

KTW1623/1627/1635 Battery-Strapping-Machine



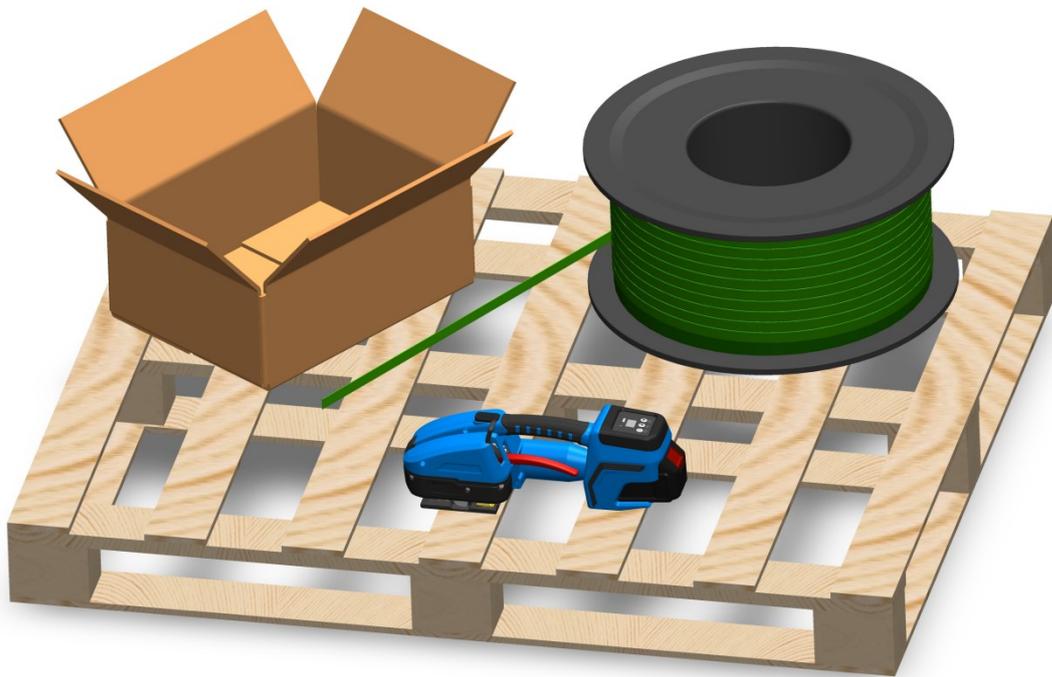
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Note: This operating manual is for reference only.

Specifications are subject to change without notice and should be verified against the actual product.

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For your safety, please read this manual carefully before operating

1. Safety Instructions

Please read these instructions carefully. Non-compliance may result in operator injury during operation.



1.1 Operating the Battery

Environmental Protection

- Ⓞ Do not dispose of old batteries in household trash or wastewater containers, or burn them.
- Ⓞ The dealer offers a battery recycling service.

Short Circuit Hazard

- Ⓞ Do not store the battery with other metal objects.
- Ⓞ Do not open the battery; store it in a dry, frost-resistant room with a maximum temperature of 50 degrees Celsius. Keep it dry at all times.
- Ⓞ Do not charge waste batteries; replace them immediately.

1.2 Eye Injury Hazard

Working without safety glasses with protective sides may result in eye injury or even blindness. It is required to wear safety glasses with protective sides.

1.3 Operation

Untrained personnel are not allowed to operate the strapping machine. Before tightening the straps, read and understand the operating instructions for the machine. Incorrect operation or loading of the strap may cause the strap to break.

Note: Before getting familiar with the strapping machine, keep your fingers away from the pinch or cutting areas.

1.4 Bonding Area

You should check the compressed bonding area, familiarize yourself with the bonding control and adjustment. Irregular bonding might be insecure and cause severe injuries. Do not ship packages that are not properly secured.

1.5 Strap Dispensing

Use a specially designed dispensing device for distributing straps. When not in use, fold the end of the strap into the dispenser.

1.6 Strap Hazard

Do not use straps for dragging or lifting loads; it can cause personal injury.

1.7 Strap Breakage Hazard

Incorrect operation; over-tightening; improper use of straps, or sharp load angles can cause sudden loss of tension or strap breakage, possibly leading to:

1. The operator losing balance and falling.
2. The strapping machine and strap rapidly flying towards the operator's face.

Note:

- Ⓞ If the load has sharp angles, add edge protectors.
- Ⓞ Wrap the strap around an appropriate load surface.
- Ⓞ If the operator is in line with the strap during tightening and bonding, injuries from flying straps or the machine are possible, so stand beside the strap during operation and keep bystanders away. Use good quality straps recommended in this manual, with suitable width and strength. Incompatible straps might break during tightening.

1.8 Cutting the Strap

When cutting straps, use appropriate cutting tools and ensure a safe distance from people. Do not stand in line with the strap and stay away from the direction in which the strap may loosen. Use tools specifically designed for cutting straps, not hammers, pliers, hacksaws, axes, etc.

1.9 Slipping Hazard

Keep the work area clean. An unclean work area may cause injury risks. Poor footing or imbalance before tightening can easily lead to falls, especially in stair areas. Therefore, maintain balance. Both feet should be on a flat, sturdy surface. Do not operate the tool if you are in an uncomfortable position. Pay attention to the specific preventive precautions mentioned for the work area.

1.10 Strapping Machine Hazard

- ⊙ It is essential to keep the strapping machine well-maintained.
- ⊙ Periodically check for broken or worn parts, and do not use the strapping machine if there are any cracks or wear.
- ⊙ Do not modify or retrofit the strapping machine, as this may cause personal injury.

2. Technical Specifications

2.1 Description of the Strapping Machine

This strapping machine uses plastic steel straps, manually operated feeding device, wrapping the plastic steel strap around the box (package). The strap end is inserted into the strapping machine, tightened by pressing the tightening button, and separated after friction bonding.

2.2 Dimensions of the Battery-Powered Strapping Machine (Reference Values)

Length: 379mm

Width: 137mm

Height: 127mm

Weight: 3.07kg

Battery Weight: 0.58kg

2.3 Strap Material

Strap Quality: Flat or embossed PET (Polyester) and PP (Polypropylene) straps.

Strap Dimensions (mm): Width 13~16, Thickness 0.5~1.2

Please choose the appropriate size of strap for the strapping machine you have purchased.

2.4 Strap Strength

Tensile Force: Adjustable within 600-3200N.

Maximum depends on the quality of the strap and model of the product.

Tightening Speed: 50~180mm/S.

Bonding Strength: Approximately 75% of the strength of the plastic steel strap (depends on the quality of the strap).

2.5 Operating Temperature

- ⊙ Ambient temperature should be between 5 degrees and 45 degrees Celsius.
- ⊙ The optimal operating temperature is between 15 degrees and 25 degrees Celsius.

3. Attachments

Use only the parts and attachments mentioned in the operating manual; using other attachments may harm you and others.

3.1 Battery-Powered Electric Strapping Machine

As the strapping machine can use NiCd (Nickel Cadmium) or NiMH (Nickel Metal Hydride) batteries, please purchase the battery separately according to the following specifications.

Model: Lithium Battery Voltage: 18V or 21V Capacity: 4.0Ah

3.2 Battery Charger

Standard Charger:

Voltage Frequency: 100V-245VAC, 50-60HZ, DC18V- 3.0A

Voltage Frequency: 100V-245VAC, 50-60HZ, DC18V- 2.0A

Voltage Frequency: 100V-245VAC, 50-60HZ, DC18V- 0.7A

Charging Time

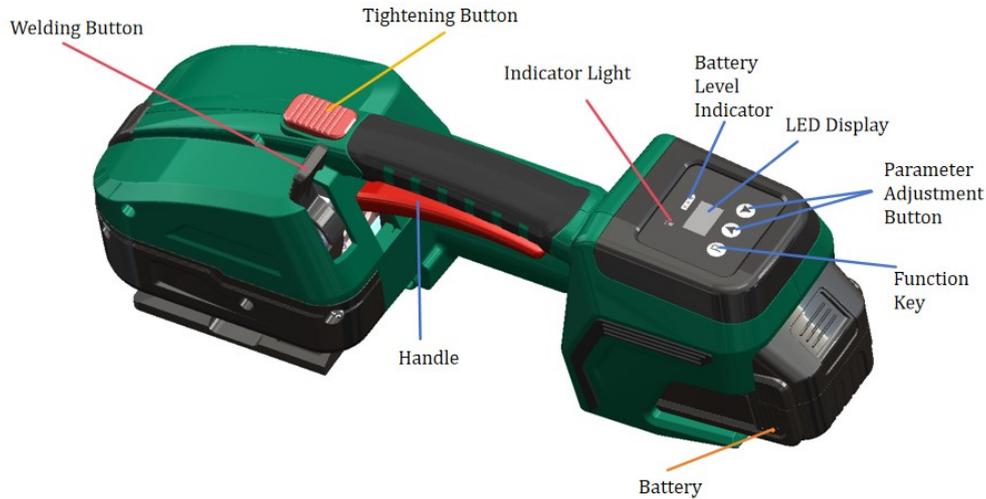
For a 4.0A/h lithium battery, using a charger with a voltage frequency of 100V-245VAC, 50-60HZ, DC18V- 2.0A, the charging time is approximately 90~120 minutes.

3.3 All models come with a carton + pearl cotton packaging

3.4 Each machine comes with a set of commonly used tools

3.5 Suspension System (Optional Purchase)

4. Operating Components



Indicator Light Status Display

Red Flashing: Standby Mode

Blue Steady: Operational Mode

Purple Steady: Operation Complete

Red/Blue/Purple Rapid Flashing: Machine Fault, Disconnect Power and Check

5. Operation

5.1 Installation

- ⊙ Do not expose the strapping tool to rain or water.
- ⊙ For safety reasons, the battery is not charged upon delivery.
- ⊙ Charge the battery before use. Refer to the separate battery charger manual provided.



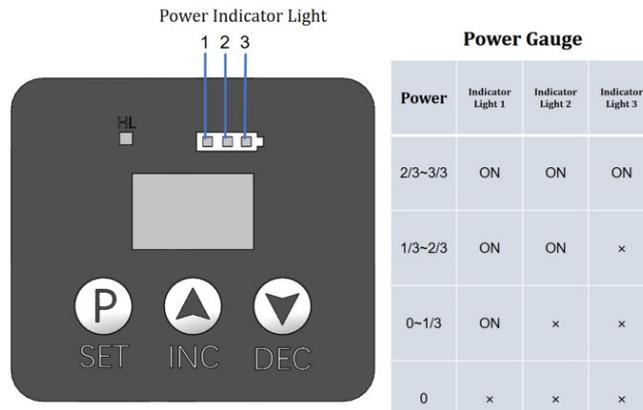
Battery Installation and Removal:

- ⊙ To install, press the battery release button and slide the battery into the slot.
- ⊙ When the battery is inserted, the battery status will briefly display; press the function key to recheck.
- ⊙ The battery status is indicated by the LED charging light.

Removing a Depleted Battery:

If the LED flashes red during tightening or welding, it indicates that the battery is depleted, and all electrical functions of the strapping machine will be disabled.

Warning: If the bond is insufficient, remove the strapping! The battery must be charged.



Adjustments for welding time and tightening force based on the size and quality of the strap can be made using the function key and the parameter adjustment buttons.

LED Display: P1 Tightening Force (01~10), P2 Welding Duration (0.5~5.0 seconds).

SET Function Key: Single press to toggle, selecting adjustment for welding time or tightening force.

INC Parameter Adjustment Button: Increase P1 or P2.

DEC Parameter Adjustment Button: Decrease P1 or P2.

5.3 Wrapping the Strap

1



Wrap the Strap as Illustrated

Preparation: First, insert the battery and press the tightening button to activate.

Warning! Keep away from oil during plastic steel strap welding. Grease and other dirt prevent welding of dirty straps.

5.4 Inserting the Strap

2



Lift the handle with your right hand, insert the strap with your left hand, layering two parallel strips, then release the handle.

5.5 Tightening the Strap

3



Press the tightening button; once the strap reaches the desired tension, release the switch knob. Tightening can be interrupted or restarted at any time. During tightening, the LED displays blue. Do not press the switch knob after reaching the desired tension; there is a risk of the strap breaking.

Note:

Keep the strapping tool balanced and moving freely during tightening; do not obstruct its path.

5.6 Bonding the Joint

4



Press the welding button and immediately remove your hand. The plastic steel strap is welded and the excess strap cut off. During welding, the LED displays blue or purple. Welding complete.

5.7 Removing the Strapping Tool

Lift the handle to loosen the strap slightly, then pull the strapping machine to the right away from the strap.

Note: The machine automatically powers off after 3 minutes of inactivity; reactivate by pressing the tightening button.

5.8 Bond Control

Proper control of bonding is essential. The quality of the bond can be visually assessed.

As shown in Figure 5-7 to the right, separation and assessment are as follows:

© **Overly Long Welding Time:** Figure 5-7 (1)

If the welding time is too long, the strap overheats, and melted plastic spills out from the sides, affecting the bond quality. Warning! Straps with insufficient bond strength must be removed. Adjust the welding time.

© **Correct Bonding:** Figure 5-7 (2)

The entire width of the strap is welded, with a welding length of approximately 19mm.

A small amount of melted plastic may spill over the edges.

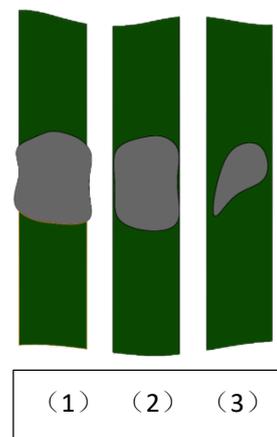


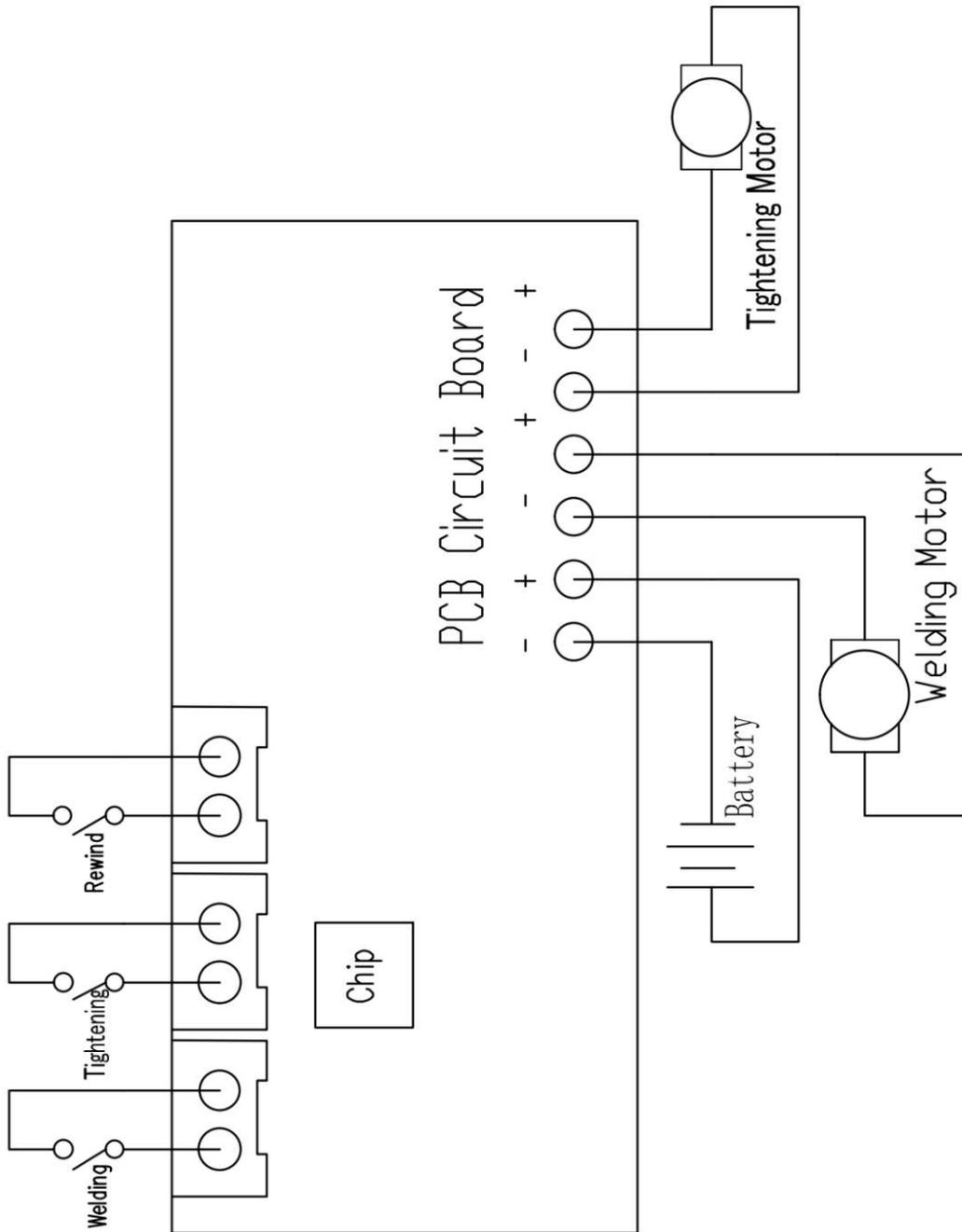
Figure 5-7

© **Insufficient Welding Time:** Figure 5-7 (3)

If the entire width is not welded, the bond is insufficient.

Warning! Straps with inadequate welding must be removed. Adjust the welding time.

6. Electrical Connections and Common Faults



- 1、 Special Reason: If the machine stalls during the strapping process (LED flashing rapidly), causing the strapping tape to get stuck in the equipment and unable to be removed, immediately disconnect the power. Cut the strapping tape, remove the screws from the left and right side panel covers and move them away. Remove the strapping tape and check the machine. Inspect the wires on the travel switch for disconnection and replace the microswitch.
- 2、 If pressing the welding and tightening buttons does not cause the motors to operate, check the motors and microswitches, and replace the motors and microswitches.

7. Wear Part Replacement

Each time maintenance is performed, please remove the battery.

Cutter (BB4003): First, remove the screws from the left side panel cover and set it aside, remove the screws from the cutter and set aside, replace the cutter; reassemble in the reverse order.

Lower Friction Plate (BB2006): First, remove the screws that secure the welding tooth plate at the base and set aside, push out the tooth plate to replace, and reassemble in the reverse order.

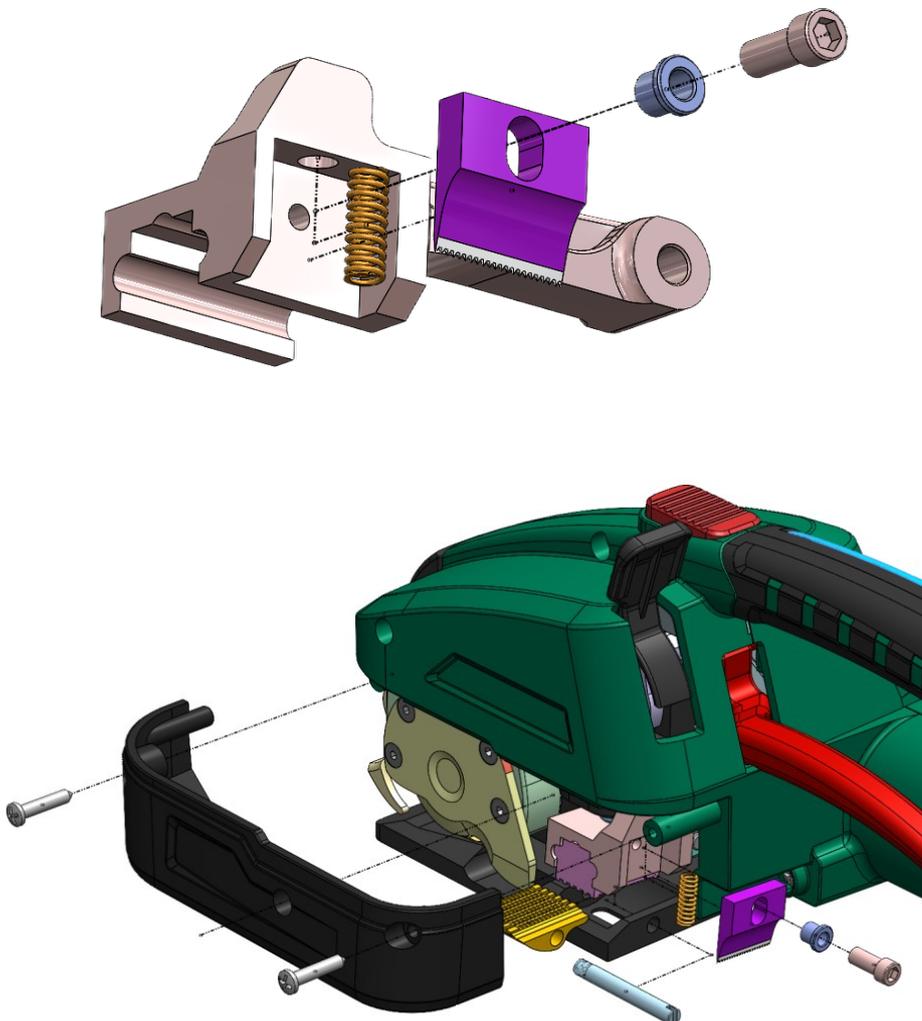
Lower Tension Plate (BB6004): Remove the screws securing the tension tooth plate on the base and set aside, push out the tooth plate to replace, and reassemble in the reverse order.

Tension Wheel (BB6003): Remove the left plastic cover, remove the screws of the tension wheel guard (AIBA06) and set aside, remove the tension wheel. Reassemble in the reverse order.

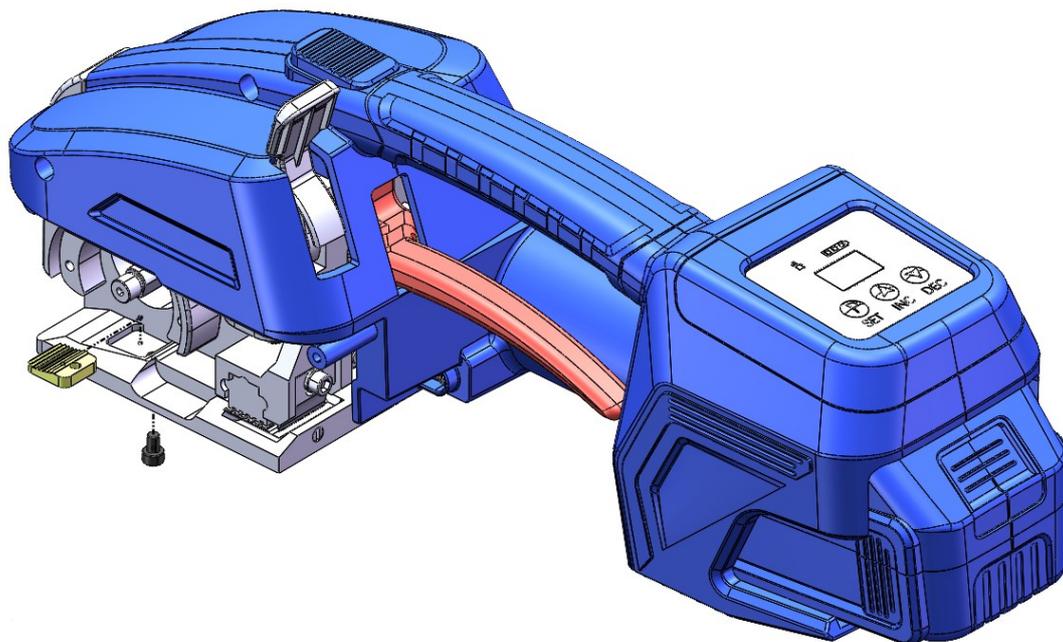
Tension and Cutting Adjustment: If there is slippage during tensioning, remove the screws securing the tension tooth plate on the base and set aside, push out the tooth plate to replace. Place a factory-supplied shim under the tension tooth plate and reassemble in the reverse order. If the cutter is not operating smoothly, replace the cutter (BB4003) or the cutter compression spring (OUT405), see the wear parts cutter replacement section.

8. Wear Part Replacement Illustrations

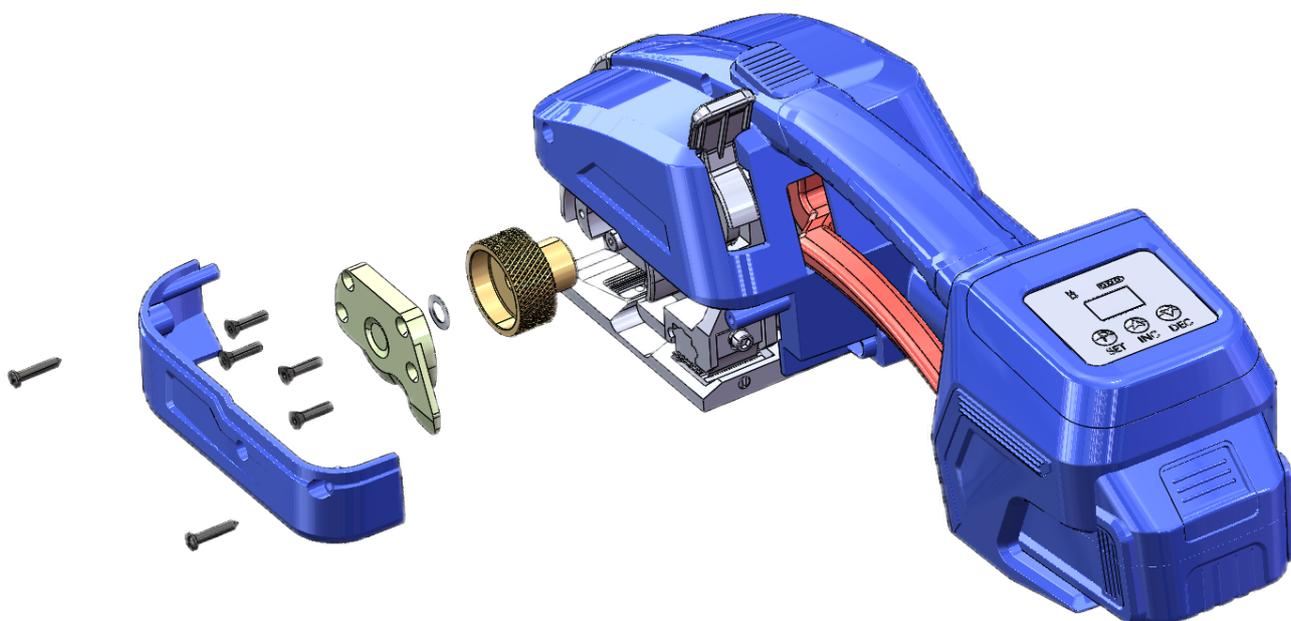
Replacement of the Cutter Blade and Lower Friction Plate :



Replacement of the Lower Tension Plate:
(It is recommended to remove the tension wheel before replacing)



Replacement of the Tension Wheel:



9. Spare Parts Inquiry Table

Material Code	Drawing Number	Name	Ratio
31607001	AIBA01	Main Frame	1
31607002	AIBA02	Disassembly Cover	1
31607014	AIBA06	Disassembly Cover Frame	1
31607015	AIBA07	Disassembly Cover Screw	4
31505001	AXLE08	Bearing 619-8	1
31607003	BB6003	Tension Wheel	1
31611203	OUT203	Side Spacer for Tension Wheel	1
31607004	BB6004	Lower Tension Plate	1
31607022	OUT503	Lower Tension Plate Screw	1
31607005	OUT201	Twist Rod Spacer 10	1
31607016	OUT205	Twist Rod Spacer 8	1
31607006	OUT101	Twist Rod Sleeve	1
31607007	OUT301	Twist Rod Nut	1
31607008	OUT307	Twist Rod Shaft Circlip M9	1
31607009	PIN001	Pull Pin	1
31607010	PIN002	Auxiliary Rod	1
31607017	PIN008	Auxiliary Rod Circlip	1
31607011	OUT401	Tension Spring	1
31607012	BB5000	Handle	1
31607018	BB5001	Handle Limit Pin	1
31607013	OUT402	Button Spring	1
31607019	OUT103	M2 Screw (Welding Switch)	2
31607020	OUT104	M2 Screw (Handle Switch)	2
31607021	OUT105	M2 Nut	4
31607100	AIBA03	Gearbox Housing	1
31607101	AIBA04	Side Cover	1
31607102	AIBA05	Shaft Cap	1
31607103	GEAR01	Motor Gear	1
31607104	GEAR02	Intermediate Drive Gear	1
31607105	GEAR03	Gear 12	1
31607106	GEAR04	Worm Gear	1
31607107	GEAR05	Worm	1
31607108	GEAR06	Output Shaft Gear	1
31607109	AXLE01	Bearing MR105	2
31607110	AXLE02	Bearing 619-7	1
31607122	AXLE05	Bearing 607	1

31607111	AXLE03	Bearing 618-8	1
31607112	AXLE04	Bearing 61900	1
31607113	BB1001	Twist Rod	1
31607114	OUT304	6mm Shaft Circlip for Worm	1
31607115	OUT305	Threaded Limit Sleeve	1
31607116	STAN03	4mm Steel Ball	1
31607117	STAN04	4mm Screw (Gearbox)	6
31607117	STAN06	4mm Screw (Short Gearbox)	1
31607118	STAN05	4mm Motor Screw	2
31607119	OTHE01	O-Ring	0or1
31607120	ELEC01	Tension Motor	1
31607121	OUT502	Spring Plate	1
31712001	PIN003	Cam Block Connecting Pin	1
31712041	OUT206	Connecting Pin Circlip	1
31712002	BB2001	Lower Cam	1
31712003	PIN006	Lifting Pin	1
31712004	OUT102	Connecting Sleeve	1
31712005	BB3003	Pressure Roller	1
31712006	PIN007	Pressure Roller Pin	1
31712008	utbdv	1 Steel Wire Circlip for Pressure	1
31712009	OUT202	Pressure Sleeve Circlip Washer	1
31712010	OUT403	Pressure Sleeve Spring	1
31712011	BB2003	Pressure Rod	1
31712012	BB3001	Pressure Sleeve	1
31712013	BB3002	Pressure Sleeve Sleeve	1
31712014	OUT207	Small Tension Spring Screw	2
31712015	OUT404	Small Tension Spring	1
31712016	BB2004	Bearing Link Rod	1
31712017	OUT405	Cutter Spring	1
31712018	OUT208	Cutter Screw	1
31712029	BB4003	Cutter	1
31712019	BB3004	Cutter Limit Screw Set	1
31712020	BB2005	Upper Friction Block	1
31712021	BB2006	Lower Friction Plate	1
31712022	PIN009	4mm Steel Ball (Welding)	4
31712023	OUT501	de 12.9 Lower Friction Plate Sc	1
31712024	BB2002	Reciprocating Link Rod	1
31712025	PIN004	Reciprocating Link Rod Pin	1

31712026	OUT306	Reciprocating Link Rod Circlip	1
31712027	PIN005	Bearing Link Rod Pin	1
31712045	OUT504	Link Rod Fixing Screw	1
31711204	OUT204	Bearing Link Rod Side Spacer/Circ	2
31712030	AXLE06	Bearing 61900 (Welding)	2
31712031	BB2007	Crankshaft	1
31712032	AXLE07	Bearing 606	2
31712033	BB4001	Crankshaft Spacer	2
31712034	BB4002	Coupling	1
31712035	BB4004	Quick Adapter	1
31712036	ELEC02	Welding Motor	1
31712037	OUT308	Motor Adapter Block Screw	2
31712038	ELEC03	Inductive Switch SS5HGL	3
31712040	BB6001	Wear-Resistant Chassis	1
31712042	BB6002	Front Plate	1
31712043	PIN010	Front Plate Torsion Spring	1
31712044	PIN011	Front Plate Pin	1
31801001	PLA001	Plastic Left Outer Shell	1
31801020	PLA003	Plastic Left and Right Shell	1
31801021	PLA004	Plastic Protective Cover	1
31801022	PLA005	Plastic Display Cover	1
31801023	PLA006	Plastic Button Cover	1
31801024	PLA007	Plastic Lower Press Wrench Cov	1
31801002	ELEC04	Battery Pack	1 or 2
31801003	ELEC05	Circuit Board	1
31801025	ELEC09	Circuit Board (Display)	1
31801004	PLA002	Panel PVC Film	1
31801005	OUT505	Plastic Press Screw	1
31801006	ELEC08	Battery Socket	1
31801007	SCR001	Self-Tapping Screw	11
31801017	SCR002	Self-Tapping Screw (Long)	1
31801018	SCR003	4mm Hex Outer Shell Screw	3
31801012	ELEC06	Charger	1
31801030	/	Tool Kit	1
31801013	/	Packing Box	1
31801015	/	Instruction Manual	1
31801016	/	Warranty Card	1

10.Product Exploded View

10.1Shell, Buttons, Circuitry, Battery Section

