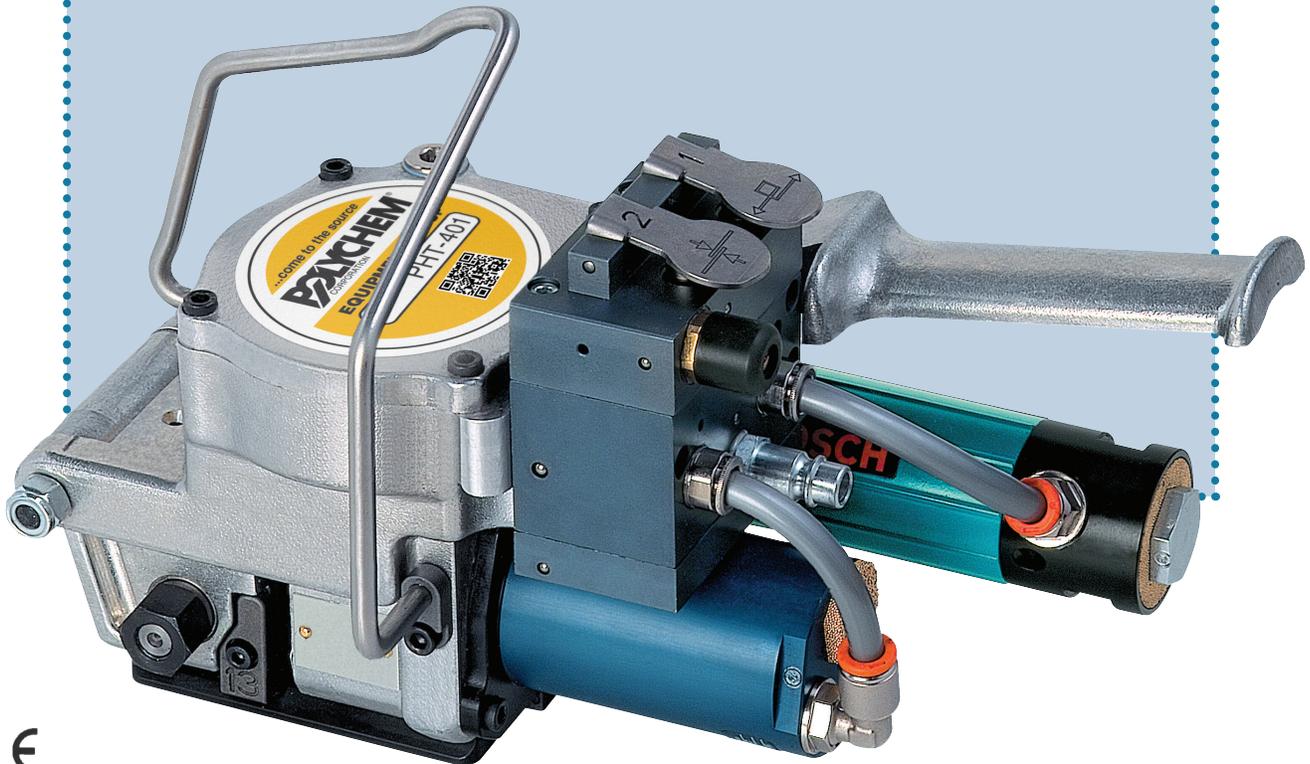




# PHT401

## OPERATION MANUAL | SPARE PARTS LIST

### ***PNEUMATIC PLASTIC STRAPPING TOOL***



CE

**READ ALL INSTRUCTIONS BEFORE OPERATING THE TOOL**

**POLYCHEM CORPORATION**  
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**ED. 06/11**

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### 1) SAFETY INSTRUCTIONS



**READ THE OPERATING INSTRUCTION CAREFULLY**



**WHEN OPERATING THE TOOL, WEAR EYE, FACE AND HAND SAFETY PROTECTION**



**GENERAL SAFETY INSTRUCTIONS :**

The tool must be used by properly trained people. Failure to follow the operating instructions or improper use could cause strap breakage, injuries, or package damages.

Check tool daily, do not use tool with worn or damaged parts. Use original spare parts for replacement. Never modify any tool part.

Do not put fingers, hands or other body parts between the strap and package during the cycle.

It is your responsibility to check the seal joints made by your tool. Training about the weld time adjustment will be useful to check the seal quality in order to avoid severe injury. Never move goods with bad quality seals. Only use specific strap dispenser to dispense the strap. Keep your working area clean and always use the tool in good balance and safety conditions. Never use straps as a means of pulling or lifting goods.

Always use a proper safety strap cutter and keep other people and yourself at a safe distance from strap, always stand to side of strap, away from direction of strap trajectory once cut. Hold the upper strap portion and pay attention that the lower strap will snap forward away from you.

Improper operation, excessive tensioning, use of non recommended strap, or sharp corners on the package could cause a loss of strap tension and/or strap breakage that could lead to packaging failure or injury. The following is recommended; use edge protectors if package has sharp corners, place the strap correctly around a properly positioned package, stand in safety position (on one side of strap) during strapping cycle, and use the correct strap quality, width, thickness, and break strength as recommended in this manual.

Please save this manual, as it is a part of the tool. This tool is manufactured without any substances which could be dangerous to health. National instructions must be observed for disposal of all the parts.



**GENERAL SAFETY INSTRUCTIONS FOR COMPRESSED AIR:**

Never operate this tool using a bottled air or other gas source. Do not exceed the air pressure range as shown in this operation manual. For all adjustments, repairs or cleaning of the tool, always disconnect air supply. Always use dry, clean and lubricated compressed air.

## 2) TECHNICAL DATA

TOOL SIZE				
Length:				280mm – 11”
Width:				150mm – 6”
Height:				175mm – 6.9”
Weight:				4.9 kgs – 10.8lbs
AIR REQUIRED				
Pressure range:				4.5-7 bar / 64-99 psi
Air consumption:				14 L/s – 29cuft/min
SPECIFICATION				
Max.Tension force:				2500N* - 6.5 bar – 92 psi
Tensioning speed:				11 mt/min
Sealing:				Friction weld seal
Joint strength:				80% plastic strap strength*
Level sound emission. Measurement type A (2003/10/CE)				77 dB (A)
Vibrations at handle (2002/44/CE)				<2.5 ms <sup>2</sup>

- depends of kind strap

### CHART OF TYPES

ITEM	MODEL	STRAP	THICKNESS
T101013	PHT401 *	PP-PET -3/8”	>.016” – 0.047”<
T101313	PHT401 *	PP-PET -1/2”	>.016” – 0.047”<
T109913	PHT401 *	PP-PET -5/8”-3/4”	>.016” – 0.047”<

\* only with clutch on tensioning

## 3) WARRANTY CONDITIONS

POLYCHEM warrants all its tools during a period of 4 months from the shipping date document. Warranty includes free replacement of faulty parts ex works. The warranty is not valid in case of improper use, lack of maintenance, tampering, arbitrary modifications and reparations, use of non original parts, disregard of instructions of the operation manual, and missing serial number. The warranty excludes the wearing parts shown on spare parts list.

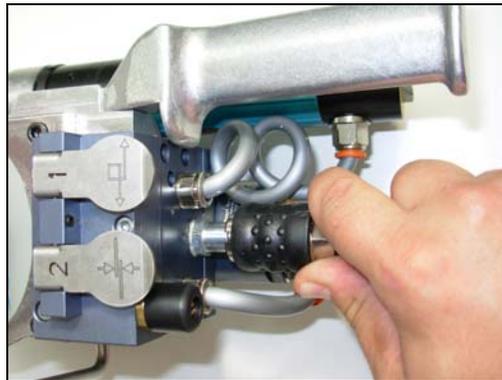
No compensation can be claimed for production shutdowns and for damages to people and objects due to tools defects. POLYCHEM Corporation reserves the right to modify the tools and documentation without any obligation to update previous ones.

#### 4) INSTALLATION

It is recommended to always use a dryer unit near the compressor and a filter-regulator-lubricator unit with pressure gauge (Polychem part # 200-0025) close to the tool air connection to avoid water and dirt in the valves or in the pneumatic motors. Connect the tool to air with quick connector  $\frac{1}{4}$ " and use minimum 8mm or  $\frac{3}{8}$ " internal diameter pipe; max length for flexible pipe 10 m between tool and regulator group. Check that your compressor / air distribution plant is able to supply the right air quantity as shown in the operation manual without losing pressure.



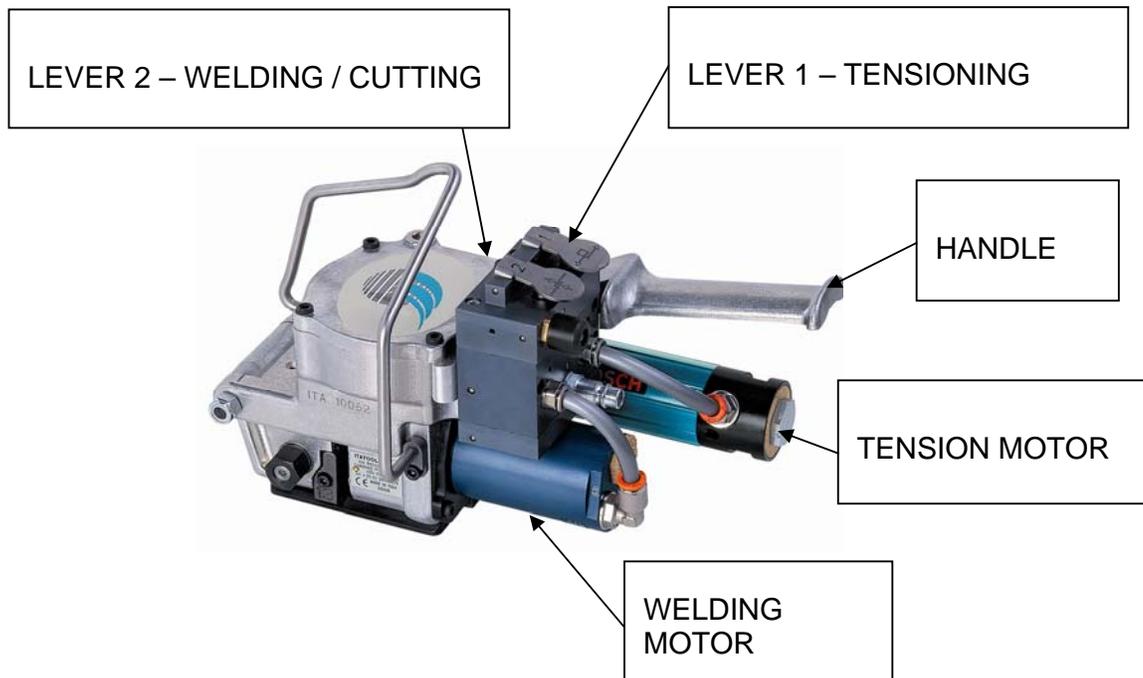
200-0025



TOOL AIR CONNECTION

#### 5) OPERATING ELEMENTS AND / ADJUSTMENTS

**DO NOT OPERATE THE TOOL WITHOUT STRAP, YOU COULD DAMAGE THE FEED WHEEL AND THE WELDING / CUTTING GROUP**



**Welding - cutting time adjustment**

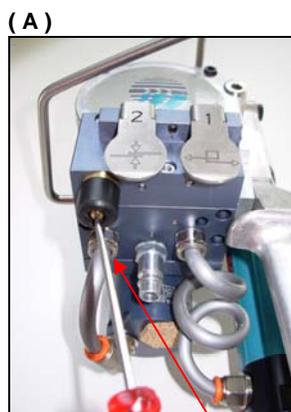
The welding time can be adjusted with a screwdriver (pic.A), depending on strap quality and dimensions. Turning clockwise will increase the time, turning counter clockwise will decrease the time

**Adjusting strap tension by motor**

The strap tension can be adjusted with a screwdriver on the pneumatic motor, depending on strap quality and dimensions. (pic.B). Turning clockwise will reduce the force, turning counter clockwise will increase the force – do not exceed in counter clockwise.

**Adjusting strap tension by clutch**

The strap tension can also be adjusted with clutch system (pic.C). Turning the nut clockwise the force will be increased, turning counter clockwise it will be reduced – do not exceed in both directions –

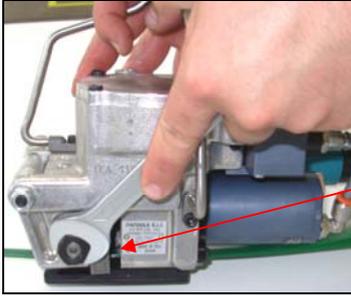


Welding time adjustment



Tension motor adjustment force

(C)

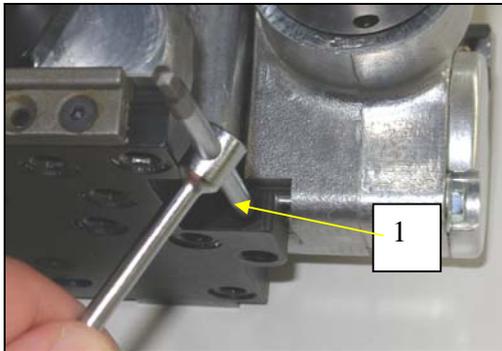


Clutch adjustment

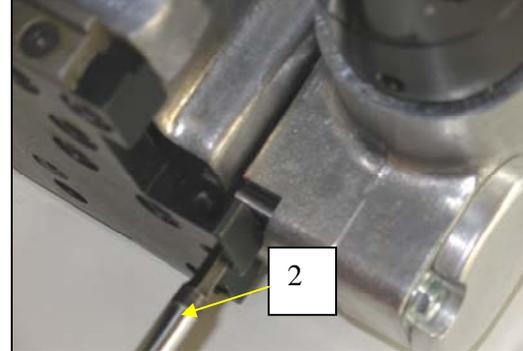
### Feed Wheel gap adjustment

It is possible to adjust the gap between feed wheel and grippers in order to change the teeth pressure on strap; unscrew the locking screw 1(pic.D1) and turn screw 2 (pic.D2), clockwise the gap will be increased, counter clockwise the gap will be reduced. Screw 2 pushes against the gearbox housing pin (pic.D3). After adjusting, lock screw 1 again. The standard gap is 0.2mm (0.008") (pic.D4).

(D1)



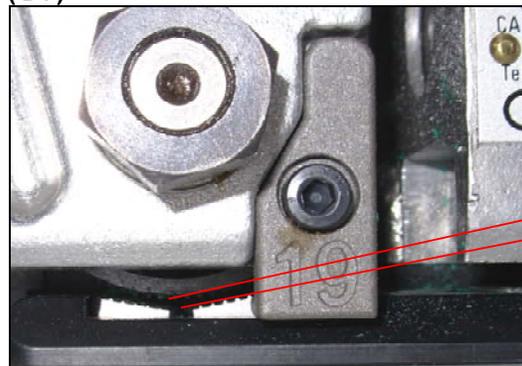
(D2)



(D3)



(D4)



0.2mm  
0.008"

## Strap size conversion

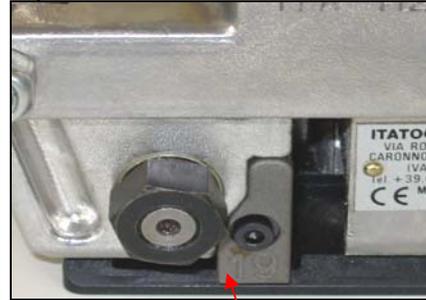
To set the tool for (13mm, 1/2") – (16mm, 5/8") – (19mm, 3/4") strap sizes, follow the instructions below:

(E1)



Front Strap Guide (1)

(E2)



Side Strap Guide (2)

(E3)

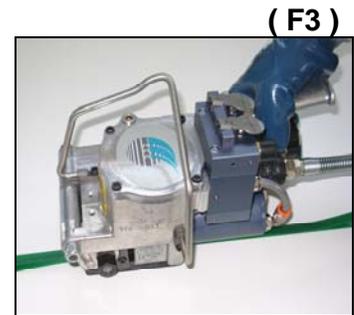
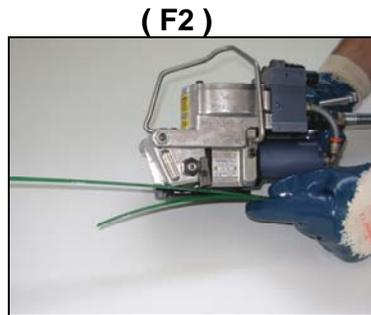
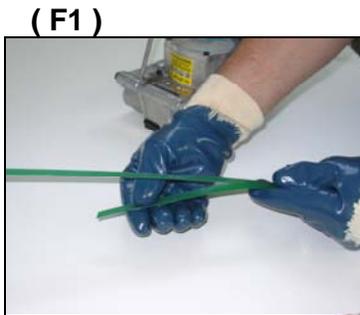


Rear Strap Guide (3)

<p><b>19 &gt; 16</b> <b>3/4" &gt; 5/8"</b></p>	<p>Turn the strap guides 1 and 3 to 16mm 5/8" position (pic.E1-E3)- Replace the strap guide 2 with model 16mm 5/8"(pic.E2)</p>
<p><b>16 &gt; 19</b> <b>5/8" &gt; 3/4"</b></p>	<p>Turn the strap guides 1 and 3 to 19mm 3/4" position (pic.E1-E3)- Replace the strap guide 2 with model 19mm 3/4"(pic.E2)</p>
<p><b>16/19 &gt; 13</b> <b>5/8"- 3/4"</b> <b>&gt; 1/2"</b></p>	<p>Replace the strap guides 1 and 3 with 10/13 model in 13mm 1/2" position (pic.E1-E3)- Replace the strap guide 2 with model 13mm 1/2"(pic.E2)</p>
<p><b>13 &gt; 16/19</b> <b>1/2" &gt; 5/8"- 3/4"</b></p>	<p>Replace the strap guides 1 and 3 with 16/19 model in required position (pic.E1-E3)- Replace the strap guide 2 with required size (pic.E2)</p>

## 6) OPERATION

The tool model **PHT401** is designed to strap packages with plastic strap. The strap is fed around the package manually and inserted in the tool, tensioned, cut, and friction welded by the tool. Wrap the package to be strapped with the strap, as shown in pic.F1. Open the tool by squeezing the lever and motor together with right hand and insert the two straps. Make sure they are aligned between the body and bottom plate and against the front / rear strap guides (pic.F2). Release the lever. (pic.F3).



Push tension lever no.1 until required tension or maximum force (motor stalls) is reached, as shown in pic.F4, release lever no.1 and push lever no.2 (do not hold down) (pic.F5) to cut and weld the strap.



### **WARNING**

**After the welding cycle wait 2-3 seconds to cool the strap before removing the tool (pic.F6)**

## **Seal check**

A regular seal quality control is very important and it can be checked visually as follows:

**G1)** Sealing time set too low

**G2)** Sealing time set correct

**G3)** Sealing time set too long

**( G1 )**



**NO** – seal strength insufficient

**( G2 )**



**YES** -- right

**( G3 )**



**NO** – seal strength affected

## **7) SERVICING - CLEANING**

**Disconnect the air line from the tool before performing any service.**

Periodically clean the tool from strap dust, particularly the feed wheel, the gripper plates and the cutter by using compressed air or wire brush (do not use other tools or objects) (pic. H1,H2)

**(H1)**



**(H2)**



## Cutter replacement

Disconnect the air pipes from welding motor and tension motor (pic.L1), remove the opening lever screw and remove the opening lever (pic.L2), remove 3 pneumatic valve screws and remove the valve (pic.L3) remove the 2 locking welding motor screws (pic.L4), remove the motor (pic.L5). Pull out the cutter spring with pliers (pic.L6), insert air into the disconnected pipe to push down the piston and free the cutter and remove it with pliers (pic.L7). Replace it and reassemble in reverse order putting grease on spring and cutter seat.

(L1)



(L2)



(L3)



(L4)



(L5)



(L6)



(L7)



## Feed Wheel replacement

(M1)



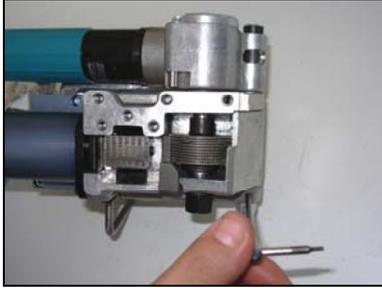
(M2)



(M3)



(M4)



(M5)



(M6)



(M7)



(M8)



(M9)



Remove the pushing spring (pic.M1), disconnect the motor pipe (pic.M2), remove the 6 bottom plate screws (pic.M3), unscrew the holding screw (pic.M4), remove the nut on connection shaft (pic.M5) and pull it out from main frame (pic.M6) pay attention to the shim. Remove the feed wheel shaft nut (pic.M7) Remove the front cover, the bush, the clutch system with the feed wheel (pic.M8); replace the worn part (pic. M9) Reassemble in reverse order.

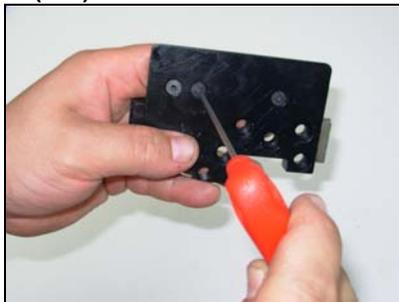
### **Bottom plate grippers replacement**

Remove the 6 bottom plate screws (pic.N1), unscrew the grippers screws (pic.N2), replace the parts (pic.N3), and reassemble.

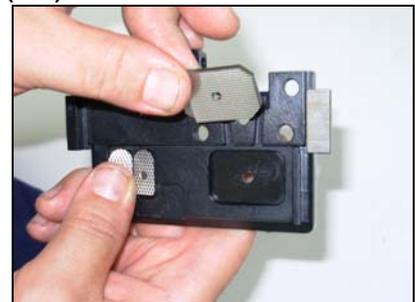
(N1)



(N2)



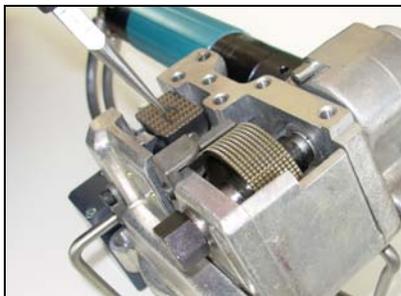
(N3)



### **Welding gripper replacement**

Remove the cutter as shown in L1 to L5 sequence, remove the bottom plate as point N1, remove the safety circlip from welding gripper pin (pic.O1), remove the pin from welding gripper (pic.O2), and replace the worn out part (fig. O3). Reassemble all parts in reverse order.

(O1)



(O2)



(O3)



## 8) TROUBLESHOOTING

PROBLEM
REMEDY
<b>Insufficient strap tension</b>
Check the following: air pressure value (min.4.5 bar), if the filter / lubricator and/or the pneumatic motor is damaged or dirty, the pneumatic circuit, tension button, connections, pipes, valve. - Check if the clutch is loose.
<b>The feed wheel slips and mills the strap</b>
Check if the feed wheel and grippers are dirty or damaged. Adjust the gap between feed wheel and grippers (around 0,2mm– 0.008"). Adjust the motor power—too much tension force. Check if the strap qualities are right for the strapping tool and application
<b>The strap is breaking during tension</b>
Adjust the motor power—too much tension force. Check if the strap qualities are right for the strapping tool and application. Check package for sharp edges.
<b>The strap is sideways after tensioning; The seal isn't in the middle of strap width</b>
Adjust the motor power—too much tension force. Check if the strap qualities are right for the strapping tool and application. Check strap size; Check the strap guides for alignment.
<b>The lower strap isn't locked between the grippers and feed wheel so the tool goes forward during the tension</b>
Adjust the gap between feed wheel and grippers (around 0,2mm– 0.008"). Check if the locking strap plates are dirty or damaged. Adjust the motor power.
<b>Strap locks against itself</b>
Adjust the gap between feed wheel and grippers (around 0,2mm– 0.008")- try to increase the gap. Check if the strap qualities are right for the strapping tool and application.
<b>Tool is leaking air</b>
Check the gaskets and pipes, replace if necessary
<b>The strap does not seal; the upper strap isn't completely cut; the cutting is inconsistent</b>
Improper weld time adjustment. Check if the sealing foot and the cutter are damaged or worn out. Check if the sealing foot slides on strap. Check the air pressure value. Check if the strap qualities are right for the strapping tool and application. Check if the sealing motor is locked or dirty and, the pneumatic valve - try to clean the timer valve. The cutter spring is damaged, try to replace it.
<b>Strap is oversealed; the strap is breaking during the sealing – cutting</b>
Improper weld time adjustment, may be too long.
<b>During the sealing both straps are cut</b>
Check if the gripper plate (under the sealing foot) is dirty or damaged (clean or replace it) Check if the strap is over tensioned. Improper weld timing adjustment, may be too long.
<b>After the cycle is not possible to remove the tool from package</b>
Check if there is too much tension. If it is not possible to remove the tool by hand, cut the strap from package and disassemble the foot from the main frame to remove the strap.
<b>The sealing time will not remain constant</b>
Timer valve problem, try to clean, lubricate or replace it.

## 9) LAYOUT-SPARE PARTS LIST

Ed. 07/09

POLYCHEM PART #	ITEM	DESCRIPTION	QNTY		
401-0042	A000014	ASSEMBLED GEARBOX BODY	1		
401-0003	A000086	ASSEMBLED FRONT COVER	1		
200-0027	B100032	PLASTIC PIPE 6x8	0,09		*
400-0021	B100296	GRUB SCREW 1/4" S2610 CAMOZZI	1		
400-0039	B100310	SWING ELBOW RL31 8 1/4	1		*
400-0094	B100313	AIR FITTING 1/4"	1		*
401-0037	B100403	SPIRAL PIPE 6x8	0,25		
400-0004	B200309	FAST AIR MALE CONN. APAG261.14	1		
400-0126	B200357	PNEUM.VALVE 3/2	1		*
400-8004	B300019	GASKET RING RP6287.85	1		
400-0019	B300020	GASKET 1.5X6.1 IN MTS	0,11		
400-0086	B300021	O-RING 2125 (D32)	1		
400-0014	B300022	O-RING 3300 (D85)	1		
400-0223	B300055	O-RING 2043	1		
400-0089	B400001	ROLLER BEARING BK0810	1		
400-0091	B400002	BEARING 7200BE 2RS	1		
400-0049	B400003	ROLLER BEARING HK0808	2		
400-0085	B400004	BEARING 6001 2Z	2		
400-0054	B400005	ROLLER BEARING NK1616	1		
400-0108	B400008	BEARING 6001 2RS	1		
400-0073	B400009	BUSHING RING IR 12x16x16	1		
401-0008	B400340	AXK1226 SKF	1		
401-0009	B400341	AS 1226 SKF	2		
400-0095	B500037	SCREW M4X8	1		
400-0038	B500039	SCREW UNC 10X1/2"	9		*
400-0044	B500040	SCREW M6X16	6		*
400-0088	B500043	SCREW ECOFIX M5X12 ZINC	2		
400-0199	B500045	SCREW M4X5	1		
401-0140	B500047	SCREW M5X8	2		
400-7135	B500048	SCREW M4X6	3		*
401-0248	B500050	SCREW M4X35	3		
400-0070	B500053	SELFLOCK.NUT M8 H10 DIN982	1		
401-2149	B500068	SCREW M3X8 UNI5931	2		
401-0011	B500071	SCREW M8X6 UNI5923L	1		
401-2028	B500379	SCREW STEI M4X5 UNI5923	1		
401-0013	B500394	SCREW M6X14	1		*
400-0102	B600011	WASHER PS 10x16x0.5	1		
400-0092	B600012	CIRCLIP A10 DIN471	1		
400-0059	B600013	CIRCLIP 5 UNI 7434	1		*
400-0103	B600014	WASHER PS 22x30x0,1	VAR		
400-0104	B600015	WASHER PS 22x30x0,5	VAR		
400-0202	B600016	WASHER PS 10x16x1	1		
400-8008	B600028	SPRING R10-051 ISO 10243	1		*
400-0077	B600059	CUP WASHER CB25x12.2 x 1.5	3		
401-0014	B600338	GUIDE SOCKET BM 12 14 25	1		
401-0015	B600342	GUIDE SOCKET BM 16 18 10	1		

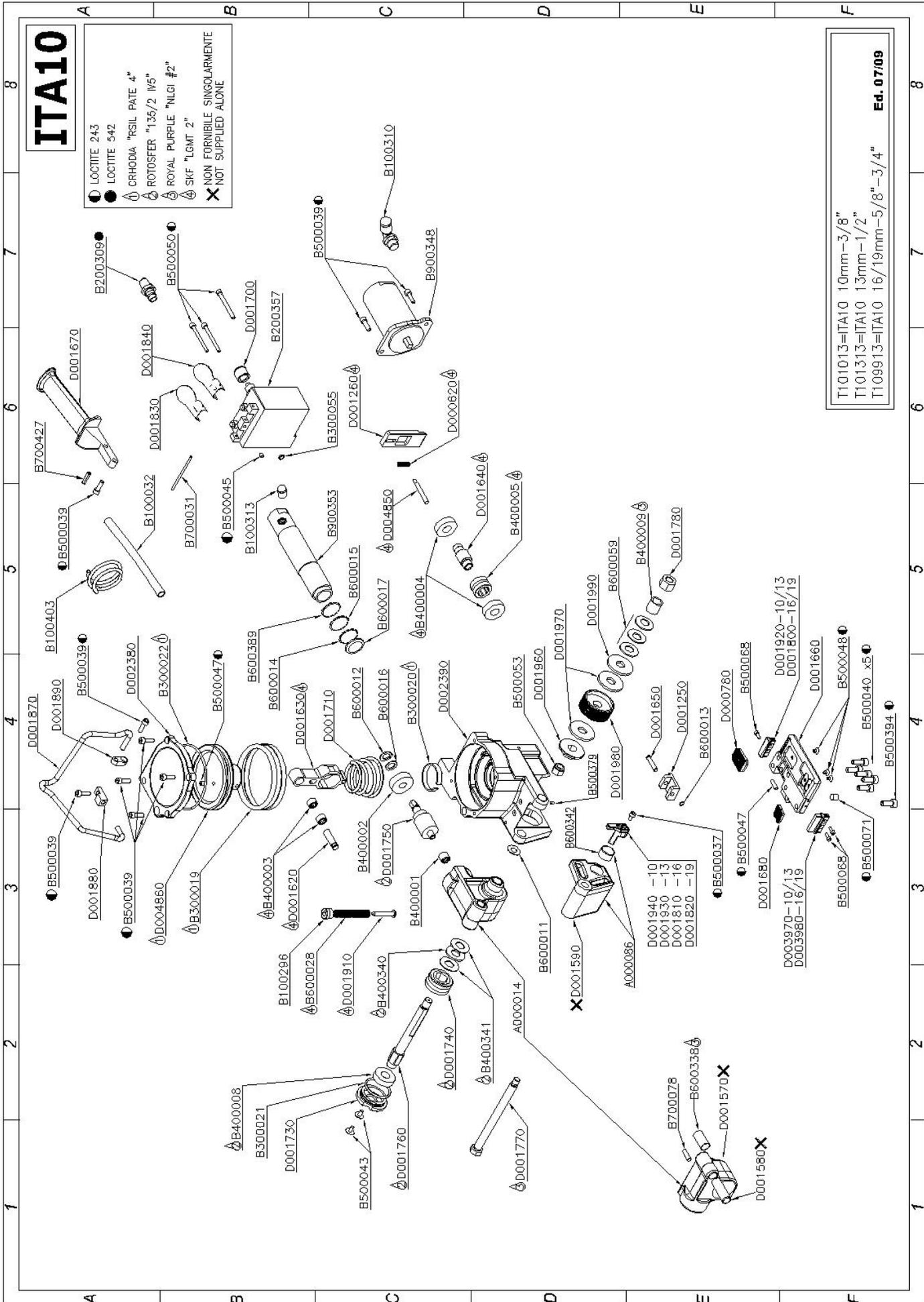
POLYCHEM PART #	ITEM	DESCRIPTION	QNTY		
401-0211	B600389	WASHER PS 22x30x0,2	VAR		
400-8034	B700031	PIN 3x60 DIN6325	1		
401-0016	B700078	PIN 6X18DIN6325	1		
401-0110	B700427	ELASTIC PIN 5x16 UNI6874			
400-0036	B900348	PNEUMATIC WELD MOTOR	1		
401-0038	B900353	PNEUMATIC TENSION MOTOR	1		
400-0034	D000620	CUTTER BLADE SPRING	1		*
400-0063	D000780	LOCKING STRAP PLATE	1	§	*
400-0057	D001250	WELDING FOOT	1	§	*
400-0035	D001260	CUTTER	1	§	*
400-0205	D001620	CONNECTING ROD PIN	1		
400-0055	D001630	CONNECTING ROD	1		
400-8014	D001640	EXCENTRIC SHAFT	1		
400-0058	D001650	WELDING FOOT PIN	1		
401-0021	D001660	BOTTOM PLATE	1		
400-8010	D001670	OPENING LEVER	1		
400-0123	D001680	LOCKING STRAP PLATE	2	§	*
400-0067	D001700	WELD TIMER COVER	1		
400-0020	D001710	PISTON SPRING	1		
400-0087	D001730	GEARBOX COVER	1		
400-8016	D001740	CROWN	1		
400-0090	D001750	WORMGEAR	1		
400-0083	D001760	FEEDWHEEL SHAFT	1		
400-0080	D001770	SHAFT	1		
400-0100	D001780	SPECIAL NUT	1		
401-0024	D001800	REAR STRAP GUIDE 5/8" 3/4"	1		
401-0025	D001810	SIDE STRAP GUIDE 5/8"	1		
401-0026	D001820	SIDE STRAP GUIDE 3/4"	1		
401-0027	D001830	TENSION START LEVER	1		
401-0028	D001840	WELDING START LEVER	1		
401-0030	D001870	SUSPENSION HOOK	1		
400-0046	D001880	SIDE SUSPENSION HOOK SUPPORT	1		
400-0043	D001890	UPPER SUSP. HOOK SUPPORT	1		
401-0032	D001910	SPRING PIN	1		
401-0033	D001920	REAR STRAP GUIDE 3/8" 1/2"	1		
401-0034	D001930	SIDE STRAP GUIDE 1/2"	1		
401-0039	D001940	SIDE STRAP GUIDE 3/8"	1		
401-0207	D001960	REAR FRICTION PLATE	1		
400-0075	D001970	FRICTION PLATE	2	§	*
400-0076	D001980	FEEDWHEEL	1	§	*
400-0074	D001990	FRONT FRICTION PLATE	1		
401-0040	D002380	PISTON COVER	1		
401-0041	D002390	MAIN FRAME	1		
401-0035	D003970	FRONT STRAP GUIDE 3/8" 1/2"	1		
401-0036	D003980	FRONT STRAP GUIDE 5/8" 3/4"	1		
401-0209	D004850	CUTTER PIN	1		
401-0210	D004860	PISTON	1		

	§	WEARING PART
	*	PART THAT SHOULD BE STOCKED

# ITA10

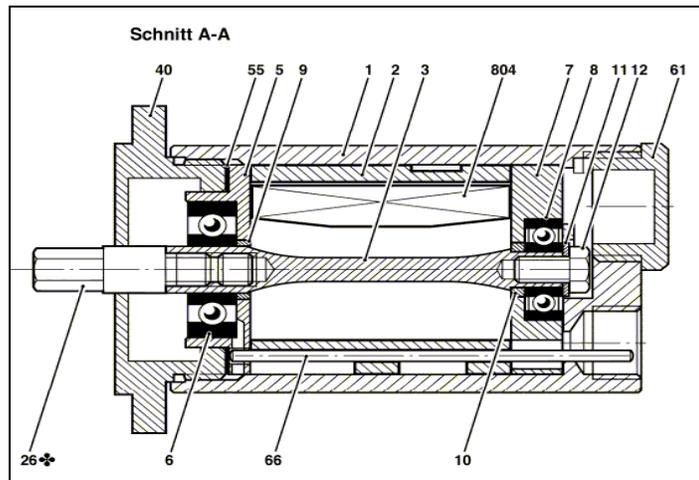
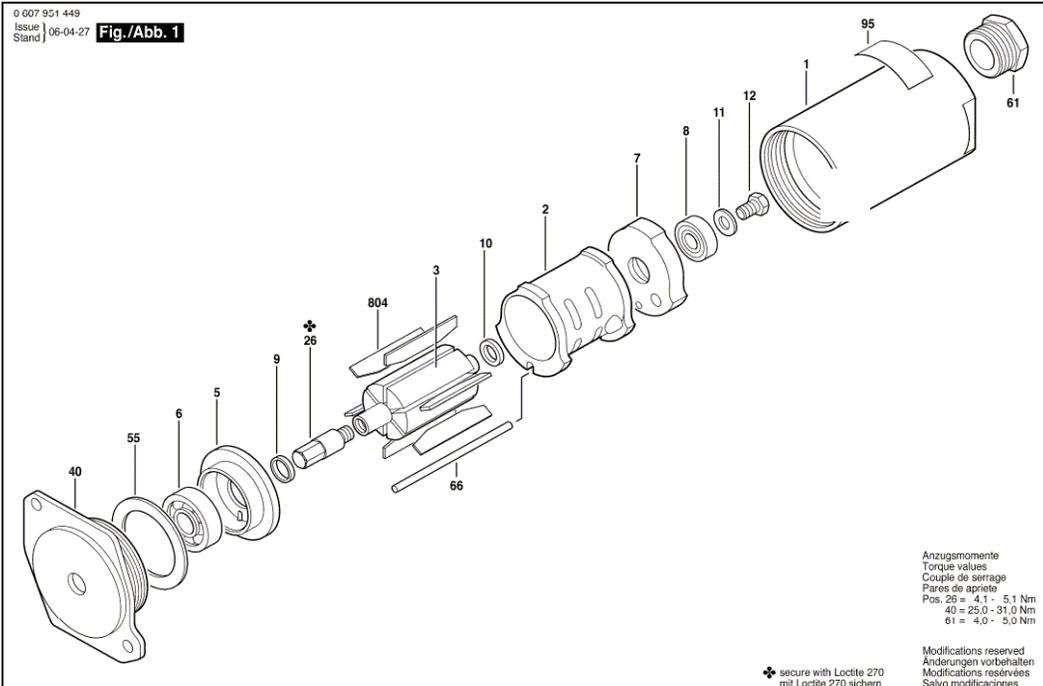
- LOCITE 243
- LOCITE 542
- ▲ CRHODIA "RSIL PATE 4"
- ▲ ROTOSFER "1,35/2 IV5"
- ▲ ROYAL PURPLE "NLGI #2"
- ▲ SKF "LGMT 2"
- ✗ NON FORNIBILE SINGOLARMENTE
- ✗ NOT SUPPLIED ALONE

T101013=ITA10 10mm-3/8"  
 T101313=ITA10 13mm-1/2"  
 T109913=ITA10 16/19mm-5/8"-3/4" Ed. 07/09



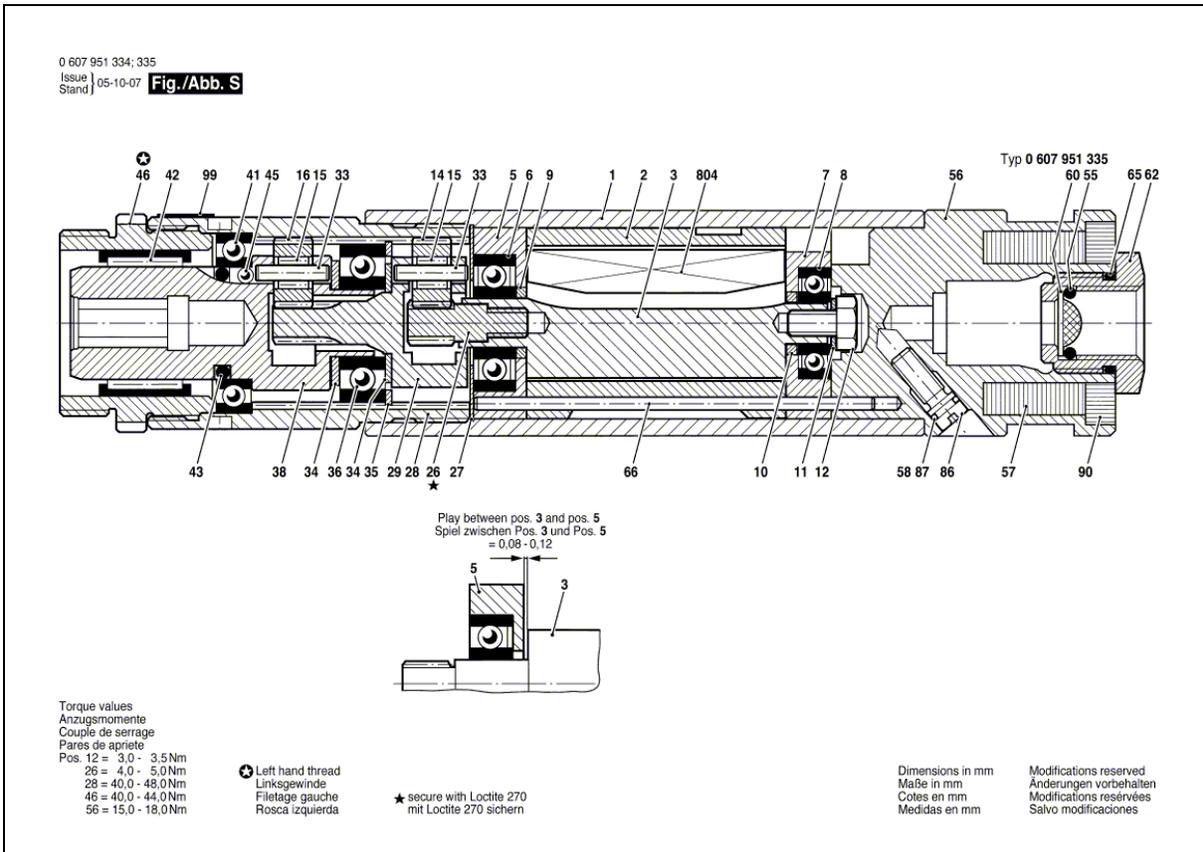
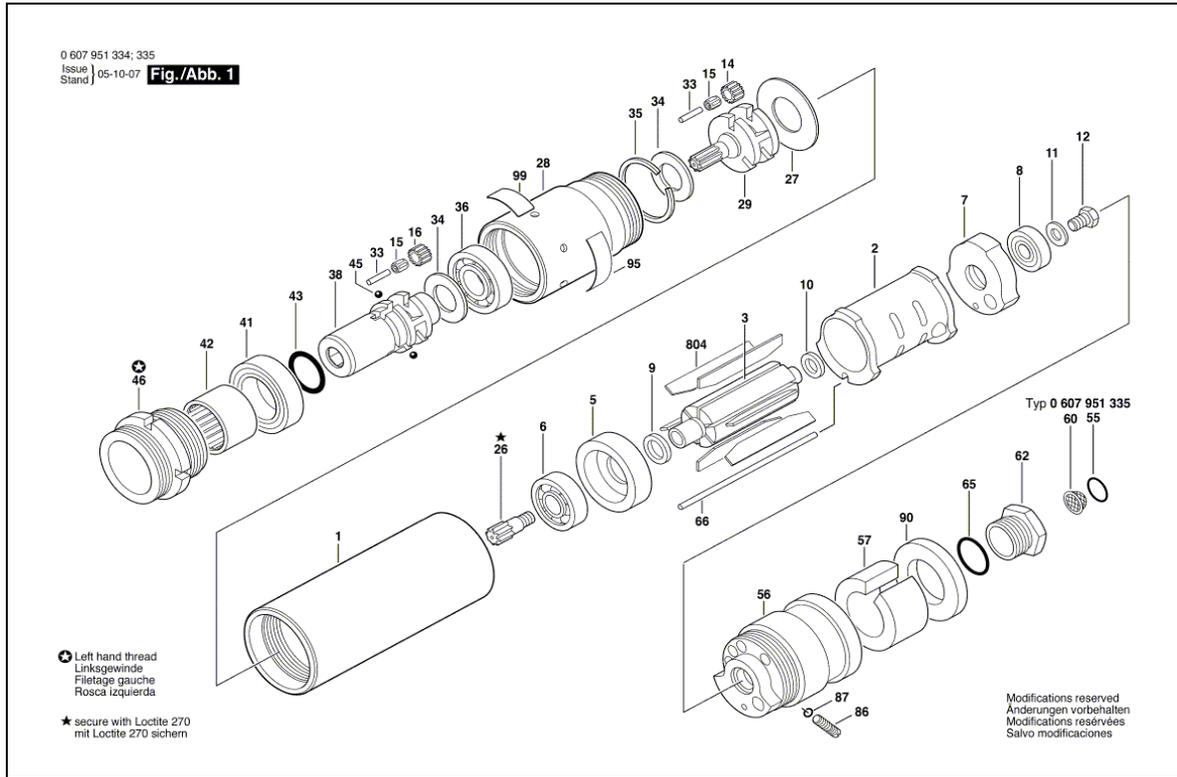
# BOSCH 0 607 951 449 –B900348

## WELDING MOTOR



Item	Quantity	Part No.	Description
1	1	3 605 125	MOTOR HOUSING
2	1	3 604 090	STATOR / 550W
3	1	3 604 220	ROTOR
5	1	3 605 700	BEARING FLANGE
6	1	1 900 905	DEEP-GROOVE BALL BEARING / 6000-2Z/C3 DIN
7	1	3 605 700	BEARING FLANGE
8	1	1 900 905	DEEP-GROOVE BALL BEARING / DIN 625-608-2Z-C3
9	1	2 600 200	SPACER RING
10	1	3 600 202	SPACER RING
11	1	2 916 011	PLAIN WASHER / DIN 125-A5,3-ST
12	1	2 911 061	HEX SCREW / DIN 933-M5x8-8.8
26	1	3 606 337	CARRIER
40	1	3 600 390	FLANGE
55	2	3 600 100	SEALING DISC
61	1	3 603 462	SILENCER
66	1	3 604 710	STRAIGHT PIN
95	1	3 601 106	NAMEPLATE
99	1	3 601 119	REFERENCE PLATE
804	1	3 607 030	ASSEMBLY OF SERVICE PARTS / 5 PIECE

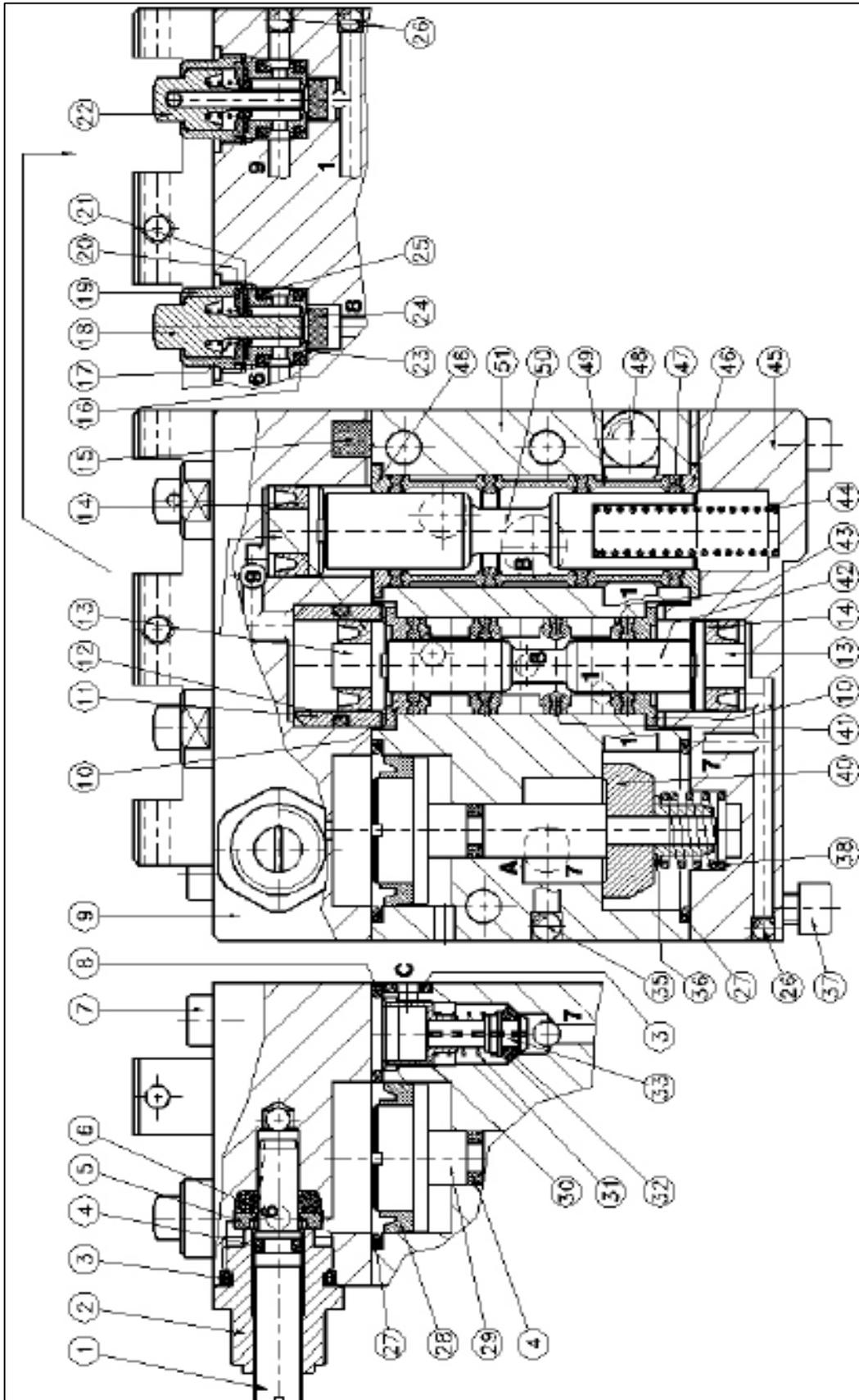
# BOSCH 0 607 951 445 –B900353 TENSION MOTOR



SPARE PARTS LIST B900353

#	QNTY	CODE	DESCRIPTION
1	1	3 600 760 114	MOTOR HOUSING / BLUE
2	1	3 604 090 003	STATOR / 370W
3	1	3 604 220 025	ROTOR
5	1	3 605 700 005	BEARING FLANGE
6	1	3 600 905 039	DEEP-GROOVE BALL BEARING / 9x24x7mm
7	1	3 605 700 007	BEARING FLANGE
8	1	3 600 905 148	DEEP-GROOVE BALL BEARING / DIN 625-7x19x6
9	1	2 600 202 013	SPACER RING
10	1	2 600 202 014	SPACER RING
11	1	2 916 011 012	PLAIN WASHER / DIN 125-A5,3-ST
12	1	2 911 061 150	HEX SCREW / DIN 933-M5x8-8.8
14	3	3 606 316 000	CYLINDRICAL GEAR / Z=12
15	6	3 600 913 000	NEEDLE-ROLLER ASSEMBLY / INA K3x5x7
16	3	3 606 316 002	CYLINDRICAL GEAR / Z=18
26	1	3 606 300 002	PINION / Z=23
27	1	3 600 101 001	STOP DISC
28	1	3 606 334 000	RING GEAR / Z=49
29	1	3 606 337 207	PLANETARY-GEAR CARRIER
33	6	3 603 201 000	NEEDLE ROLLER
34	2	3 600 103 002	SHIM RING
35	1	3 600 224 000	RETAINING RING
36	1	1 900 900 287	DEEP-GROOVE BALL BEARING / 6001 DIN 625
38	1	3 606 337 206	PLANETARY-GEAR CARRIER
41	1	3 600 905 145	DEEP-GROOVE BALL BEARING
42	1	3 600 910 018	FREEWHEELING
43	1	1 900 210 113	O-RING / 15x2,5 mm
45	3	1 903 230 004	BALL / DIN 5401-3 MM-III-ST
46	1	3 603 344 056	THREADED RING
56	1	3 605 190 190	VALVE HOUSING
57	1	3 601 010 002	SILENCER
62	1	3 603 458 019	FITTING
65	1	3 600 210 036	O-RING / 16x1,25 mm
66	1	3 604 710 051	STRAIGHT PIN
86	1	3 603 435 032	ADJUSTING SCREW
87	1	3 600 210 015	O-RING / 4x1 mm
90	1	3 600 105 002	SILENCER
95	1	3 601 106 047	NAMEPLATE
96	1	3 601 110 331	MANUFACTURER'S NAMEPLATE
99	1	3 601 119 236	REFERENCE PLATE
804	1	3 607 030 249	ASSEMBLY OF SERVICE PARTS

**B200357 PNEUMATIC VALVE**



SPARE PARTS LIST B200357

#	CODE	DESCRIPTION	QNTY
1	10.077.0	NEEDLE	1
2	12.002.1	REGULATOR NIPPLE	1
3	OR 2043	OR 2043	2
4	OR 102	OR 102	2
5	12.103.1	GASKET HOLDER REG.908	1
6	5x3x11	OR NBR 70 5x3x11	1
7	M4x20	SCREW M4x20 UNI 5931	3
8	OR 110	OR 110	1
9	10.106.1	CONTROL	1
10	00.008.0	GASKET HOLDER Ø15,5 - 1/8	2
11	00.046.0	REDUCTION	1
12	OR 2050	OR 2050	1
13	00.013.0	PISTON Ø12	3
14	00.018.0	LIP GASKET Øe12	3
15	00.021.0	SINTERED	1
16	OR 105	OR 105	2
17	08.006.0	BUTTONS SPRING	2
18	08.023.1	BUTTON	1
19	08.013.1	BUTTON GUIDE	2
20	08.008.0	GASKET HOLDER	2
21	08.007.N	OR WITH MEMBRANE Ø2,6	2
22	08.010.1	BUTTON	1
23	08.004.0	SPACER	2
24	1/82/M	SHUTTER SH75	2
25	OR 106	OR 106	3
26	SF 1/8	SPHERE 1/8 AISI 420 grade B	8
27	OR 2081	OR 2081	2
28	01.014.0	GASKET HOLDER Øe20	1
29	10.043.0/S	PISTON Ø20 WITH SUTTLE WITHOUT SCREW	1
30	11.001.0	SHUTTER GUIDE	1
31	11.004.0	SPRING	1
32	OR 101	OR 101	1
33	10.017.0	SHUTTER HOLE Ø0,5	1
34	OR 2010	OR 2010	1
35	SF 5/32	SPHERE 5/32 AISI 420 grade B	2
36	03.025.0	GUIDE SPRING	1
37	M4x12	SCREW M4x12 UNI 5931	2
38	01.036.0	UNDERPISTON SPRING	1
39	SF 3/32	SPHERE 3/32 AISI 420 grade B	1
40	03.032.0	SHUTTER	1
41	00.001.0	GASKET 1/8	4
42	00.010.0	3 WAY SHUTTLE 1/8	1
43	00.002.0	SPACER 1/8	3
44	01.047.0	SPRING	1
45	10,164,1	BOTTOM PLATE	1
46	01.013.0	GASKET HOLDER Ø17,4 - 1/4	2
47	01.002.0	GASKET 1/4	4
48	SF 9/32	SPHERE 9/32 AISI 420 grade B	1
49	01.001.0	SPACER 1/4	3
50	01.011.1	3 WAY SHUTTLE 1/4	1
51	10.105.1	BODY	1
52	OR 102	OR 102	1
53	00,407,0	PIPI CARTRIDGE	2
54	20,000,0	PISTON Ø8	1
55	DE08	DE 08	1
56	OR110	OR 110	1
57	20.002.0	CYLINDER BODY Ø8	1

58	20.001.0	STEM	1
59	20.004.0	SPRING	1

## CE DECLARATION OF CONFORMITY

Polychem Corporation declares under own responsibility that the under mentioned machinery, to which this declarations refers, is in conformity with **2006/42/CE** Directive and successive modifications, as well as with standards **EN12100-1 / EN12100-2**.

**MODEL:**  
**PHT401**



**MACHINE TYPE:**

PNEUMATIC PLASTIC STRAPPING TOOL

**POLYCHEM CORPORATION**  
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Manufactured in Italy