

OPERATION, PARTS AND SAFETY MANUAL



SIGNODE®

PRHR-34/114
PUSH TYPE POWER COMBINATION
STRAPPING TOOL

IMPORTANT! **DO NOT DESTROY**

**It is the customer's responsibility to
have all operators and servicemen
read and understand this manual.**

Contact your local Signode representative
for additional copies of this manual.

READ ALL INSTRUCTIONS BEFORE OPERATING THIS SIGNODE PRODUCT

SIGNODE • 3620 WEST LAKE AVENUE • GLENVIEW, ILLINOIS 60025 U.S.A.

PARTS LIST

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	9	174149	SHCS, M6 x 25
4	1	423416	Cylinder cover
5	1	004152	Cylinder gasket
6	1	004104	Conical compression spring
7	1	004166	O ring, 5 3/4 x 6 1/8 x 3/16"
8	1	423573	Nylock nut, M10 x 1.25
10	1	423410	Sealer piston
11	1	423568	SHSS, M8 x 30
12	1	423405	Cylinder
13	1	005460	Roll pin, 6 x 20
14	1	423395	Elbow, regular
16	1	<u>004131</u>	<u>Valve latch spring</u>
17	1	<u>423555</u>	<u>Valve latch</u>
18	1	023670	Shoulder screw
19	1	004111	Upper sleeve spacer
20	1	004193	Upper sleeve spacer
21	2	423563	Valve spring (LC055H-12)
22	7	004165	O ring, 3/4 x 1 x 1/8"
23	5	423414	Valve sleeve
24	1	004113	Lower sleeve spacer
25	1	004114	Tensioner valve stem
26	1	004115	Sealer valve stem
27	1	004144	Lower valve spacer
28	1	023677	Hansen socket
29	1	020704	Hansen socket
30	1	008478	Bushing
31	1	004190	Street elbow
32	1	422130	Hanger
33	1	071581	Washer
34	1	004637	Locknut, 1/2-12
48	1	423572	Roll pin, 8 x 24
64	1	423412	Pivot shaft
65	1	020701	O ring, 7/32 x 11/32 x 1/16"
66	1	<u>423393</u>	<u>Stop lever</u>
67	1	004130	Spring
68	1	004136	Cover plate
69	1	306047	SHSS, M5 x 6
70	2	423288	SHCS, M5 x 12
71	1	422837	Nylock nut, M8
73	1	<u>280840</u>	<u>Roll pin, 3 x 16</u>
74	1	004109	Valve handle spring
75	1	423413	Roll pin, 3 x 10
76	1	004138	Valve arm
77	2	004106	Valve arm roller
102	1	171655	Nylon washer
103	1	433398	Warning sign
110	1	006594	O ring, 5/8 x 13/16 x 3/32"
111	1	286373	Information sign.
112	1	424230	Nameplate (PRHR-34)
	1	436121	Nameplate (PRHR-114)
113	1	424237	Washer, 13mm ID x 24mm OD x 2.5mm thick
114	2	423584	Belleville spring washer, B-1000-073

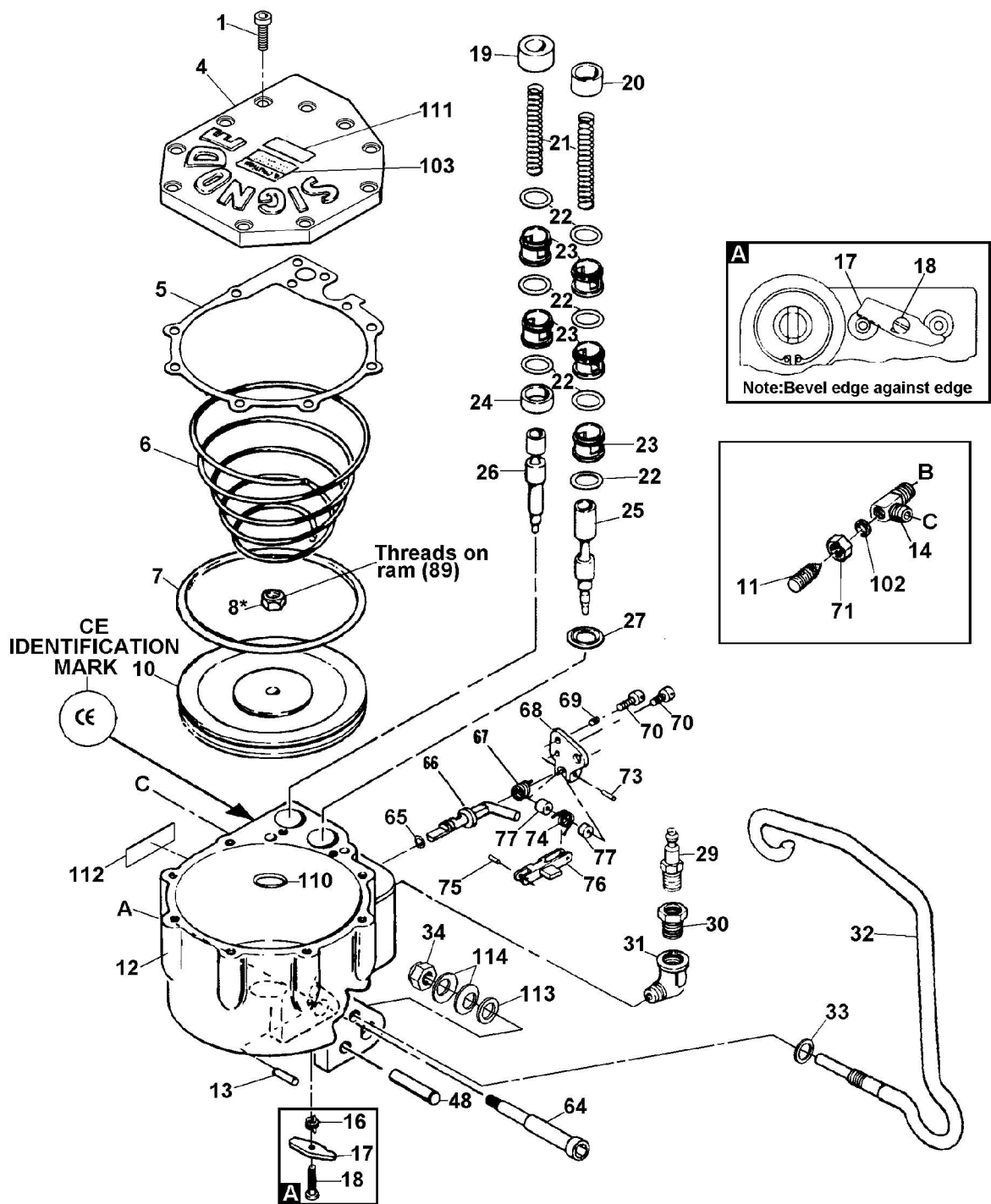
WARNING

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

The conical compression spring (6) is compressed and is under tension. Use care when removing the cylinder cover (4).

Failure to follow the above could result in serious personal injury.

- ! When ordering parts, please show tool model, part number and description.
- ! Wearing parts are usually limited to those underlined and should be stocked.
- ! Standard hardware may be obtained at any local hardware supply.



* Apply one drop of Loctite #242 or equivalent to cleaned parts. Allow 12 hours to set, if possible. Do not apply to small screws or close moving parts as the fluid spreads easily.

NOTE: Torque socket head cap screws (Key 1) to 100-120 in-lbs (11.3-13.6 Nm).

PARTS LIST , Continued

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	2	174149	SHCS, M6 x 25
8	1	423573	Nylock nut, M10 x 1.25
15	1	423355	Air hose assembly
35	1	280819	Locknut, M5
36	1	306509	<u>Cutter</u>
37	1	015626	<u>Cutter spring, Lee #LC-029C-10</u>
39	1	423397	Cutter housing
40	1	162374	SHCS, M6 x 30
41	2	280840	Roll pin, 3 x 16
42	1	424442	<u>Seal stop (34)</u>
	1	423559	<u>Seal stop (114)</u>
43	1	423401	<u>Breaker foot</u>
44	1	423517	Backup roller
45	1	423553	Roller pin
46	1	250310	Roll pin, 4 x 16
47	1	423572	Roll pin, 8 x 24
49	1	423398	Feedwheel
50	1	008863	<u>Outer bearing</u>
52	2	253596	Dowel pin, 6 x 14
53	1	013538	O ring, 1 3/8 x 1 9/16 x 3/32"
54	1	423408	Position piston
55	1	004163	O ring, 1 3/8 x 1 1/2 x 1/16"
56	1	423409	Cylinder plug
57	1	004167	Retaining ring
58	1	006594	O ring, 5/8 x 13/16 x 3/32
60	1	423554	Roll pin, 5 x 16
61	1	423562	Piston link
62	1	423406	Outer link, upper
63	1	423571	Dowel pin, 6 x 20
78	1	423556	SHCS, M5 x 55
79	1	423565	Lever assembly
80	1	423407	Outer link, lower
81	4	010032	SHCS, M6 x 12
82	1	020710	Regulator elbow
100	1	010078	Split lock washer, M10
106	1	173955	Guard
107	1	006057	Washer, #10 SAE
108	1	423560	PRHR tension unit
109	1	424229	Dowel pin (PRHR-34)
110	1	423392	Shim (PRHR-1444 conversion kit)

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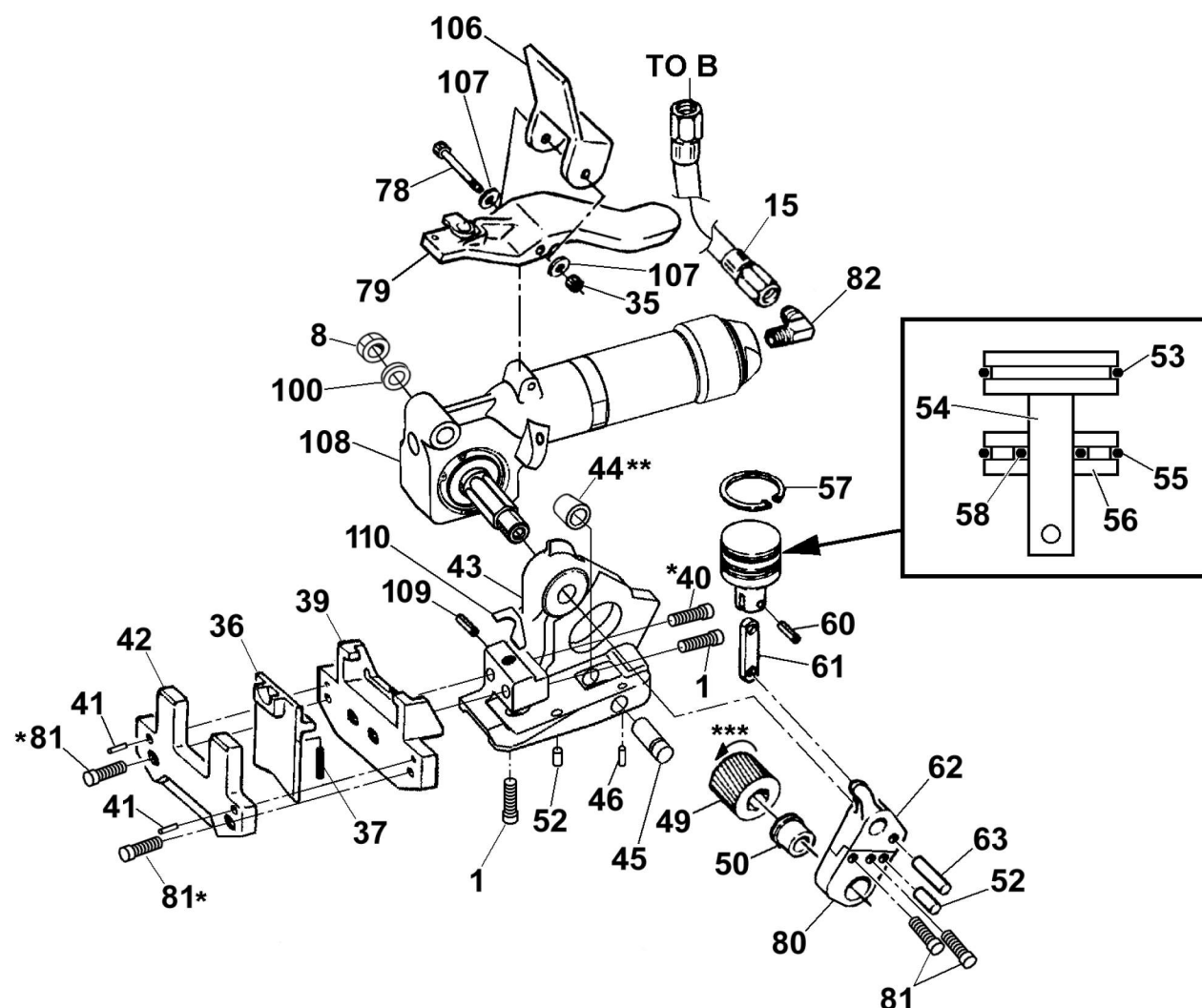
⚠ WARNING

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

* Apply one drop of Loctite #242 or equivalent to cleaned parts. Allow 12 hours to set, if possible.

** Install backup roller (Key 44) with the larger end facing out from tool.

*** Install feedwheel (Key 49) in noted rotational direction as shown by arrows.



PART REMOVAL, REPLACEMENT & ADJUSTMENT - FEEDWHEEL

To replace the feedwheel (Key 49), make sure the air supply has been disconnected from the tool before proceeding.

1. Remove the lower outer link by removing the two M6 mounting screws, and remove the feedwheel.
2. Feedwheel clearance should be checked after replacing any parts associated with the tensioning system. This clearance should be maintained to prevent the feedwheel from touching the backup roller. Feedwheel clearance should be adjusted to .001"-.007".
3. Turn the set screw (Key 4, Page 21) to adjust clearance.

PARTS LIST , Continued

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
51	1	<u>306512</u>	<u>Guard</u>
85	1	<u>424227</u>	<u>Rear side plate (PRHR-34)</u>
	1	<u>423417</u>	<u>Rear side plate (PRHR-114)</u>
86	2	<u>004127</u>	<u>Spacer</u>
88	1	<u>424228</u>	<u>Notcher (PRHR-34)</u>
	1	<u>306503</u>	<u>Notcher (PRHR-114)</u>
89	1	<u>423411</u>	<u>Ram</u>
90	2	<u>004134</u>	<u>Sealer link</u>
92	1	<u>004126</u>	<u>Ram pin</u>
93	2	<u>008507</u>	<u>Link pin</u>
94	4	<u>424233</u>	<u>Jaw (PRHR-34)</u>
	4	<u>423558</u>	<u>Jaw (PRHR-114)</u>
95	2	<u>008506</u>	<u>Jaw pin</u>
96	1	<u>424226</u>	<u>Front side plate (PRHR-34)</u>
	1	<u>423418</u>	<u>Front side plate (PRHR-114)</u>
97	2	<u>423557</u>	<u>Socket head shoulder screw, Dia 10 x M8 x 60</u>
98	1	<u>422837</u>	<u>Nylock nut, M8</u>
99	1	<u>423567</u>	<u>Flat head socket cap screw, M8 x 60</u>

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- ! Wearing parts are usually limited to those underlined and should be stocked.
- ! Standard hardware may be obtained at any local hardware supply.

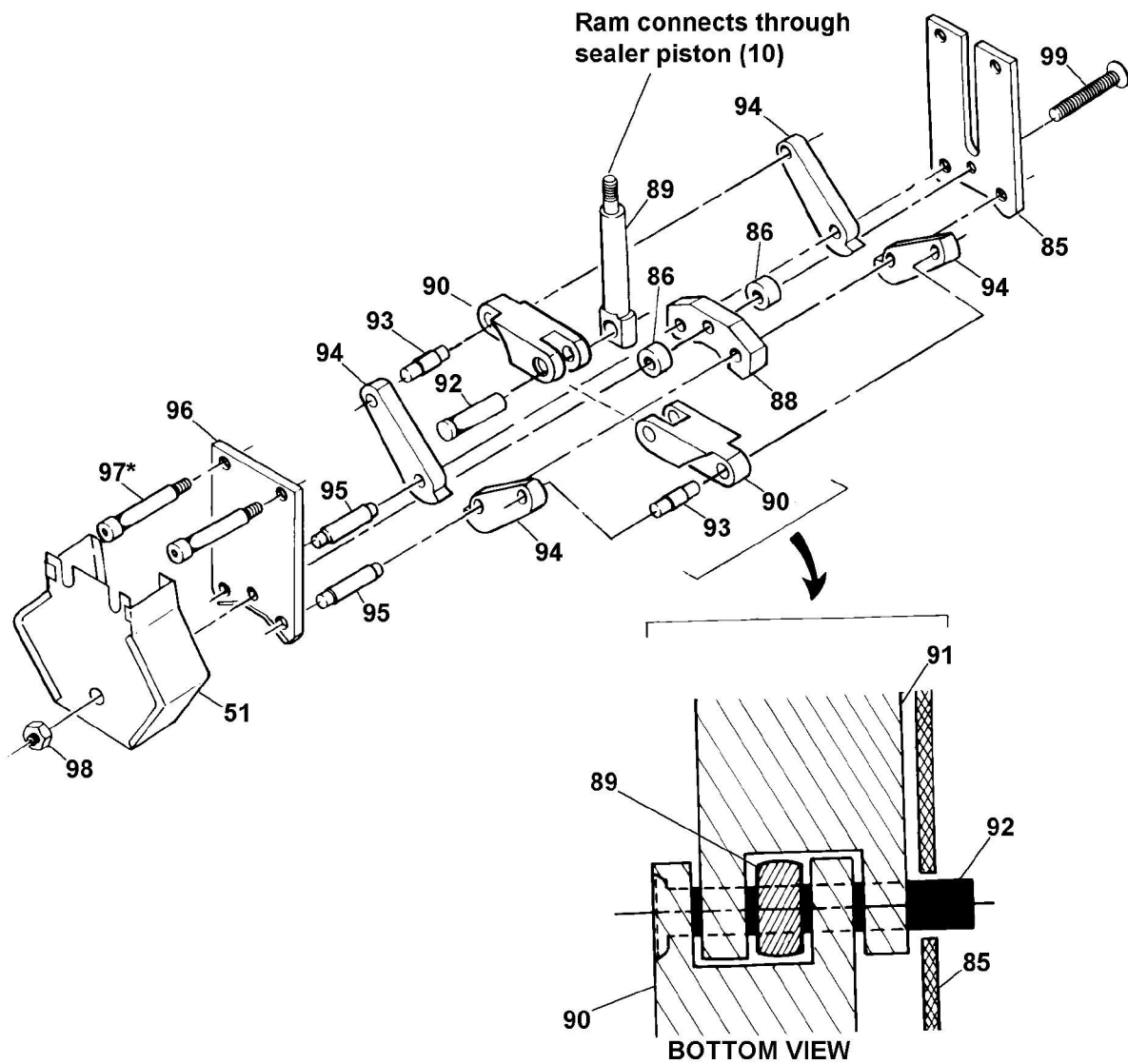
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NOTE:

To convert a standard PRHR-114 (0.031") to use 0.044" gauge strapping the following parts must be replaced/added. These conversion parts can be ordered together as PRHR-1444 Conversion Kit, Signode Part No. 424232.

<u>KEY</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>STATUS</u>
88	1	306996	Notcher	Replace
110	1	423392	Shim	Add
112	1	424236	Nameplate	Replace



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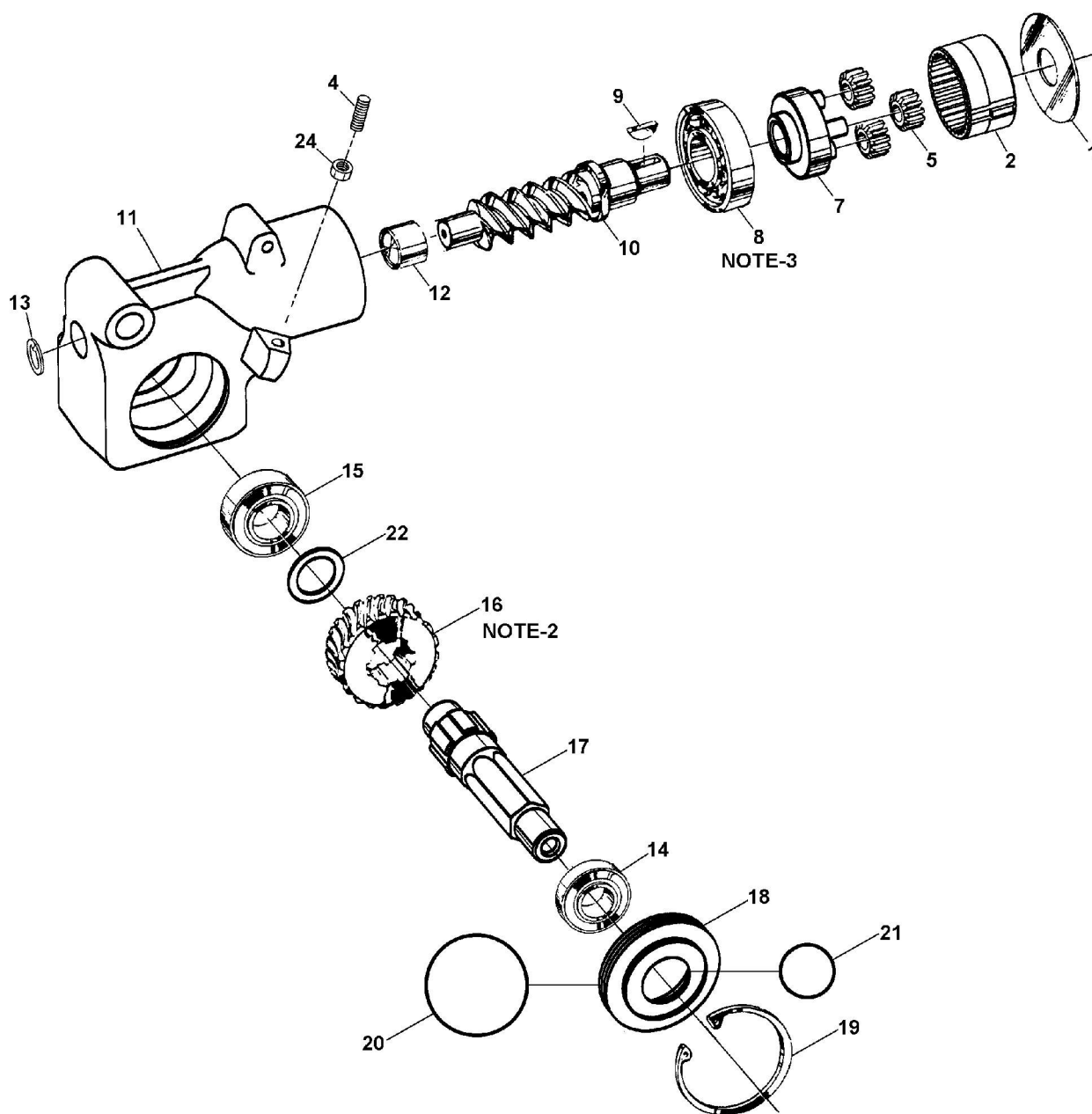
PARTS LIST, GEAR HOUSING

<u>KEY</u>	<u>QTY</u>	<u>PART NO</u>	<u>DESCRIPTION</u>
1	1	008781	Thrust washer
2	1	423402	Ring gear
4	1	423419	SHSS, M6 x 25
5	3	<u>008766</u>	<u>Idler gear</u>
7	1	<u>306389</u>	<u>Idler gear plate assy</u>
8	1	008756	Bearing, Fafnir #7203
9	1	008774	Key
10	1	423530	Worm
11	1	423421	Gear housing
12	1	008751	Needle bearing, Torrington #M781
13	1	008752	Truarc ring ,#500-62
14	1	423515	Bearing, Fafnir #B539DD
15	1	024038	Bearing, Fafnir #KP10A
16	1	423529	Worm Gear
17	1	423551	Feedwheel shaft
18	1	423396	Bearing support
19	1	250731	Truarc ring, N5000-185
20	1	256755	O ring, SAE 30
21	1	004165	O ring, SAE 210
22	1	423533	Thrust washer
23	1	423390	Air motor
24	1	280849	Hex nut, nylock, M6

- ! When ordering parts, please show tool model, part number and description.
- ! Recommended spare parts those underlined and should be stocked.
- ! Standard hardware may be obtained at any local hardware supply.

NOTES:

1. Pack the gear housing (11) about 1/3 full with Non-Fluid Oil K#55 or equivalent.
2. When assembling the worm gear, the side stamped "T" or "BT" must face towards the back of the housing.
3. Bearing must be installed with wide shoulder away from worm.



WARNING

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PARTS LIST, SIGNODE AIR MOTOR, PART NO. 423390

<u>KEY</u>	<u>QTY</u>	<u>PART NO</u>	<u>DESCRIPTION</u>
1	1	024631	Filter assembly
9	1	423424	Motor housing assembly
12	1	423534	Deflector assembly
	1	161171	Deflector assembly (optional non-metallic)
13	1	024633	Ball bearing
14	1	024653	Back end plate
15	1	024652	Cylinder
16	1	423423	Rotor
17	5	024651	Vane
18	1	024602	Spacer
19	1	023510	Align pin
20	1	423794	Front end plate
21	1	023481	Ball bearing
22	1	023547	Ball bearing
24	1	423403	Idler carrier assembly
25	3	423060	Idler
26	1	423798	Ring gear
27	1	023558	Seal, Tros B-44-28-2
28	1	423404	Spacer
29	2	423793	Bevel spring washer
30	1	306612	Pin
31	1	423394	Gear housing

NOTES

1. Align pin (Key 19) and mark on motor housing as indicated.
2. Idler gears and bearings (except Key 13), are to be lubricated with Non-Fluid Oil #K55 or equivalent. Idler (Key 25) and vanes (Key 17) must soak in air line oil overnight before assembling air motor.
3. If the rear motor housing (Key 9) becomes loose, it must be retightened while the motor is running at 20 to 30 psig (1.6 to 2.0 Bar) air pressure. This will ensure proper alignment and rotor freedom.
4. Bevel spring washers (Key 29) must be assembled back to back with cupped shape outward)(.

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