

**OPERATION, PARTS  
AND SAFETY MANUAL**

**SIGNODE®**

**VXL-2000-Z and VXM-2000-Z**

**TENSION-WELD®  
STRAPPING TOOLS**

**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**

# PARTS LIST, AIR MOTOR 20R38V

Part No. 273830

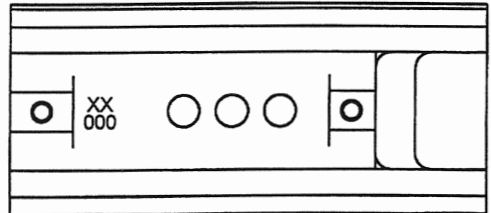
KEY	QTY	PART #	DESCRIPTION	KEY	QTY	PART #	DESCRIPTION
1	1	020704	Quik disconnect plug	22	1	023552	Ball bearing
2	1	024631	Filter assembly	23	2	024607	Idler assembly
3	2	273822	Fitting	24	1	024621	Cage
4	1	024688	Truarc, #N5000-45	25	2	023555	Pin
5	1	024686	Valve sleeve	26	1	024601	Retainer
6	1	091624	O-ring	27	1	024608	Ring gear
7	1	024685	Valve stem	28	1	023551	Seal
8	1	020728	O-ring	29	1	023556	Pin
9	1	024683	Valve spring	30	1	024682	Gear housing
10	1	004658	Roll pin 1/8 x 13/16	31	1	274435	Cover
11	1	273888	Motor housing	32	3	013625	SHCS, 8-32 x 1/2
13	1	024633	Ball bearing	34	1	023446	O-ring
14	1	024643	Back end plate	36	1	422086	Valve housing assy
15	1	024623	Cylinder	37	2	274438	BHCS, 8-32 x 1/4
16	1	024687	Align pin	38	1	422312	Motor control lever
17	5	024612	Vane	39	2	273821	Tubing
18	1	024625	Rotor	41	1	280522	Information tag
19	1	024602	Spacer				
20	1	024622	Front end plate				
21	2	023481	Ball bearing				

- When ordering parts, please show Air Motor number and description.
- Standard hardware parts may be obtained from any local hardware supply.
- Wearing parts are usually limited to those underlined and should be stocked.

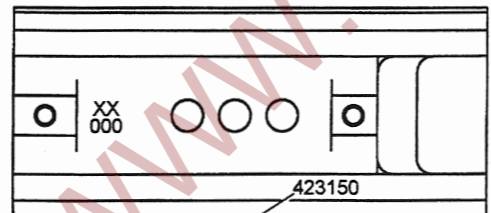
### VXL/VXM AIR MOTOR IDENTIFICATION

There are two air motors (20R38V or N20R38V) available to VXL/VXM tools. Use the information below to determine the correct air motor for your tool before ordering any replacement parts. Air motor 20R38V can be identified by the absence of a part number engraved or stamped on the underside of the motor housing. Air motor N20R38V can be identified by the presence of the part number (423150) engraved or stamped on the underside of the motor housing.

20R38V (P/N 273830)



N20R38V (P/N 423150)



PART NUMBER

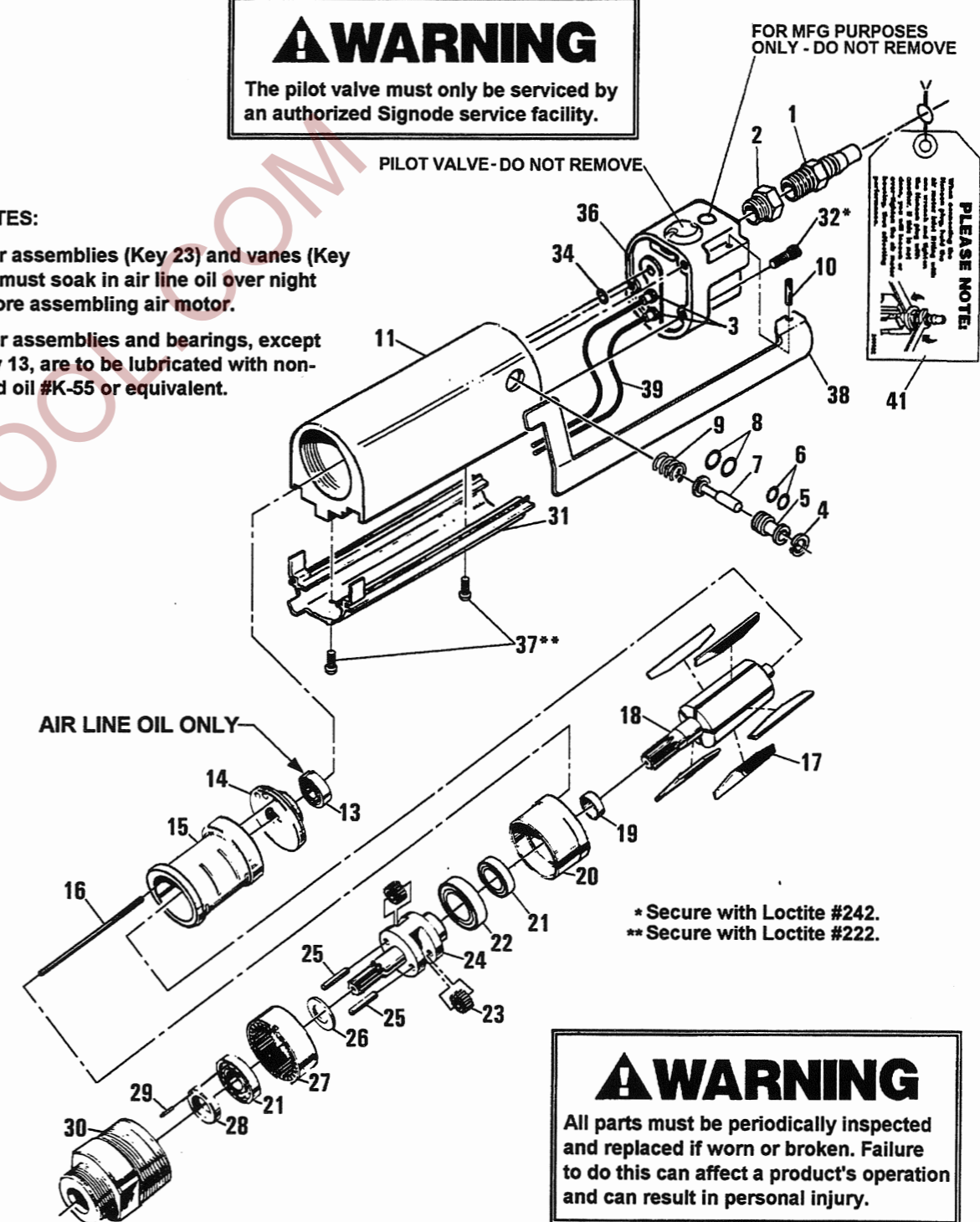
**WARNING**

The pilot valve must only be serviced by an authorized Signode service facility.

**NOTES:**

Idler assemblies (Key 23) and vanes (Key 17) must soak in air line oil over night before assembling air motor.

Idler assemblies and bearings, except Key 13, are to be lubricated with non-fluid oil #K-55 or equivalent.



PARTS LIST, TOOL

KEY	QTY	PART #	DESCRIPTION	KEY	QTY	PART #	DESCRIPTION
3	2	023540	Lock plug	51	1	422110	Pin, pivot
4	3	020694	Set screw	52	1	422121	Upper gripper "Z"
5	1	273881	End cap	53	1	273820	Flow control
6	1	023096	O-ring	54	2	274442	Fitting
7	1	023097	Bearing, Faf. #9101K	56	1	273819	3-way valve
8	1	023082	O-ring	58	1	273827	Oil seal
9	1	023014	Spacer	60	1	422549	Weld handle
10	1	014567	Gear, VXL	61	1	422575	Knob
	1	023002	Gear, VXM	64	1	273815	Bushing
11	1	008734	Bearing, Faf. #B-542	65	1	273816	Bushing
12	1	008552	Oil seal	66	1	273823	Pressure Eccentric
14	1	306842	Handle	68	1	007631	Roll pin, 1/8 X 5/8
15	2	023093	Key, Woodruff 213 alloy steel	69	1	023446	O-ring
				70	1	286392	Warning sign
16	1	306863	Tensioner foot	71	1	286349	Nameplate, VXL-Z
17	1	274104	Gripper plug		1	286350	Nameplate, VXM-Z
18	1	274105	Strap guide, (1/2")	72	1	273854	Gear housing
	1	014565	Strap guide, (7/16")	73	1	023963	Brush, not shown
19	1	004860	FHSCS, 10-32 x 3/8	74	1	273814	Pivot pin, cutter
20	1	008624	Roll pin, 1/8 x 1/4	75	2	016342	SHCS, 1/4-20 x 1 1/2
21	1	014515	Feedwheel shaft	76	4	009041	SHCS, 1/4-20 x 3/4
22	1	014518	Feedwheel	78	1	273808	Lower gripper "Z"
23	1	306806	Spring torsion	79	1	273824	Needle bearing
24	1	273847	Weld housing	80	2	273825	Needle bearing
25	1	274068	Support pin	81	1	273828	Shim
26	1	273861	Eccentric shaft	82	1	422571	Disk
27	1	273859	Idle Gear	83	1	261385	Wear pin
27A	1	422913	Gear/Bearing assy	84	1	045203	Compression spring, LEE #LC-020 A-5
28	1	014566	Spiroid worm, VXL	85	1	273838	Stripper pin
	1	014517	Spiroid worm, VXM	86	1	273834	Spacer
29	1	014530	Needle bearing, Torrington #B-47	87	1	306545	Slotted screw, 4-40 x 3/16
30	1	014522	Pin	88	2	306847	Adjustment screw
31	1	014527	Bearing, Fafnir #7202W	92	1	008746	SHCS, 1/4-20 x 3/8
32	1	014556	Washer	94	1	286373	3-Icon info. sign
33	2	014549	Brake spring	95	1	433392	Information tag
34	1	306839	Brake				
35	1	273886	Spacer sleeve				
36	1	014542	Clutch spring				
37	1	306865	Clutch				
38	1	014529	Bearing needle, Torrington #B-68				
39	1	161156	Drive gear				
39A	1	161157	Gear/Bearing assy				
40	1	014528	Bearing				
41	1	273852	Motor mount				
42	1	422301	Locking ring				
43	1	273883	Compression plate				
44	1	273858	Contact stem				
45	1	273812	Die spring				
46	1	422111	Cutter blade				
47	1	306869	Pin				
48	1	422122	Slider link				
49	1	273850	Lift tab				
50	1	273842	Pin				

NOTES:

- Keys 27 and 80 comprise assembly 27A.
- Keys 38 and 39 comprise assembly 39A.
- When ordering parts, please show tool model, part number and description.
- Standard hardware parts may be obtained from any local hardware supply.
- Wearing parts are usually limited to those underlined and should be stocked.

**WARNING**  
All parts must be periodically inspected and replaced if worn or broken. Failure to do this can affect a product's operation and can result in personal injury.

**KEY 42**  
ALTERNATE STYLE LOCKING RING

