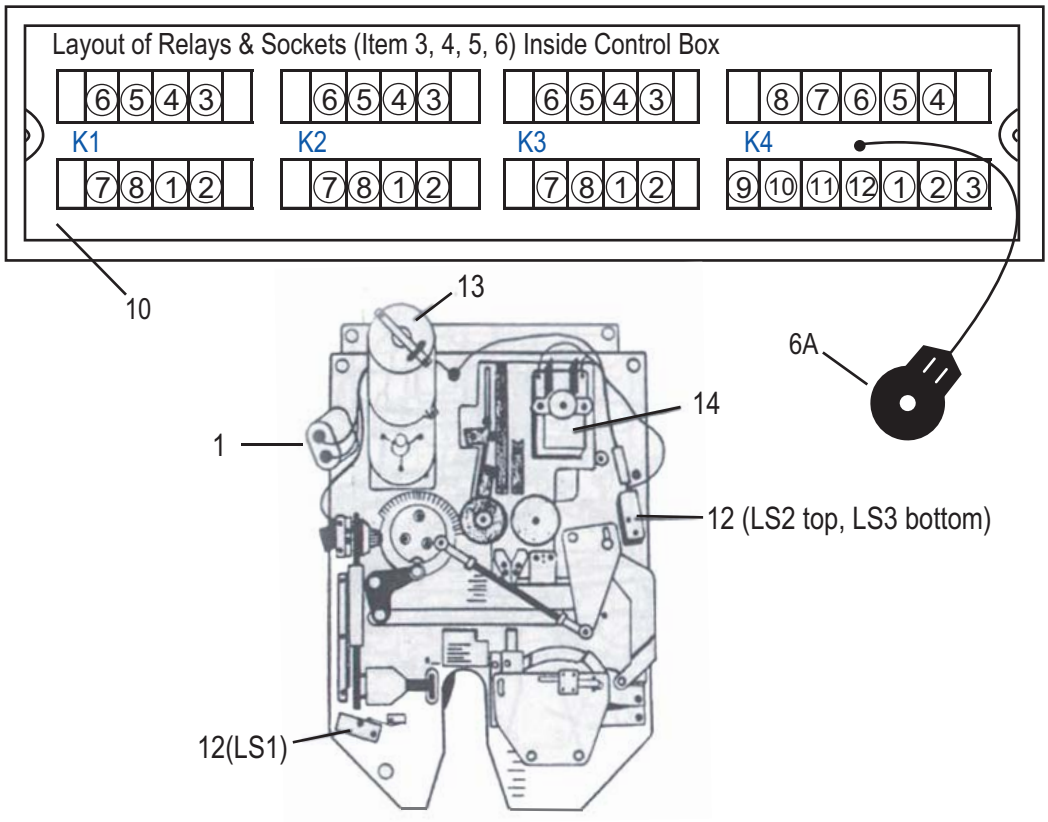
INDEX #	PART #	DESCRIPTION	QTY
1	506341	Capacitor	1
	56913	Capacitor Cover *	1
	16932	Capacitor Clamp *	1
2	505B222	Track, Mounting*	1
3	56933	Socket, Relay #RS-8	3
4	56922	Relay (115V) GV-DPDT-115A (K1, K2, K3)	3
	56822	Relay Clips *	1
5	506340	Socket, Timer	1
6	505B132	Relay, Time Delay (115V)	1
	56403	Strain Relief *	1
6A	Part of 6	Potentiometer for Time Delay Relay (R1)	1
	56905	Knob #409-D2-K1 *	1
7	56908	Fuse holder #342028 *	1
	56909	Fuse (115V) AGC-5 * (F1)	1
	16912	A.C. Cord *	1
9	56924	On/Off Switch and Lamp (S1 and L1) *	1
	56970	Optional Food Activated Switch *	1
10	505D142	Control Box Chassis	1
	505C190	Cover, Back *	1
	505C225	Cover, Front *	1
11	16953	Circuit Breaker 1.5 Amp * (CB1)	1
12	16907	Microswitch (LS1, LS2, LS3, LS4)	1
13	56926	Main Motor (M1)	1
	505B172	Main Motor Sprocket	1
	56928	Transformer #GSD-350(230V) Options	2
14	505C027-1	Ribbon Feed Motor (m2)	1
	505B158	Sprocket Ribbon Feed Wheel	1
	505B228	Sprocket	1

* Denotes not shown. LS4 is located on left side of enclosure, in front& under enclosure lid.



PLAS-TIES XL-2 Electrical System Schematic & Functions

Schematic illustrates condition of all switches when the XL2 is at rest (in between tying cycles) with cover closed (LS4) closed).

When the product to be tied is inserted into the tying area, Trigger Switch (LS1) closes and activates the main motor and cam. As the main motor and cam begin to turn, the cam closes top and bottom cam switches (LS2 & LS3) activating relasy (K2 & K4).

Then, when the main motor and cam finish one complete rotation, the cam switches are re-opened causing three effects:

1. Relays (K1 & K3) are activated, disabling the main motor and cam.
2. Timing relay (k4) begin its delay cycle.
3. The ribbon feed motor begins to turn.

When timing relay (K4) times out (depending on the setting of the “Tying Adjustment Dial”), all relays deactivate, the ribbon feed motor shuts off, and the unit is once again at rest.