

OPERATION, PARTS AND SAFETY MANUAL



SIGNODE®

B-250

MANUAL SEALER

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



SAFETY INSTRUCTIONS

READ THESE INSTRUCTIONS CAREFULLY.

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

GENERAL SAFETY CONSIDERATIONS

1. 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 tool's 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.

2. 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.

3. 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 or EN 166.



4. 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.

5. CUT HAZARD.

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



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.

Use the correct Signode products for your application. If you need help contact your Signode Representative.

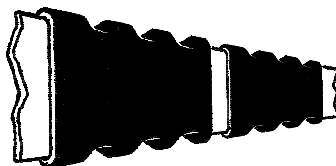
Signode tools and machines are designed and warranted to work together with Signode strapping and seals. Use of non-Signode strap, seals and/or manufactured or specified replacement parts may result in strap breakage or joint separation while applying strapping to a load or during normal shipping and handling. This could result in severe personal injury.

SAFETY PROCEDURES FOR TOOL OPERATION

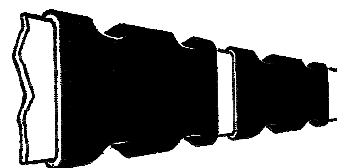
1. **OPERATION SEQUENCE.**
Before using this tool, read its Operation and Safety Instructions contained in this manual.

2. This tool is a single crimp type sealer that requires two (2) seals with two (2) or three (3) sealing operations for each joint depending on the seal type being used. Properly crimped seals will appear as shown in the illustration. If the crimped seals do not appear as shown, then the operator must proceed as follows:

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



(203 SEALS)



(208-DG SEALS)

If the crimped seals still do not appear as shown, then inspect the tool for worn and/or damaged parts. Replace tool parts as needed. **BEFORE MOVING ANY PACKAGE BE CERTAIN THAT THE SEALS ARE PROPERLY CRIMPED AS SHOWN.** Miscrimped joints may not secure the load and could cause serious injury.

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

CUTTING TENSIONED STRAP

FLYING STRAP HAZARD.

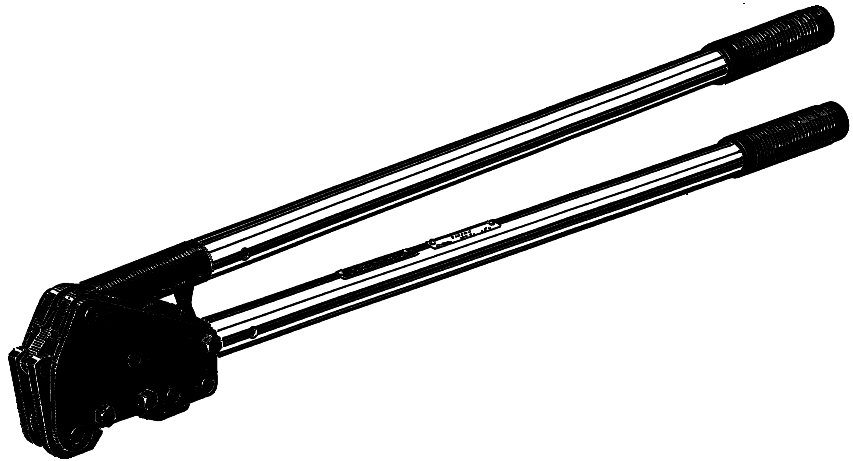
Using claw hammers, crowbars, chisels, axes or similar tools will cause tensioned strap to fly apart with hazardous force. Use only cutters designed for cutting strap. Read the instructions in the cutters manual for proper procedure in cutting strap. Before using any Signode product read its Operation and Safety Manual.

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Signode tools and machines are designed and warranted to work together with Signode strapping and seals. Use of non-Signode strap, seals and/or manufactured or specified replacement parts may result in strap breakage or joint separation while applying strapping to a load or during normal shipping and handling. This could result in severe personal injury.

B-250
Part No. 020530



TOOL SPECIFICATIONS

MODEL	STRAP			SEALS (2 SEALS PER JOINT)
	TYPE	WIDTH	THICKNESS	
B-250	Magnus	2" (51mm)	.044" to .050" (1.01mm to 1.27mm)	203 (3 Crimps) 208-DG (2 Crimps)

TOOL MAINTENANCE

1. Clean the tool and apply light machine oil to all moving parts on a weekly basis.
2. Inspect the tool before each use for worn or broken parts. Replace parts if necessary.

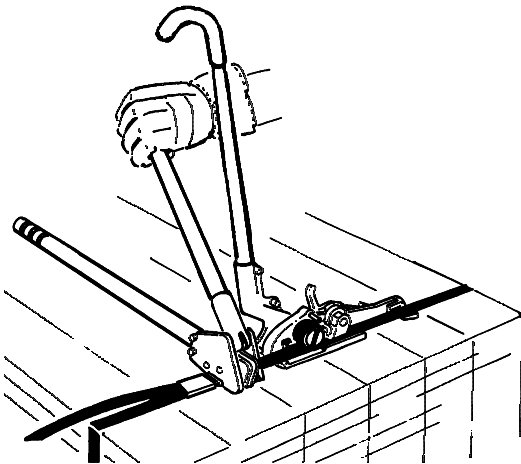
OPERATING INSTRUCTIONS FOR USE WITH 208-DG SEALS

⚠ WARNING

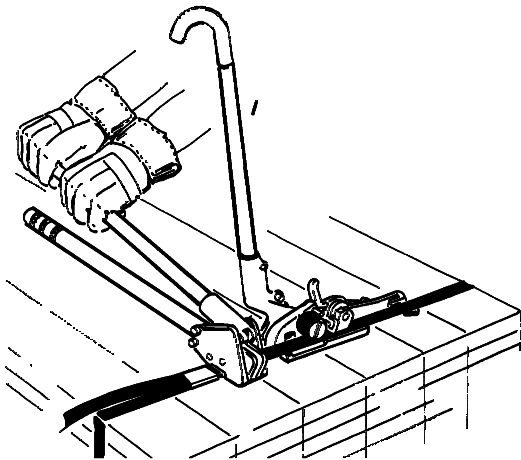
Wear safety glasses which conform to ANSI Standard Z87.1 or EN 166. Stand to one side of the tensioned strap while sealing. Maintain proper footing and balance. Make sure all bystanders are clear before proceeding.

When using a 208-DG seal, two crimping operations are required for each seal.

1. Thread two (2) seals onto the strap.
2. Fully open sealer handles and place the open jaws to one end of the first seal.



3. Bring sealer handles completely together to assure a proper crimp.

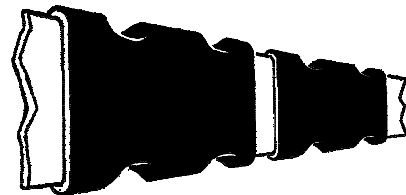


place the sealer on the opposite end of the seal and bring the handles completely together.

5. Repeat steps 2 and 3 for the second seal.
6. Inspect strap joint for proper formation, see Joint Inspection. Cut the strap off by bending the strap back and forth until it breaks off flush with the seal.
7. To avoid contact with sharp end of strap, retract strap end back into strap dispenser.

JOINT INSPECTION, 208-DG SEAL

This tool is a single crimp type sealer that requires two (2) seals and two (2) sealing operations for each seal. Properly crimped seals will appear as shown in the illustration. If the crimped seals do not appear as shown, then the operator must proceed as follows:



- A. E (208-DG SEALS)
nsure that the tool's operating instructions are being followed before applying another strap.
- B. Cut the strap off and apply another.

If the crimped seals still do not appear as shown, then inspect the tool for worn and/or damaged parts. Replace tool parts as needed. **BEFORE MOVING ANY PACKAGE BE CERTAIN THAT THE SEALS ARE PROPERLY CRIMPED AS SHOWN.** Miscrimped joints may not secure the load and could cause serious injury.

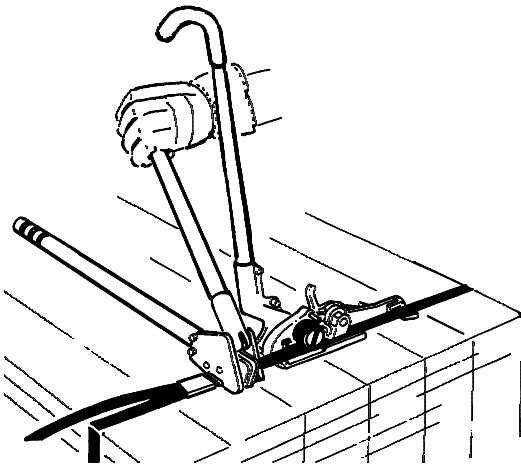
OPERATING INSTRUCTIONS FOR USE WITH 203 SEALS

⚠ WARNING

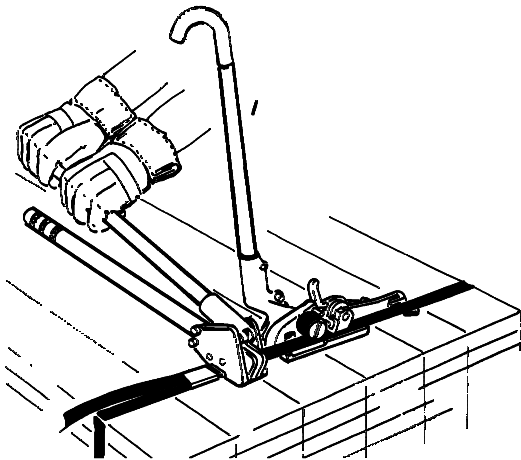
Wear safety glasses which conform to ANSI Standard Z87.1 or EN 166. Stand to one side of the tensioned strap while sealing. Maintain proper footing and balance. Make sure all bystanders are clear before proceeding.

When using a 203 seal, three crimping operations are required for each seal.

1. Thread two (2) seals onto the strap.
2. Fully open sealer handles and place the open jaws to one end of the first seal.



3. Bring sealer handles completely together to assure a proper crimp.

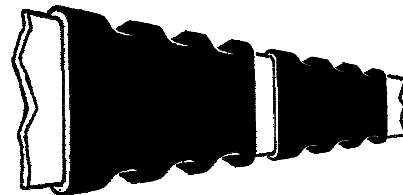


Crimp the seal in the center then again at the opposite end.

5. Repeat steps 2 and 3 for the second seal.
6. Inspect strap joint for proper formation, see Joint Inspection. Cut the strap off by bending the strap back and forth until it breaks off flush with the seal.
7. To avoid contact with sharp end of strap, retract strap end back into strap dispenser.

JOINT INSPECTION, 203 SEAL

This tool is a single crimp type sealer that requires two (2) seals and three (3) sealing operations for each seal. Properly crimped seals will appear as shown in the illustration. If the crimped seals do not appear as shown, then the operator must proceed as follows:



- A. E (203 SEALS)
nsure that the tool's operating instructions are being followed before applying another strap.
- B. Cut the strap off and apply another.

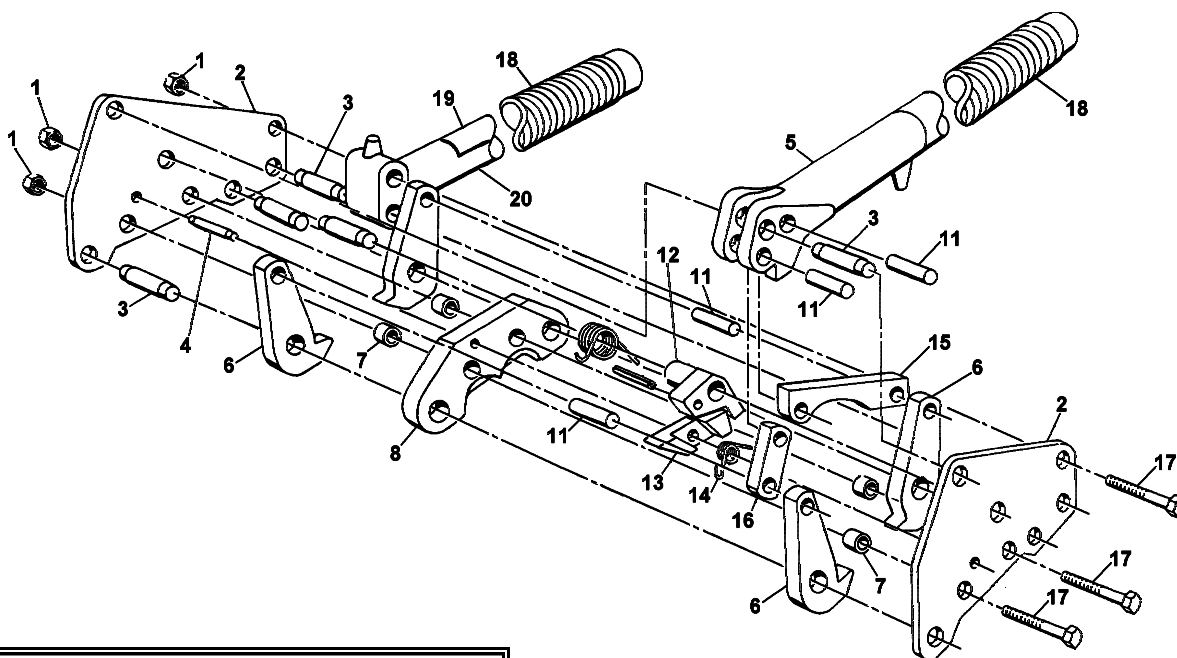
If the crimped seals still do not appear as shown, then inspect the tool for worn and/or damaged parts. Replace tool parts as needed. **BEFORE MOVING ANY PACKAGE BE CERTAIN THAT THE SEALS ARE PROPERLY CRIMPED AS SHOWN.** Miscrimped joints may not secure the load and could cause serious injury.

PARTS LIST

KEY	QTY.	PART NO.	DESCRIPTION
1	3	003868	Flexloc nut, 3/8-24
2	2	<u>020534</u>	<u>Side plate</u>
3	5	<u>020528</u>	<u>Pivot pin</u>
4	1	<u>020533</u>	<u>Holding pawl pin</u>
5	1	<u>020535</u>	<u>Upper handle assembly</u>
6	4	<u>020521</u>	<u>Jaw</u>
7	4	<u>020536</u>	<u>Spacer</u>
8	1	<u>020519</u>	<u>Crimper</u>
9	1	<u>020531</u>	<u>Pawl spring</u>
10	1	<u>006787</u>	<u>Roll pin, 3/16 x 1</u>
11	4	<u>020529</u>	<u>Link pin</u>
12	1	<u>020522</u>	<u>Holding pawl</u>
13	1	<u>020523</u>	<u>Locking pawl</u>
14	1	<u>020532</u>	<u>Lock pawl spring</u>
15	1	<u>020527</u>	<u>Long link</u>
16	1	<u>020526</u>	<u>Short link</u>
17	3	<u>020540</u>	<u>Hex head cap screw, 3/8-24</u>
18	2	<u>020578</u>	<u>Handel grip</u>
19	1	003132	Caution plate
20	1	<u>020525</u>	<u>Lower handel assembly</u>

- When ordering parts, please show tool model, part number and description.
- All recommended spare parts are underlined and should be stocked.
- Standard hardware parts may be obtained from local hardware suppliers.

NOTE: Apply Lubriplate 3000W (Signode P/N 422793) to all jaws, crimpers and pins.



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.

