

Operating Instructions

Threading and Changing Ribbon Spool

Step 1: Turn the power switch “OFF”, unplug the power cord and remove any ribbon pieces and/or debris inside the XL-2.

Step 2: Remove empty ribbon spool by depressing the brake spool arm and then pull the spool straight away from brake spindle. Slide the new ribbon spool onto brake spindle. Feed the ribbon from the top of spool to under and around the roller wheel on the brake assembly.

Step 3: With the ribbon now directed toward the rear of the XL-2, look at both sides of the ribbon. One side has a “bump” (wire), the other is flat. Pull 1 foot of ribbon from the spool and feed into the rear of the XL-2.

Step 4: Turn the pressure release cam to separate the ribbon drive wheel and insert the ribbon through the ribbon guide, ensuring that the “bump” (wire) side is against wheel and into the cutter anvil guide, but not protruding beyond the cutter space.

Step 5: Release the pressure release cam to bring the ribbon drive wheel together, making sure the ribbon is between the restraint flanges on the ribbon drive wheel.

Tying Operation

Step 1: Support the product to be tied with both hands and insert into the left side of tying area when tying in the vertical position. **Insert into bottom of tying area when in the horizontal tying position.*

Step 2: Hold the product in place until the product is twist tied. Tying cycle is approximately 3 seconds.

Step 3: The product may be removed from the tying area any time after the tying cycle is complete.

Please Note:

Periodically the ribbon length will need to be either lengthened or shortened. Slightly turn the Tying Diameter Adjustment Dial to the left to decrease ribbon length and to the right to increase ribbon length.

Always remove any ribbon pieces from the XL-2 before tying.

Adjusting Tying Diameter

Adjusting XL-2 Tying Diameter

Caution

Before attempting any adjustments of this machine, the power switch should be in the "OFF" position and the power cord disconnected.

The XL-2 machine can be adjusted to twist tie almost any product gathered into a round shape from 3/8" up to a maximum of 2" diameter. Prior to adjusting any internal components of the XL-2, you must pre-determine the following:

1. Material Diameter
2. Chute Length
3. Ribbon Length

Step 1: Set Tying Diameter Dial

1. Rotate tying diameter adjustment dial to point arrow to the desired product diameter. This diameter will then align with and indicate ribbon length and the required chute length. Example: if the tying diameter is 2", then the chute length is 4" and the ribbon length is 9.5".

Step 2: Adjust Stop Guides

1. Loosen screw and move the stop guide to the correct product diameter.
2. Tighten screw. This aligns and centers the product to be tied directly in front of the twist shaft. **Top guide is under top cover and should be adjusted to align with bottom guide.*

Step 3: Adjust Ribbon Drive Motor

1. Loosen the sockethead cap screw and slide the entire ribbon drive assembly to align with required ribbon length as indicated from Step 1.
2. Retighten the sockethead cap screw.

Step 4: Change Ribbon Chute

1. Remove screw and washer and swing scissor actuator rod out of the way.
2. Loosen screw and washer and lift out chute.
3. Install new ribbon chute and tighten screw. (Be certain that the ribbon chute is centered to the slot in the ribbon cutter anvil.)
4. Re-thread ribbon through machine.

Step 5: Test Tying Material

1. Reconnect power supply and turn the power switch on.
2. Insert desired material into left side of tying area and activate the tying cycle.
3. Fine tune ribbon length if required, by slightly rotating the Tying Diameter Adjustment Dial to achieve optimum ribbon length.