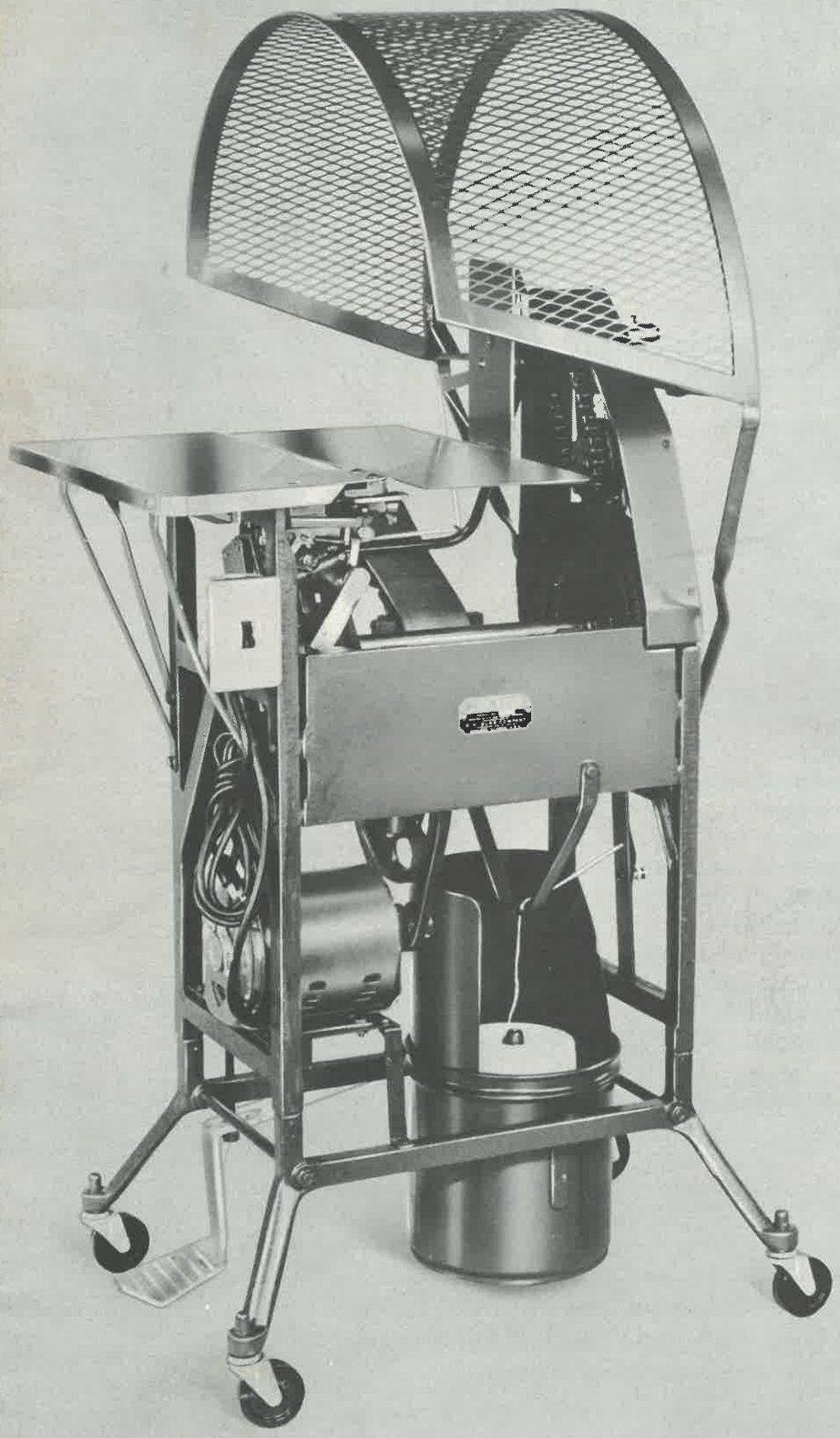
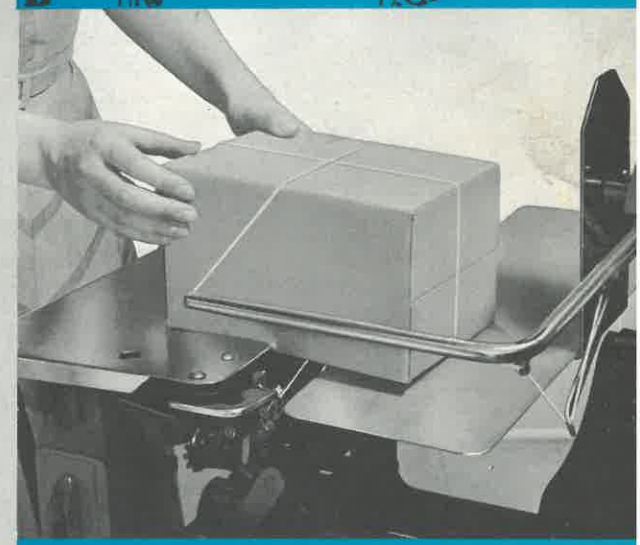


Maintenance Manual and Parts Catalog



BUNN®

PACKAGE TYING MACHINES
for over half a century

B. H. BUNN COMPANY
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Maintenance Manual & Parts Catalog

BUNN PACKAGE TYING MACHINES

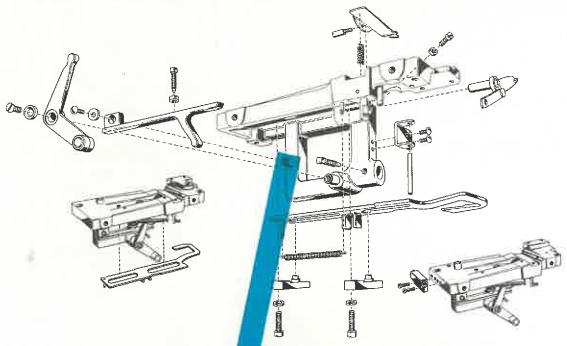
Table of Contents **Page**

Note:

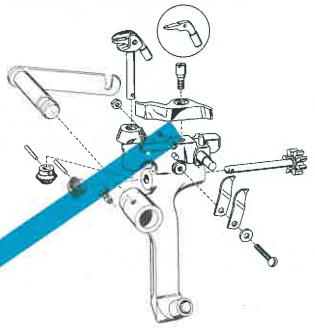
When ordering parts, please give the serial number of your Bunn Tying Machine. You will find it on the name plate on the right side panel of the machine.

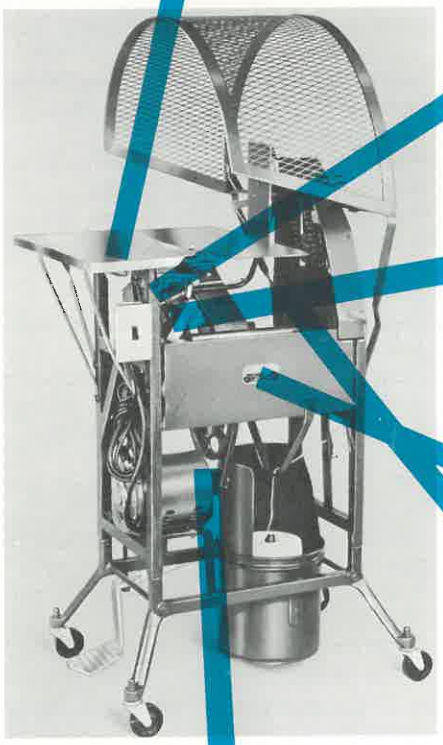
How to identify the main assemblies

MAIN TABLE ASSEMBLY

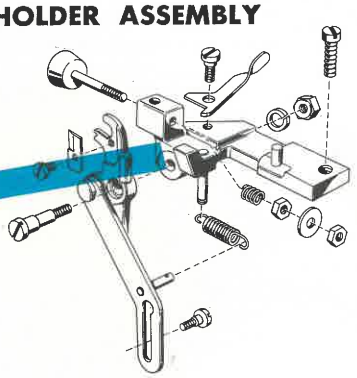


KNOTTER HEAD ASSEMBLY

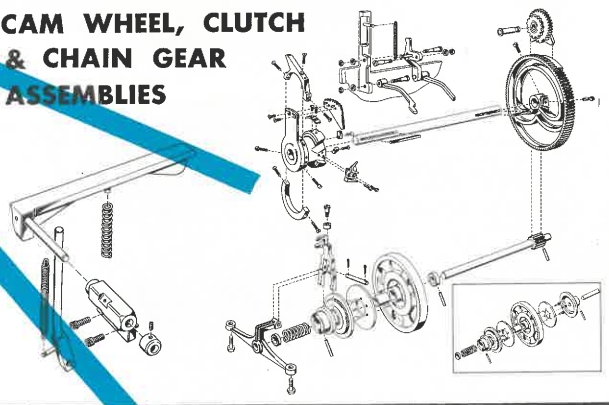




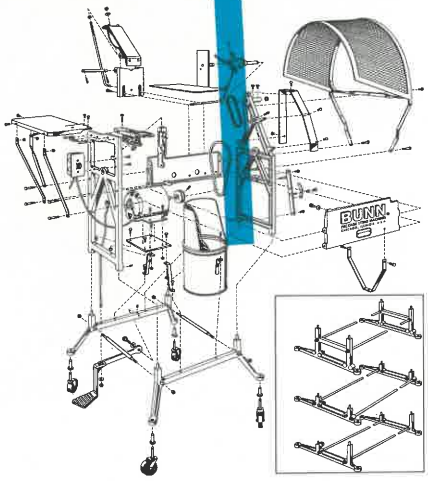
STRINGHOLDER ASSEMBLY



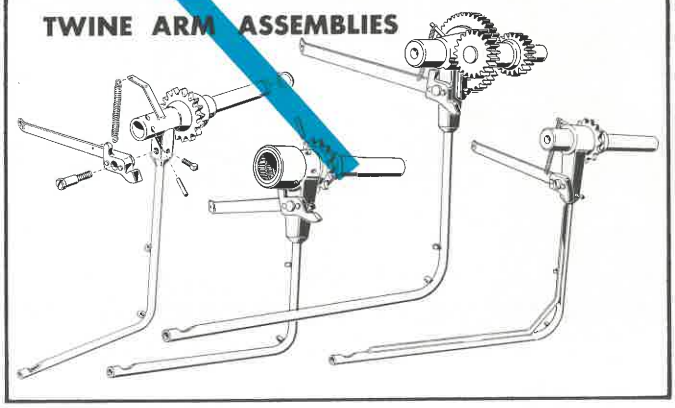
CAM WHEEL, CLUTCH & CHAIN GEAR ASSEMBLIES



BASE PARTS



TWINE ARM ASSEMBLIES



Installation and Operation

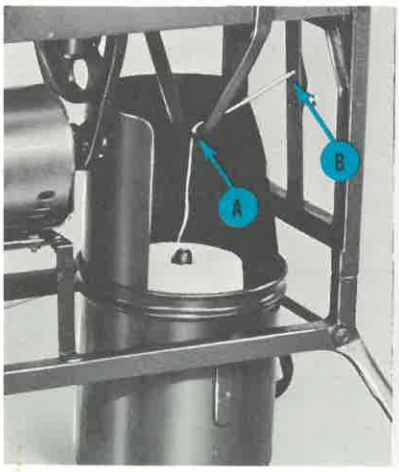
The Bunn Package Tying Machine is shipped to you crated. Uncrate your machine and cut the twine holding the twine arm to the central shaft. Attach the guard which you will find in the crate with the machine.

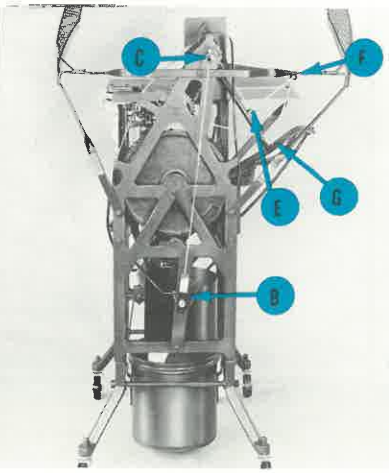
Threading Instructions

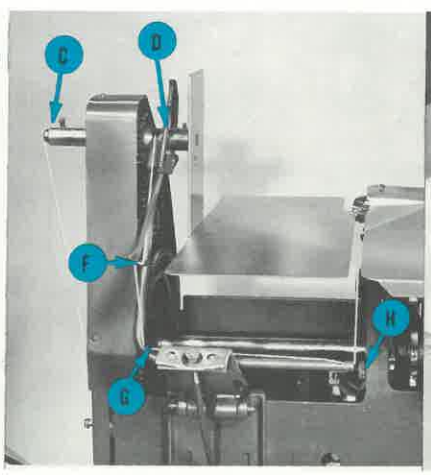
Before the machine is shipped it is threaded through each guide from the twine can to the stringholder button. Please note the various openings through which the twine passes so that the subsequent threadings may be simplified. A quantity of rock wool in the bottom of the can prevents twine from tangling under the cone and should remain in the container.

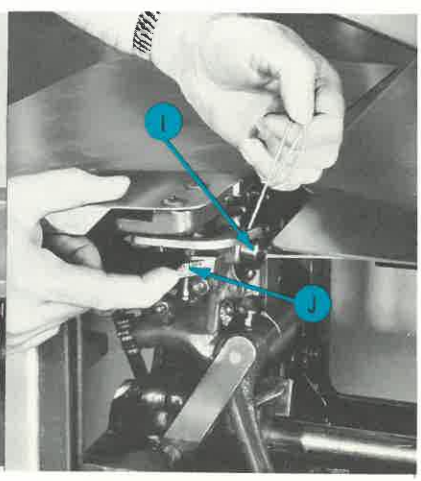
1. TURN switch to "OFF" position. (Machine is now ready to thread.)
2. RAISE twine from end of "CONE" to hole "A" in bracket, directly above cone.
3. PULL twine thru hole "A" to hole "B" in "TENSION BRACKET."
4. PUSH twine thru hole "B."
5. PULL twine upward and behind flat spring on tension bracket covering hole "B."
6. PUSH about eight inches of twine into hole "C."
7. BLAST air into hole "C" until twine "POPS" out at hole "D."
8. PULL twine thru eyelet "E."
9. RAISE twine to hole "F" at end of draw back lever arm.
10. PULL twine thru hole "F" and eyelet "G."
11. PUSH twine thru hole "H" at end of twine arm.
12. PULL twine under and around button "I" and hold with left hand.
13. PULL twine tightly with left hand until twine SLIDES INTO CUTTING POSITION.
14. LOWER left hand to rest on work table and PULL twine *tightly*.
15. PULL cutting knife lever handle "J" with right hand until twine is cut.
16. TURN switch to "ON" position. (Machine is now ready for operation.)

NOTE: If the end of the old cone of twine is caught before running out of the machine, the first of the next cone can be tied to it with a square knot. The knot will work through the machine. If the end of twine is not caught as it leaves the cone, the machine may be threaded from the new cone up to any point.









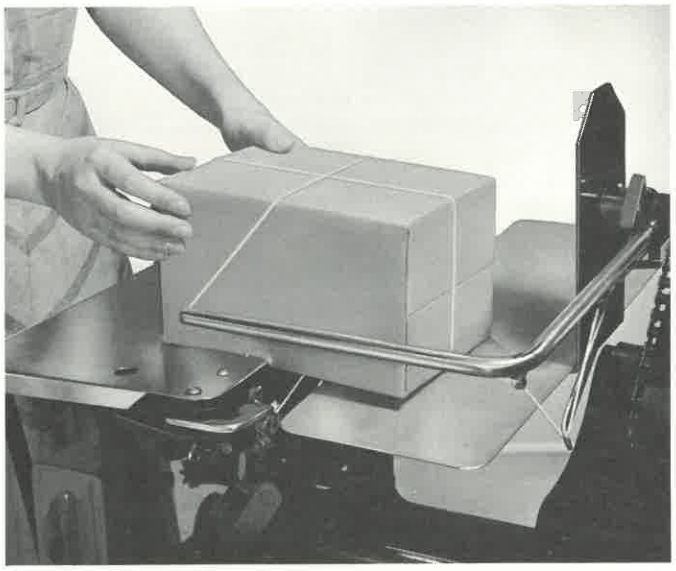
Machine Operation

We advise making a thorough study of your machine as it is turned through a complete cycle by hand.

To turn your machine over by hand the following method is suggested:

1. With motor turned off, face the machine from the side on which you find the nameplate and serial number.
2. Press the foot trip. Grasp the large pulley wheel at the top and pull down. With the machine threaded and a package in place, the complete cycle can be observed when hand operated in this manner.
3. Turn on the motor and the machine is ready for use.

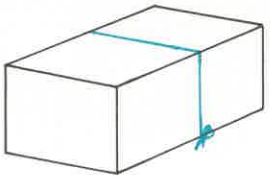
CAUTION: Be careful to avoid being struck by the twine arm as it makes a circular revolution.



Correct Operating Procedure

Grasp both ends of bundle between thumbs and forefingers. Press right end against vertical standard and then press foot trip (or on Post Office model press entire bundle down on pressure trip). Hold bundle steady and firmly until tie is complete. (After tie is completed on post office models, quickly pick up bundle before next tying cycle begins. THEN turn bundle to tie the short way and repeat above directions.)

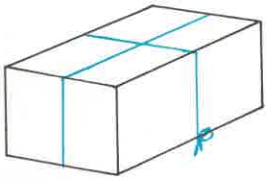
One way wraps



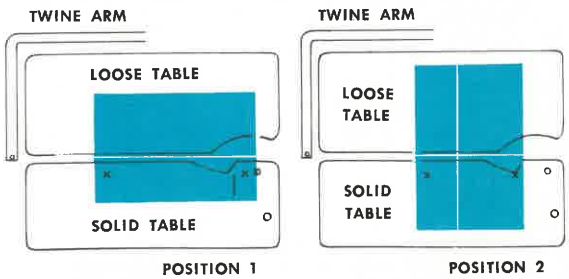
To operate your Bunn Tying Machine to the best advantage, we suggest the following steps for a single, double, or triple wrap one way machine:

1. Standing in front of the machine at the operating position, which is the widest side of the fixed table (hereafter referred to as the trough), hold the package firmly in tying position and step on foot trip.
2. The position of the package should be such that the center is directly over the separation of the trough and the loose table. Also, the right side of the package should be located against the shoulder or groove in the trough.
3. While holding the package firmly with both hands, fingers at side, thumbs on top, step on the foot-trip and remove foot instantly. As soon as the tie is completed, remove the package and you should find a snug, secure package tied with a non-slip knot that will stand even the roughest handling.

Cross ties



For tying packages, boxes, etc., with a cross tie, place the package on the machine for the long-way wrap first. The package need not set against the ledge above the knotter, but rather slightly on top of this ledge. Step on the foot-trip, INSTANTLY removing the foot. The twin arm will make one wrap and come to a stop. Grasp the package, and turn in a clock-wise direction one-quarter of a turn, bringing the right hand toward the body. Set the right-hand side of the package against the ledge, and do not force the package away from the operator, but rather draw it back slightly. This action makes the cross, bringing the string in position for the tip-up to catch it. Holding the package firmly in this position, set the foot-trip once more—INSTANTLY removing the foot. The twine arm will make the final revolutions, and the machine will tie the knot. This is a very simple operation when once it is understood.



How to avoid problems

CAUTION: Never file the face of the stringholder casting! It was filed by a trained workman, and the groove was put there for a purpose, and is not caused by wear. Necessary adjustments can be made by regulating the spring tension.

1. **Threading:** Be sure your machine is threaded properly. This is the major cause of machines not working properly (see threading instructions).
2. **Twine:** Your machine is adjusted for a definite size twine. For best results this should be used at all times.
   a. Weak twine will cause trouble, as it will break at the stringholder button instead of pulling out smoothly.
   b. If the twine is too large it will not be released by the knotter jaws.
   c. If the twine is too small it will cause a loose knot.
3. **Stringholder Button:** If you are using the proper size and a good grade of twine, and it breaks frequently, leaving short pieces behind the stringholder button, this is usually caused by too much spring pressure on the button. This can be remedied by loosening the two lock nuts, with washer between, that regulate the spring tension.
4. **Stringholder Button Adjustment:** Keep the stringholder button free of broken bits of twine. If there is a small piece of twine wrapped around the shaft of the stringholder button this will take the tension from the end of the twine, permitting it to jerk out or pull part way back into the button at the time the arm starts its revolution, causing a half or single loop knot to be formed. Use the lever attached to the side of the stringholder button for releasing the tension and removing small bits of twine from this unit.
5. **Clean Stringholder Button:** After a period of use the hole in the stringholder casting may become filled with lint. A small pair of tweezers can be used to clean out this material.
   CAUTION: Do not use a sharp instrument to force the button open. Always use the release lever!
6. **Twine Running Tension:** A smooth, easy running tension is always the best. Neither too tight nor too loose. This can be tested by pulling a quantity out from the end of the twine arm. The adjustment for running the tension is the flat spring held in place by two knurled brass nuts at the back of the machine. If the tension is too tight these should be loosened approximately one-half turn at a time, until the proper tension is made. If the tension is too loose they should be tightened one-half turn at a time until the tension is correct.
7. **Single Loop Knots:** If your machine is making a one-loop knot that always slips out, it is possible that the running tension is too tight, and the tension should be loosened until a double-loop knot is formed. This adjustment can be made as outlined in No. 6.
8. **Cutting Knife:** When the knife becomes dull it can be replaced by removing the screw that holds it in place and inserting a new knife, or the edge can be sharpened by grinding a small quantity off the cutting edge on a grinding wheel or hand stone.

...but just in case you do have a problem, here's how to:

4

replace the drive belt

1. Remove clutch fork No. 63 located just above motor by removing the clutch fork pivot pin No. 66.
2. Remove the two cap screws that hold the lower bearing No. 67 to the side frames and remove lower bearing (do not pull clutch out).
3. Slip belt over clutch and re-assemble lower bearing.
4. Re-assemble clutch fork No. 63 and clutch fork pivot pin No. 66, making sure the clutch block lever No. 112 fits into the slot of the clutch fork. (See page 15.)

replace the stripper spring

If the twine continually catches in the stripper No. 52, it may mean that the spring that operates the stripper is broken or has lost its tension.

1. Remove sheet metal trough from main table.
2. Remove stripper screw No. 53 and remove stripper.
3. Replace stripper coil spring No. 54 and re-assemble. Be sure screw is all the way in. (See page 13).

replace the stripper

1. Remove sheet metal trough from main table.
2. Remove stripper screw No. 53 and remove stripper.
3. Re-assemble with new stripper. The notched face of the stripper should be close to the side of the knotter body when using twine 12-ply and under. When heavy twine, 16- to 24-ply, is used a space of .010" should be allowed between the stripper face and side of knotter body. (See page 13.)

4. Check to see if the notch in the stripper is in line with the point of the knotter as the knotter withdraws from the stripper.
5. Adjustments can be made by bending the stripper. A few taps with a light hammer will normally give the correction needed.

replace the knotter

In replacing the *knotter* in your Bunn Machine, the mechanic must be careful to time the new *knotter* properly. When the *knotter* is timed correctly, the two *taper pins* in the *bevel gears* should be parallel to each other, with the *knotter roller* at the bottom of the *cam*. In other words, when the *knotter* is pointing straight ahead.

Note the position of the teeth on the *star wheel*. You will see that the *star wheel* contains seven uniform teeth and one slightly beveled. When timed properly the beveled tooth will be slightly to the right of the center line — as shown at right. If the *pointed tooth* is not in correct position — remove the *taper pin* and *bevel gear*, located at the end of the *star wheel shaft*, and time correctly.

If knotter holds the loops of the knot, and fails to release after the tying cycle—

1. There is an *adjusting screw* located directly back of the knotter for adjusting the space between the jaws.
2. The *adjusting screw* is set at a 45° angle and is held in positive location by a small hexagon lock nut.
3. By holding the *set screw* in place with a screw driver, the *lock nut* is released and the *set screw* turned in a clockwise direction until the twine is released (usually a quarter turn is sufficient).
4. Then by holding the *set screw* in location with a screw driver, tighten the *lock nut* securely.

correct clutch slipping

1. Your machine is equipped with a dry clutch and no oil should be allowed to get between the clutch plate and the clutch disc, as this will cause the clutch to slip.
2. When oil on the clutch is causing the machine to not operate properly, it is suggested that an oil can containing a solvent be used and a few drops "squirted" between the clutch disc and the clutch plate. This should dissolve the oil and allow the machine to operate satisfactorily.
3. Another method that may be used is to place a small quantity of powdered rosin between the clutch disc and the clutch plate. This is done by turning off the motor with the machine in neutral position, and by using a screw driver and the frame of the machine for leverage force the large main gear to move about two teeth in a counterclockwise direction. This will cause a small space to open between the clutch disc and the clutch face. Now drop a small quantity of powdered rosin in this opening and start the machine.
4. If this does not correct the slipping, it is necessary that the clutch be removed and the disc wiped clean.

clean the clutch

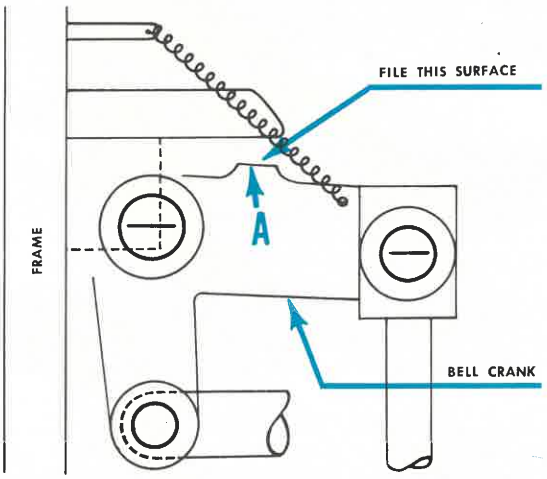
1. With machine in neutral position, drive out the tapered pin in the clutch gear washer No. 83. This will allow the clutch to come apart.
2. Wipe both faces of the clutch clean and reassemble.

correct automatic tripping of cross tie

Note: Automatic tripping may occur on older tying machine models which don't have a wedge (part No. 112W) in the trip mechanism.

When cross tie machine trips automatically on the cross tie, the following remedy is recommended:

1. Turn off motor at switch.
2. Step on foot trip and hold down. This will cause the bell crank located at the left side of machine just under main table to remain open.
3. Using a small Pillar file, file a small amount off of surface "A" of bell crank.
4. Start machine and step on foot pedal and release instantly. If this does not cause the machine to stop for the cross tie, file off an additional amount of stock from surface "A" until the arm will revolve and stop when the foot pedal is engaged, and the foot instantly removed.



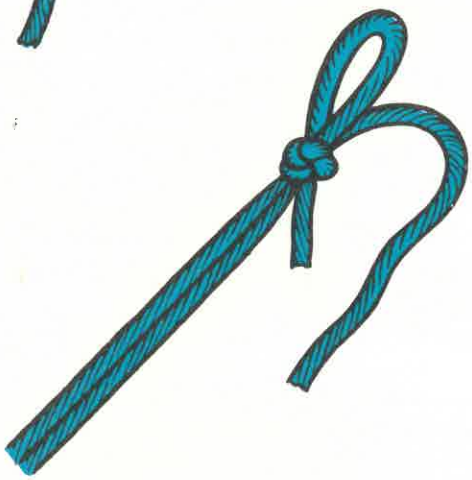
Or when machine trips automatically it may be due to one of the following reasons:

1. Trip rod may be bent and is binding. This can be easily straightened.
2. Vibration set up by dry bearing in clutch wheel. Bearing should be oiled.
3. Clutch block lever loosing its position on clutch fork roller. File surface "A".

The knot tells the story

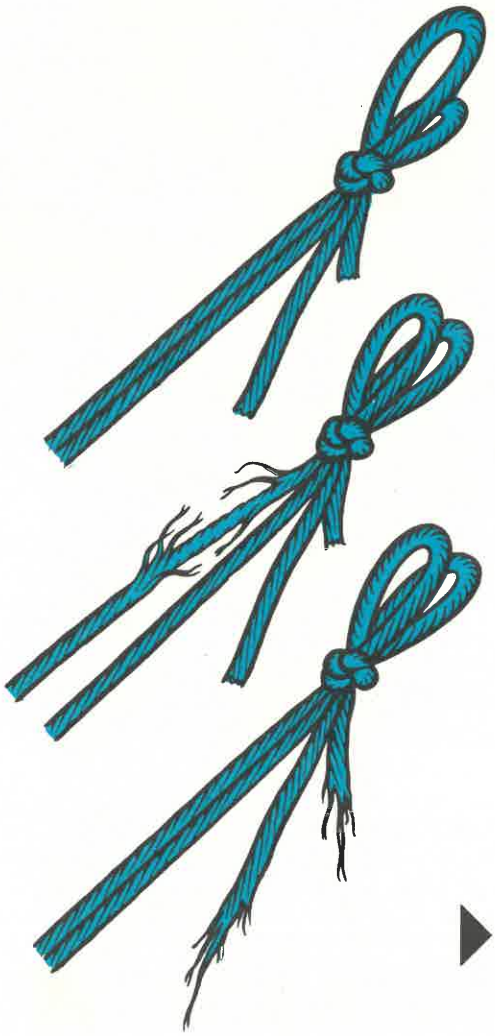
This is a perfect knot

A perfect knot, like the illustration, has two long even loops extending out one side of the knot with one short end and one long end, the body of the knot is tight and hard. The stripper should be on the line where the upper and lower jaws meet at the lip of the lower jaw and very little space between them as the stripper pushes the twine off the knotter.



single loop

A knot with a single loop or "half knot" will not hold, as only one end is tied into the knot. The other end is free to pull out of the knot. This can be caused by the running tension being set too tight for the stringholder button tension, which will not leave enough free end of twine in the bottom to completely form the double loop knot. If this free end pulls out of the button at any time before the knife trap operates to cut the twine, and at the same time, pull out the residue of the free end, then the result will be a single loop knot. Another fault could be that too much running tension could cause the end in the button to jerk back part way, when the twine arm starts its revolution. This would not leave enough end to form a double loop knot. The remedy is to loosen the running tension to average easy running. Still another cause of single loops is a clogged stringholder. Keep the stringholder button clear of lint and bits of twine. Too much clogging will cause the twine to jerk out of the button as soon as the twine arm starts to revolve. Press on the release lever aid in removing lint and broken off ends. Do not use a sharp instrument to pry out lint between button and face of stringholder.



long and short loops

One long and one short loop, while not serious, is usually caused by wrong weight of twine for opening between jaws of knotter. Each knotter will take several different weights of twine, but if the twine used is too large, one loop can be caught in the back of the throat of the knotter and held there until released by the adjusting screw. To release turn knotter release screw in a clockwise direction.

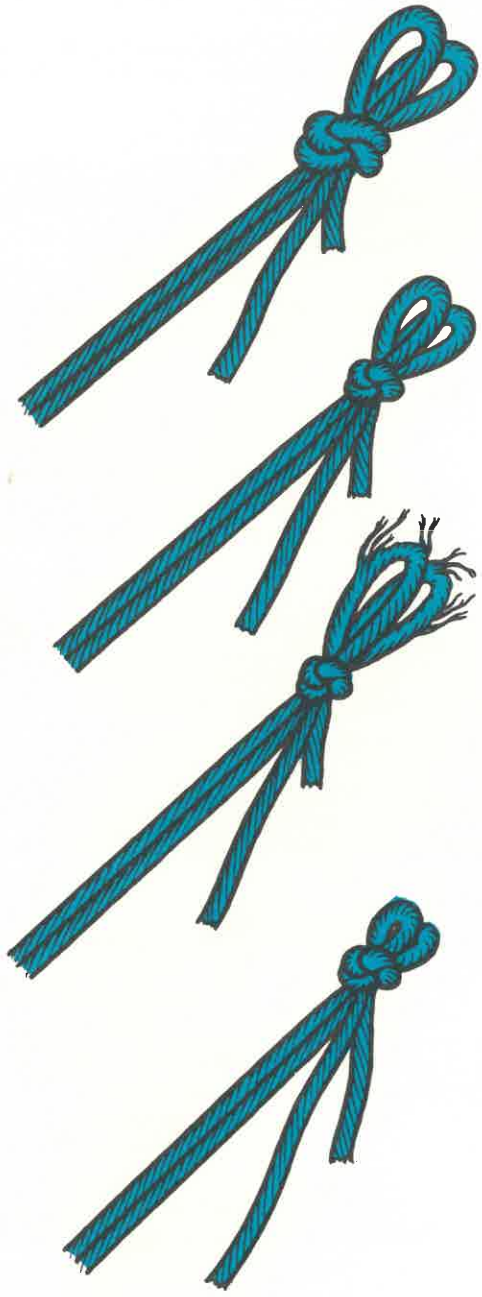
break in twine in front of knot

If there are any broken plys in the twine running around the package and close to the knot, this usually caused by either friction against the mechanism or is due to too much tension in tying a firm, solid package. All edges except the stripper points must be kept smooth.

ragged ends

Frayed or ragged ends of twine at the knot indicate a dull knife. The knife can be sharpened by grinding on a fine emery wheel or honing on a whetstone. The ends should have very clean cuts. To remove the knife for sharpening, pull the knife trap forward with the hand, thus permitting easy access to the screw holding the knife or remove the A30 stringholder assembly.

Watch for improperly tied, poor knots; they indicate the machine requires proper adjustment to prevent development of trouble which might result in major repairs.



loose knot

When the body of the knot is loose and the loops slightly shorter than normal this indicates that the knotter release screw is set in too far, allowing the loops to release from the knotter too soon. Turn release screw in counterclockwise direction. The stripper could be too short.

short loops

Short loops and tight knot can be caused by lack of balance between the running tension and the stringholder button tension. With stringholder tension properly set, the running tension should be neither too tight nor too loose. If running tension is too loose, knotter does not take up enough slack causing strain on free end of twine held in button.

cut loop ends

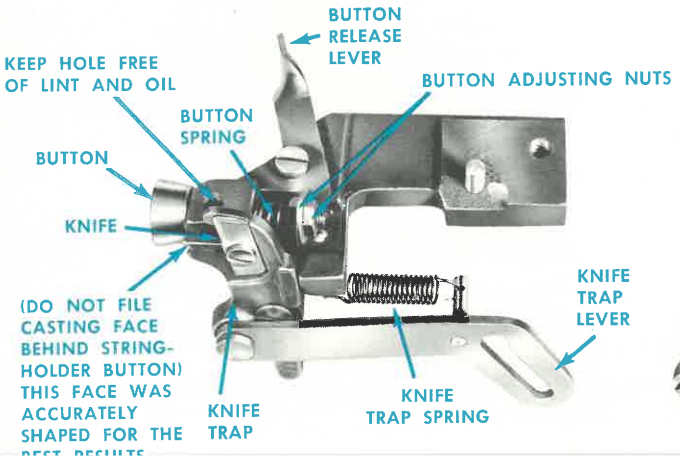
One or more cut plys of twine in loop of knot are caused by the stripper points shearing against the side of knotter jaws when stripping. This shearing is not serious unless one or both loops are entirely cut. If only one or two plys are cut there is no weakening of the tie. To remedy, bend down top front end of the stripper with a light hammer.

very short loops and long ends

Very short loops and extra long ends caused either by knot slipping by the stripper or the knotter flat springs becoming weakened or both. The stripper to form a perfect knot should rub slightly against the side of knotter jaws and should be flush with top of knotter. It should also follow down the shoulder at the side of the jaws to get behind the knot for proper stripping. To close gap between stripper point and knotter, hit left side of stripper with hammer. The stripper is lightly case hardened. If knotter flat springs are weak, the loops will force out of knotter jaws before forming proper length. Replace weak springs with new ones to restore original performance.

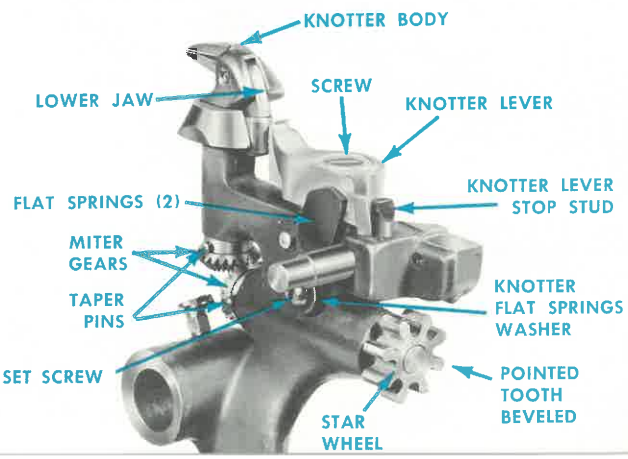
For fast efficient maintenance, please study the illustrated examples of improperly tied knots, due to the wrong adjustments, and read the explanation on how to correct the trouble and obtain smooth machine operation.

STRINGHOLDER ASSEMBLY



STRIPPER

KNOTTER HEAD ASSEMBLY



Complete list of parts

Part No.	Description	Illustrated on Page Number
□ ○ 1	Frame—left end (tent)	17
○ 2	Frame—front end (square)	17
□ ○ 3	Frame—near side, long	17
3C	Frame—near side, clamp model	
○ 3B	Frame—near side	
○ 3FS	Screw—fillister head	
○ 3HS	Screw—hex. head	
□ ○ 4	Frame—far side, long	17
4C	Frame—far side, clamp model	
5L	Base—left side, long, regular	17
○ 5LPO	Base—left side, long	17
5DL	Base—left side, low	17
5UL	Base—left side, high	17
5TL	Base—left side, tilted	17
5R	Base—right side, long, regular	17
○ 5RPO	Base—right side, long	17
5DR	Base—right side, low	17
5UR	Base—right side, high	17
5TR	Base—right side, tilted	17
5SS	Screw—socket set, base	17
□ ○ 6	Tie-Rod-Base (specify length measure shoulder to shoulder)	17
6E	Screw—hex. head, machine	17
○ 6A	Nut-base tie-rod	17
□ 7	Trough—split type	17
□ ○ 7A	Bracket—trough, front	17
7B	Bracket	17
□ 7L	Trough—laundry type	
□ ○ 7PO	Trough—post office type	
□ 7RT	Trough—roll towel	
□ 7MR	Trough—meat roll	
○ 7N	Nut—bracket screw	17
○ 7S	Screw—bracket	17
△ □ ○ A8-17-30	Tying unit—complete, (composed of assemblies indicated in part number)	
A8	Main table assembly—regular	13—17
A8B	Main table sub-assembly—regular	13
A8BC	Main table sub-assembly—clamp model	
○ A8BPO	Main table sub-assembly	
A8C	Main table assembly—clamp model	13
○ A8PO	Main table assembly	13
○ 8C	Screw-set, knotter pivot	13
○ 8D	Stud—drawslide spring	13
○ 8E	Stud—knotter head stop	13
○ 8F	Stud—drawslide lever	13
○ 8G	Stud—riser lever	13
○ 8H	Washer—riser lever	13
○ 8I	Screw—riser lever	13
○ 8R	Screw—hex. head, main table mounting	17
○ 8S	Screw—fil. head, main table mounting	17
□ ○ A9	Cam wheel assembly	
□ ○ 9	Cam wheel	15
○ 9AS	Screw—set, short, cam wheel	15
○ 9AL	Screw—set, long, cam wheel	15
○ 9B	Key—cam wheel	15
10 and 11	Cam—drawslide, regular (sold in pairs only)	15
○ 10PO and ○ 11PO	Cam—drawslide, regular (sold in pairs only)	15
○ 10A	Pin-dowell—drawslide cam	15
○ 11A	Screw—drawslide cam	15
□ ○ 12	Switch—knotter head cam	15
□ ○ 12A	Pin—switch	15
□ ○ 12B	Screw—switch	15
○ 13	Rack—knotter	15
○ 13A	Pin—knotter rack	15
○ 13B	Screw—knotter rack	15
○ 14	Kick-out, clutch, regular	15
14H	Kick-out, clutch, heavy	
○ 14A	Screw—clutch kick-out	15
□ ○ 16	Cam riser	15
○ 16A	Screw—riser cam	15
△ □ ○ A17L	Knotter head assembly—light (10 ply and below)	
△ □ A17H	Knotter head assembly—heavy (12 ply and above)	
○ A17A	Knotter head sub-assembly	12
○ 17B	Pin	
○ 17C	Oil cup	12—17
○ 17D	Stud—knotter lever stop	
○ 17E	Stud—tip-up link	
△ ○ A18LM	Knotter body assembly—light, with miter gear	12
△ A18HM	Knotter body assembly—heavy, with miter gear	
△ ○ 18JL	Jaw-knotter—light	
△ ○ A18J	Knotter-jaw assembly	12
△ 18JH	Jaw-knotter, heavy	
○ 18P	Pin-knotter jaw	12
○ 18R	Roller-knotter jaw	12
○ 19	Gear-miter, knotter	12
○ 19TP	Pin-taper, knotter miter gear	12
○ A20	Star wheel assembly, with miter gear	12
○ 21	Lever-knotter	12
○ 22	Screw—knotter lever	12
○ 22S	Screw-set, knotter lever screw	12
○ 23	Spring-knotter flat	
○ 23A	Screw-knotter flat spring	12
○ 23B	Washer—knotter flat spring	12
○ 23C	Nut-knotter flat spring	12
○ 24	Stud—knotter head roller	12
○ 25	Roller—knotter head	12
○ A26	Pivot assembly—knotter head	12
○ 26A	Screw—pivot assembly—lock	17
○ 26B	Washer—pivot assembly—lock screw	17
○ 27	Screw—knife trap	
○ 28	Screw—knotter release adjusting	13

○Used in post office models, too. Order may be written with "P.O." appended to part number.

□Must order with machine serial number. △Specify twine size used. ☆Used with backgeared models.

Part No.	Description	Illustrated on Page Number
○ 28A	Nut—knotter release screw	13
○ 29	Post—knotter release	13
○ 29A	Pin—knotter release post	13
△ □ ○ A30L	Stringholder assembly—light, regular	
△ □ ○ A30H	Stringholder assembly—heavy, regular	
△ □ ○ A30CL	Stringholder assembly—light, clamp models	
△ □ ○ A30CH	Stringholder assembly—heavy, clamp models	
△ □ ○ 30L	Stringholder sub-assembly—light, regular	14
△ □ 30H	Stringholder sub-assembly—heavy, regular	
△ □ 30CL	Stringholder sub-assembly—light, clamp model	
△ □ 30CH	Stringholder sub-assembly—heavy, clamp model	
○ 30FS	Screw-stringholder mounting	
○ 30P	Pin—spring perch	14
○ 30PP	Pin—stringholder locating	14
○ A31L	Knife trap assembly—long lever	14
A31S	Knife trap assembly—short lever (for very heavy ply only)	
○ 31	Knife trap	14
○ 32L	Lever—long, knife trap	14
32S	Lever—short, knife trap (for very heavy ply only)	
○ 33	Screw—knife trap pivot	14
○ 33L	Washer-lock—pivot screw	14
○ 33N	Nut—pivot screw	14
○ 34	Rivet—knife trap	14
○ 35	Spring—knife trap	14
○ 35A	Stud-knife trap spring	14
○ 36	Knife	14
○ 37	Screw—knife mounting	14
○ 38	Button—stringholder	14
○ 39L	Spring—light, stringholder button (for 10 ply and below)	14
39H	Spring, heavy, stringholder button (for 12 ply and above)	
○ 40	Nut—stringholder button	14
○ 41	Washer—stringholder button	14
○ 42	Lever-release, stringholder button	14
○ 43	Screw-release lever	14
○ A45	Drawslide assembly—regular (sold with A47 only)	13
A45C	Drawslide assembly—clamp type (sold with A47 only)	13
A45D	Drawslide assembly—double headed type	
○ A47	Cap assembly—drawslide	13
○ 47A	Roller—drawslide cap	13
○ 47B	Stud-roller—drawslide cap	13
○ 47C	Screw—drawslide cap	13
○ 47D	Washer-lock—drawslide cap	13
○ A49	Lever assembly—drawslide	
○ 49A	Washer—lever retaining	13
○ 49B	Screw—lever retaining	13
○ 49C	Roller—drawslide lever	13
○ 49D	Stud-roller—drawslide lever	13
○ 50	Spring—drawslide (post office trip)	13—15
○ 50A	Pin—grooved	13
○ A51	Tip-up assembly	13
○ 51A	Rivet—tip-up lever	13
○ 51L	Lever—tip-up	13
△ □ ○ 52	Stripper—(styles listed below)	13
△ □ ○ 52A	Stripper—light, regular	
△ □ 52B	Stripper—heavy, regular	
△ □ 52LA	Stripper—light, laundry	
△ □ 52LB	Stripper—heavy, laundry	
○ 53	Screw-stripper	13
○ 54	Spring-stripper	13
○ 55	Lever-riser	13
○ 55A	Screw-riser lever stop	13
○ 55B	Nut-riser lever stop screw	13
○ 56	Guide—riser pin	13
○ 56A	Screw—guide mounting	13
○ 57	Pin—riser	13
58	Spring—trip	15
○ 59	Bell-crank trip	15
○ 59PO	Bell-crank trip—regular	
60A	Nut-pivot screw (clamp model & replacement)	
60	Screw-pivot, (clamp model & replacement on old style)	
○ 61	Screw-pivot	15
○ 61A	Nut-pivot screw	15
○ 61B	Washer-lock—pivot screw	15
62	Rod-trip—(sizes below)	17
○ 62PO	Rod-trip	15
□ 62S	Rod-trip, short (23″)	
□ 62T	Rod-trip, medium (24⅛″)	
□ 62U	Rod-trip, long (28½″)	
62N	Nut-trip rod	17
62W	Washer-trip rod	17
○ A63	Fork assembly—clutch	
○ 63	Fork—clutch	15
○ 64	Roller-clutch fork	15
○ 65	Screw—clutch fork roller	15—17
○ 66H	Pin-clutch fork pivot (includes cotter pins)	15
○ 67	Bearing—lower	15
○ 67S	Screw—lower bearing	15
□ A68	Loose table assembly	17
○ 68P1	Pin—loose table retaining, for ¾″ diam. stud	16—17
68P2	Pin—loose table retaining, for ⅞″ diam. stud	16
68S	Housing—ball bearing, double (loose table)	
68S short	Housing—ball bearing, single (loose table)	
69	Yoke—clamp	
69R	Rod—yoke	
69T	Screw—thumb, yoke clamp	
70	Lever—short	
70P	Pin—taper, short lever	
70R	Roller—short lever	
70S	Stud-roller—short lever	
71	Lever—long	
71LS	Stud—large, long lever	

○Used in post office models, too. Order may be written with "P.O." appended to part number.
□Must order with machine serial number. △Specify twine size used. ☆Used with backgeared models.

Part No.	Description	Illustrated on Page Number
71SS	Stud—small, long lever	
72	Rod—yoke lever pivot	
72C	Collar—pivot rod	
72CS	Screw—pivot rod collar	
73	Joint—yoke	
73P	Pin—taper, yoke joint	
74	Fork—yoke	
74A	Plate—yoke fork cap	
74B	Rivet—cap plate	
74C	Pin—yoke fork	
74D	Plate—narrow, fork guide	
74E	Plate—wide, fork guide	
74F	Screw—guide plate	
□ ○ 75A	'V' Belt	17
75B	Bushing—motor pinion	
□ 75P-11	Pinions—motor	
□ 75P-12	Pinions—motor	
□ 75P-13	Pinions—motor	
□ 75P-14	Pinions—motor	
□ 75P-15	Pinions—motor	
□ 75P-18	Pinions—motor	
□ 75P-20	Pinions—motor	
□ 75P-22	Pinions—motor	
□ 75-S	Pinions—motor	17
□ ○ 75S-15	Sheave—motor	
□ 75S-17	Sheave—motor	
□ 75S-20	Sheave—motor	
□ 75S-22	Sheave—motor	
○ 75SS	Screw—set, motor sheave	17
75Q	Key—fibre pinion	
□ 76	Gear—main cam	15
□ 76B	Gear—main cam (for two wrap cross tie & laundry models)	
□ 76E	Gear—main cam (single wrap clamp models)	
□ ○ 76EP	Gear—main cam (single wrap models)	
□ 76F	Gear—main cam (for 10″ & 16″ cross tie models & all one-way machines)	
○ 76SS	Screw-set—short, main cam gear	15
○ 76SL	Screw-set—long, main cam gear	15
○ 77	Key—main cam gear	15
□ ○ 78	Shaft—main	15
□ ○ A79	Clutch gear & shaft assembly—single	
□ A79D	Clutch gear & shaft assembly—double	
□ ○ A79A	Clutch pulley & shaft assembly —single, (8¼″ diam.)	
□ A79AD	Clutch pulley & shaft assembly —double (8¼″ diam.)	
	Clutch pulley & shaft assembly —large, single (9¼″ diam.)	
	Clutch pulley & shaft assembly —large, double (9¼″ diam.)	
□ 79	Gear assembly—single clutch	
□ 79D	Gear assembly—double clutch	
□ ○ 79A	Pulley assembly—single clutch, small (8¼″ diam.)	15
□ 79AD	Pulley assembly—double clutch, small (8¼″ diam.)	15
□ 79AL	Pulley assembly—single clutch, large (9¼″ diam.)	
□ 79ADL	Pulley assembly—double clutch, large (9¼″ diam.)	
○ 79B	Rivet—clutch disc	15
○ 79C	Bearing—clutch	15
○ 79E	Disc—clutch	15
○ 80A	Pinion—clutch shaft, 1-cut	15
80B	Pinion—clutch shaft, 2-cut	15
○ 80P	Pin—taper, pinion	15
□ ○ 81	Shaft—single clutch	15
□ 81A	Shaft—double clutch	15
○ 82	Clutch member—outer	15
82A	Clutch member—inner	15
82B	Pin-taper—double clutch member	15
○ 83	Collar—clutch pulley	15
○ 83A	Collar—clutch shaft end	15
○ 83D	Pin-collar—clutch pulley	15
○ 83E	Pin-end collar—clutch pulley	15
□ ○ 84	Spring—clutch	15
□ 85	Twine arm	16
□ A85BB	Twine arm assembly—ball bearing	16
□ A85NB	Twine arm assembly—needle bearing	16
□ ○ A85BrB	Twine arm assembly—bronze bearing	16—17
□ ☆ A85BG	Twine arm assembly—back geared	16
○ 85PO	Twine arm	
□ 85-102	Twine arm—10″ 2 wrap	
□ 85-162	Twine arm—16″ 2 wrap	
□ 85-163	Twine arm—16″ 3 wrap	
□ 85-182-4	Twine arm—18″ 2 wrap ext. 4″	
□ 85-183-4	Twine arm—18″ 3 wrap ext. 4″	
□ 85-202-4	Twine arm—20″ 2 wrap ext. 4″	
□ 85-203-4	Twine arm—20″ 3 wrap ext. 4″	
□ 85-232-4	Twine arm—23″ 2 wrap ext. 4″	
□ 85-233-4	Twine arm—23″ 3 wrap ext. 4″	
□ 85-262	Twine arm—26″ 2 wrap	
□ 85-263	Twine arm—26″ 3 wrap	
85BR2	Bearing—bronze, 2 wrap twine arm	
○ 85BR3	Bearing—bronze, 3 wrap twine arm	
85C	Collar—twine arm stem	
85CS	Screw-set, collar	
○ 852D1	Ring—retaining	16
○ 85E	Eye—twine guide	16
85F	Plate-bearing retaining	
85FP	Pin-plate	
85FS	Screw-plate	
85GP	Pin—drawback spring	
☆ 85K	Gear—21T. twine arm transfer	
☆ 85LS	Gear—42T. twine arm pivot	
☆ 85LL	Gear-back—loose table	
85M	Key-sprocket—twine arm	
☆ 85N	Shaft-transfer—twine arm	
☆ 85NA	Bearing-transfer shaft— twine arm	

○Used in post office models, too. Order may be written with "P.O." appended to part number.
□Must order with machine serial number. △Specify twine size used. ☆Used with backgeared models.

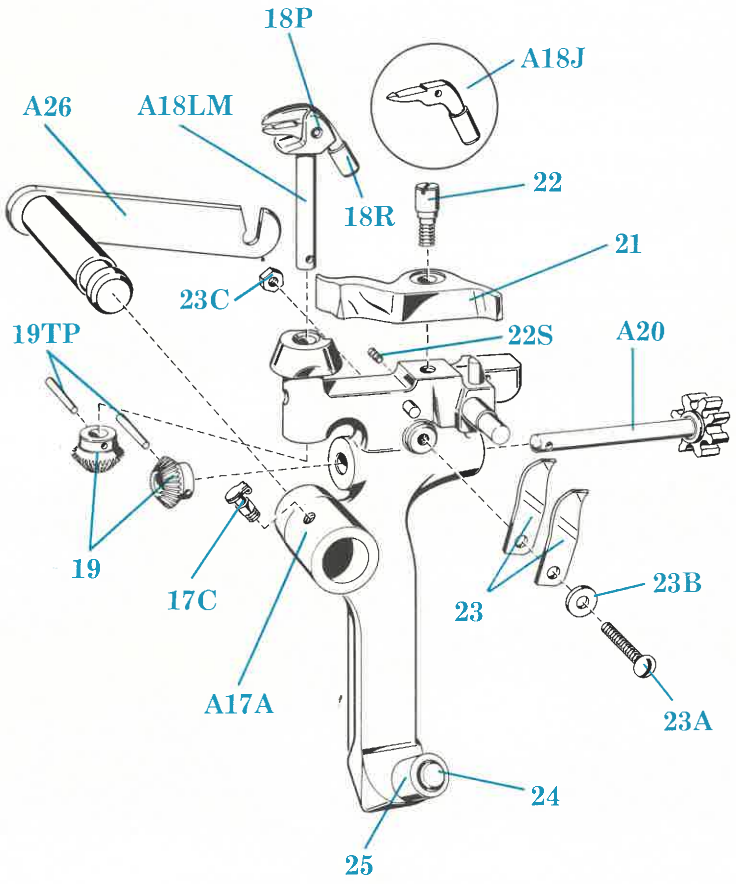
Part No.	Description	Illustrated on Page Number
85P2	Pin—15T. sprocket, twine arm	
85P3	Pin—12T. sprocket, twine arm	
85Q	Pin-taper—twine arm transfer gear	
85R	Race-needle bearing—1″ long	
85S	Spacer—twine arm stem—¾″ long	
85TB-A	Bearing-needle—½″ long	
85TB-B	Bearing-needle—1″ long	
85TB-S	Spacer-bearing—1⅞″ long	
☆ 85U	Bearing-ball—T. A. pivot	
☆ 85V	Housing—ball bearing	
85W	Washer-thrust, T.A. stem	
☆ 85X	Flag-T.A. back gear	
☆ 85XS	Screw—flag mounting	
90A	Caster—2½″ plastic, regular	17
90H	Caster—3″ plastic, lock	
○ 90J	Caster—3″ plastic, regular	
○ 90S	Sleeve—caster	17
○ 91A	Nut-knurled tension—small	17
91B	Nut-knurled tension—large (used on tension booster only)	
○ 92	Spring—tension	17
○ 92Q	Stud—tension spring	
○ 92R	Screw—tension spring	
○ 93G	Guard—running tension	
93M	Bracket—large tension holder	17
93S	Screw—bracket mounting	
○ A94	Lever assembly—pressure trip	15
□ 94L	Lever-trip—model 'L'	
□ 94M	Lever-trip—model 'M'	17
□ 94U	Bracket—'U' trip support	
□ 94UI	Treadle—'U' trip	
94N	Washer-trip lever pivot	17
94P	Screw-trip lever pivot	17
○ 94PS	Spring—pressure trip	15
○ 94Q	Stud—pressure trip spring	
○ 94S	Screw—pressure trip bearing	13—15
○ 94T	Bearing—pressure trip	13—15
○ 94TP	Pin—bearing locating	
○ 94V	Collar-P.T. pivot stud	15
○ 94W	Screw-set—collar	
96	Spring—straight hook pressure	
A103-6	Drawback lever assembly—6″	
○ A103-8½	Drawback lever assembly—8½″	16
A103-10	Drawback lever assembly—10″	
A103-12	Drawback lever assembly—12″	
103R	Rivet—drawback pivot arm	
103S	Screw-set—drawback	16
○ 104L	Spring—light drawback (up to 16″)	16
104M	Spring—medium drawback (18″ model & above)	
105	Clip—drawback spring	16
106N	Screw—drawback	16
○ 110	Twine can—regular	17
110JO	Twine can—jumbo, outside mounting	
110JU	Twine can—jumbo, under machine mounting	
○ 110CL	Cone—wooden, large	
110CS	Cone—wooden, small	
○ 110D	Screw—cone mounting	
○ 110P	Disc—fibre	
110PR	Disc—foam plastic	
○ 110T	Screw—can mounting	
□ 111	Pad—straight yoke	
□ 111N	Nut—straight yoke pad	
□ 111S	Screw—straight yoke pad	
112	Lever—clutch block kickout, large (replacement-old style)	
○ 112A	Lever—clutch block kickout, small	15
○ 112W	Wedge—kickout lever	15
○ 112WS	Stud—kickout lever wedge	15
115A	Screw—tension booster adjusting	
115TB-B	Bracket—tension booster	
115TB-R	Rocker arm—tension booster	
115G	Guard—tension booster	
115H	Screw—tension booster guard	
115S	Screw—tension booster bracket mounting	
115T	Screw—tension booster rocker pivot	
115U	Nut—tension booster rocker pivot screw	
115V	Spring—compression, tension booster	
115W	Plunger—compression spring, tension booster	
○ A116	Running tension assembly	
○ 117	Screw—assembly mounting	17
118C	Collar-T.B. plunger	
118P	Plunger-tension—booster	
118S	Screw-set—T.B. plunger collar	
119	Guide—T.B.	
119A	Stud—T.B. spring	
119B	Spring—tension booster	
119C	Stud—T.B. spring rocker	
119N	Nut-T.B. guide lock	
120	Cam—tension booster	
121	Screw—T.B. cam	
122	Pin—T.B. cam	
□ ○ 123C	Chain-roller	17
□ ○ A123SA	Chain gear assembly	15
○ 123SA	Shoe—small radius, chain gear	15
123SB	Shoe—large radius, chain gear (roll towel & 10″ models only)	
○ 123R	Rivet—chain gear shoe	
123D2	Stud—chain gear, 2W	15
○ 123D3	Stud—chain gear, 3W	
☆ 123D2BG	Stud—chain gear, 2W back gear	
☆ 123D3BG	Stud—chain gear, 3W back gear	
123MR-BG	Stud—chain gear, meat roll	
○ 123E	Screw-set, chain gear stud	17
□ 124-10	Shield—10″ machine	
□ ○ 124-16	Shield—16″ machine	17
□ 124-18	Shield—18″ machine	
□ 124-20	Shield—20″ machine	
□ 124-23	Shield—23″ machine	
□ 124-26	Shield—26″ machine	
○ 124S	Screw—shield mounting	17
□ 125	Brake—casting	17
□ A125	Brake assembly	
□ ○ A125PO	Brake pad assembly	17

○ Used in post office models, too. Order may be written with "P.O." appended to part number.
□ Must order with machine serial number. △Specify twine size used. ☆ Used with backgeared models.

Part No.	Description	Illustrated on Page Number
□ 125A	Rod—brake adjusting	17
○ 125APO	Rod—brake adjusting	
○ 125BL	Nut—brake adjusting rod	17
○ 125WL	Washer—brake adjusting rod	17
○ 125P	Pivot—brake	17
○ 125Q	Pin—brake pivot cotter	17
○ 126	Plate—motor	17
□ ○ 126A	Bracket—motor plate	17
○ 126N	Nut—bracket screw	
○ 126R	Riser—motor plate	17
○ 126S	Screw—frame	17
□ ○ 127	Standard—knotter	
○ 127S	Screw—knotter standard	17
128	Loop—jumbo twine can	
○ 128A	Loop—regular twine can	17
○ 128AS	Screw—loop mounting	17
129A	Cord set—regular, 8 ft. with switch	17
129B	Cord set—grounded, 8 ft. with switch	
129C	Cord set—3 phase, 8 ft. with switch	
○ 129DB	Cord set—post office, 12 ft. with switch & pilot light	
○ 129DBL	Light—pilot	
129F	Switch toggle	
○ 129S	Screw—switch mounting	17
○ 130	Motor—electric (give information from motor specification plate)	17
132E10	Guard—expanded metal, 10″ machine	
132E16	Guard—expanded metal, 16″ machine	17
□ ○ 132E16PO	Guard—expanded metal	
□ 132E18	Guard—expanded metal, 18″ machine	
□ 132E20	Guard—expanded metal, 20″ machine	
□ 132E23	Guard—expanded metal, 23″ machine	
□ 132S18	Guard—strap metal, 18″ machine	
□ 132S20	Guard—strap metal, 20″ machine	
□ 132S23	Guard—strap metal, 23″ machine	
□ 132S34	Guard—strap metal, 34″ machine	
□ 132S10MR	Guard—strap metal, 10″ meat roll machine	
□ 132S16MR	Guard—strap metal, 16″ meat roll machine	
□ 132E8	Guard—expanded metal, 8″ roll towel machine	

A17L—Knotter Head Assembly

Light (10 ply and below)



○	A17A	Knotter head sub-assembly
○	17C	Oil cup
△ ○	A18J	Knotter-jaw assembly
△ ○	A18LM	Knotter body assembly—light, with miter gear
○	18P	Pin-knotter jaw
○	18R	Roller-knotter jaw
○	19	Gear-miter knotter
○	19TP	Pin-taper, knotter miter gear
○	A20	Star wheel assembly, with miter gear
○	21	Lever-knotter
○	22	Screw—knotter lever
○	22S	Screw-set, knotter lever screw
○	23	Spring—knotter flat
○	23A	Screw-knotter flat spring
○	23B	Washer—knotter flat spring
○	23C	Nut—knotter flat spring
○	24	Stud—knotter head roller
○	25	Roller—knotter head
○	A26	Pivot assembly—knotter head

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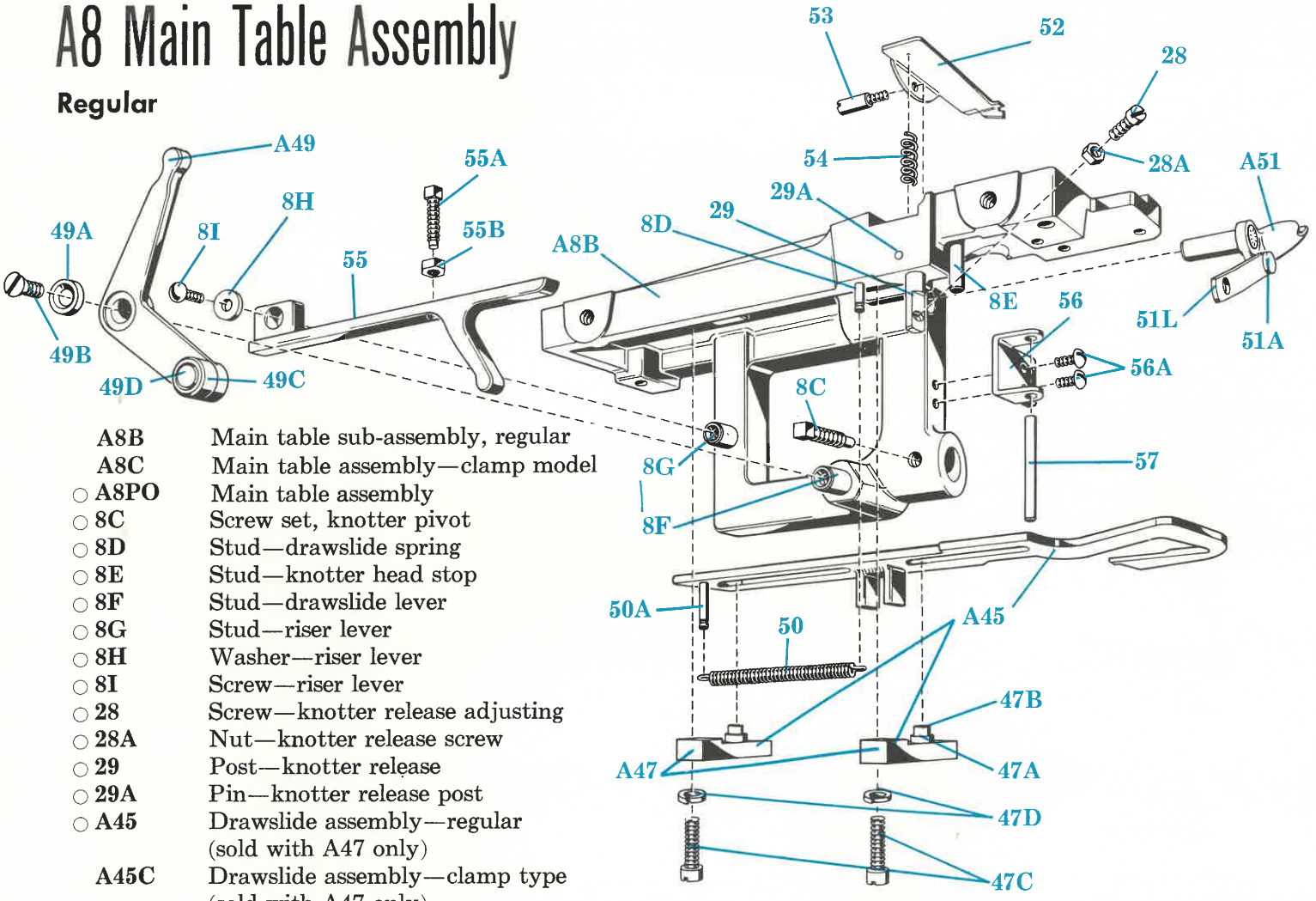
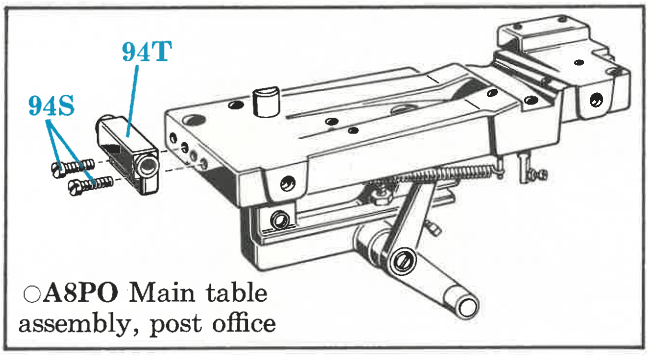
□Must order with machine serial number. △Specify twine size used. ☆Used with backgeared models.

A8 Main Table Assembly

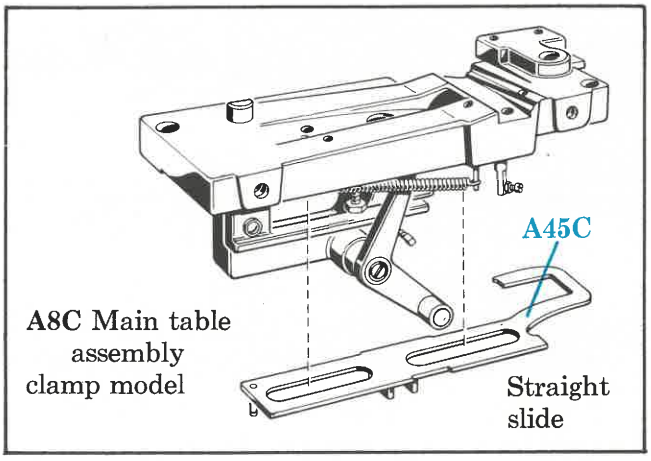
Regular



	A8B	Main table sub-assembly, regular
	A8C	Main table assembly—clamp model
○	**A8PO**	Main table assembly
○	**8C**	Screw set, knotter pivot
○	**8D**	Stud—drawslide spring
○	**8E**	Stud—knotter head stop
○	**8F**	Stud—drawslide lever
○	**8G**	Stud—riser lever
○	**8H**	Washer—riser lever
○	**8I**	Screw—riser lever
○	**28**	Screw—knotter release adjusting
○	**28A**	Nut—knotter release screw
○	**29**	Post—knotter release
○	**29A**	Pin—knotter release post
○	**A45**	Drawslide assembly—regular (sold with A47 only)
	A45C	Drawslide assembly—clamp type (sold with A47 only)
○	**A47**	Cap assembly—drawslide
○	**47A**	Roller—drawslide cap
○	**47B**	Stud-roller, drawslide cap
○	**47C**	Screw—drawslide cap
○	**47D**	Washer-lock—drawslide cap
○	**A49**	Lever assembly–drawslide
○	**49A**	Washer—lever retaining
○	**49B**	Screw—lever retaining
○	**49C**	Roller—drawslide lever
○	**49D**	Stud-roller, drawslide lever
○	**50**	Spring—drawslide (post office trip)
○	**50A**	Pin-grooved
○	**A51**	Tip-up assembly
○	**51A**	Rivet—tip-up lever
○	**51L**	Lever—tip-up
△ □ ○	**52**	Stripper
○	**53**	Screw-stripper
○	**54**	Spring-stripper
○	**55**	Lever-riser
○	**55A**	Screw-riser lever stop
○	**55B**	Nut-riser lever stop screw
○	**56**	Guide—riser pin
○	**56A**	Screw—guide mounting
○	**57**	Pin—riser
○	**94S**	Screw—pressure trip bearing
○	**94T**	Bearing—pressure trip



○**A8PO** Main table assembly, post office

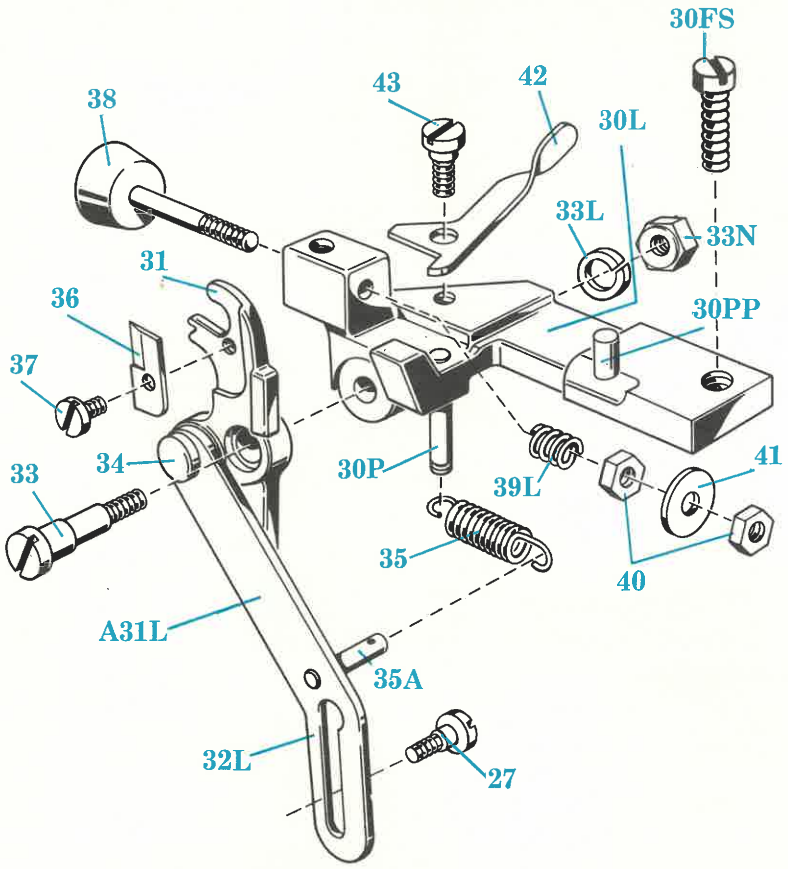


A8C Main table assembly clamp model

Straight slide

A30L—Stringholder Assembly

Light, Regular (Post Office)
10 Ply Twine and Under

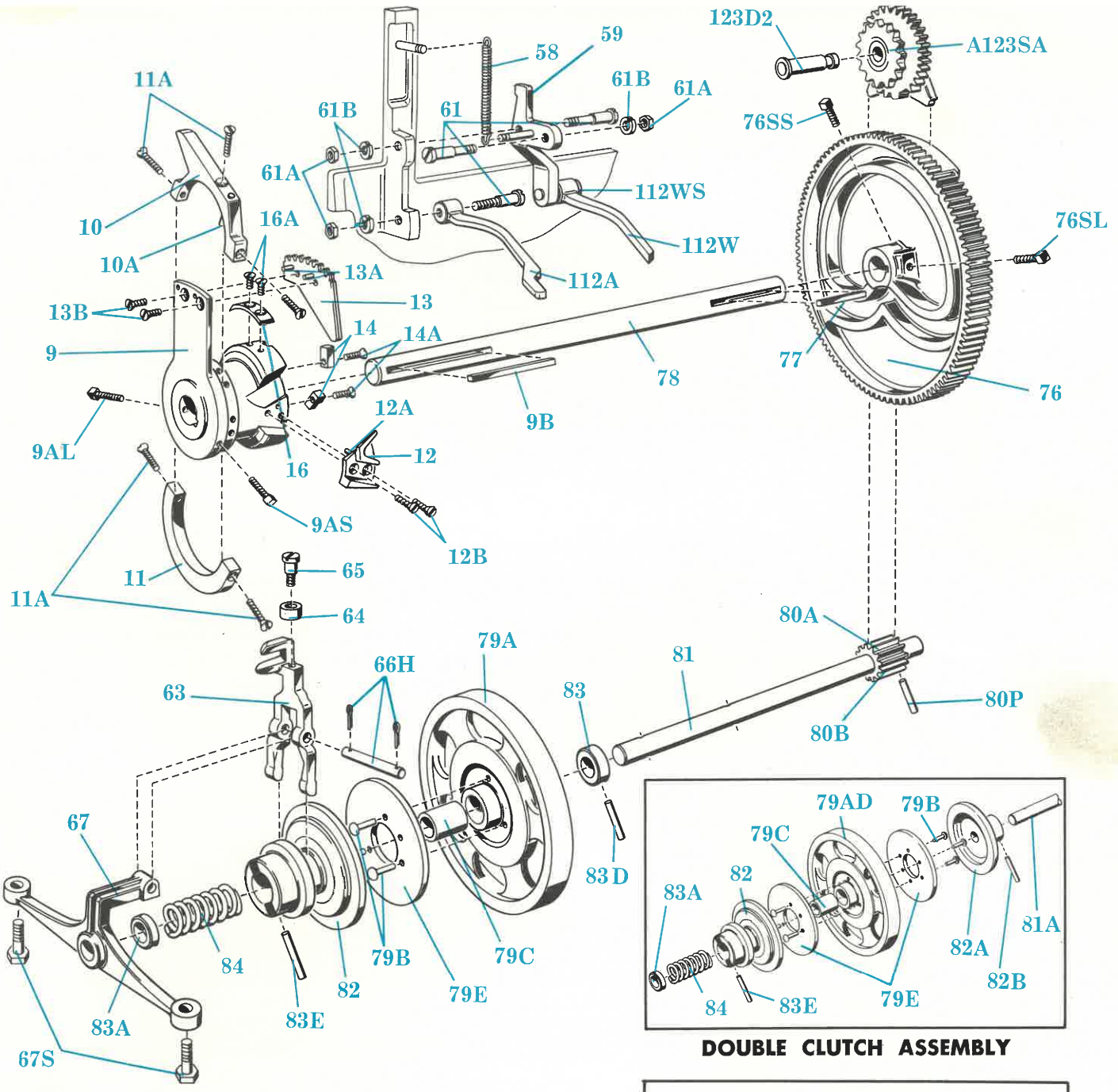


○	27	Screw—knife trap
○	30FS	Screw—stringholder mounting
△□○	30L	Stringholder sub-assembly—light, regular
○	30P	Pin—spring perch
○	30PP	Pin—stringholder locating
○	A31L	Knife trap assembly, long lever
○	31	Knife trap
○	32L	Lever—long, knife trap
○	33	Screw—knife trap pivot
○	33L	Washer-lock, pivot screw
○	33N	Nut—pivot screw
○	34	Rivet—knife trap
○	35	Spring—knife trap
○	35A	Stud-knife trap spring
○	36	Knife
○	37	Screw—knife mounting
○	38	Button—stringholder
○	39L	Spring—light, stringholder button (for 10 ply and below)
○	40	Nut—stringholder button
○	41	Washer—stringholder button
○	42	Lever-release, stringholder button
○	43	Screw-release lever

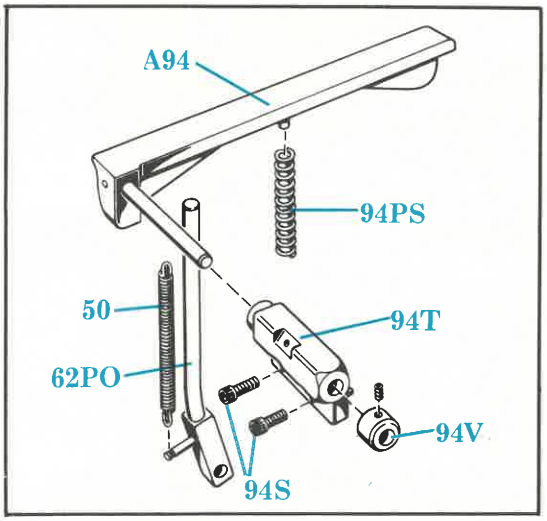
Cam Wheel, Clutch & Chain Gear Assemblies

□○	9	Cam wheel
○	9AL	Screw—set, long, cam wheel
○	9AS	Screw—set, short, cam wheel
○	9B	Key—cam wheel
	10 & 11	Cam—drawslide, regular—(sold in pairs only)
○	10A	Pin-dowell, drawslide cam
○	11A	Screw—drawslide cam
□○	12	Switch—knotter head cam
□○	12A	Pin—switch
□○	12B	Screw—switch
○	13	Rack—knotter
○	13A	Pin—knotter rack
○	13B	Screw—knotter rack
○	14	Kick-out, clutch, regular
○	14A	Screw—clutch kick-out
□○	16	Cam riser
○	16A	Screw—riser cam
○	50	Spring—drawslide (post office trip)
	58	Spring—trip
○	59	Bell crank—trip
○	61	Screw—pivot
○	61A	Nut—pivot screw
○	61B	Washer—lock, pivot screw
○	62PO	Rod-trip
○	63	Fork—clutch
○	64	Roller—clutch fork
○	65	Screw—clutch fork roller
○	66H	Pin—clutch fork pivot (includes cotter pins)
○	67	Bearing—lower
○	67S	Screw—lower bearing
□	76	Gear—main
○	76SL	Screw-set, long, main cam gear
○	76SS	Screw-set, short, main cam gear
○	77	Key—main cam gear
□○	78	Shaft—main
□○	79A	Pulley assembly—single clutch, small (8¼ diam.)
□	79AD	Pulley assembly—double clutch, small (8¼ diam.)
○	79B	Rivet—clutch disc
○	79C	Bearing—clutch
○	79E	Disc—clutch
○	80A	Pinion—clutch shaft, 1-cut
	80B	Pinion—clutch shaft, 2-cut
○	80P	Pin—taper, pinion
□○	81	Shaft—single clutch
□	81A	Shaft—double clutch
○	82	Clutch member—outer

○Used in post office models, too. Order may be written with "P.O." appended to part number.
□Must order with machine serial number. △Specify twine size used. ☆Used with backgeared models.



DOUBLE CLUTCH ASSEMBLY



POST OFFICE PRESSURE TRIP

	82A	Clutch member—inner
	82B	Pin-taper, double clutch member
○	**83**	Collar—clutch pulley
○	**83A**	Collar—clutch shaft end
○	**83D**	Pin-collar—clutch pulley
○	**83E**	Pin-end collar—clutch pulley
□ ○	**84**	Spring—clutch
○	**A94**	Lever assembly—pressure trip
○	**94PS**	Spring—pressure trip
○	**94S**	Screw—pressure trip bearing
○	**94T**	Bearing—pressure trip
○	**94V**	Collar—P.T. pivot stud
○	**112A**	Lever—clutch block kickout, small
○	**112W**	Wedge—kickout lever
○	**112WS**	Stud—kickout lever wedge
□	**123D2**	Stud—chain gear, 2W
□ ○	**A123SA**	Chain gear assembly

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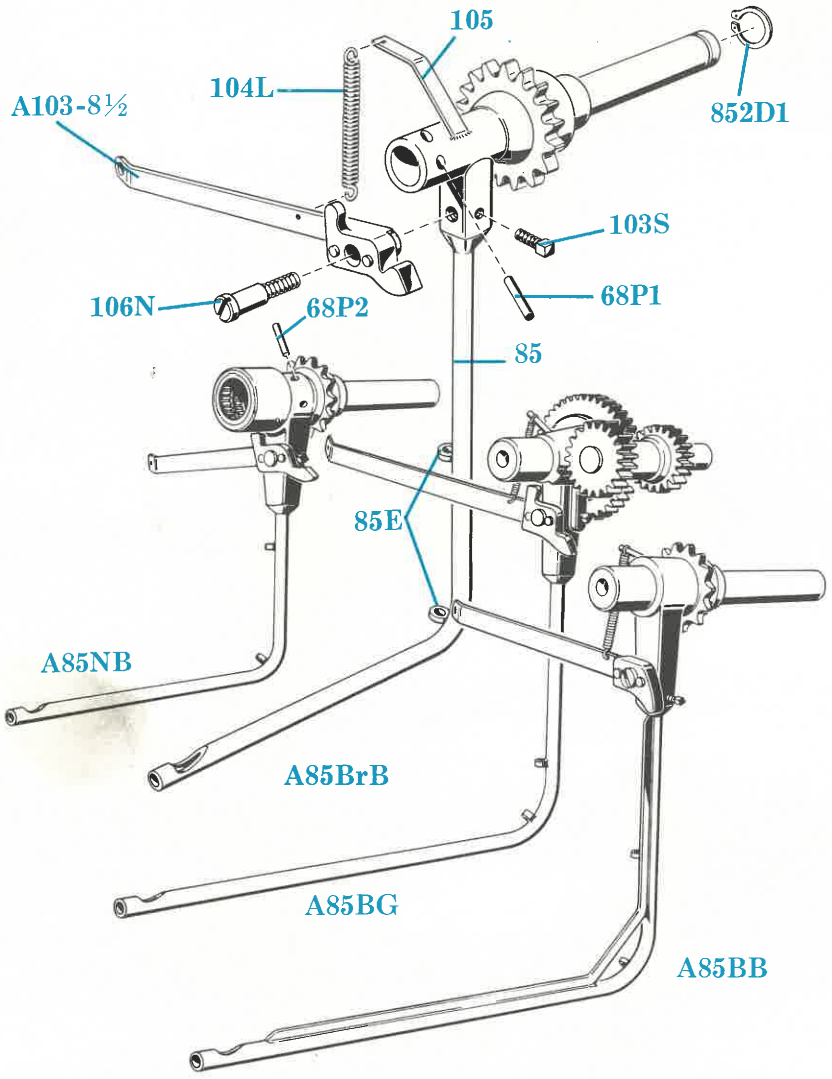
□Must order with machine serial number. △Specify twine size used. ☆Used with backgeared models.

Twine Arm Assemblies

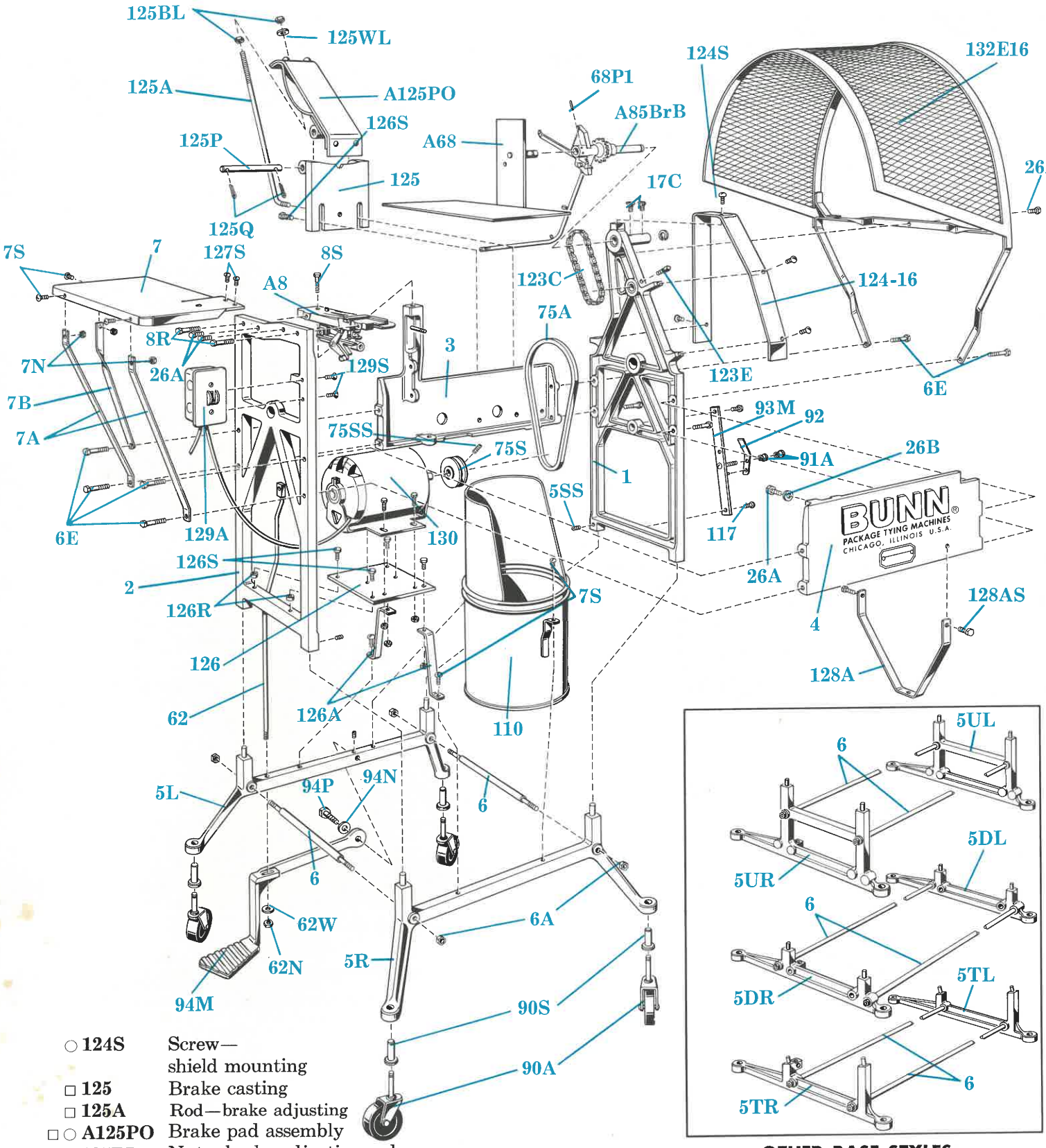


○	**68P1**	Pin—loose table retaining, for ¾″ dia. stud
	68P2	Pin—loose table retaining, for ⅞″ dia. stud
□	**A85BB**	Twine arm assembly—ball bearing
□ ☆	**A85BG**	Twine arm assembly—back geared
□ ○	**A85BrB**	Twine arm assembly—bronze bearing
□	**A85NB**	Twine arm assembly—needle bearing
□	**85**	Twine arm
○	**852D1**	Ring—retaining
○	**85E**	Eye—twine guide
	103S	Screw-set—drawback
○	**A103-8½**	Drawback lever assembly—8½″
○	**104L**	Spring—light drawback (up to 16″)
	105	Clip—drawback spring
	106N	Screw—drawback

Base Parts

□ ○	**1**	Frame—left end (tent)
○	**2**	Frame—front end (square)
□ ○	**3**	Frame—near side, long
□ ○	**4**	Frame—far side, long
	5L	Base—left side, long, regular
	5R	Base—right side, long, regular
○	**5LPO**	Base—left side, long
○	**5RPO**	Base—right side, long
	5DL	Base—left side, low
	5DR	Base—right side, low
	5UL	Base—left side, high
	5UR	Base—right side, high
	5TL	Base—left side, tilted
	5TR	Base—right side, tilted
	5SS	Screw—socket set, base
○	**6A**	Nut-base tie-rod
□ ○	**6**	Tie-rod-base (specify length measure shoulder to shoulder)
	6E	Screw—hex. hd. cap
□	**7**	Trough—split type
□ ○	**7A**	Bracket—trough, front
□	**7B**	Bracket
○	**7N**	Nut—bracket screw
○	**7S**	Screw—bracket
	A8	Main table assembly, regular
○	**8R**	Screw—hex. hd., main table mtg.
○	**8S**	Screw—fil. hd., main table mtg.
○	**17C**	Oil cup
○	**26A**	Screw—pivot assembly lock
○	**26B**	Washer—pivot assembly lock screw
□	**62**	Rod-trip
	62N	Nut-trip rod
	62W	Washer-trip rod
□	**A68**	Loose table assembly
○	**68P1**	Pin—loose table retaining, for ¾″ diam. stud
□ ○	**75A**	'V' Belt
□	**75S**	Pinions—motor
○	**75SS**	Screw—set, motor sheave
□ ○	**A85BrB**	Twine arm assembly—bronze bearing
	90A	Caster—2½″ plastic, regular
○	**90S**	Sleeve—caster
○	**91A**	Nut-Knurled tension—small
○	**92**	Spring—tension
	93M	Bracket—large tension holder
□	**94M**	Lever-trip, model 'M'
	94N	Washer-trip lever pivot
	94P	Screw-trip lever pivot
○	**110**	Twine can—regular
○	**117**	Screw—assembly mounting
□ ○	**123C**	Chain-roller
○	**123E**	Screw-set, chain gear stud
□ ○	**124-16**	Shield—16″ machine

○Used in post office models, too. Order may be written with "P.O." appended to part number.
□Must order with machine serial number. △Specify twine size used. ☆Used with backgeared models.



OTHER BASE STYLES

○ **124S**	Screw—shield mounting	○ **128A**	Loop—regular twine can
□ **125**	Brake casting	○ **128AS**	Screw—loop mounting
□ **125A**	Rod—brake adjusting	**129A**	Cord set—regular, 8 ft. with switch
□ ○ **A125PO**	Brake pad assembly	○ **129S**	Screw—switch mounting
○ **125BL**	Nut—brake adjusting rod	○ **130**	Motor—electric (give information from motor spec. plate)
○ **125WL**	Washer—brake adjusting rod	**132E16**	Guard—expanded metal, 16″ machine
○ **125P**	Pivot—brake		
○ **125Q**	Pin—brake pivot cotter		
○ **126**	Plate—motor		
□ ○ **126A**	Bracket—motor plate, reg.		
□ ○ **126R**	Riser—motor plate		
○ **126S**	Screw—frame		
○ **127S**	Screw—knotter standard		

○Used in post office models, too. Order may be written with "P.O." appended to part number.
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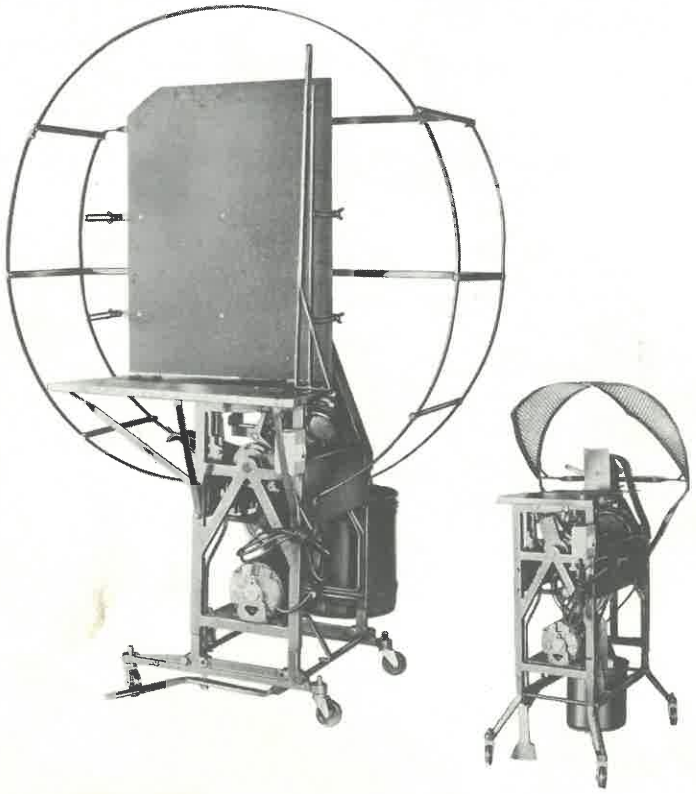
The RIGHT model



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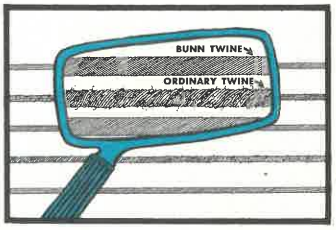

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