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## Engineered Packaging Solutions

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A Division of Signode Industrial Group LLC

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Reference:            Signode Model M20-TLA Power Strapping Machine

The Signode Model M20-TLA Power Strapping Machine is designed to strap coils of wire located on the conveyor system supplied by others.

Enclosed you will find complete descriptive information on the M20-TLA Power Strapping Machine.

### SIGNODE MODEL M20-TLA POWER STRAPPING MACHINE

#### DESCRIPTION OF EQUIPMENT

**MODEL M20 POWER STRAPPING HEAD** - The 3 H.P. electric motor powered strapping head is a rugged self-contained unit designed to pull up to 1,200 lbs. of tension. The head automatically performs the feeding, gripping, tensioning, sealing, and cutting operations. The sealing mechanism is covered by an automatically operated face gate during the strap feeding operation. The entire strapping head is mounted on a retractable carriage.

**STRAP CHUTE SYSTEM** - A heavy gauge framework supports the chute and helps prevent damage that may result from impact. Heavy duty spring loaded stainless steel gates, attached to the strap chute, confine the strapping during the feeding cycle and permit a controlled release during the tensioning cycle. A strap chute vertical bayonet is a part of the chute system. It closes through the eye of the coil to create a continuous strap passage.

**MACHINE FRAME** - A heavy gauge framework supports the chute and helps prevent damage that may result from impact. It also houses the head carriage.

**ELECTRICAL SYSTEM** - The machine is equipped with a "NEMA 12" control enclosure. Operator controls are mounted in a free-standing pedestal to be located at installation. The strapping head and machine functions are controlled with an Allen-Bradley CompactLogix programmable logic controller. Push button controls for servicing the strapping head are located on the main control enclosure.

**OUT-OF-SEAL INDICATOR** - A warning light is provided to indicate the need to replenish the seal supply.

**SIGNODE MODEL DP-1-12R STRAPPING DISPENSER**

The DP-1-12R pneumatic reversing strap dispenser is designed for 100 lb. millwound coils of strap.

**M20-TLA POWER STRAPPING SYSTEM**

Each Signode model M20-TLA power strapping machine consists of: one (1) M20 power strapping head, strap chute system with bayonet, supporting structure, out-of-seal signal, bundle fixture, DF-1-12 strap dispenser, Allen-Bradley CompactLogix Programmable Logic Controller, operatorless electrical interlocks, all necessary air cylinders and valving, two (2) Operation, Parts and Safety manuals. Each machine is completely piped, wired and tested prior to shipment.

**SPARE PARTS:** It is essential that the user maintain an adequate stock of spare parts for this machine. A listing of recommended spare parts will be prepared after your machine has been entered into our production schedule.

**SPARE PARTS ARE DIVIDED INTO TWO SCHEDULES:**

Schedule I - Standard parts for the M20 strapping head only.

Schedule II - Proprietary parts manufactured by other suppliers.

**INSTALLATION:** A qualified Signode service representative will be available on a per-diem basis (as indicated in the attached Terms and Conditions of Sale). He will supervise the installation of the Signode equipment, which consists of a pre-installation meeting, supervision of the installation, make any necessary adjustments and instruct your customer's personnel in the operation and maintenance of the equipment.

**NON-SIGNODE STRAP/SEALS**

Signode tools and machines are designed and warranted to work together with Signode strapping and seals. Use of non-Signode strap, seals and/or manufactured or specified replacement parts may result in strap breakage or joint separation while applying strapping to a load or during normal shipping and handling. This could result in severe personal injury.

## SIGNODE MODEL M20-TLA POWER STRAPPING MACHINE

### DESCRIPTION OF OPERATION

The Signode Model M20-TLA Power Strapping Machine is designed to be used for the bundling of wire coils travelling on the conveyor supplied by others.

The strapping cycle is initiated either automatically or manually by the operator from the push button station.

The basic strapping cycle is completely automatic as follows:

1. The strap chute bayonet closes, allowing the strap feed through the chute.
2. The power strapping head advances toward the bundle and the strapping is drawn taut.
3. The strap is pulled to the desired tension (adjustable), the seal is notched and strap is cut, and a new seal is inserted.
4. The power strapping head retracts, the chute system opens.
5. When the strap chute is open, the signal is given to allow the load rotation. Once completed, the machine is now ready for the next cycle.

**SIGNODE MODEL M20-TLA POWER STRAPPING MACHINE**

**GENERAL SPECIFICATIONS**

**BUNDLE SPECIFICATIONS**

To suit application

**M20 POWER STRAPPING HEAD DATA**

Tension	Adjustable 50 to 1,200 lbs.
Strap Size	3/8", 1/2" or 5/8" Apex/Magnus Grade or Equivalent
Seal Type	38MNA, 12MNA or 58MNA (Nestack)
Seal Capacity	250 Pcs.
Type of Seal Joint	Double Notch (3/8", 1/2") Single Notch (5/8")
Seal Location	Side of Bundle
Motor	3 H.P., 1800 RPM, 220/460 Volt, 3 Phase, 60 Cycle, T.E.F.C.

