

OPERATION, PARTS AND SAFETY MANUAL

SIGNODE[®]

RCNS-250

PNEUMATIC SEALER

IMPORTANT!
DO NOT DESTROY

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

READ ALL INSTRUCTIONS BEFORE OPERATING THIS SIGNODE PRODUCT



SAFETY INSTRUCTIONS

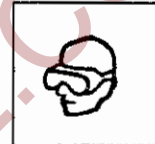
READ THESE INSTRUCTIONS CAREFULLY.

FAILURE TO FOLLOW THESE INSTRUCTIONS CAN RESULT IN SEVERE PERSONAL INJURY.

GENERAL SAFETY CONSIDERATIONS

1. EYE INJURY HAZARD.

Failure to wear safety glasses with side shields can result in severe eye injury or blindness. Always wear safety glasses with side shields which conform to ANSI Standard Z87.1.



2. STRAP BREAKAGE HAZARD.

Improper operation of the tool or sharp corners on the load can result in strap breakage during tensioning, which could result in the following:

- A sudden loss of balance causing you to fall.
- Both tool and strap flying violently towards your face.

Failure to place the strap properly around the load or an unstable or shifted load could result in a sudden loss of strap tension during tensioning. This could result in a sudden loss of balance causing you to fall.

Read the tools operating instructions. If the load corners are sharp use edge protectors. Place the strap correctly around a properly positioned load.

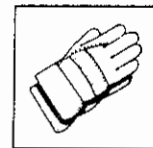
- Positioning yourself in-line with the strap, during tensioning and sealing, can result in severe personal injury from flying strap or tool. When tensioning or sealing, position yourself to one side of the strap and keep all bystanders away.
- Using strap not recommended for this tool can result in strap breakage during tensioning. Use the correct Signode products for your application.

3. FALL HAZARD.

Maintaining improper footing and/or balance when operating the tool can cause you to fall. Do not use the tool when you are in an awkward position.

4. CUT HAZARD.

Handling strap or sharp parts could result in cut hands or fingers. Wear protective gloves.



5. TRAINING.

This tool must not be used by persons not properly trained in its use. Be certain that you receive proper training from your employer. If you have any questions contact your Signode Representative.

6. TOOL CARE.

Take good care of the tool. Inspect and clean it daily, lubricate it weekly and adjust when necessary. Replace any worn or broken parts.

7. WORK AREA.

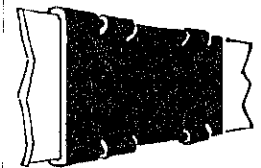
Keep work areas uncluttered and well lighted.

Several combinations of strap, seals and tools can be used with this tool. Use the correct Signode products for your application. If you need help contact your Signode Representative.

SAFETY PROCEDURES FOR TOOL OPERATION

1. Before using this tool, read these operating and safety instructions.

- Do not exceed the operating air pressure of 110 psi.
- Use Signode's approved filter-regulator-lubricator unit (P-173111).
- Never operate a pneumatic tool with a bottled air or gas source.
- For tension adjustments, follow instructions in this manual. For all other adjustments, repairs or cleaning of the tool, disconnect air supply.
- This tool is a single reverse notch type sealer. It must be operated twice to produce two sets of notches. A properly made joint will appear as shown in the illustration. If the joint does not appear as shown, then the operator must proceed as follows:
 - A. Insure that the tool's operating instructions are being followed before applying another strap.
 - B. Cut the strap off and apply another.



TYPICAL SEAL WITH TWO SETS OF NOTCHES.

If the joint still does not appear as shown, then inspect the tool for worn and/or damaged parts. Replace tool parts as needed. **NEVER HANDLE OR SHIP ANY LOAD WITH IMPROPERLY NOTCHED SEALS.** Misnotched seals may not secure the load and could cause serious injury. Some applications may require more than one notch of the seal.

- Tuck strap end back into the dispenser when not in use.

CUTTING TENSIONED STRAP

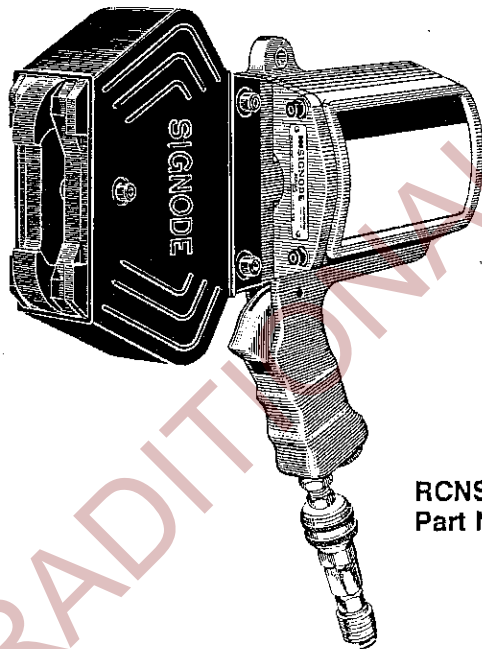
Use only cutters designed for cutting strap; never use claw hammers, crowbars, chisels, axes or similar tools. Such tools will cause the strap to fly apart with hazardous force. Before using any Signode product read its Operation and Safety Manual.

Safety instructions in Spanish are available from your Signode Sales Representative.

Su vendedor Signode le puede proporcionar los instructivos de seguridad en español.

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RCNS-250
Part No. 046840

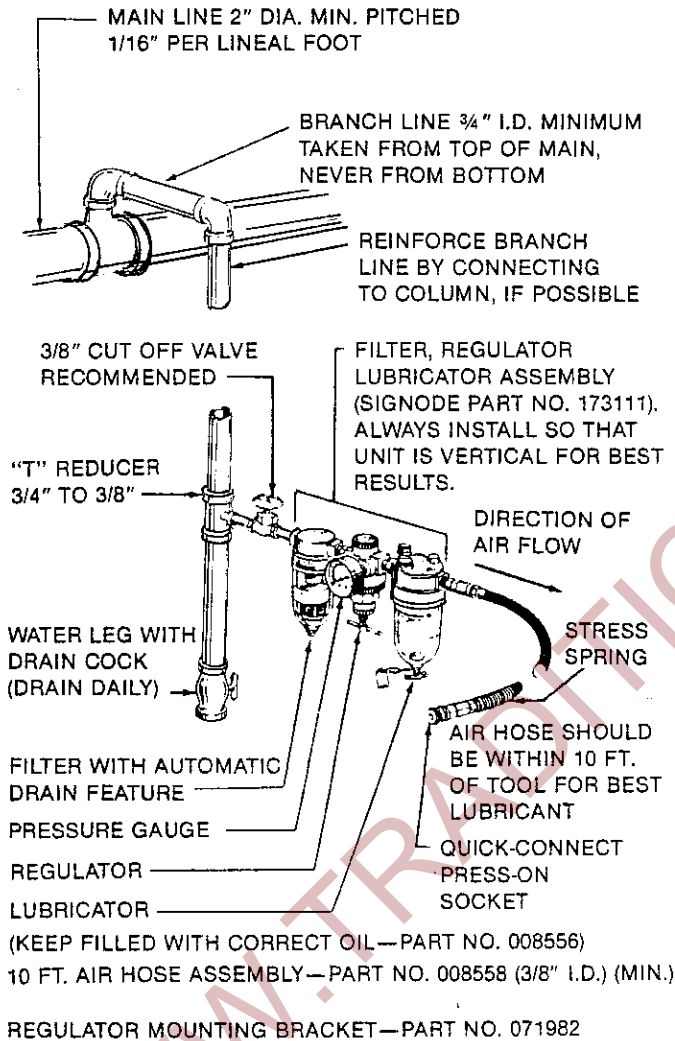
SPECIFICATIONS

STRAP				
MODEL	TYPE	WIDTH	THICKNESS	SEALS
RCNS-250	Magnus	2"	.044 to .050	203 & 208

AIR LINE PIPING INSTRUCTIONS

INSTALLATION

If compressor has a good dryer unit, use black pickled pipe. When a dryer unit is not installed, use galvanized or copper pipe.



To perform reliably, a pneumatic tool requires a continuous source of clean, water-free air at adequate pressure.



WARNING

Never operate this tool using a bottled air or gas source.

A filter-regulator-lubricator unit (Signode Part No. 173111) must be installed as close to the air tool as possible (preferably within 10 feet). It should be placed in a convenient location where it can easily be drained, adjusted, and filled with oil. The air hose must have at least a 3/8" I.D. A quick-connect press-on socket is installed on the stress spring end of the hose for convenient hookup to the air tool.

Filter and lubricator bowls are made of polycarbonate material. Do not install where bowls may be exposed to materials incompatible with polycarbonate. Certain oils, solvents, and chemicals or their fumes can weaken these bowls and possibly cause them to burst. Clean only with warm water.

A cut off valve placed ahead of the filter will be useful when cleaning the filter or replenishing the lubricator.

MOISTURE

Moisture is always present in air lines due to condensation within the lines as the air cools. Steps must be taken to remove this moisture and to keep it from the air tool. This is because water tends to wash away lubricants and cause corrosion, sticking and failure of internal parts.

The main line should be pitched so the far end terminates in a water leg. Branch lines are taken from the top of the main, never off the bottom. Every branch should have a water leg at its lowest point, with a drain cock which is drained daily.

If these precautions are taken and water is still present, an after cooler and a moisture separator are required between the compressor and the air receiver tank. A large air line separator can be installed in the air tool line, but precautions must be taken to insure that it will be drained daily, before the air tool is operated.

AIR LINE PIPING INSTRUCTIONS, Continued

Water in air lines is a constant threat to the proper operation of air tools. Even near freezing operating conditions, a good refrigerant type dryer is essential. A good dryer will remove 95% or more of water right at the compressor. The remaining moisture is removed at the water leg in the piping system or in the filter (Signode Part No. 173111).

NOTE: Additional information is available in the Signode publication, "Air Supply Manual" (p. 25) 186038. If you have any questions, contact your local Signode Representative.

LUBRICATION

The air tool must be properly lubricated. This is achieved by keeping the air line lubricator filled with oil and correctly adjusted. Without proper lubrication, the tool will become sticky and it may be difficult to release from the strap.

Install the lubricator as close to the air tool as possible. The arrow on the lubricator's top surface must point in the direction of air flow.

For proper operation, oil must drop through the lubricator sight glass at a rate of 4 to 10 drops per minute. Only 20% of this oil is actually delivered to the tool. The remaining oil drops back into the oil reservoir. The unit is factory set and should require no adjustment. If an adjustment is required, the adjusting screw on top of the lubricator may be turned as marked to reduce or increase the flow of oil.

The correct grade of oil must be used in the lubricator; too heavy an oil will not provide sufficient lubrication and will cause sticking and sluggish operation of the air tool.

Recommended oils are any good grade of rust and oxidation inhibiting oil with a viscosity of 80-120 S.U.S. at 100 degrees Fahrenheit. (0.15 to 0.25 cm² /sec. at 38 degrees Celsius), such as:

Non Fluid Oil Co., grade #LS-1236
Signode oil - Part No. 008556

NOTE: Some oils contain anti-wear additives which may disable the air tool. Be certain to use recommended oil.

COLD WEATHER OPERATION

If air tools do not operate satisfactorily in freezing temperatures, certain steps can correct the problem. The best system will employ:

- a. An air line dryer adjacent to the compressor.
- b. A hot box, large enough to contain the air tool, air hose and filter-regulator-lubricator. While in use the filter-regulator-lubricator should remain in the hot box. The colder the temperature, the more sluggish the oil, thus reducing lubrication to the air tool. A hot box will keep the oil and collected water thawed out. A 60 to 100 watt household light bulb in the box is sufficient. An alternative is a small industrial radiant type heater of 60 to 100 watts. When the tool is not in use, store all components in the hot box.



- c. The use of a recommended lubricant. The Signode Corporate Product Reliability and Safety Department have tested anti-freezes. None works well in air tools; the tools gum when anti-freezes are introduced and will not function properly. The best lubricant for freezing weather is SAE #5 or SAE #10, non-detergent oil, cut 1 to 1 with kerosene.

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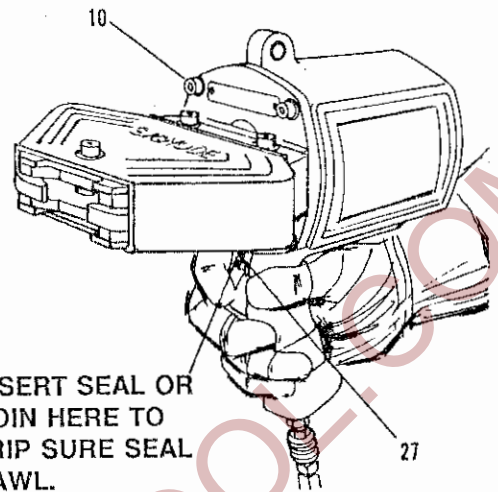
OPERATING INSTRUCTIONS

INTRODUCTION

The RCNS-250 is a single reverse notch pneumatic sealer designed for use with Signode 2" steel strap. The pistol-grip feature makes it convenient to seal with one hand.

AIR PRESSURE REQUIREMENTS

Air pressure must be maintained between 60-110 psi. Adjust the pressure regulator on the filter-regulator-lubricator unit to deliver the proper pressure.



INSERT SEAL OR COIN HERE TO TRIP SURE SEAL PAWL.



WARNING

Air line pressure must not exceed 110 psig.

SEALING OPERATION

Sealing is performed by positioning the sealing jaws over the seal in the desired notching location, then actuating the trigger located on the handle grip. When the notching action is complete, the trigger will release automatically and the sealing jaws will return to the neutral position. Remove the tool and inspect the joint to make sure the tool has formed a proper seal.

If the air pressure is too low or interference from the application prevents the sealing jaws from making a complete notch, the sure-seal pawl will prevent the sealing jaws from returning to neutral. If this occurs, the sure-seal pawl (27) must be manually released. Insert a seal or coin at the trigger, as shown in the illustration, and trip the pawl. Increase the air pressure or clear the obstruction and reseal.



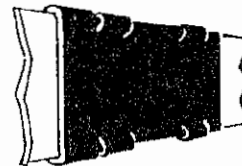
WARNING

Keep fingers and other body parts away from sealer jaws. Failure to do so could result in severe personal injury.

SEALING OPERATION

This tool is a single reverse notch type sealer to be used with the recommended seals and steel strap only. Each seal requires two sealing operations. A properly notched seal will appear as shown in the illustration. If the seal does not appear as shown, then the operator must proceed as follows:

1. Ensure that the tool's operating instructions are being followed before applying another strap.
2. Cut the strap off and apply another.



TYPICAL SEAL WITH TWO SETS OF NOTCHES.

If the seal still does not appear as shown, then inspect the tool for worn and/or damaged parts. replace tool parts as needed. **NEVER HANDLE OR SHIP ANY LOAD WITH IMPROPERLY NOTCHED SEALS.** Misnotched seals may not secure the load and could cause serious injury.

MAINTENANCE



WARNING

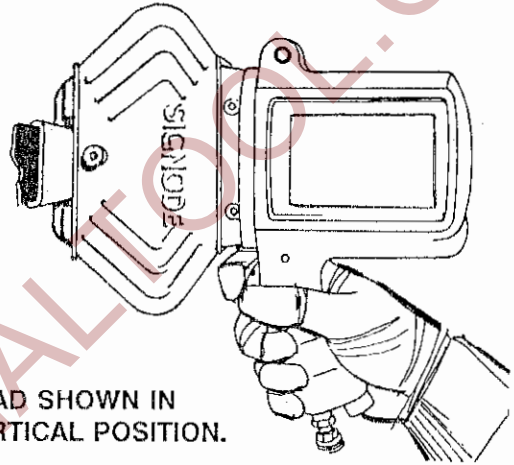
Before servicing this tool, make sure compressed air has been disconnected. Failure to do so could result in severe personal injury.

A periodic cleaning of all external moving parts and the application of a light machine oil will greatly prolong the serviceability of this tool. In applications where a lubricator is not used, daily addition of a light machine oil, added directly to the hose connection, is recommended. The sealer, if functioning properly, will not leak air when the trigger is in the OFF position or when holding the trigger firmly down in the ON position. If leakage is present, the O-ring (5) should be examined for damage or extreme wear. Remove 4 cap screws (10) and separate the head from the cylinder. Note the position of the spring (6) for proper reassembly. Remove O-ring from piston head, and replace if necessary.

Apply a high melting point grease to the groove in the piston prior to replacing the O-ring. The O-ring is purposely larger than the bore of the cylinder so care must be taken upon reassembly. Position spring, replace cap screws and test for leakage. If leakage continues to exist, check valve plug (39) and pipe bushing (31) for tightness.

HEAD ROTATION

The sealing head and the mounting plate may be turned to permit the operator to hold the tool in a vertical position while sealing a horizontal strap. To rotate the sealing head, remove the four cap screws (10) and separate the sealing head from the cylinder (41). Rotate the head 90°, reposition the sure seal spring, and replace the screws.



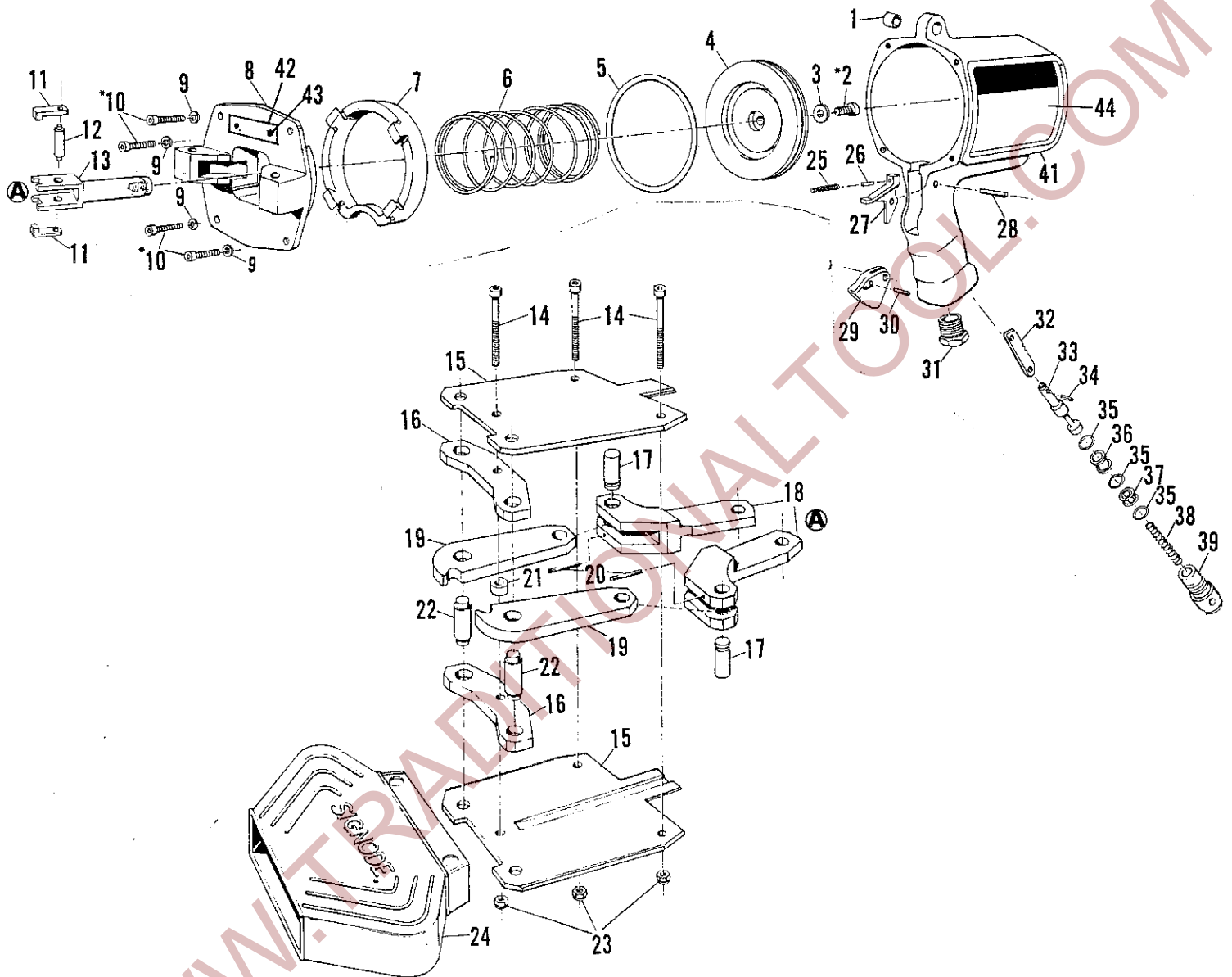
HEAD SHOWN IN VERTICAL POSITION.

PARTS LIST

<u>KEY</u>	<u>QTY.</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	1	008672	Bushing
2*	1	055606	Low head cap screw
3	1	007453	Flat washer, 3/8
4	1	046835	Piston
5	1	015627	O-ring
6	1	032371	Return spring
7	1	047639	Rubber bumper
8	1	046836	Mounting plate
9	4	002187	Split lock washer, 1/4
10	4	009042	Socket head screw, 1/4-20 x 1
11	2	015606	Ram guide
12	1	015608	Ram pin
13	1	046834	Ram
14	3	015628	Socket head screw, 5/16-24 x 1 7/8
15	2	<u>046833</u>	<u>Side plate</u>
16	2	<u>046829</u>	<u>Notcher</u>
17	2	<u>046830</u>	<u>Link pin</u>
18	2	<u>046837</u>	<u>Link</u>
19	2	<u>046828</u>	<u>Jaw</u>
20	2	005709	Roll pin, 3/32 x 11/16
21	1	046832	Spacer
22	2	046831	Jaw pin
23	3	003911	Hex locknut, 5/16-24
24	1	055927	Protecting boot
25	1	015626	Spring
26	1	014572	Roll pin, 3/32 x 1/4
27	1	015633	Pawl
28	1	012582	Dowel pin, 3/16 x 1
29	1	015632	Trigger
30	1	008837	Roll pin, 1/8 x 9/16
31	1	008478	Pipe bushing, 1/4 x 3/8
32	1	015630	Valve link
33	1	015629	Valve stem
34	1	006045	Roll pin, 1/8 x 3/8
35	3	008596	O-ring
36	1	015636	Valve sleeve, intake
37	1	023040	Valve sleeve, exhaust
38	1	015635	Valve return spring
39	1	015634	Valve plug
41	1	015638	Cylinder
42	1	002480	Nameplate
43	2	004939	Drive screw, #12 x 3/16 long
44	1	271199	Warning sign

* Apply one drop of Loctite #271 Sealant to cleaned parts. Allow 12 hours to set if possible.

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



! WARNING
 All parts must be periodically inspected and replaced if worn or broken. Failure to do this can affect a tool's operation and present a safety hazard.