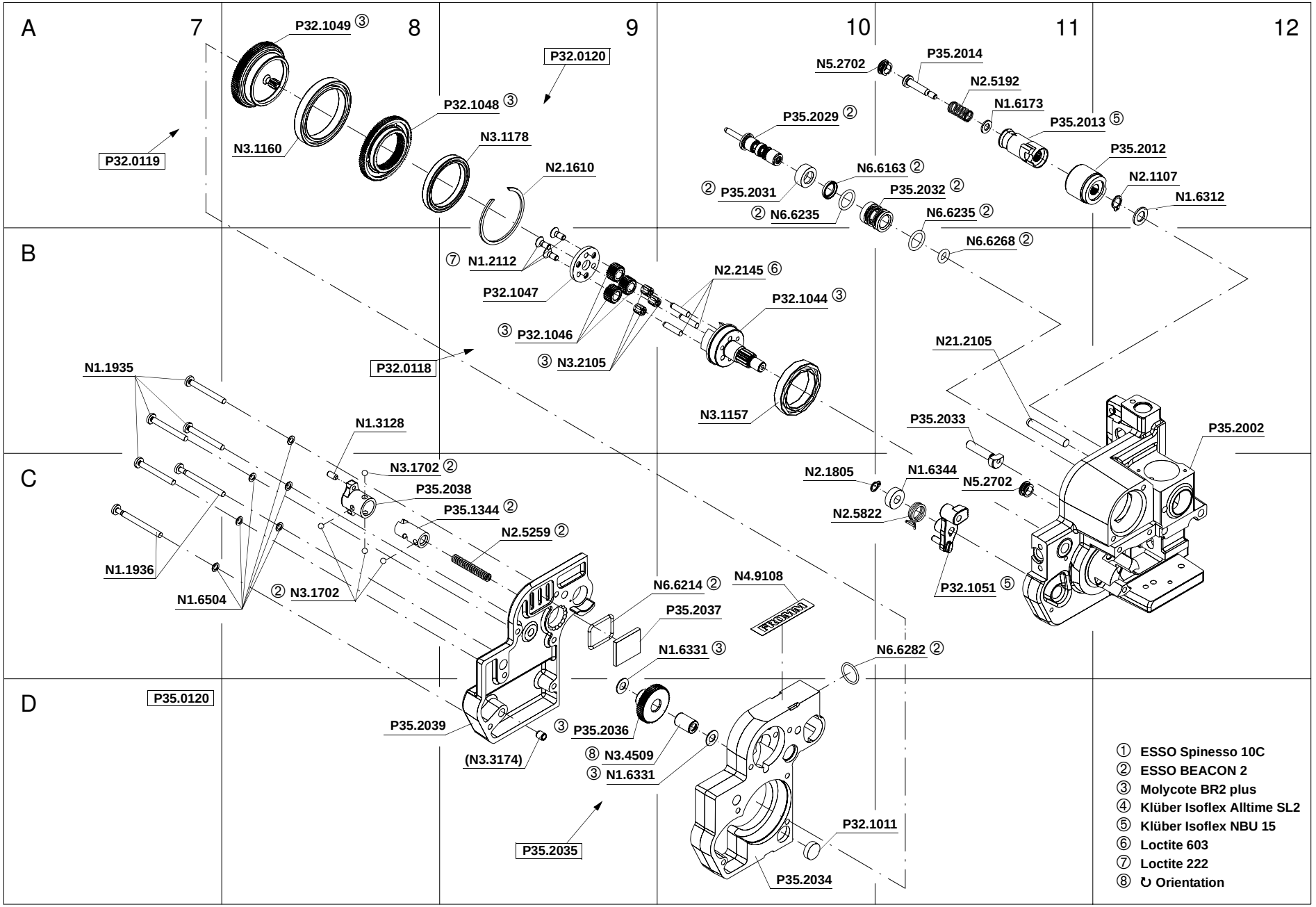
Part	Disassembly
P35.2005/ P35.2002 **F12**	**Picture 1**  **Picture 2**  **Attention!** **When disassembling the valves do not damage the ball seat of the exhaust ring P35.2005.** **Procedure:** • Press clip together and insert it into the hole, until it engages in the exhaust ring (P35.2005) • Insert coupler • Pull out exhaust ring

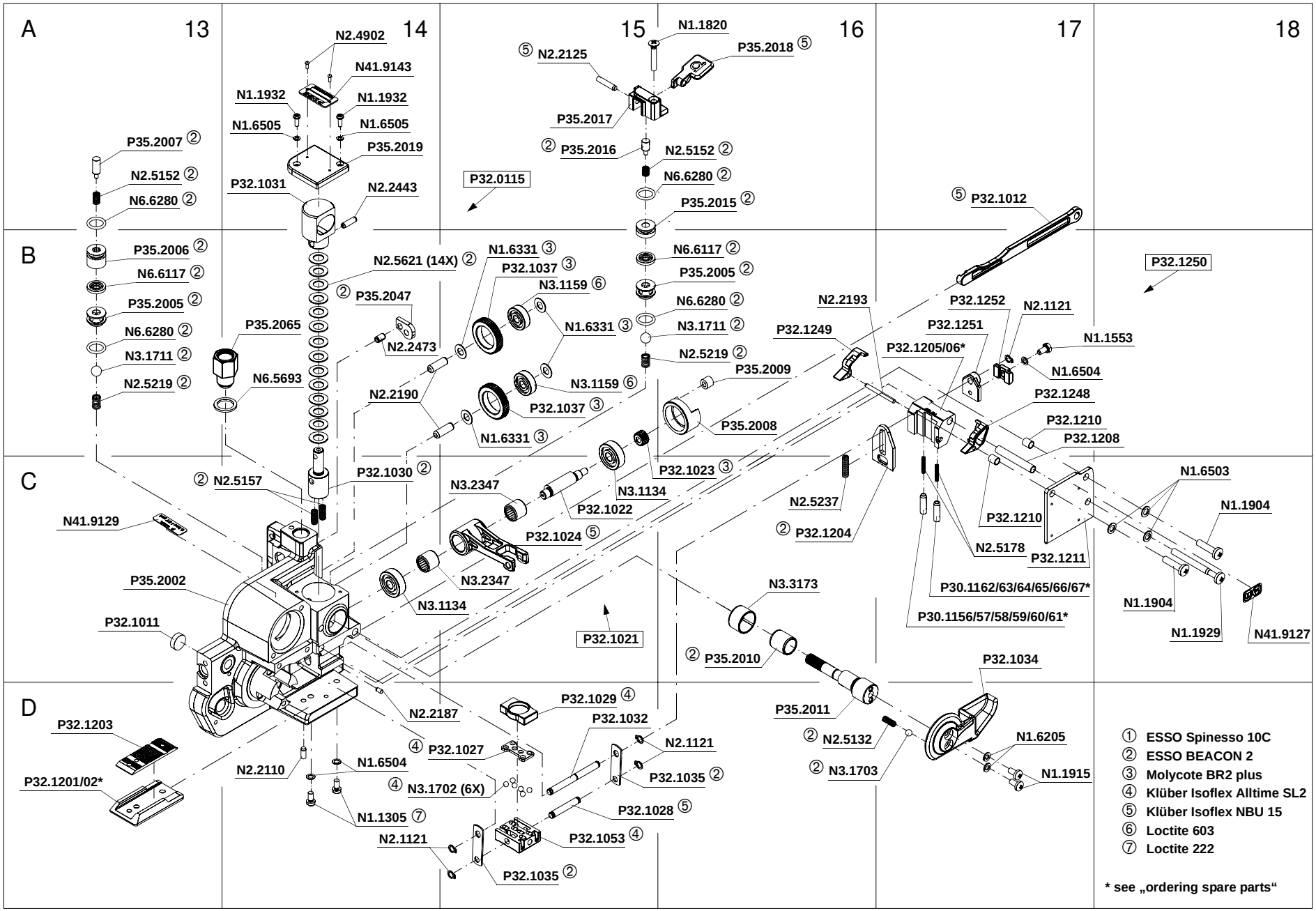


① ESSO Spinesso 10C
② ESSO BEACON 2
③ Molycote BR2 plus
④ Klüber Isoflex Alltime SL2
⑤ Klüber Isoflex NBU 15
⑥ Loctite 603
⑦ Loctite 222

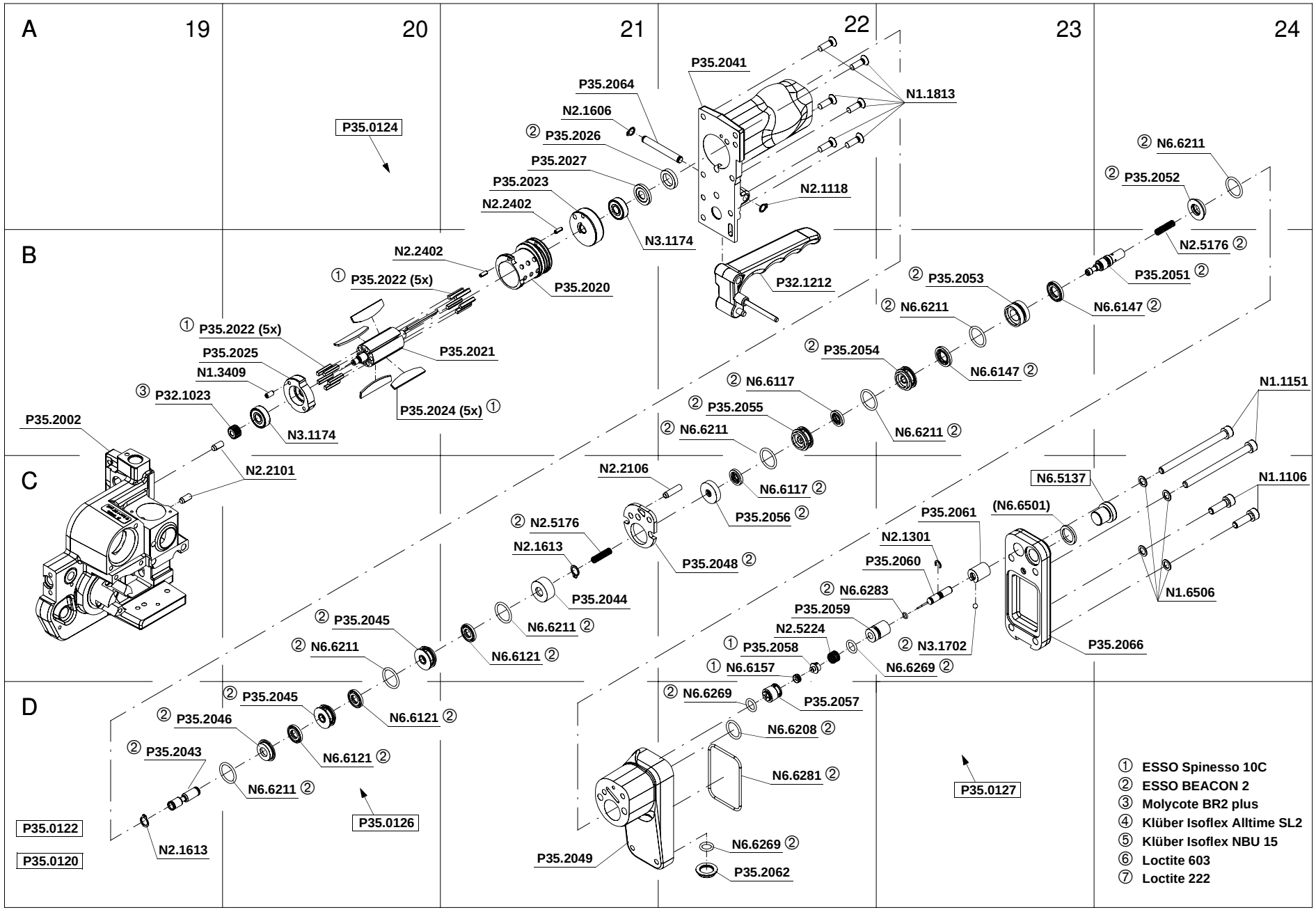
* see „ordering spare parts“

FROMM


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P32.1049 ③
P32.0120
P32.1048 ③
N3.1160
N3.1178
P32.0119
N2.1610
⑦ N1.2112
P32.1047
③ P32.1046
③ N3.2105
N2.2145 ⑥
P32.1044 ③
P32.0118
N3.1157
N5.2702
P35.2014
N2.5192
N1.6173
P35.2013 ⑤
P35.2012
N2.1107
N1.6312
P35.2029 ②
N6.6163 ②
② P35.2031
P35.2032 ②
② N6.6235
N6.6235 ②
N6.6268 ②
N21.2105
P35.2033
P35.2002
N2.1805
N1.6344
N5.2702
N2.5822
P32.1051 ⑤
N1.1935
N1.3128
N3.1702 ②
P35.2038
P35.1344 ②
N2.5259 ②
N1.1936
N1.6504
② N3.1702
N6.6214 ②
N4.9108
P35.2037
N1.6331 ③
N6.6282 ②
P35.0120
P35.2039
(N3.3174)
③ P35.2036
⑧ N3.4509
③ N1.6331
P35.2035
P32.1011
P35.2034
① ESSO Spinesso 10C
② ESSO BEACON 2
③ Molycote BR2 plus
④ Klüber Isoflex Alltime SL2
⑤ Klüber Isoflex NBU 15
⑥ Loctite 603
⑦ Loctite 222
⑧ ↻ Orientation


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C
D
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16
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18
N2.4902
N41.9143
N1.1932
N1.1932
N1.6505
N1.6505
P35.2019
P32.1031
N2.2443
P35.2007 ②
N2.5152 ②
N6.6280 ②
P35.2006 ②
N6.6117 ②
P35.2005 ②
N6.6280 ②
N3.1711 ②
N2.5219 ②
P35.2065
N6.5693
P32.0115
N1.1820
⑤ N2.2125
P35.2018 ⑤
P35.2017
② P35.2016
N2.5152 ②
N6.6280 ②
P35.2015 ②
N6.6117 ②
P35.2005 ②
N6.6280 ②
N3.1711 ②
N2.5219 ②
P35.2009
P35.2008
N1.6331 ③
P32.1037 ③
N3.1159 ⑥
N2.5621 (14X) ②
② P35.2047
N2.2473
N1.6331 ③
N3.1159 ⑥
N2.2190
P32.1037 ③
N1.6331 ③
P32.1023 ③
N3.1134
P32.1030 ②
② N2.5157
N3.2347
P32.1022
P32.1024 ⑤
N3.2347
N3.1134
N41.9129
P35.2002
P32.1011
P32.1021
N3.3173
② P35.2010
P32.1034
P35.2011
② N2.5132
② N3.1703
N1.6205
N1.1915
P32.1203
P32.1201/02*
N2.2187
P32.1029 ④
P32.1032
④ P32.1027
N2.1121
N2.2110
N1.6504
P32.1035 ②
④ N3.1702 (6X)
P32.1028 ⑤
N1.1305 ⑦
N2.1121
P32.1053 ④
P32.1035 ②
⑤ P32.1012
P32.1250
N2.2193
P32.1252
N2.1121
P32.1249
P32.1251
N1.1553
P32.1205/06*
N1.6504
P32.1248
P32.1210
P32.1208
N2.5237
② P32.1204
N1.6503
N1.1904
P32.1210
N2.5178
P32.1211
P30.1162/63/64/65/66/67*
P30.1156/57/58/59/60/61*
N1.1904
N1.1929
N41.9127
① ESSO Spinesso 10C
② ESSO BEACON 2
③ Molycote BR2 plus
④ Klüber Isoflex Alltime SL2
⑤ Klüber Isoflex NBU 15
⑥ Loctite 603
⑦ Loctite 222
* see „ordering spare parts“

FROMM


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P35.0124
P35.2041
N1.1813
P35.2064
N2.1606
② P35.2026
P35.2027
P35.2023
N2.2402
N3.1174
N2.1118
P32.1212
② N6.6211
② P35.2052
N2.5176 ②
P35.2051 ②
② P35.2053
N6.6147 ②
② N6.6211
② P35.2054
N6.6147 ②
② N6.6117
② P35.2055
N6.6211 ②
② N6.6211
N1.1151
N6.5137
N1.1106
(N6.6501)
P35.2061
N2.1301
P35.2060
② N6.6283
P35.2059
N2.5224
① P35.2058
② N3.1702
① N6.6157
N6.6269 ②
P35.2066
N1.6506
② N6.6269
P35.2057
N6.6208 ②
N6.6281 ②
P35.2049
N6.6269 ②
P35.2062
P35.0127
N2.2106
N6.6117 ②
P35.2056 ②
② N2.5176
N2.1613
P35.2048 ②
P35.2044
② P35.2045
② N6.6211
N6.6211 ②
N6.6121 ②
② P35.2045
② P35.2046
N6.6121 ②
② P35.2043
N6.6211 ②
N2.1613
P35.0126
P35.0122
P35.0120
① P35.2022 (5x)
P35.2025
N1.3409
③ P32.1023
N3.1174
P35.2024 (5x) ①
① P35.2022 (5x)
P35.2021
N2.2402
P35.2020
P35.2002
N2.2101
① ESSO Spinesso 10C
② ESSO BEACON 2
③ Molycote BR2 plus
④ Klüber Isoflex Alltime SL2
⑤ Klüber Isoflex NBU 15
⑥ Loctite 603
⑦ Loctite 222

3 SPARE PARTS LIST P355

3.1 Type independent spare parts P355.0001.01

Item-No.		in group	Pcs.	Description	Dimension	Field
N1.1106		P35.0127	2	SCREW	M6 X 20	C24
N1.1151		P35.0122	2	SCREW	M6 X 80	B24
N1.1305			2	SCREW	M4 X 7.8	D14
N1.1553		P32.1250	1	HEXAGON SCREW	M4 X 8	B17
N1.1813		P35.0120	6	SCREW	M5 X 16	A23
N1.1818		P35.0120	2	SCREW	M5 X 20	C6
N1.1820		P35.0120	1	SCREW	M4 X 25	A16
N1.1904			5	SCREW	M5 X 20	D5+
N1.1909			2	FLAT HEAD SCREW	M3 X 5	D2
N1.1915		P35.0120	2	SCREW	M4 X 8	D17
N1.1929			1	SCREW	M5 X 50	C18
N1.1932		P35.0120	2	FLAT HEAD SCREW	M3 X 8	A14
N1.1935		P35.0120	4	FLAT HEAD SCREW	M4 X 35	B7
N1.1936		P35.0120	2	FLAT HEAD SCREW	M4 X 45	C7
N1.2110		P35.0125	2	COUNTERSUNK SCREW	M5 X 16	--
N1.2112		P32.0118	3	COUNTERSUNK SCREW	M4 X 10	B9
N1.2216			1	COUNTERSUNK SCREW	M3 X 8	D3
N1.2223			1	COUNTERSUNK SCREW	M3 X 6	C4
N1.3128		P35.0120	1	SOCKET SET SCREW	M4 X 8	B8
N1.3409		P35.0123	1	SOCKET SET SCREW	M4 X 8	A3
N1.3409		P35.0124	1	SOCKET SET SCREW	M4 X 8	B19
N1.5105		P35.0125	2	HEXAGON NUT	M8	--
N1.6173		P35.0120	1	WASHER	5.3 X 9 X 1	A11
N1.6205		P35.0120	2	SPRING LOCK WASHER	M4	D17
N1.6312		P35.0120	1	SUPPORTING DISK	8 X 14 X 1.2	A12
N1.6331		P35.0120	6	SPACER WASHER	6 X 12 X 0.5	D9+
N1.6344		P35.0120	1	SPACER PIECE	6.3 X 15 X 5	C11
N1.6503			6	SAFETY WASHER	M5	D4+
N1.6504			2	SAFETY WASHER	M4	D14
N1.6504		P32.1250	1	SAFETY WASHER	M4	B17
N1.6504		P35.0120	6	SAFETY WASHER	M4	C7
N1.6505			2	SAFETY WASHER	M3	D2+
N1.6505		P35.0120	2	SAFETY WASHER	M3	A14
N1.6506		P35.0122	2	SAFETY WASHER	M6	C24
N1.6506		P35.0127	2	SAFETY WASHER	M6	C24
N21.2105		P35.0120	1	PARALLEL PIN	6 m6 X 40	B11
N2.1107		P35.0120	1	SECURITY RING	E8	A12
N2.1118			1	SECURITY RING	E6	A21+
N2.1121			1	SECURITY RING	E5	B17
N2.1121		P35.0120	4	SECURITY RING	E5	D14+
N2.1301		P35.0127	1	CIRCLIP	6	C23
N2.1606			1	SPRING RING	SW6	A21
N2.1610		P35.0120	1	SPRING RING	44	A9
N2.1613		P35.0126	2	SPRING RING		D19+
N2.1805		P35.0120	1	TENSIONING RING	6	C10
N2.2101		P35.0122	2	PARALLEL PIN	5 m6 X 12	C20
N2.2106		P35.0122	1	PARALLEL PIN	5 m6 X 20	C21
N2.2110		P35.2001	1	PARALLEL PIN	4 m6 X 10	D14
N2.2125		P35.0120	1	PARALLEL PIN	4 m6 X 20	A15
N2.2145		P32.0118	3	PARALLEL PIN	4 h6 X 18	B10

[ ] = Group * = Wearing parts

Item-No.		in group	Pcs.	Description	Dimension	Field
N2.2187		P32.0110	2	PARALLEL PIN	3 m6 X 6	C4
N2.2187		P35.2001	1	PARALLEL PIN	3 m6 X 6	D14
N2.2188		P35.2001	3	PARALLEL PIN	5 h6 X 34	B2
N2.2189		P32.0136	4	PARALLEL PIN	3 m6 X 5	D2
N2.2190		P35.0120	2	PARALLEL PIN	6 h6 X 18	B14
N2.2193			1	PARALLEL PIN	3 m6 X 32	B16
N2.2402		P35.0123	2	DOWEL PIN	3 X 8	A4
N2.2402		P35.0124	2	DOWEL PIN	3 X 8	B20+
N2.2443		P32.0115	1	DOWEL PIN	4 X 15	A14
N2.2473		P35.2001	1	DOWEL PIN	5 X 8	B14
N2.3342		P35.0120	1	FEATHER KEY	2 X 2 X 10	D1
N2.4902			4	HAMMER HEAD BOLT	1.85 X 4.76	C4+
N2.5132		P35.0120	1	PRESSURE SPRING	0.5 X 4 X 16/9.5	D16
N2.5152		P35.0120	2	PRESSURE SPRING	0.5 X 4.9 X 15/9.5	A13+
N2.5157		P35.0120	2	PRESSURE SPRING	0.6 X 4.8 X 20/15.5	C14
N2.5176		P35.0122	1	PRESSURE SPRING	0.6 X 5.5 X 31/17.5	C21
N2.5176		P35.0127	1	PRESSURE SPRING	0.6 X 5.5 X 31/17.5	B24
N2.5178			2	PRESSURE SPRING	0.32 X 2.82 X 20.5/ 20.5	C17
N2.5192		P35.0120	1	PRESSURE SPRING	0.7 X 8 X 28/8.5	A11
N2.5219		P35.0120	2	PRESSURE SPRING	0.7 X 5.7 X 12/6	B13+
N2.5224		P35.0127	1	PRESSURE SPRING	0.5 X 9 X 17/6.5	C22
N2.5237			1	PRESSURE SPRING	0.8 X 4.8 X 25/18.5	C16
N2.5259		P35.0120	1	PRESSURE SPRING	0.9 X 5.9 X 36.5/21.5	C9
N2.5621		P32.0115	14	CUP SPRING	15 X 8.2 X 0.7	B14
N2.5623		P35.0125	2	CUP SPRING	20 X 8.2 X 1/1.55	--
N2.5822		P35.0120	1	TORSION SPRING	1.25 X 11/3.75	C10
N2.5823			1	TORSION SPRING	2.8 X 17/4	D3
N3.1134		P32.1021	1	BALL BEARING	7 X 22 X 7	C15
N3.1134		P35.0120	1	BALL BEARING	7 X 22 X 7	C14
N3.1157		P32.0118	1	BALL BEARING	30 X 42 X 7	B10
N3.1159		P35.0120	2	BALL BEARING	6 X 19 X 6	B15
N3.1160		P32.0119	1	BALL BEARING	40 X 52 X 7	A8
N3.1172			2	BALL BEARING	30 X 42 X 7	B2+
N3.1174		P35.0123	2	BALL BEARING	7 X 19 X 6	A3+
N3.1174		P35.0124	2	BALL BEARING	7 X 19 X 6	B20+
N3.1178		P32.0120	1	BALL BEARING	35 X 44 X 5	A9
N3.1702		P35.0120	10	BALL	4 MM	C8+
N3.1702		P35.0127	1	BALL	4 MM	C23
N3.1703		P35.0120	1	BALL	5 MM	D16
N3.1711		P35.0120	2	BALL	8 MM	B13+
N3.2105		P32.0118	3	NEEDLE CAGE	K 4 X 7 X 7 TN	B9
N3.2106			3	NEEDLE CAGE	K 5 X 8 X 10 TN	B3
N3.2346		P32.0110	1	NEEDLE CASE	8 X 12 X 8	C3
N3.2347		P35.0120	2	NEEDLE BUSH	10 X 14 X 12	C15
N3.3172		P32.0136	3	SLIDE-BEARING	8 X 10 X 10	C2
N3.3172		P35.2001	1	SLIDE-BEARING	8 X 10 X 10	C1
N3.3173		P35.2001	1	SLIDE-BEARING	17 X 19 X 12	C16
N3.3174		P35.2039	1	SLIDE-BEARING	4 X 5.5 X 6	D9
N3.4509		P35.2035	1	NEEDLE FREE WHEELING	6 X 10 X 15	D9
N41.9127			1	ADHESIVE LABEL	20 X 10 X 0.1	C18
N41.9129			1	ADHESIVE LABEL	p max. 6 bar/87 psi	C13
N41.9143			1	TYPE PLATE	>>P355<<	A14
N4.9108			1	ADHESIVE LABEL	54 X 12 X 0.1	C10

[ ] = Group * = Wearing parts

Item-No.		in group	Pcs.	Description	Dimension	Field
N4.9159			1	LABEL	<<CE>>	C4
N5.2702		P35.0120	2	COVER		A10+
[N6.5137]		P35.0127	1	SEALING SCREW		C23
N6.5693		P35.0120	1	PACKING RING		B14
N6.6117		P35.0120	2	SEAL	6 X 13 X 2.3	B13+
N6.6117		P35.0127	2	SEAL	6 X 13 X 2.3	B22+
N6.6121		P35.0126	3	SEAL	8 X 15 X 2.3	D20+
N6.6147		P35.0127	2	SEAL	10 X 17 X 2.3	B23+
N6.6157		P35.0127	1	PACKING RING	4 MM	C22
N6.6163		P35.0120	1	SEAL	10 X 13.6 X 2.3	A11
N6.6208		P35.0127	1	O-RING	14 X 2	D22
N6.6211		P35.0126	3	O-RING	16 X 2	C20+
N6.6211		P35.0127	4	O-RING	16 X 2	B22+
N6.6212		P35.0125	1	O-RING	8 X 1	--
N6.6214		P35.0120	1	O-RING	23 X 2	C10
N6.6235		P35.0120	2	O-RING	12 X 2	A10+
N6.6237		P35.0120	1	O-RING	33 X 1.5	B6
N6.6268		P35.0120	1	O-RING	6 X 2.5	B11
N6.6269		P35.0127	3	O-RING	8.5 X 2.0	D22+
N6.6280		P35.0120	4	O-RING	11 X 2	A13+
N6.6281		P35.0127	1	O-RING	54 X 2	D22
N6.6282		P35.0120	1	O-RING	14 X 1.5	C11
N6.6283		P35.0127	1	O-RING	4 X 1	C23
N6.6501		N6.5137	1	FLAT SEAL	18 X 13 X 2	C23
[P32.0110]			1	END COVER		B4
[P32.0115]		P35.0120	1	SPRING PACKAGE		A15
[P32.0118]		P35.0120	1	IDLER STEP		B8
[P32.0119]		P35.0120	1	SPUR WHEEL		A7
[P32.0120]		P35.0120	1	WHEEL		A9
[P32.0136]			1	TENSIONING BODY		D1
P32.1011		P35.0120	2	FELT		D10+
P32.1012		P35.0120	1	COUPLER		A17
[P32.1021]		P35.0120	1	WELDING EXCENTRIC		C15
P32.1022		P32.1021	1	WELDING EXCENTRIC		C15
P32.1023		P32.1021	1	PINION		C16
P32.1023		P35.0124	1	PINION		B19
P32.1024		P35.0120	1	ROCKER		C15
P32.1027		P35.0120	1	BALL CAGE		D15
P32.1028		P35.0120	1	BOLT		D15
P32.1029		P35.0120	1	THRUST PIECE		D15
P32.1030		P32.0115	1	SPRING BOLT		C14
P32.1031		P32.0115	1	SPRING SLIDE		A14
P32.1032		P35.0120	1	DRIVING PIN		D15
P32.1034		P35.0120	1	LEVER		C17
P32.1035		P35.0120	2	DRIVER		D15+
P32.1037		P35.0120	2	SPUR WHEEL		B15
P32.1044		P32.0118	1	PLANET SHAFT		B10
P32.1046		P32.0118	3	IDLER GEAR		B9
P32.1047		P32.0118	1	COVER		B9
P32.1048		P32.0120	1	WHEEL		A9
P32.1049		P32.0119	1	SPUR WHEEL		A8
P32.1050		P35.0120	1	FRONT TOGGLE LINK		C1
P32.1051		P35.0120	1	LEVER		C11
P32.1053	*	P35.0120	1	WELDING GRIPPER		D15

[ ] = Group

* = Wearing parts

Item-No.		in group	Pcs.	Description	Dimension	Field
P32.1123		P35.0123	1	PINION		A3
P32.1203	*		1	WELDING STOP GRIPPER		D13
P32.1204	*		1	CUTTER		C16
P32.1208			1	CENTERING SLEEVE		B17
P32.1210			2	CENTERING SLEEVE		B17+
P32.1211			1	COVER		C17
[P32.1212]			1	HANDLE LEVER		B22
P32.1216			1	PRESSURE ROLLER		D1
P32.1217			3	IDLER GEAR		B3
P32.1218			3	DOWEL		B3
P32.1228			1	HOLDER		C3
P32.1229			1	HOLDER		C2
P32.1238		P32.0110	1	END COVER		C3
P32.1248			1	SEESAW LEVER		B17
P32.1249			1	SEESAW LEVER		B16
[P32.1250]			1	COUPLER		B18
P32.1251		P32.1250	1	COUPLER		B17
P32.1252		P32.1250	1	THRUST PIECE		B17
P32.1254		P32.0136	1	TENSIONING BODY		D2
[P35.0120]			1	BASE MODEL		D19
[P35.0122]		P35.0120	1	HANDLE HOUSING		D19
[P35.0123]		P35.0120	1	MOTOR CELL		A5
[P35.0124]		P35.0122	1	MOTOR CELL		A20
[P35.0125]			1	SUSPENSION		--
[P35.0126]		P35.0122	1	VALVE		D20
[P35.0127]		P35.0122	1	VALVE HEAD		D23
P35.1344		P35.0120	1	SLIDE GATE		C9
[P35.2001]		P35.0120	1	BODY		A1
[P35.2002]		P35.2001	1	BODY		A2
P35.2004		P35.2001	1	SWIVEL SHAFT		C1
P35.2005		P35.0120	2	EXHAUST RING		B13+
P35.2006		P35.0120	1	GUIDE		B13
P35.2007		P35.0120	1	TOUCH BOLT		A13
P35.2008		P35.0120	1	BEARING SUPPORT		B16
P35.2009		P35.0120	1	TORSIONAL STOP		B16
P35.2010		P35.0120	1	INNER RACEWAY		C16
P35.2011		P35.0120	1	ECCENTRIC SHAFT		D16
[P35.2012]		P35.0120	1	RATCHET WHEEL		A12
P35.2013		P35.0120	1	CAM		A11
P35.2014		P35.0120	1	COLLAR SCREW		A11
P35.2015		P35.0120	1	GUIDE		A16
P35.2016		P35.0120	1	TOUCH BOLT		A15
P35.2017		P35.0120	1	LEVER BODY		A15
P35.2018		P35.0120	1	TENSIONER VALVE LEVER		A16
P35.2019		P35.0120	1	COVER		A14
P35.2020		P35.0123	1	JACKET		A3
P35.2020		P35.0124	1	JACKET		B21
P35.2021		P35.0123	1	ROTOR		B4
P35.2021		P35.0124	1	ROTOR		B21
P35.2022		P35.0123	10	FELT		B4+
P35.2022		P35.0124	10	FELT		B20
P35.2023		P35.0123	1	END PLATE		B5
P35.2023		P35.0124	1	END PLATE		A21
P35.2024	*	P35.0123	5	VANE		A5

[ ] = Group * = Wearing parts

Item-No.		in group	Pcs.	Description	Dimension	Field
P35.2024	*	P35.0124	5	VANE		B20
P35.2025		P35.0123	1	END PLATE		A4
P35.2025		P35.0124	1	END PLATE		B20
P35.2026		P35.0120	1	SPRING		C5
P35.2026		P35.0122	1	SPRING		A21
P35.2027		P35.0120	1	THRUST PIECE		B5
P35.2027		P35.0122	1	THRUST PIECE		A21
P35.2028		P35.0120	1	MOTOR COVER		B6
[P35.2029]		P35.0120	1	CONTROL ROD		A10
P35.2031		P35.0120	1	END RING		A10
P35.2032		P35.0120	1	VALVE SHELL		A11
P35.2033		P35.0120	1	SHAFT		B11
P35.2034		P35.0120	1	GEAR BODY		D10
[P35.2035]		P35.0120	1	RATCHET WHEEL		D9
P35.2036		P35.2035	1	SPUR WHEEL		D9
P35.2037		P35.0120	1	EXHAUST SILENCER		C10
P35.2038		P35.0120	1	CONTROL HEAD		C9
[P35.2039]		P35.0120	1	GEARING COVER		D8
[P35.2041]		P35.0122	1	HANDLE HOUSING		A22
P35.2043		P35.0126	1	COUPLER		D19
P35.2044		P35.0126	1	SUSTAINING RING		C21
P35.2045		P35.0126	2	SUSTAINING RING		C20+
P35.2046		P35.0126	1	END RING		D19
P35.2047		P35.0120	1	SEAL PLATE		B14
P35.2048		P35.0122	1	SEAL PLATE		C22
[P35.2049]		P35.0127	1	ADAPTOR		D21
P35.2051		P35.0127	1	COUPLER		B24
P35.2052		P35.0127	1	END RING		A24
P35.2053		P35.0127	1	INTERMEDIATE RING		B23
P35.2054		P35.0127	1	SUSTAINING RING		B23
P35.2055		P35.0127	1	SUSTAINING RING		B22
P35.2056		P35.0127	1	END RING		C22
P35.2057		P35.0127	1	THROTTLE SEAT		D22
P35.2058		P35.0127	1	THROTTLE BODY		C22
P35.2059		P35.0127	1	GUIDE		C22
P35.2060		P35.0127	1	THROTTLE SCREW		C23
P35.2061		P35.0127	1	THROTTLE HOLDER		C23
P35.2062		P35.0127	1	DISK		D22
P35.2064		P35.0120	1	HANDLE SHAFT		A21
P35.2065		P35.0120	1	AIR CONNECTION		B14
[P35.2066]		P35.0127	1	COVER		C24
P35.2067		P35.0125	1	BOLT		--
P35.2068		P35.0125	1	FLANGE		--
P35.2069		P35.0125	2	RATCHET DISK		--
[P35.2070]		P35.0125	1	SUSPENSION BRACKET		--
P35.2073		P35.0125	1	DISK		--

[ ] = Group * = Wearing parts

3.2 Type dependent spare parts P355.0001.01

Type 49.0301.01

49.0301.01	P355/10/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1156			1	GUIDE PIN		C17
P30.1162			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1205			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1230			1	STRAP STOP		D3
P32.1239			1	STRAP GUIDE		C3

Type 49.0302.01

49.0302.01	P355/10/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1156			1	GUIDE PIN		C17
P30.1162			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1205			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1230			1	STRAP STOP		D3
P32.1239			1	STRAP GUIDE		C3

Type 49.0311.01

49.0311.01	P355/11.1/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1158			1	GUIDE PIN		C17
P30.1164			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1205			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1231			1	STRAP STOP		D3
P32.1240			1	STRAP GUIDE		C3

[ ] = Group * = Wearing parts

Type 49.0312.01

49.0312.01	P355/11.1/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1158			1	GUIDE PIN		C17
P30.1164			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1205			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1231			1	STRAP STOP		D3
P32.1240			1	STRAP GUIDE		C3

Type 49.0321.01

49.0321.01	P355/12/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1156			1	GUIDE PIN		C17
P30.1162			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1232			1	STRAP STOP		D3
P32.1241			1	STRAP GUIDE		C3

Type 49.0322.01

49.0322.01	P355/12/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1156			1	GUIDE PIN		C17
P30.1162			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1232			1	STRAP STOP		D3
P32.1241			1	STRAP GUIDE		C3

[ ] = Group * = Wearing parts

Type 49.0323.01

49.0323.01	P355/12.7/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1157			1	GUIDE PIN		C17
P30.1163			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1233			1	STRAP STOP		D3
P32.1242			1	STRAP GUIDE		C3

Type 49.0324.01

49.0324.01	P355/12.7/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1157			1	GUIDE PIN		C17
P30.1163			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1233			1	STRAP STOP		D3
P32.1242			1	STRAP GUIDE		C3

Type 49.0331.01

49.0331.01	P355/13/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1158			1	GUIDE PIN		C17
P30.1164			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1234			1	STRAP STOP		D3
P32.1243			1	STRAP GUIDE		C3

[ ] = Group * = Wearing parts

Type 49.0332.01

49.0332.01	P355/13/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1158			1	GUIDE PIN		C17
P30.1164			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1234			1	STRAP STOP		D3
P32.1243			1	STRAP GUIDE		C3

Type 49.0351.01

49.0351.01	P355/15/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1159			1	GUIDE PIN		C17
P30.1165			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1235			1	STRAP STOP		D3
P32.1244			1	STRAP GUIDE		C3

Type 49.0352.01

49.0352.01	P355/15/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1159			1	GUIDE PIN		C17
P30.1165			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1235			1	STRAP STOP		D3
P32.1244			1	STRAP GUIDE		C3

[ ] = Group * = Wearing parts

Type 49.0353.01

49.0353.01	P355/15.5/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1160			1	GUIDE PIN		C17
P30.1166			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1236			1	STRAP STOP		D3
P32.1245			1	STRAP GUIDE		C3

Type 49.0354.01

49.0354.01	P355/15.5/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1160			1	GUIDE PIN		C17
P30.1166			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1236			1	STRAP STOP		D3
P32.1245			1	STRAP GUIDE		C3

Type 49.0361.01

49.0361.01	P355/16/0.40-0.64			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1161			1	GUIDE PIN		C17
P30.1167			1	GUIDE PIN		C17
P32.1201			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1219	*		1	TENSIONING WHEEL		B3
P32.1222	*		1	GRIPPER		C3
P32.1223	*		1	GRIPPER		C3
P32.1224	*		1	GRIPPER		C3
P32.1237			1	STRAP STOP		D3
P32.1246			1	STRAP GUIDE		C3

[ ] = Group * = Wearing parts

Type 49.0362.01

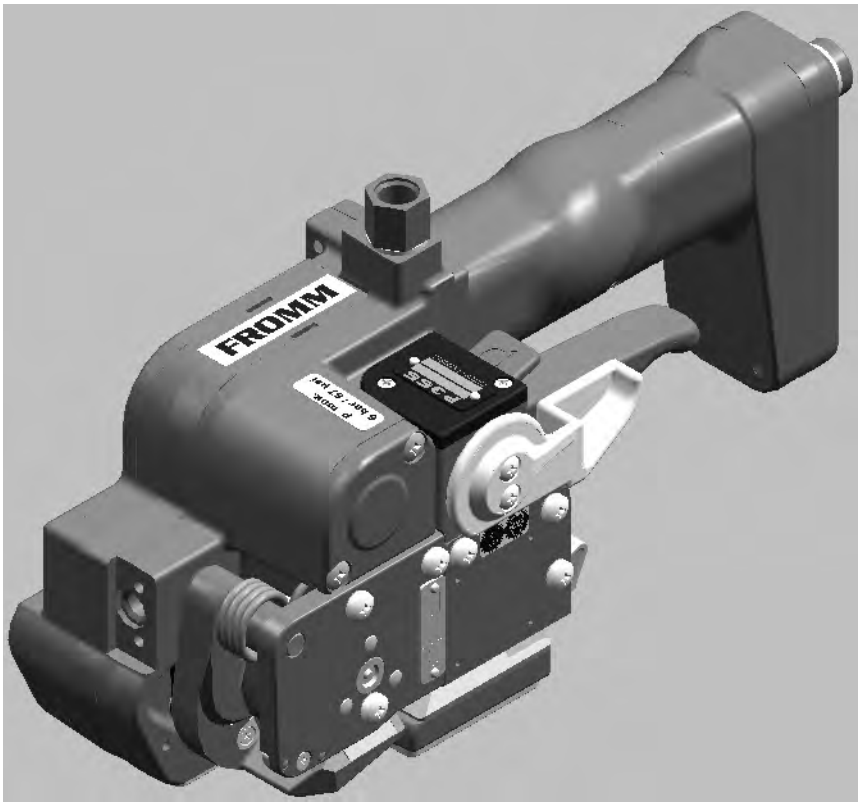
49.0362.01	P355/16/0.65-1.05			P355.0001.01		28.03.02
Item-No.		in group	Pcs.	Description	Dimension	Field
P30.1161			1	GUIDE PIN		C17
P30.1167			1	GUIDE PIN		C17
P32.1202			1	STEEL INSERT		D13
P32.1206			1	GUIDE CASE		B17
P32.1220	*		1	TENSIONING WHEEL		B3
P32.1225	*		1	GRIPPER		C3
P32.1226	*		1	GRIPPER		C3
P32.1227	*		1	GRIPPER		C3
P32.1237			1	STRAP STOP		D3
P32.1246			1	STRAP GUIDE		C3

[ ] = Group * = Wearing parts

FROMM

OPERATION MANUAL

PNEUMATIC
PLASTIC STRAPPING TOOL
MODEL P355



CE Declaration of conformity

We declare that the machine P355
is in conformity with the following standard or
standardised documents:
98/37/EEC

FROMM Holding AG
Hinterbergstrasse 26
CH - 6330 Cham
22.01 2002

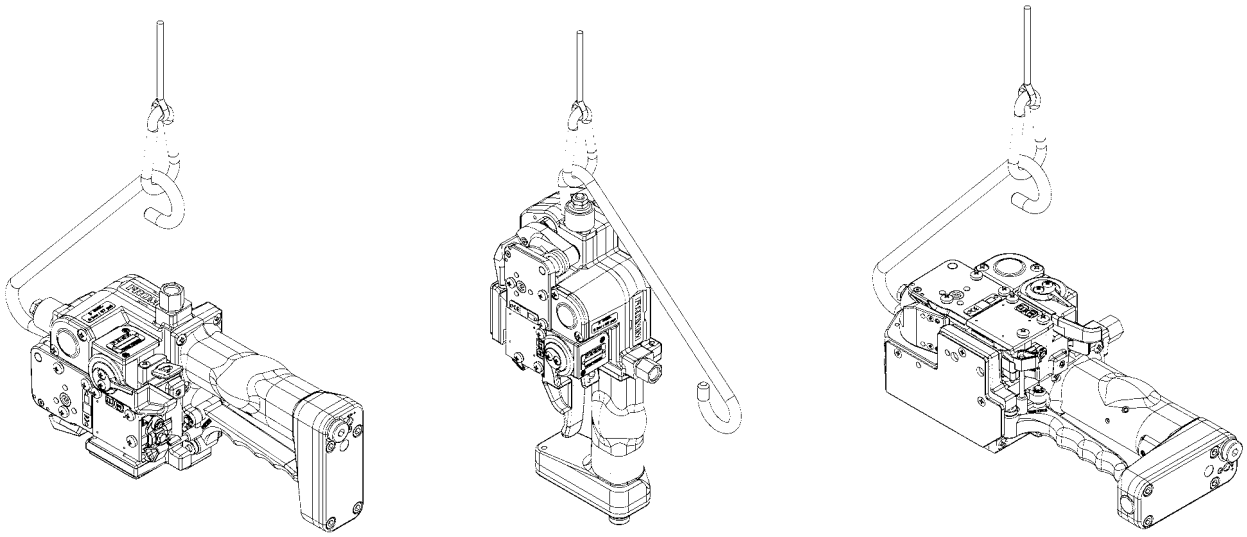
R.Fromm
Director

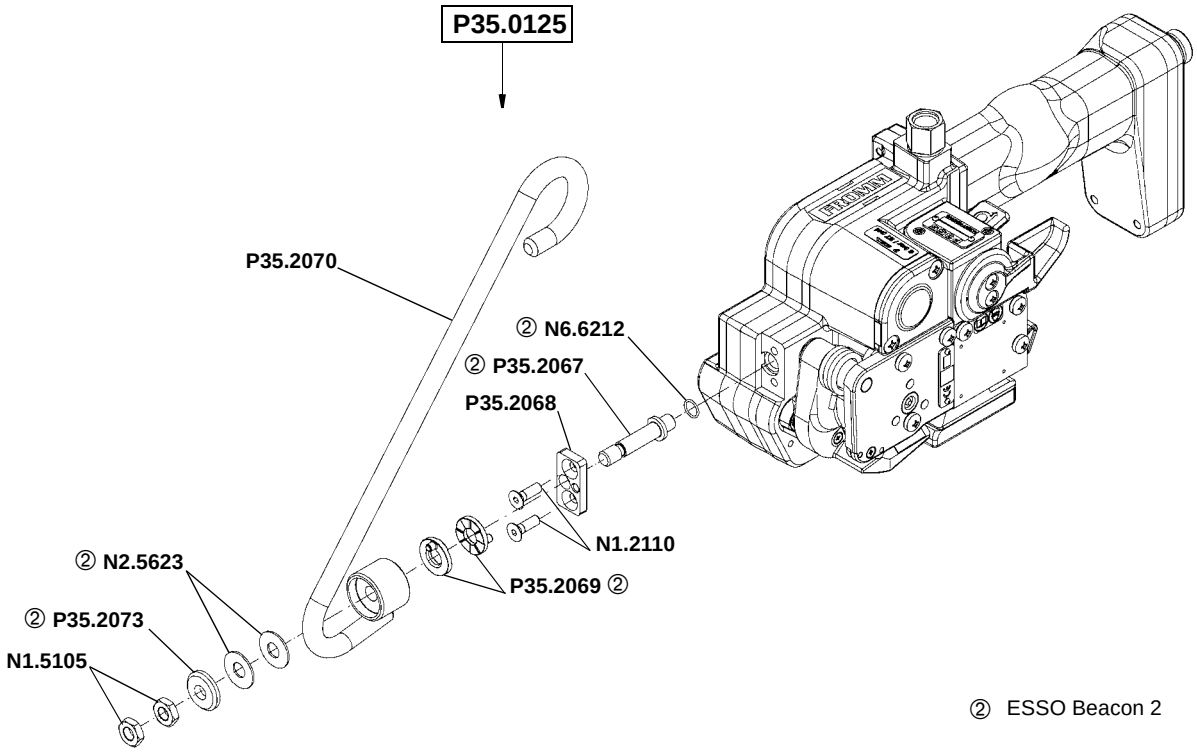
CE

P355.0001.01.en.fm/MAS/© 11.03

Suspension of tool

It is possible to suspend the tool on a spring loaded balancer using the suspension bracket P35.0125 which is supplied with the tool. The suspension bracket has been designed in such a way, that the tool can be used for all three working positions.





② ESSO Beacon 2

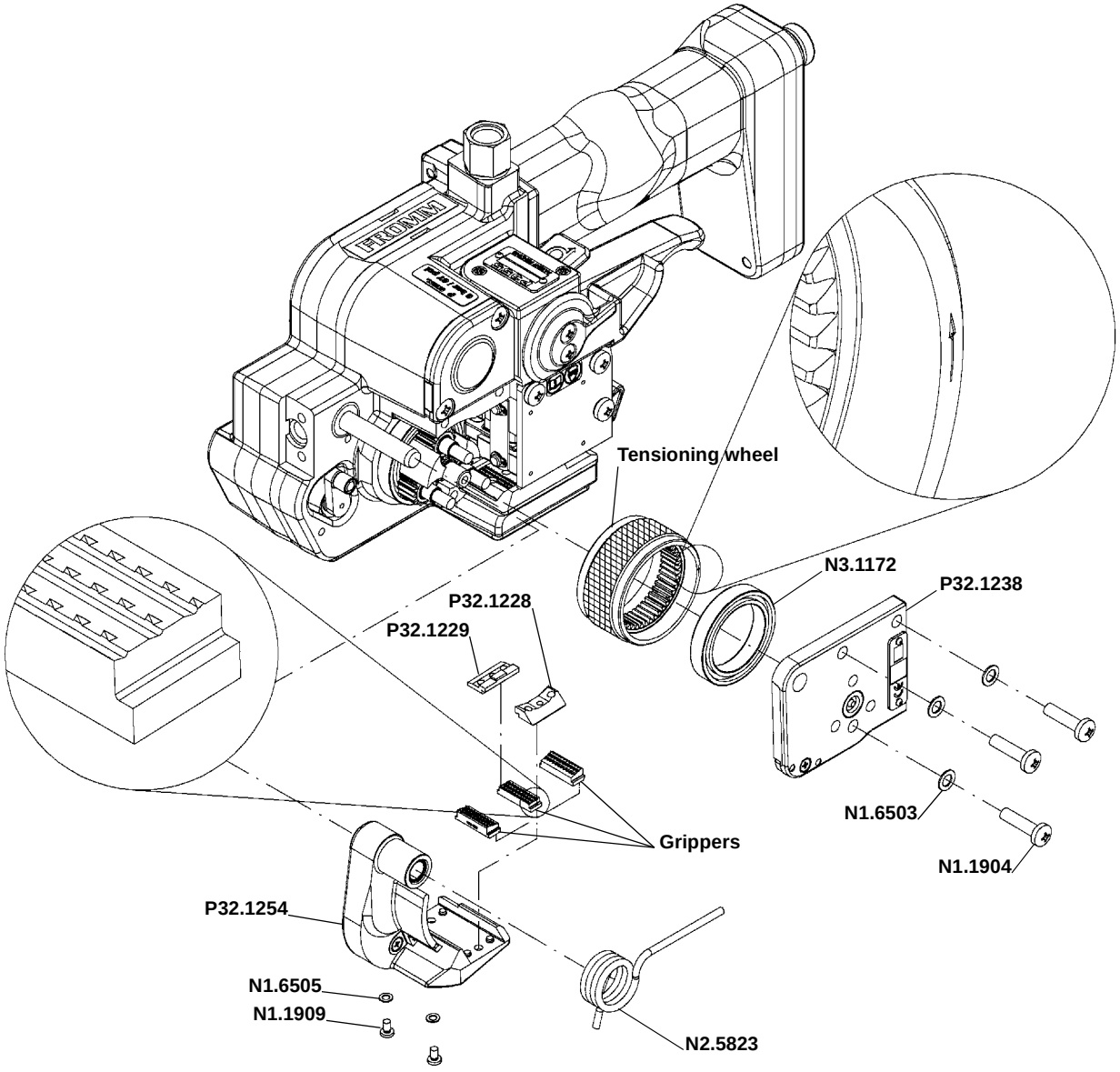
4.9 EXCHANGE OF WEARING PARTS

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

4.9.1 Exchange of tensioning wheel and grippers

Disassembling

- Unscrew end cover P32.1238 and remove it;
- Remove the torsion spring N2.5823;
- Remove the tensioning body P32.1254;
- Remove the tensioning wheel together with the bearing N3.1172 from the tool;
- Unscrew the holders P32.1228 and P32.1229 and remove them from the tensioning body;
- Remove the grippers from the tensioning body.



Assembling

Assembling in opposite order. Observe the following:

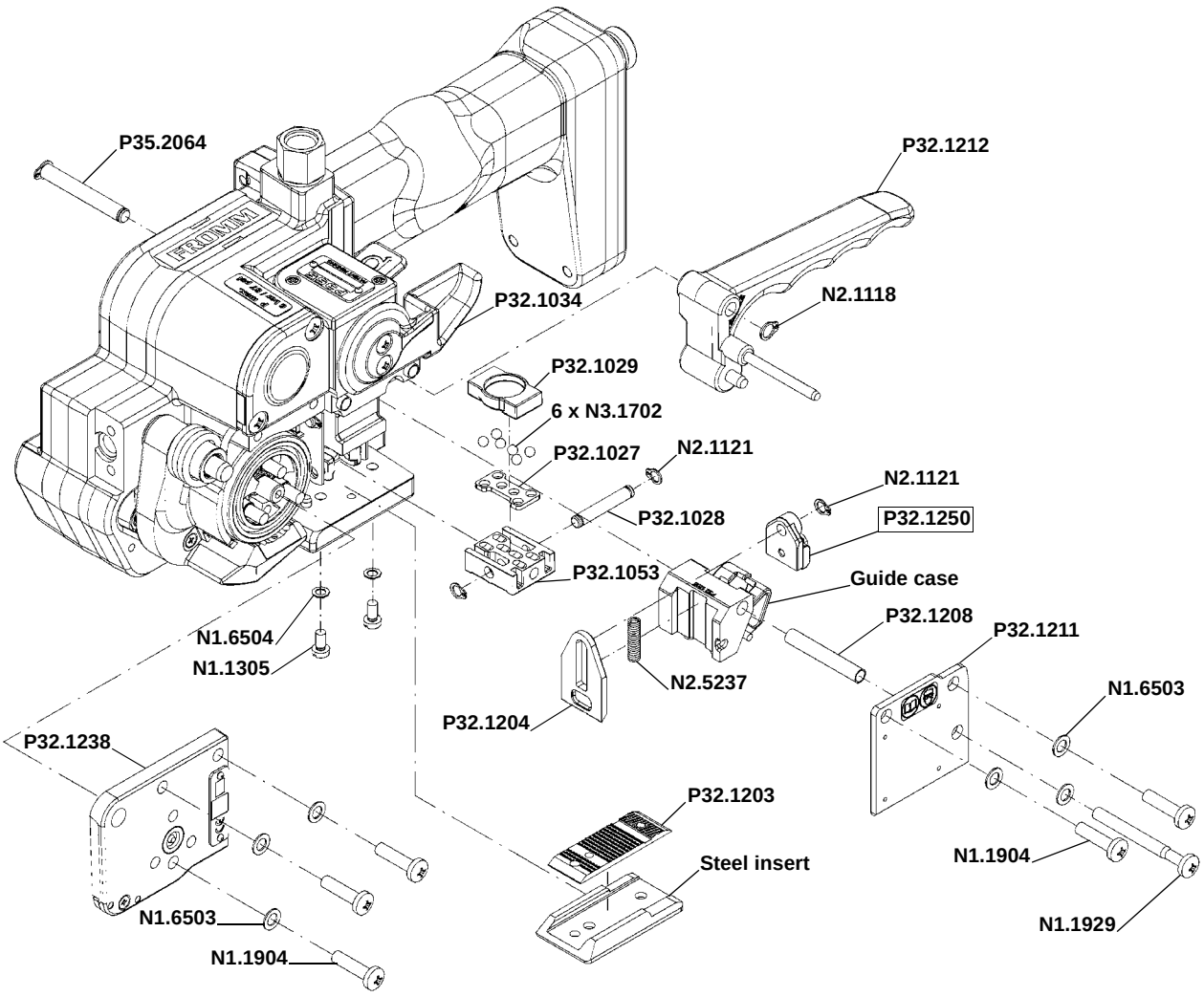
- Lubricate the internal toothing of the tensioning wheel with Molykote BR 2 plus.

Observe the position of the tensioning wheel. The direction of rotation of the tensioning wheel is marked at the front of the tensioning wheel (see drawing). Observe the position of the grippers (see drawing).

4.9.2 Exchange of cutter, welding stop gripper and welding gripper

Disassembling

- Unscrew cover P32.1211 and remove it;
- Unscrew end cover P32.1238 and remove it;
- Disassemble security ring N2.1118, pull the grip axle P35.2064 from the tool;
- Tilt down the handle lever P32.1212 and remove it from the tool;
- **Don't loosen** screw N1.1553 at the coupler P32.1250.
- Disassemble the security ring N2.1121 from the coupler P32.1250, remove the coupler;
- Pull out the centering sleeve P32.1208 from the guide case to left, disassemble the guide case;
- Pull out the pressure spring N2.5237 with a screw driver from the cutter P32.1204;
- Remove the cutter from the driving pin P32.1032;
- Disassemble the screws N1.1305, lift slightly the welding stop gripper P32.1203 and the steel insert and remove them from the tool;
- Adjust the welding pressure with the cam to the thickness of the strap 0.40 - 0.57 mm;
- Push the steel insert without welding stop gripper under the welding gripper P32.1053 until it touches the parallel pin N2.2110;
- Turn the lever P32.1034 in welding position;
- Disassemble the safety ring N2.1121 from the bolt P32.1028, remove the bolt from the welding gripper;
- Turn the lever P32.1034 in start position;
- Pull out the steel insert with care to right under the welding gripper;
- Lift the rocker P32.1024 behind the welding gripper with a screw driver, remove the welding gripper together with the ball cage P32.1027 and the balls N3.1702 from the tool;
- Lower the rocker, remove the thrust piece P32.1029 from the tool.



Assembling

Assembling in opposite order. Observe the following:

- Pay attention to the proper seat of the thrust piece on the spring bolt P32.1030 when lifting the rocker.
- Pay attention to the fitting position of the cutter (see drawing).
- Safe the screws N1.1305 with Loctite 222.

Lubrication

- Lubricate the rocker and the bolt P32.1028 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.
- Lubricate the cutter and the driver with Esso Beacon 2.

After assembling

Adjust the welding pressure according to the thickness of the strap! (see 6.3.3)

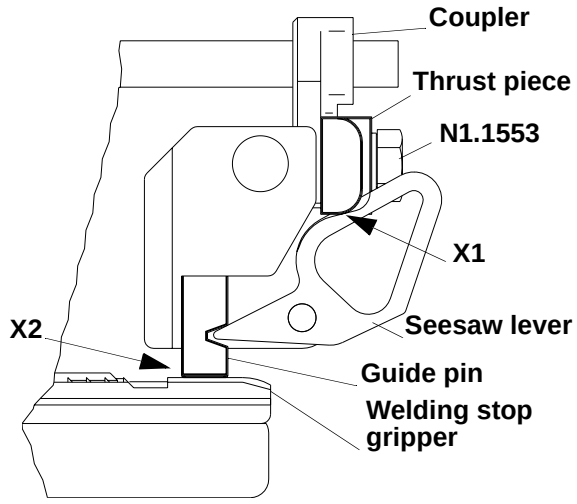
4.9.3 Adjustment of the coupler P32.1250

The coupler is adjusted in our works.

In case of replacing the seesaw lever, the coupler or the lever body, the coupler has to be readjusted.

Procedure as follows:
Lever P32.1034 in start position.
The tool is disconnected from the air supply.
The coupler is fitted into the tool.

- Loosen screw N1.1553.
- Displace thrust piece P32.1252, so that it touches the two seesaw levers without moving them.
- Retighten screw N1.1553.



Control:

The thrust piece must touch the seesaw levers (X1).
Both guide pins must sit on the welding stop gripper(X2).

4.10 SERVICE

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 center (see name and address on the rear page of this manual). Use original packing.

The pneumatic plastic strapping tool P355 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.

4.11 CLEANING

Clean strap gripping parts from strap abrasion regularly using compressed air (do not use any mechanical tool for cleaning).

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