

1998

# Tube-Line 5500

Parts and Service  
Manual and Automatic

## Notes

Electric Solenoid valves can be manually operated by pushing a small punch into end of spool and holding it in .

### **CAUTION STAY AWAY FROM WRAP HOOP WHEN ENGINE IS RUNNING.**

Inside Control Panel, control relays are numbered CR1 to CR6 from left to right, relay CR1 is wired to table trigger . CR1 will activate solenoid valve to extend ram cylinder . CR2 and CR3 are wired to motion sensor switch at rear roller, when switch arm is between teeth on sprocket, CR3 is energized, as roller turns switch arm it will be pushed to top of tooth on sprocket energizing CR2 and vice-versa . After both relays CR2 and CR3 are activated, wrap solenoid is energized causing wrap motor to turn . When ram cylinder is extended to the limit switch at the engine CR1,CR2 and CR3 will turn off and CR4 turns on. Wrap motor will stop and ram cylinder will retract until ram cylinder trips limit switch at front end of table . All control relays will turn off .

Testing can be done by pushing trigger plate then going to the back and turning roller with sprocket, then waiting until machine goes through the cycle . Or, you can push the small square button on end of control relay 1, then push button on control relay 2 or 3, whichever is not activated. Then waiting until machine goes through the cycle .

When running machine through the cycle and wrapper motor or the cylinders do not work, check flow control valve to see if flow is going to both motor and cylinder

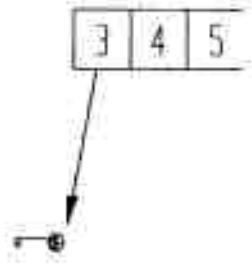
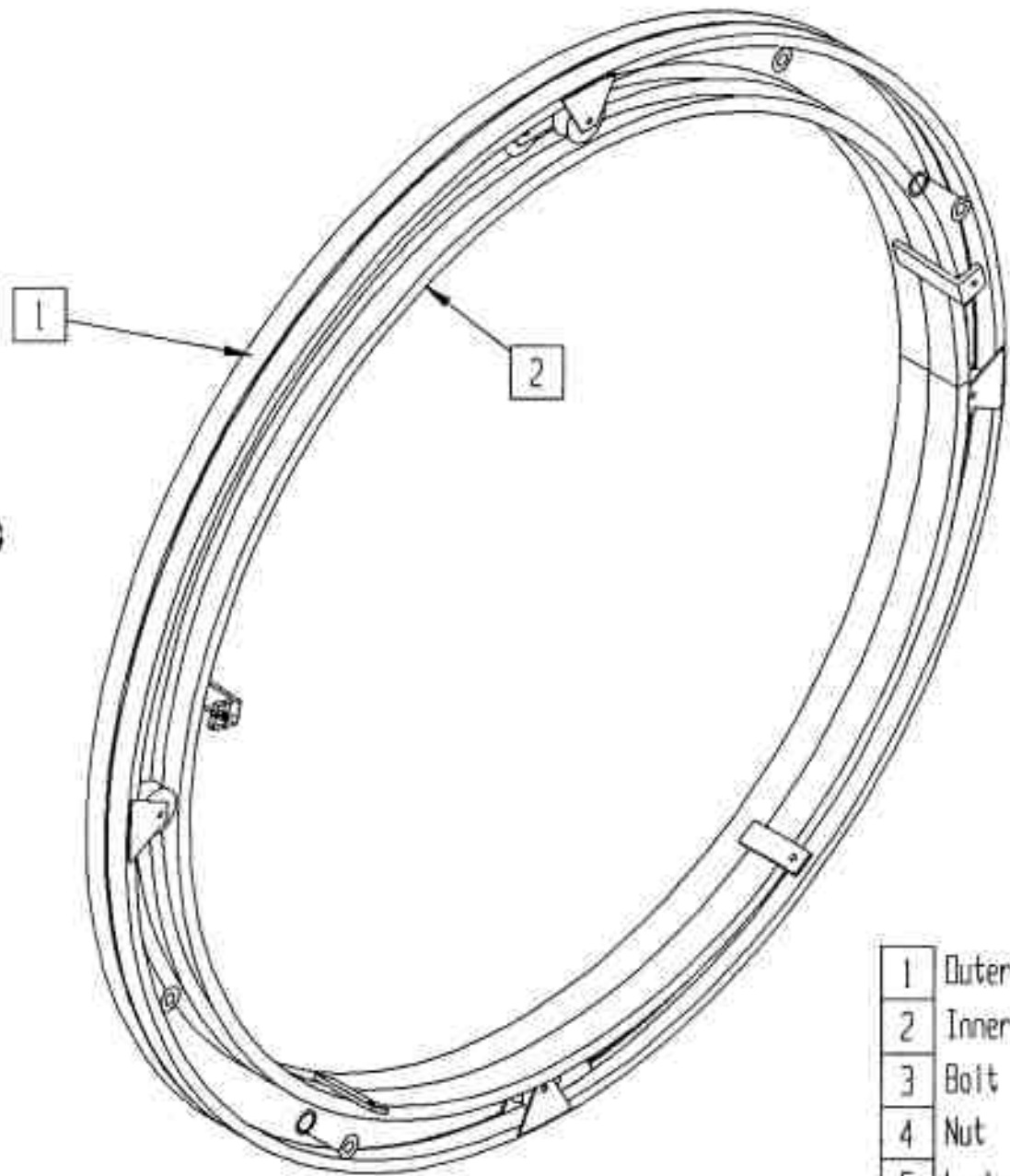
Engine is stopped by grounding ignition, in case of ignition failure make sure that stop switch wire is not shorting to frame and engine switch is not in closed position.

Steering is controlled by switch right/left on control panel through CR5 and CR6, activating coil A or B on steering solenoid valve.

Tube-Line 550  
Parts Manual  
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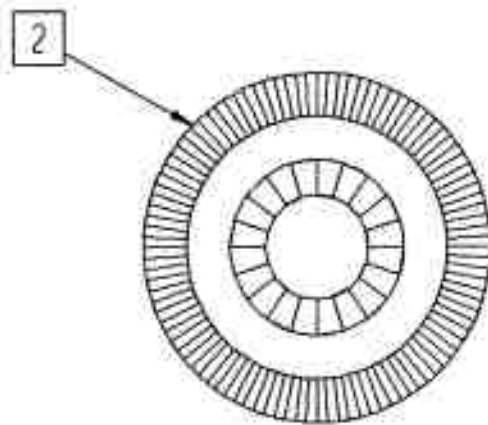
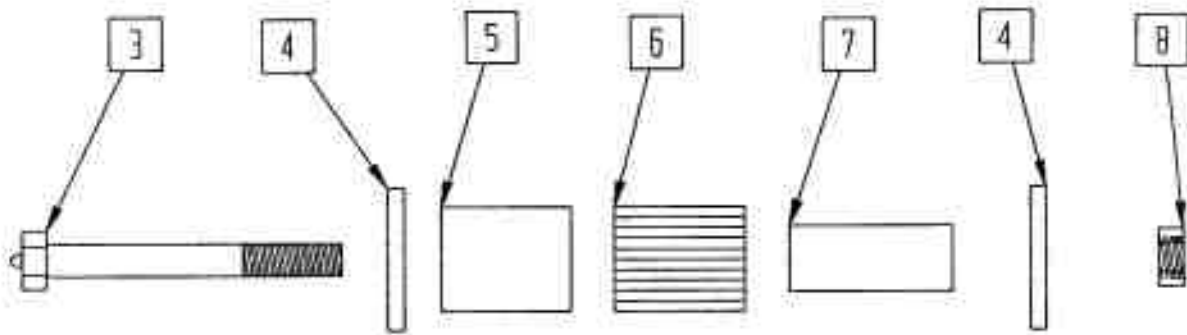
Tube-Line 550  
Hoop



- |   |            |
|---|------------|
| 1 | Outer Ring |
| 2 | Inner Ring |
| 3 | Bolt       |
| 4 | Nut        |
| 5 | Lockwasher |

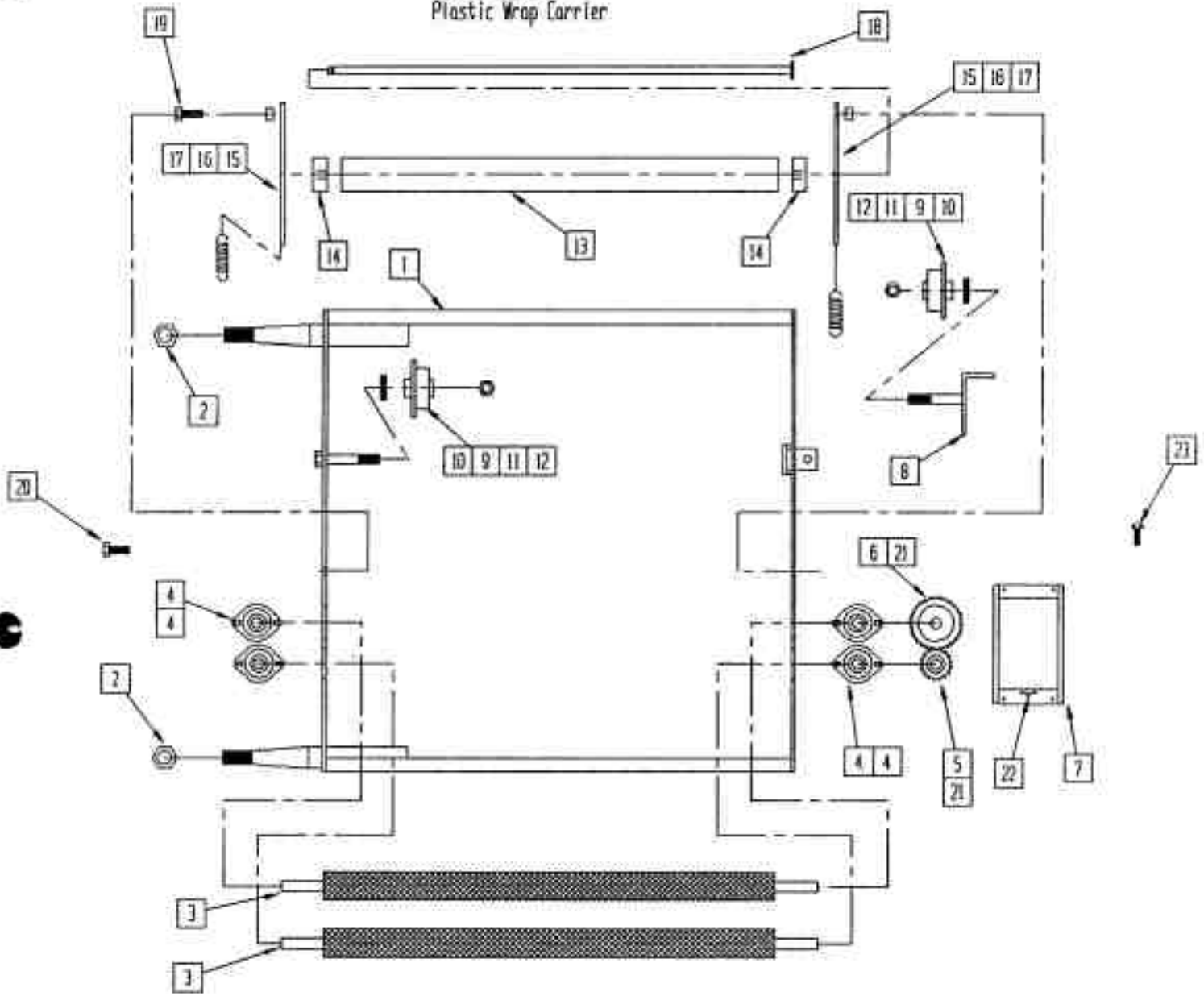
# Tube-Line 550

Hoop wheels

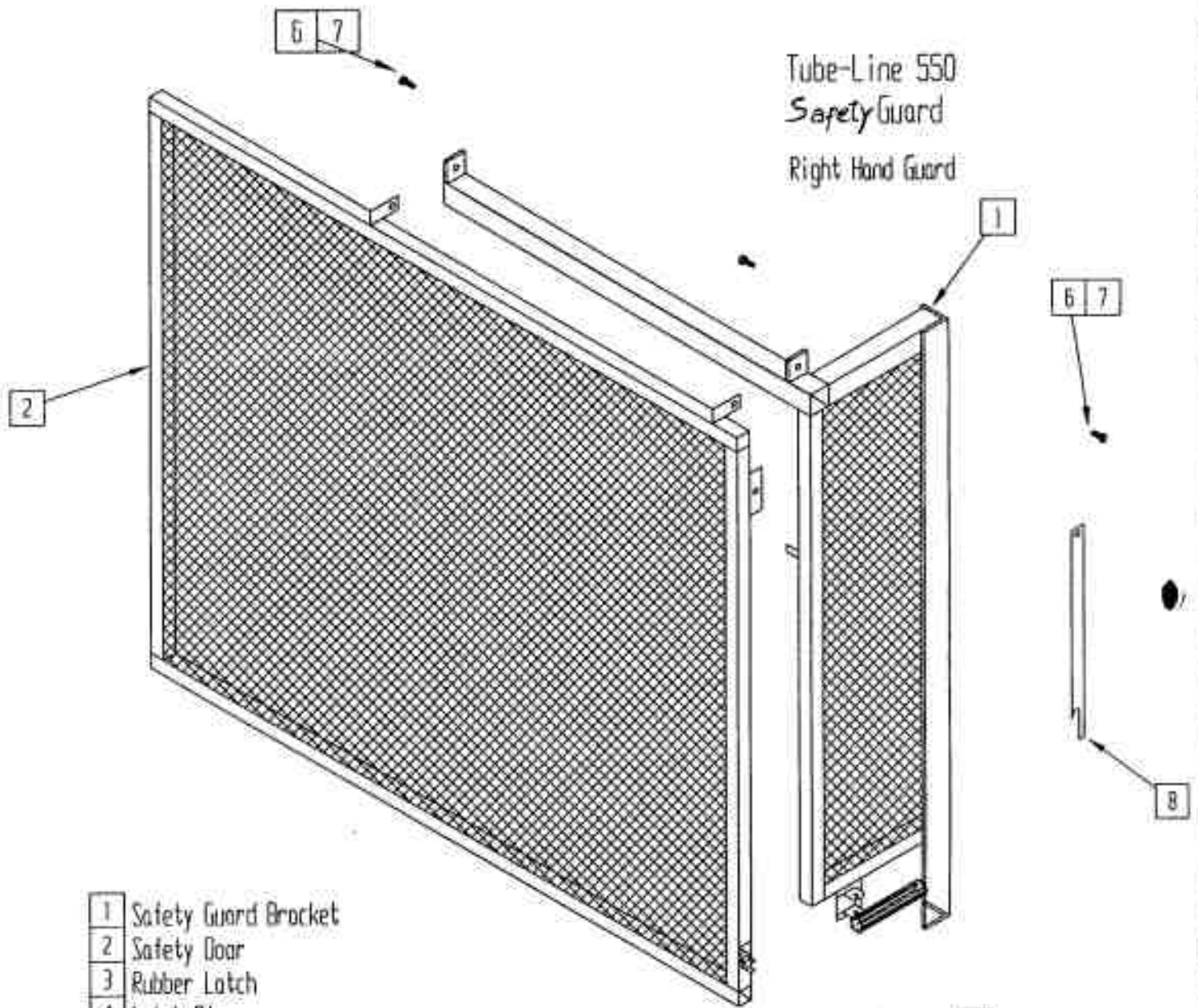


- |   |                |
|---|----------------|
| 2 | 4 in wheel     |
| 3 | axle bolt      |
| 4 | bearing seal   |
| 5 | outer race     |
| 6 | roller bearing |
| 7 | inner race     |
| 8 | locknut        |

Tube - Line 550  
Plastic Wrap Carrier

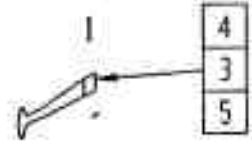


- |    |                    |    |                          |
|----|--------------------|----|--------------------------|
| 1  | Main Wrap Bracket  | 13 | ABS Pipe                 |
| 2  | 1-14 UNC Nut       | 14 | HMPC Bearing             |
| 3  | Tensioner Roller   | 15 | ABS Bracket              |
| 4  | 3/4 Bearing        | 16 | Spacer                   |
| 5  | Small Gear         | 17 | Spring                   |
| 6  | Large Gear         | 18 | ABS Axle                 |
| 7  | Gear Cover         | 19 | 1/2 x 2 Bolt             |
| 8  | Spool Holder       | 20 | 5/16 Carriage Bolt       |
| 9  | Plastic Wrap Spool | 21 | 3/16 Keystock            |
| 10 | 5/8 Flat washer    | 22 | Grease Fitting           |
| 11 | 5/8 Nylocknut      | 23 | 10-24 x 3/4 Machine Bolt |
| 12 | Oilite Bearing     |    |                          |



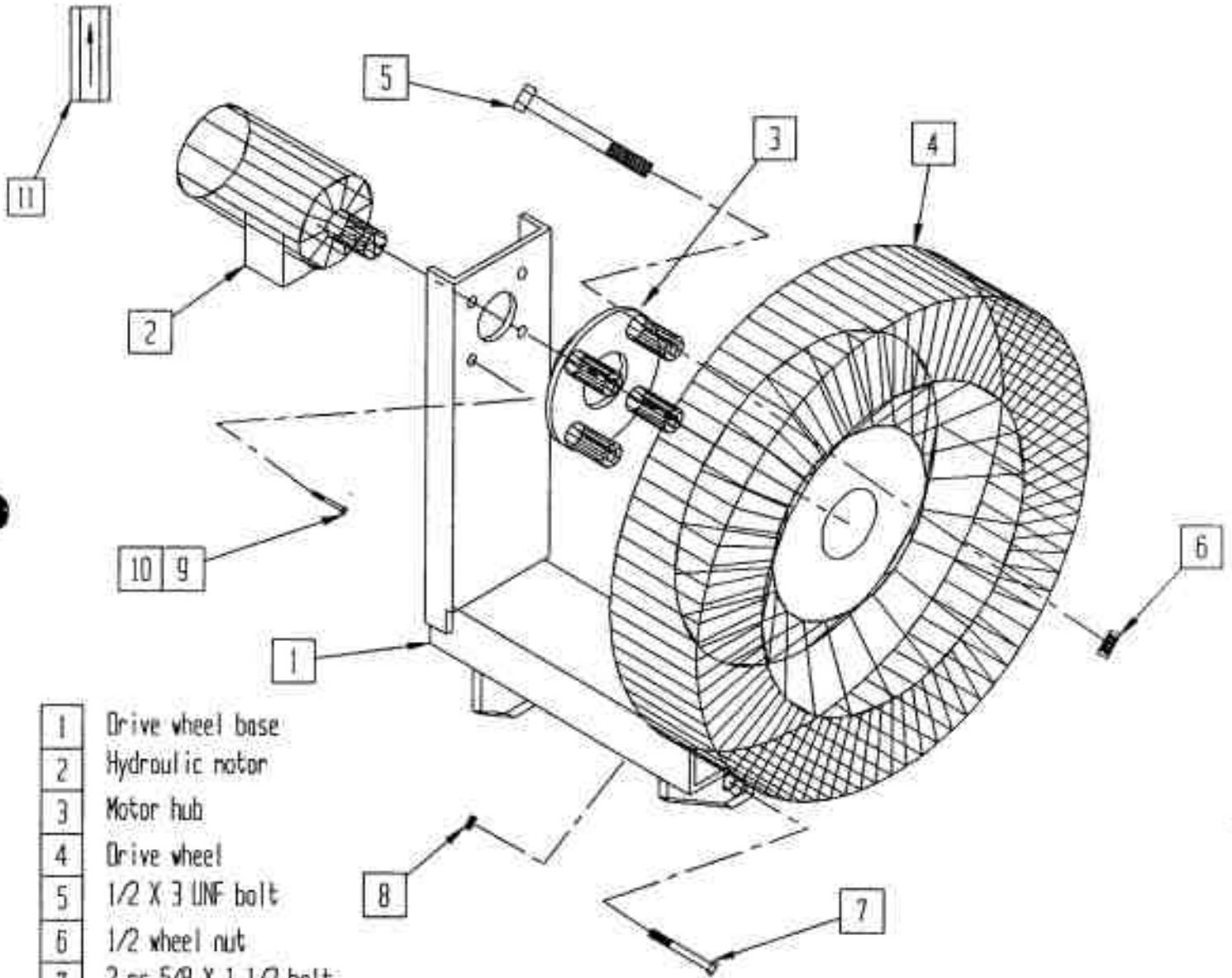
Tube-Line 550  
Safety Guard  
Right Hand Guard

- |   |                        |
|---|------------------------|
| 1 | Safety Guard Bracket   |
| 2 | Safety Door            |
| 3 | Rubber Latch           |
| 4 | Latch Pin              |
| 5 | Cotter Pin             |
| 6 | 3/8 x 1 1/4 Hinge Bolt |
| 7 | 3/8 Locknut            |
| 8 | Door Stay              |



# Tube-Line 550

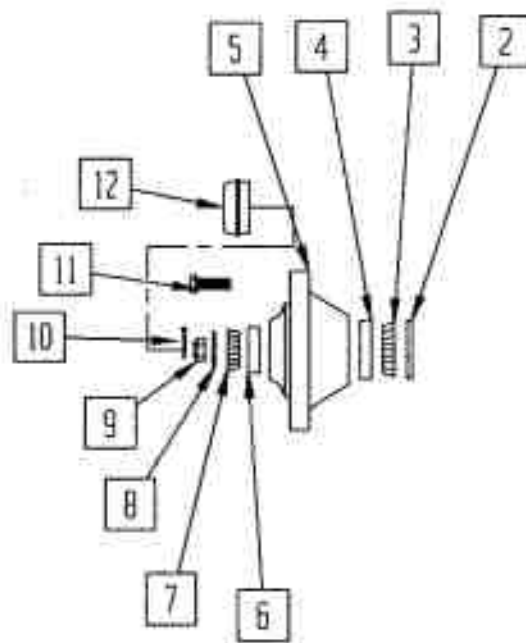
Drive wheel



- |    |                       |
|----|-----------------------|
| 1  | Drive wheel base      |
| 2  | Hydraulic motor       |
| 3  | Motor hub             |
| 4  | Drive wheel           |
| 5  | 1/2 X 3 UNF bolt      |
| 6  | 1/2 wheel nut         |
| 7  | 2 pc 5/8 X 1 1/2 bolt |
| 8  | 2 pc 5/8 locknut      |
| 9  | 4 pc 3/8 X 3/4 bolt   |
| 10 | 4 pc 3/8 lockwasher   |
| 11 | Check Valve           |

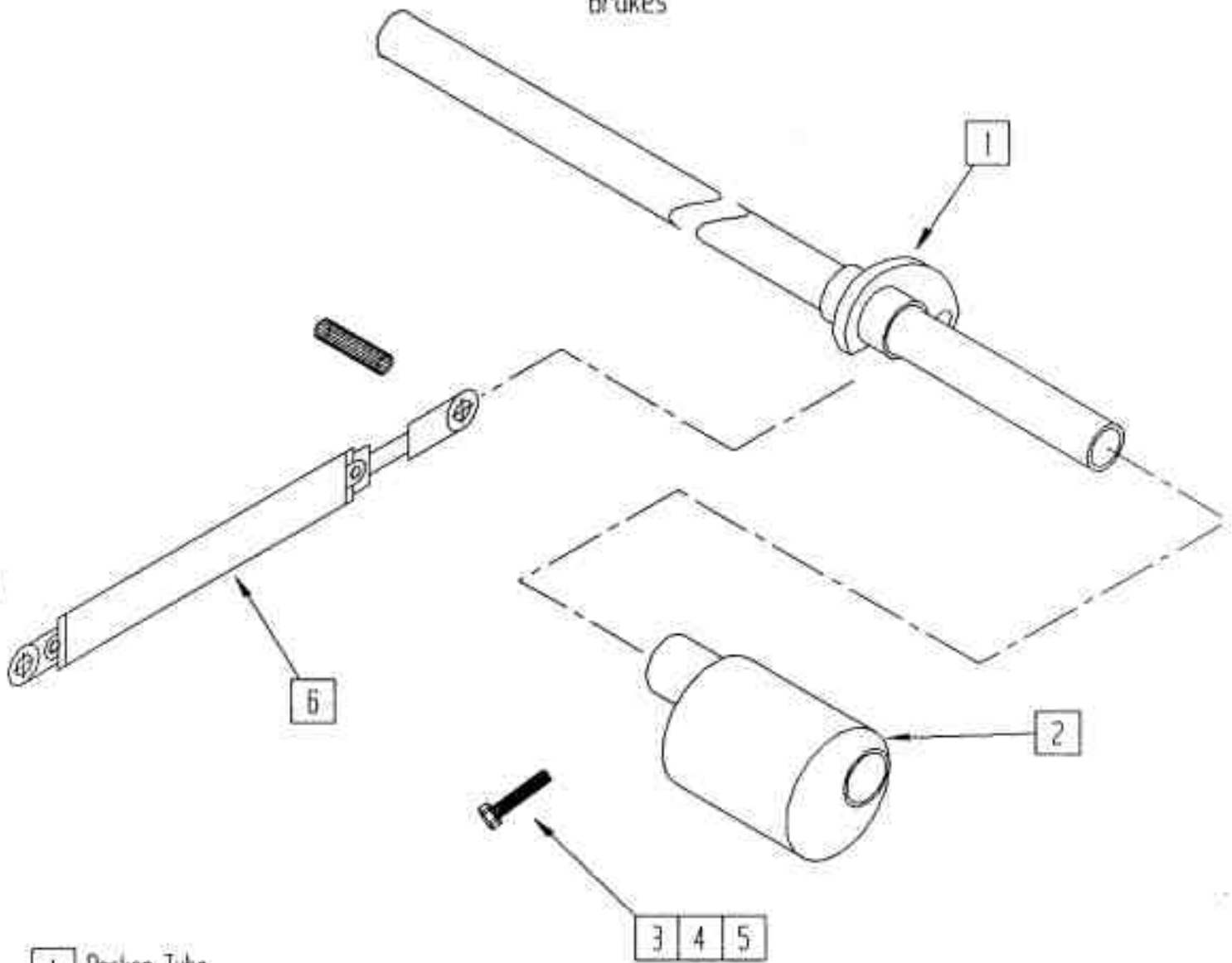
# Tube-Line 550

Axle/spindle/hub



2	seal
3	inner bearing
4	inner bearing race
5	hub
6	outer bearing race
7	outer bearing
8	flat washer
9	wheel nut
10	cotter pin
11	wheel stud
12	dust cap

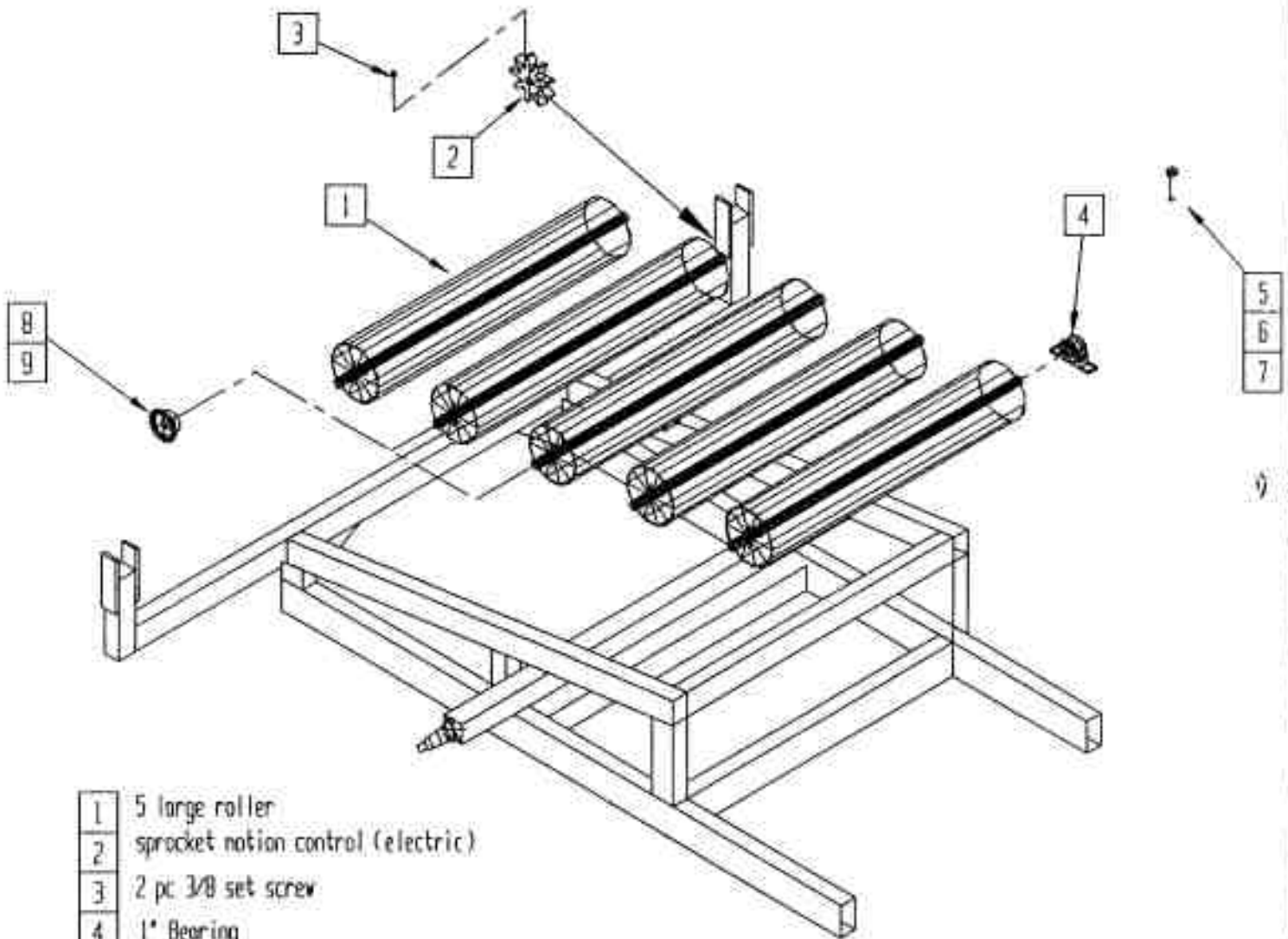
Tube - Line 550  
Brakes



- |   |                           |
|---|---------------------------|
| 1 | Rocker Tube               |
| 2 | 2 pc broke eccentric      |
| 3 | 2 pc 1/2 x 3 1/2 bolt     |
| 4 | 2 pc lockwasher           |
| 5 | 2 pc 1/2 nut              |
| 6 | 2 x 16 hydraulic cylinder |

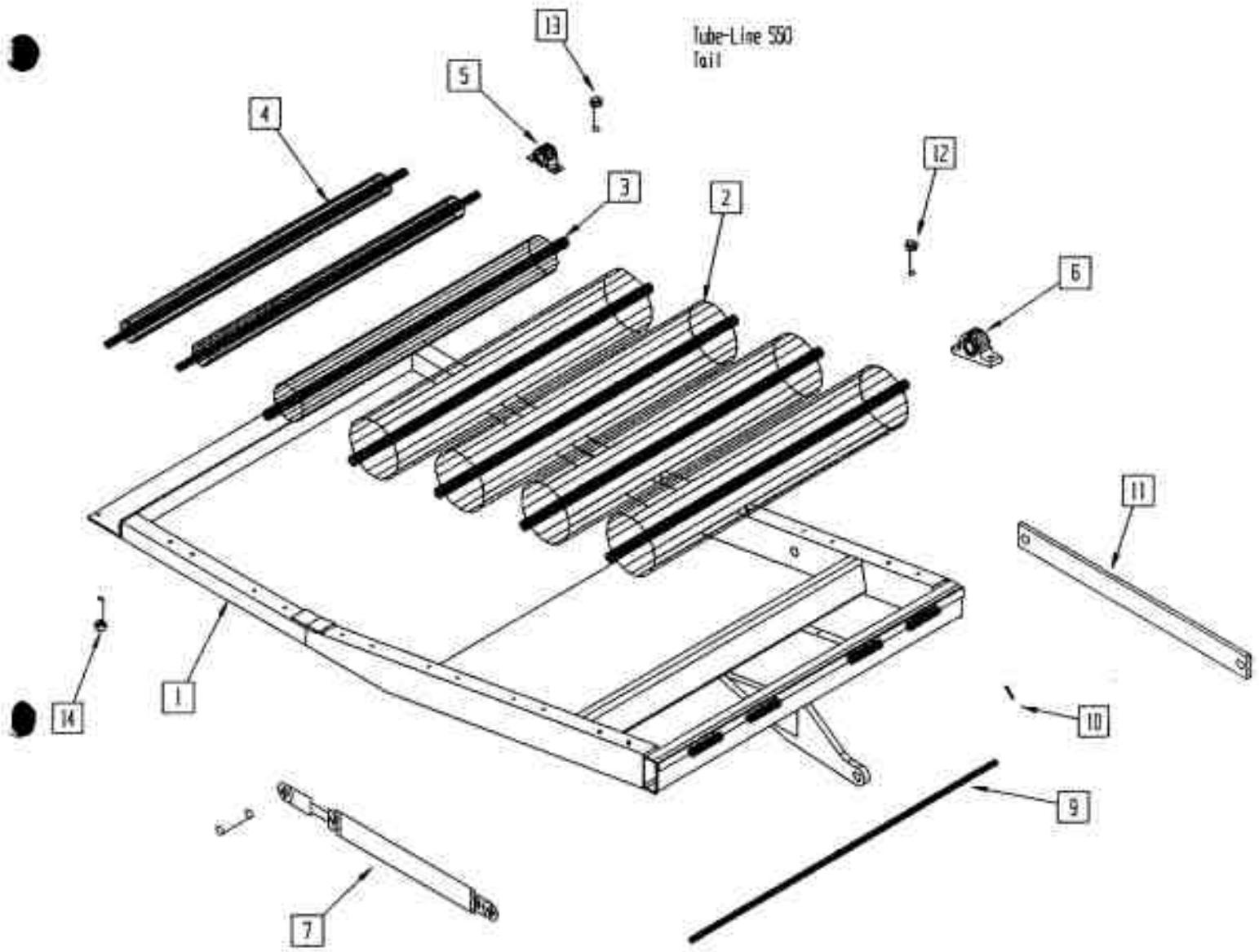
# Tube-Line 550

rear roller



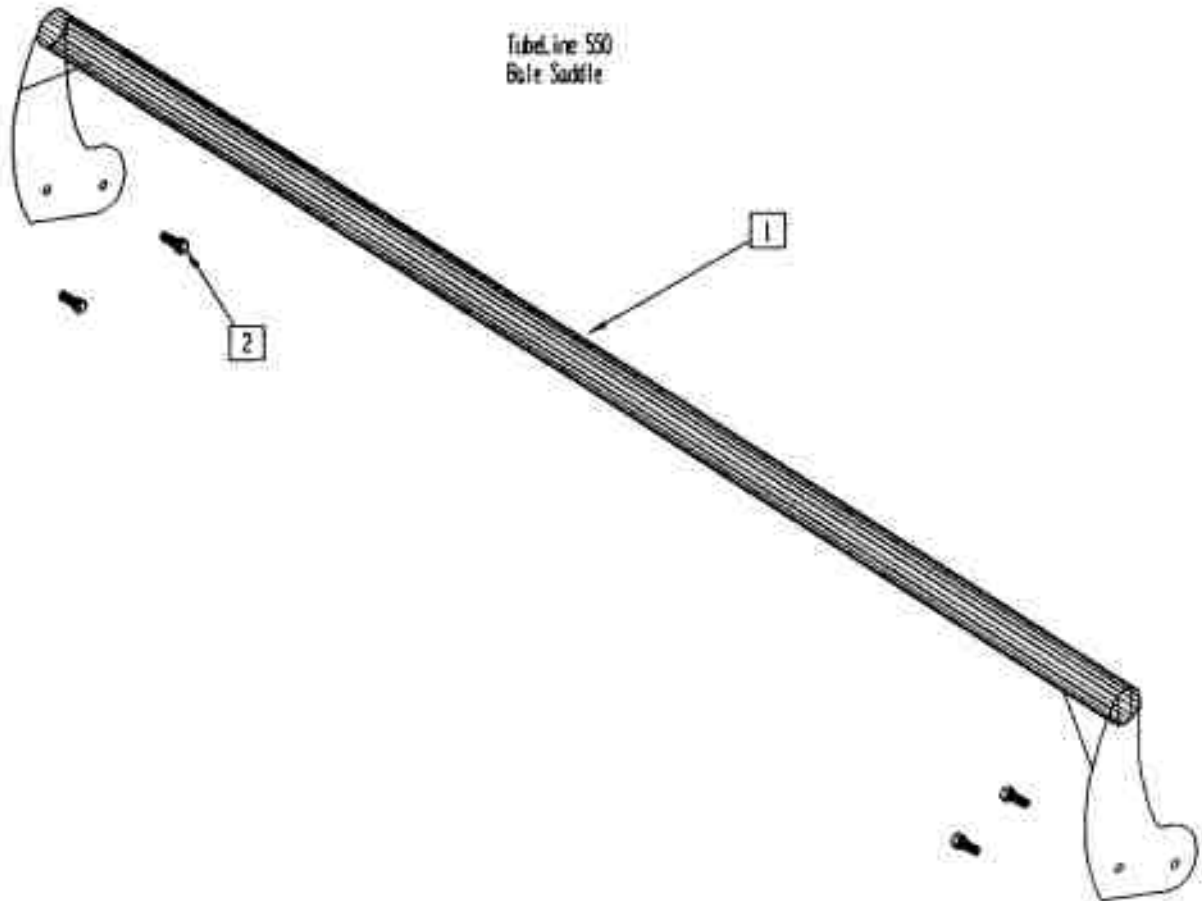
- |   |                                     |
|---|-------------------------------------|
| 1 | 5 large roller                      |
| 2 | sprocket notion control (electric)  |
| 3 | 2 pc 3/8 set screw                  |
| 4 | 1" Bearing                          |
| 5 | 20 pc 3/8 x 1 3/4 Self tapping bolt |
| 6 | 20 pc 3/8 lockwasher                |
| 7 | 20 pc 3/8 Flatwasher                |
| 8 | 2 pc 40B20 Sprocket                 |
| 9 | # 40 Roller Chain                   |

Tube-Line 550  
Tail



- |    |                                    |
|----|------------------------------------|
| 1  | Tail Base                          |
| 2  | 4 large roller                     |
| 3  | 1 pc 4" roller                     |
| 4  | 2 pc 2 3/8" roller                 |
| 5  | 4 pc 3/4" bearing                  |
| 6  | 10 pc 1" bearing                   |
| 7  | 2 X 16 hydraulic cylinder          |
| 8  | hinge pin                          |
| 9  | cotter pin                         |
| 10 | tail tie bar                       |
| 11 | 3/8 x 1 3/4 self tapping bolt      |
| 12 | 5/16 x 1 self tapping bolt         |
| 13 | 4 pc 5/16 x 1 1/2 countersink bolt |

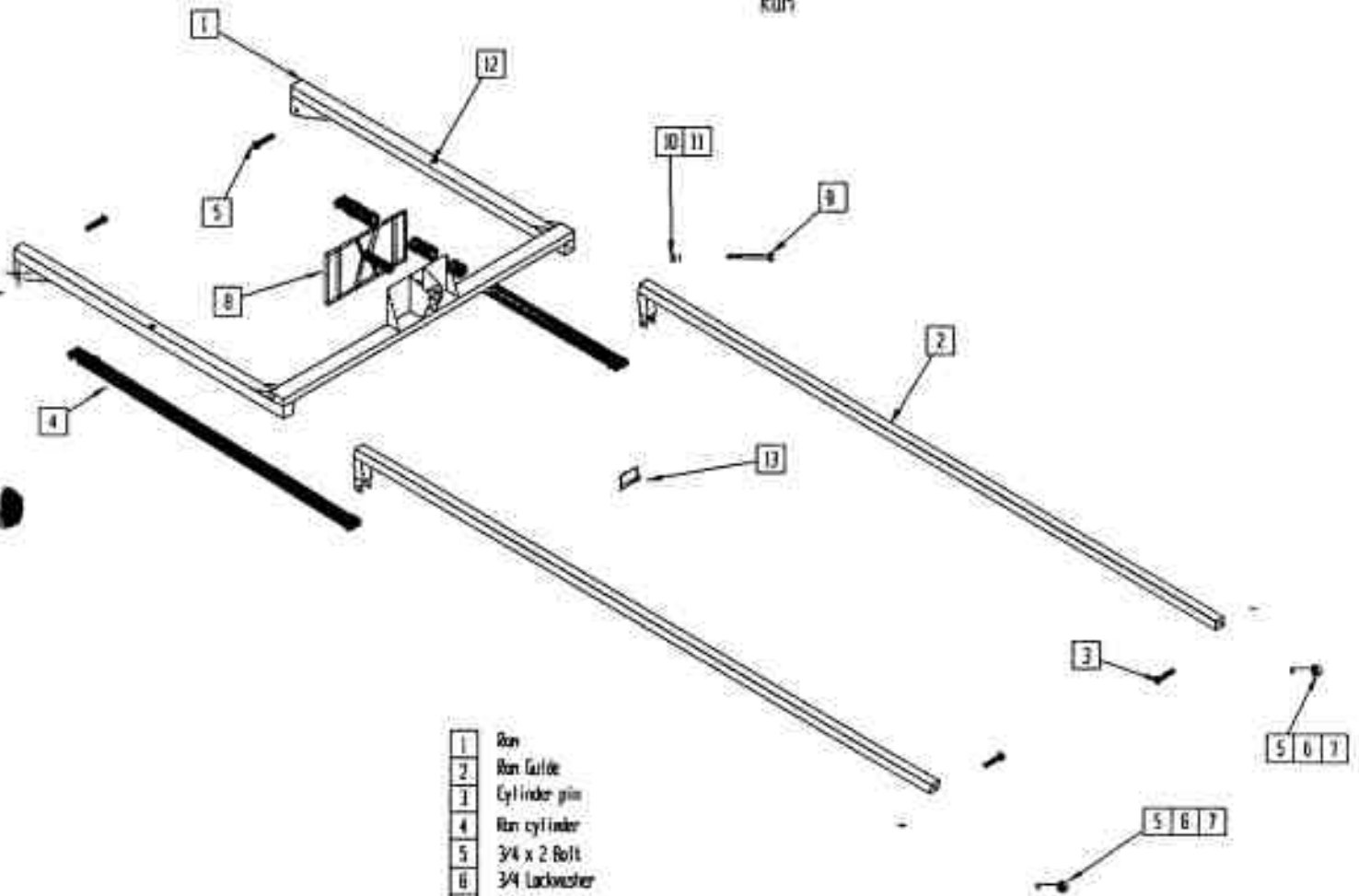
Tubeline 550  
Bolt Saddle



- 1 Saddle
- 2 1/2 x 1 1/4 bolt
- 3 1/2 locknut
- 4 1/2 nut
- 5 1/2 lockwasher

# Tube-Line 550

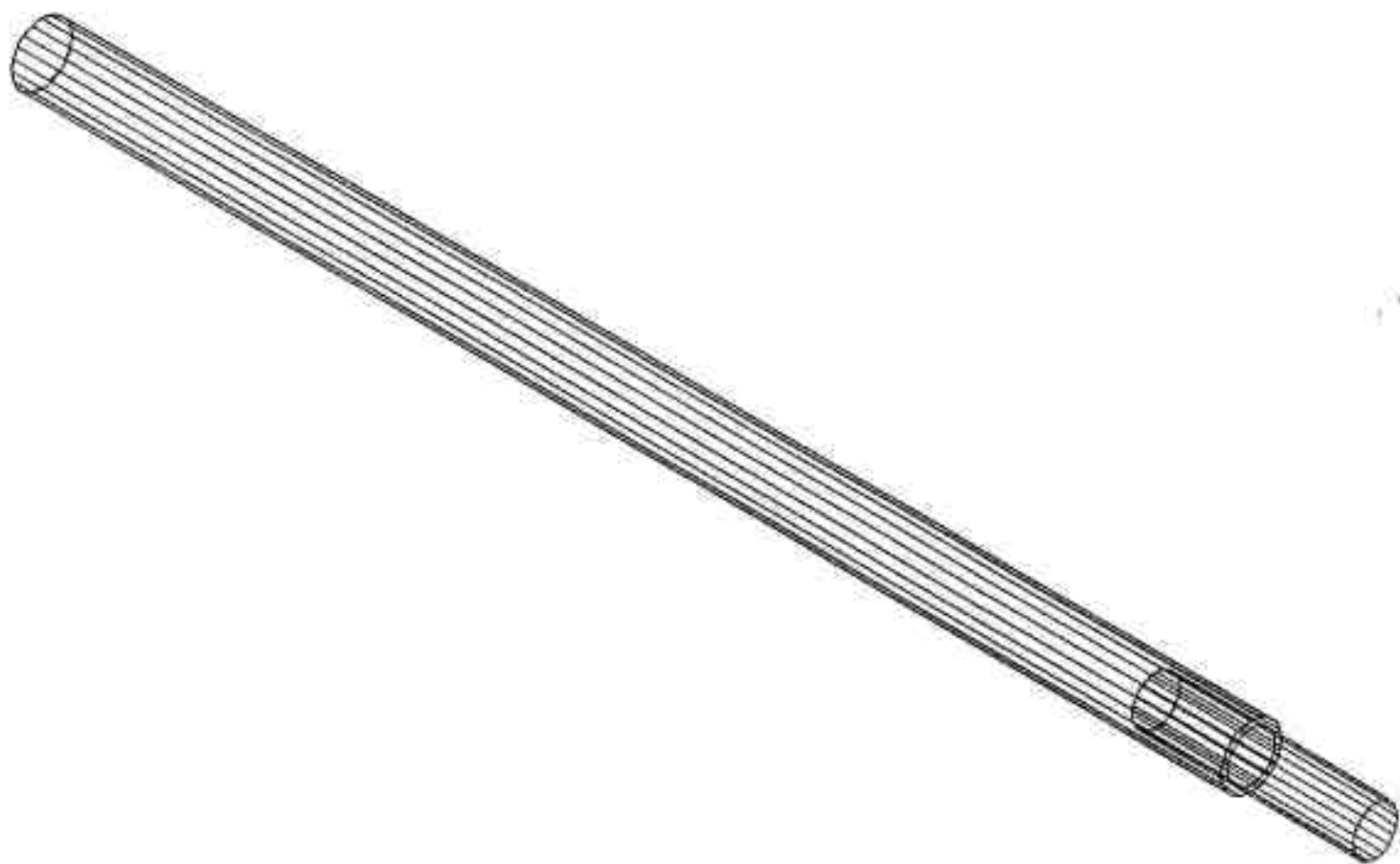
Ran



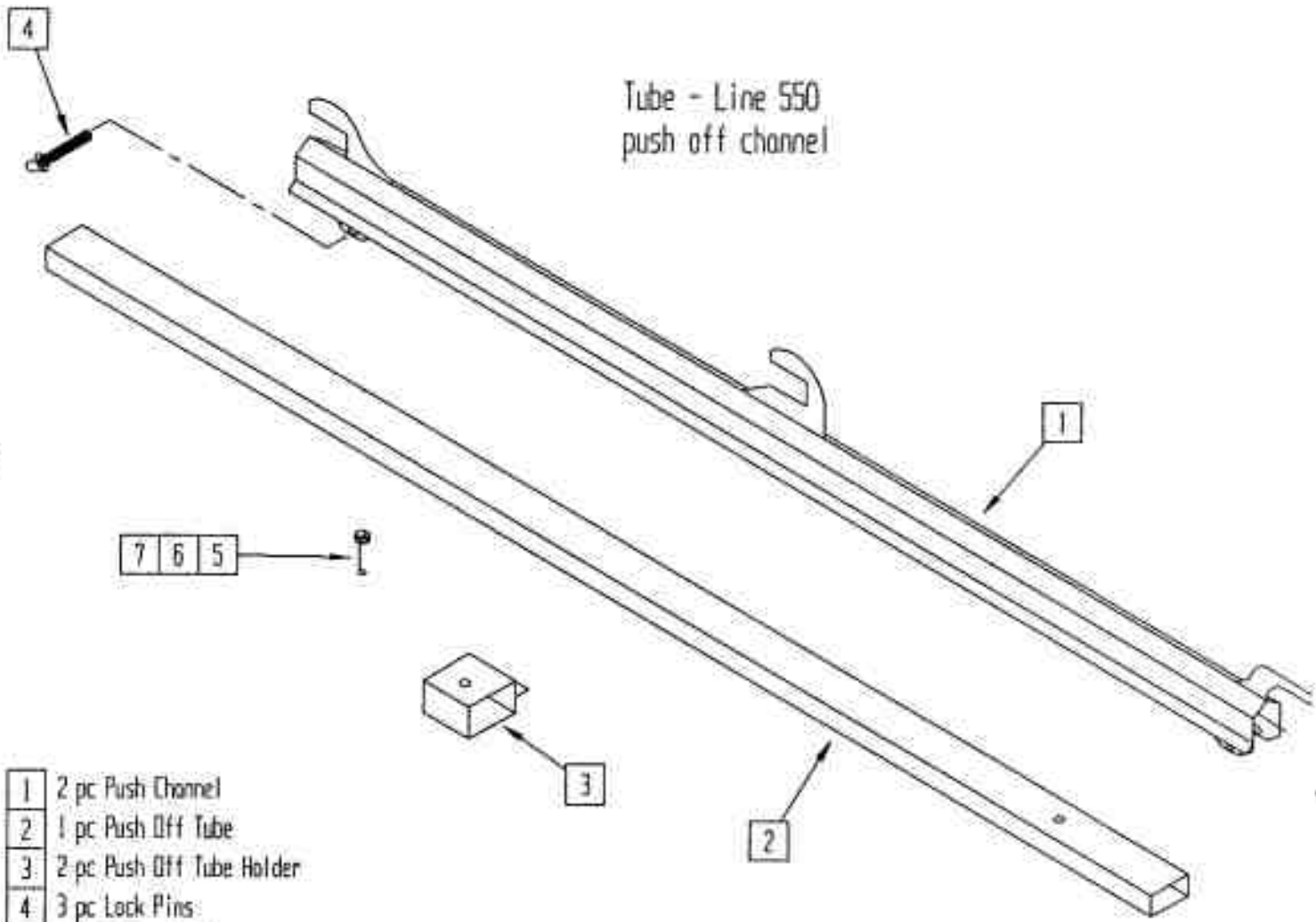
- |    |                              |
|----|------------------------------|
| 1  | Ran                          |
| 2  | Ran Guide                    |
| 3  | Cylinder pin                 |
| 4  | Ran cylinder                 |
| 5  | 3/4 x 2 Bolt                 |
| 6  | 3/4 Lockwasher               |
| 7  | 3/4 Flatwasher               |
| 8  | Push Plate                   |
| 9  | 2 pc 1/2 x 4 bolt            |
| 10 | 2 pc 1/2 nut                 |
| 11 | 2 pc 1/2 lockwasher          |
| 12 | 2 pc 1/4 - 28 grease fitting |
| 13 | Plate Lock Pin               |

# Tube-Line 550

Push tube



Tube - Line 550  
push off channel



- 1 2 pc Push Channel
- 2 1 pc Push Off Tube
- 3 2 pc Push Off Tube Holder
- 4 3 pc Lock Pins
- 5 4 pc 3/8 x 1 bolt
- 6 4 pc 3/8 nut
- 7 4 pc 3/8 lockwasher



