# Stringing Machine B-200

## MANUAL


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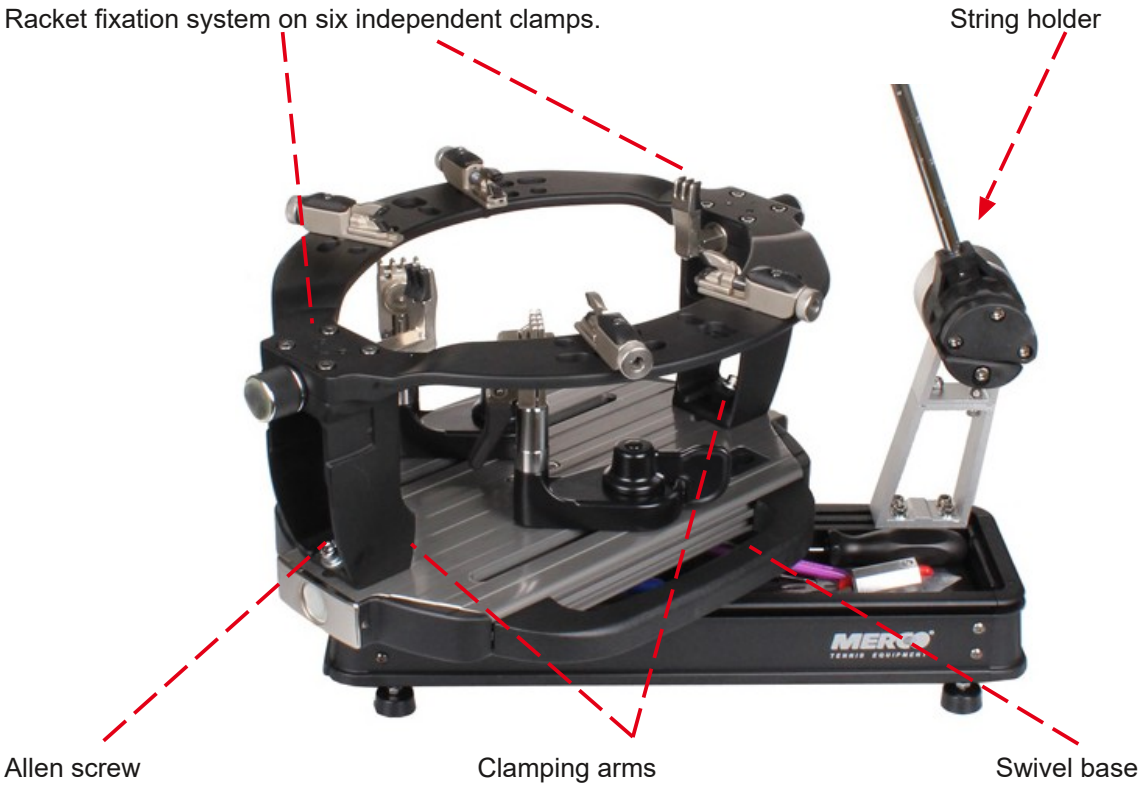
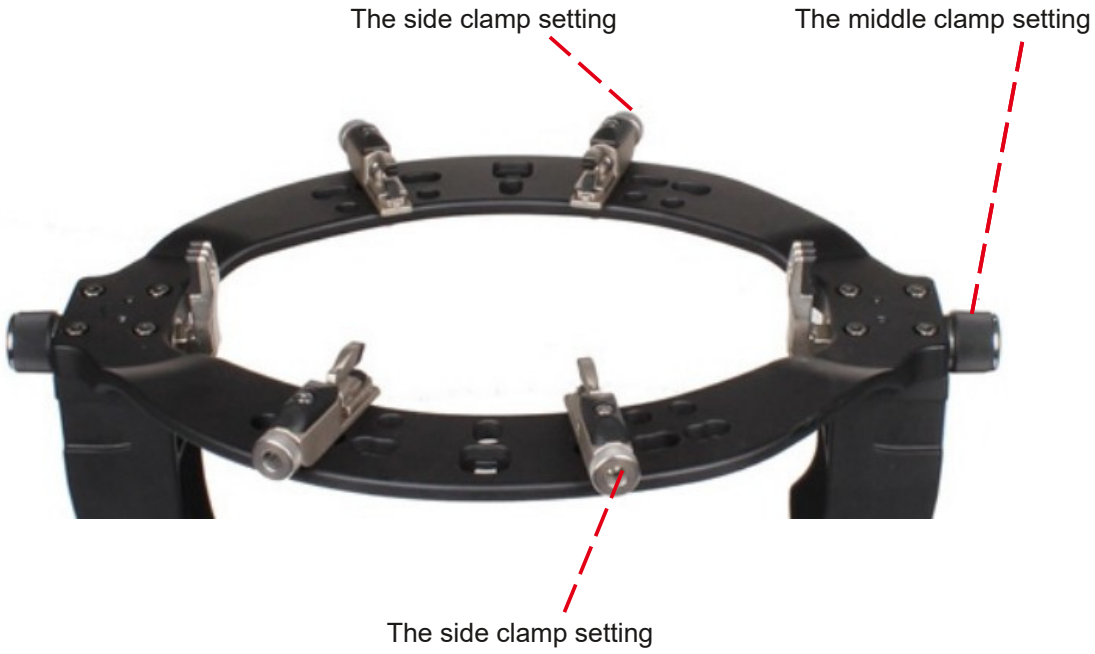
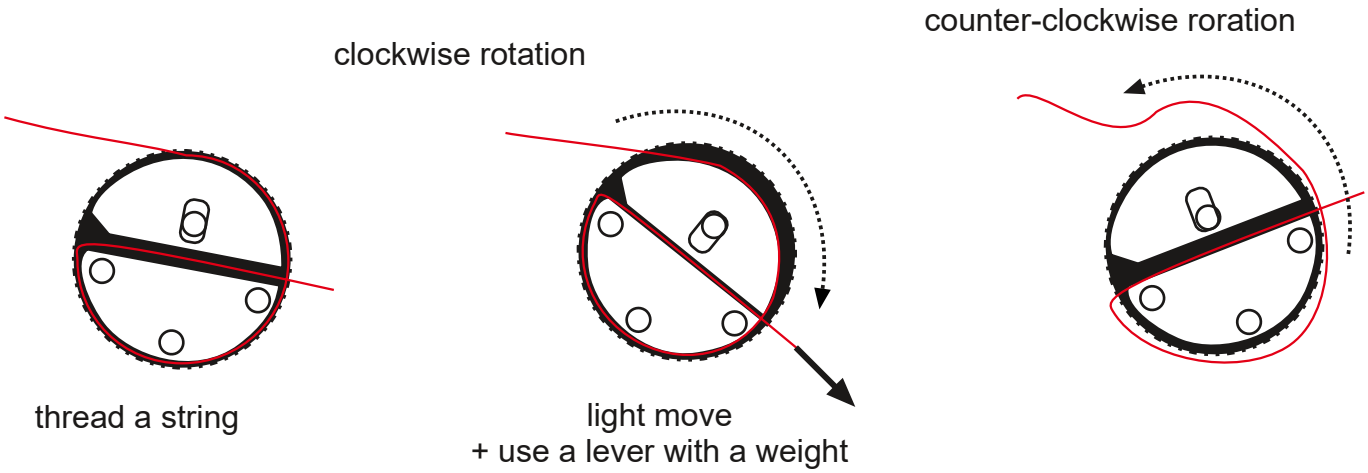
Country of origin: Taiwan




Clamping arms A and B can slide longitudinally along the rails of the swivel base.
Therefore, we have to unscrew and re-screw the screws F located on the base of the pads A and B with the help of the appropriate wrench with a handle, supplied with the machine.
The above procedure is used to make an approximate adjustment to the size of the racket.



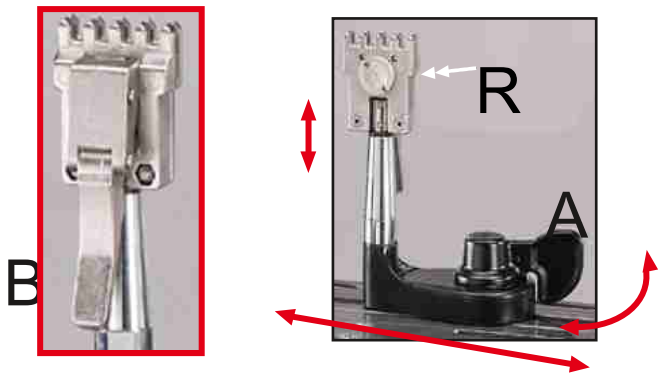
## PROCEDURE FOR ESTABLISHING A STRING




## WEIGHT


## ACCESSORIES

# ROTARY PLIERS




With these pliers, we can reach all places inside the racket and can attach the strings both vertically and horizontally.

Lever A fixes the pliers on the base. A deflection of 35 is enough to fix it. Do not press too hard.
Lever B fixes the pliers on the tensionable strings.
Screw R is used to adjust the pliers if we want to tighten or loosen the attachment to the string.

The ideal method for adjusting the pliers is to bring them closer to the string being attached so that the entire handle fits exactly to its diameter.

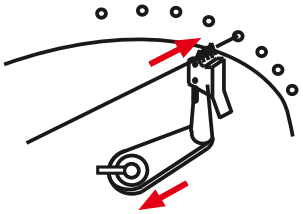
The pliers rotate 360 degrees on the base, move forward and backward along the rail in the base.

The final part with the fixing teeth is in the shape of a telescopic rod. So we can raise the pliers to get closer to the attached string. In order to secure the attachment of the string and prevent deformation, we recommend setting it according to the caliber of the string being used.

During regular monthly cleaning between the teeth, it is necessary to remove the silicone and nylon particles that settle down to prevent slippage. Pliers with five teeth and silicon processing with diamond powder are currently among the highest quality products. When cleaning, do not use metal or abrasive objects, but a cloth soaked in alcohol and let it work for a few minutes.

For perfect fixation of the string, we recommend bringing the pliers as close as possible to the frame.

IDEAL POSITION: Head fixed to the racket frame, body of pliers in the opposite direction or towards the inside of the racket.

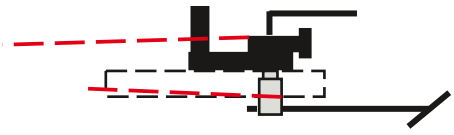


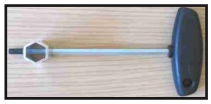
## SETTING THE FIXATION OF THE PLIERS ON THE STAND

This operation is not very common and must be performed with maximum attention and precision.
Bring the base of the rotary pliers closer to the corresponding hole under the rotary base.

You can access the fixing nut through the hole, using the appropriate screw pad from the equipment.
Set the fixation on the base while holding the upper part of the fixation lever with the wrench and you can tighten the fixing nut.

wrench
screw pad

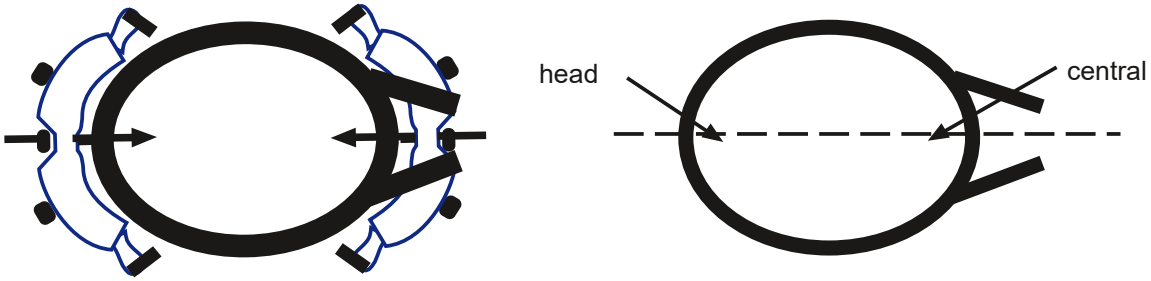




## CORRECT FIXATION OF THE RACKET

Fix the head of the racket between the arms A and B and fasten them with screws F (approximate adjustment to the size of the racket).

We remind you that the central clamps (head center) must be inside the frame, while the side clamps must be outside the frame.

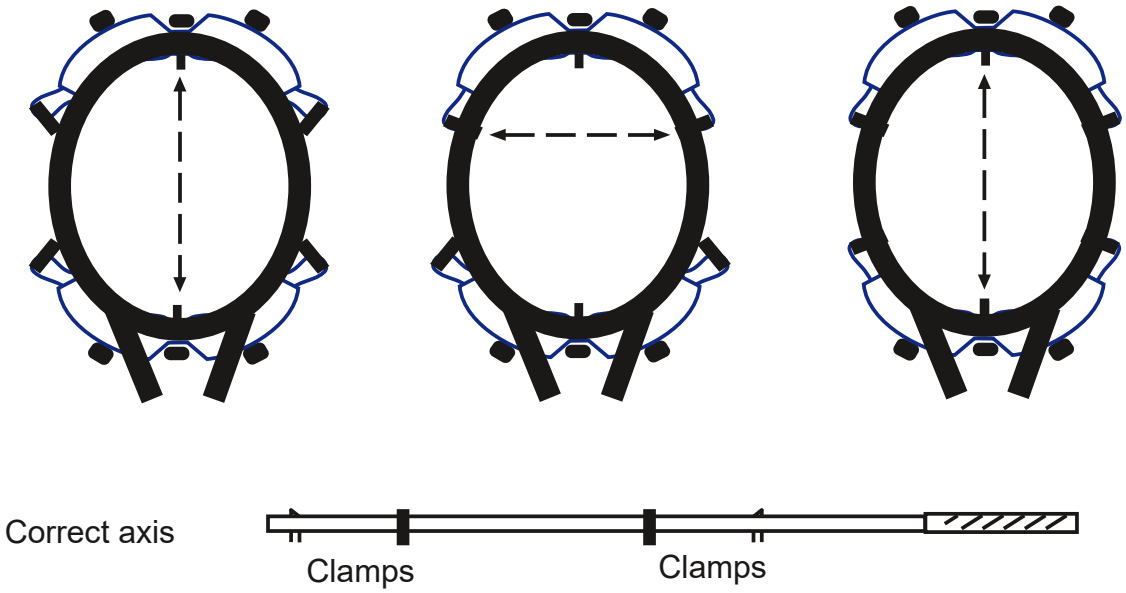



## IMPORTANT

Please pay special attention to the racket frame. The middle clamps must be located exactly on the middle axis of the racket. With an asymmetric fixation, the racket cannot be stringed and, in addition, it could cause the racket to break when the strings are stretched.

## CORRECT PROCEDURE FOR FIXING THE RACKET

Full adjustment is made with clamps that are independent and manipulated with levers. This allows for a secure fixation, preventing deformation and a longer perfect fit of the racket.
CAUTION: Never apply force to the clamp closure or attempt to move the racket into inappropriate positions. Correct fixation will prevent the racket from deforming more than allowed, but must not reverse deformation or squeeze the racket itself.

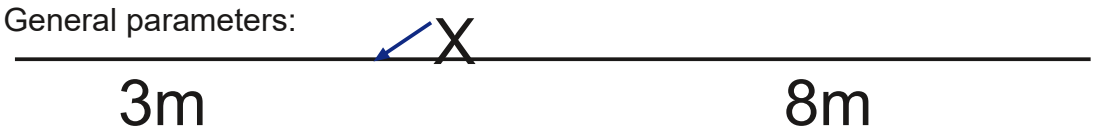



ATTENTION: Check that the frame is correctly aligned. In case of misalignment, damage and deformation or cracks may occur!

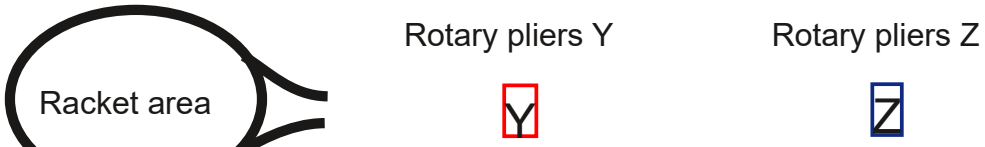
## BASIC TECHNIQUE

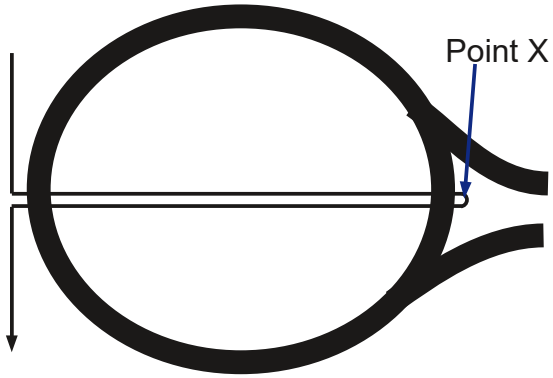
We start from the center of the longitudinal (longer) strings. This method is the most gentle for the racket frame and ensures the highest quality stringing. We often start the process by removing the original string (remember carefully where the strings were braided during the previous braiding) and dividing the string into two parts (see chapter point X). We will gradually weave all the longitudinal strings from the center to the edge. After fixing with a knot at the last longitudinal string, we go to the center again and knit the second half of the longitudinal strings and then switch to the horizontal (short) strings. Finish the procedure with a knot.

You can find a more detailed procedure here:
First, it is necessary to divide the string into two parts (half of the long strings - the other half of the long strings + all short strings). Most often, you can determine the distribution (we call the dividing point X point) from the ratio 3:8, this means that for an 11m string you divide the string into 3m and 8m, for a 12m string into 3.3m and 8.7m.

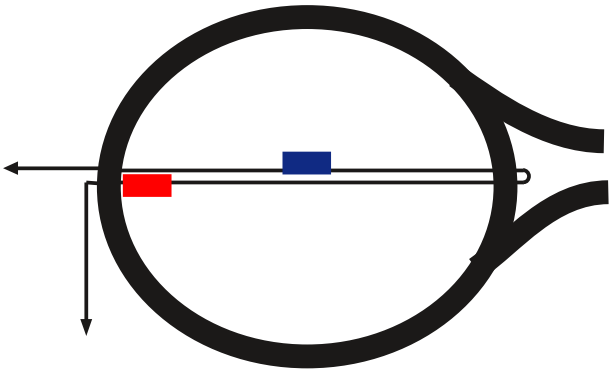



The length of the string is now divided by the point X in two different measures, namely: 3m for weaving half of the vertical string, 8m for weaving the remaining half of the vertical strings plus all the horizontal ones. This division allows almost all rockets to be spun. Gradually, with more experience, you can adapt these measures to individual types of rockets.
ATTENTION! The point X of the beginning of the weaving coincides with the center point of the vertical strings. This point is used as an orientation starting point and the methods of its placement are:- racquets with 3 pairs of string passages to the center:... point X of the start of weaving in the center.- rackets with 2 or 4 pairs of string passages to the center: point X of the beginning of weaving up.



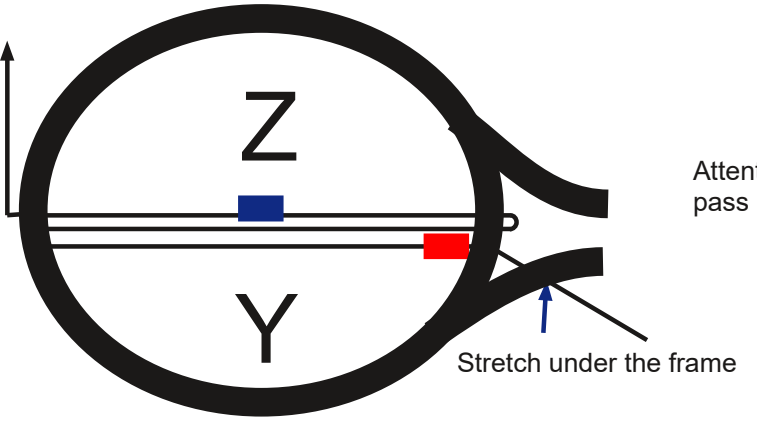




The letters Y and Z show the two different halves of the racket. This also applies to pliers. If we reverse the two halves, the procedure and the end result do not change. Before this operation, we need to make sure that the racket with the head-center clamps is correctly centered and string the two ends of the string, keeping the X point in the center.

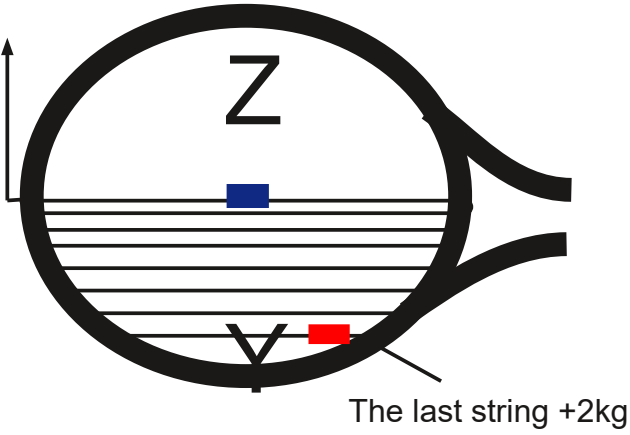


We fix the pliers Z in the middle of the first vertical string of part Z. We pull and fix the first vertical string of part Y after achieving the correct pull with the pliers Y.

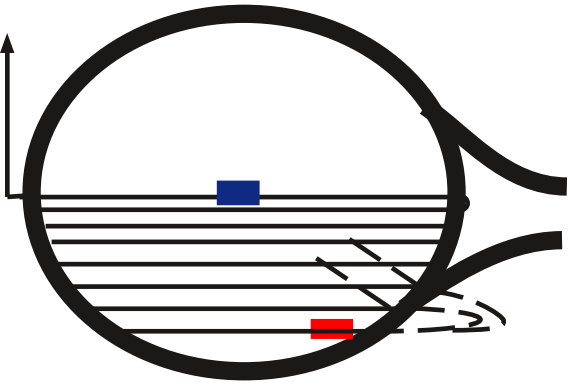
We proceed in the same way and pull string after string from the Y side.




Attention! The strings that come out of the holes in the middle must pass under the frame to avoid unwanted deformation during the pull.



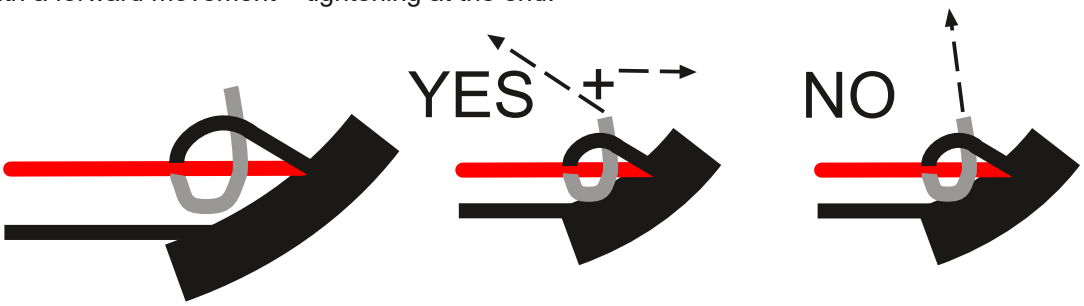

Attention! Try to place the pliers close to the racket frame. Pay special attention when weaving the last vertical string from the Y side. It must be pulled with a load 2kg higher than the tension of the other strings. This is because you will then end the string with a knot and there will be a natural loss of string tension. Use the node function (N1). After stretching the string, fix it with Y pliers and make a closing knot.



Insert the end of the string into the holes at the knot. There are usually 2 located in the crease of the racket. Only if the string cannot pass, special hooks can be used to widen the opening. Be careful not to damage the string that is already in the hole.

**CORRECT KNOT**

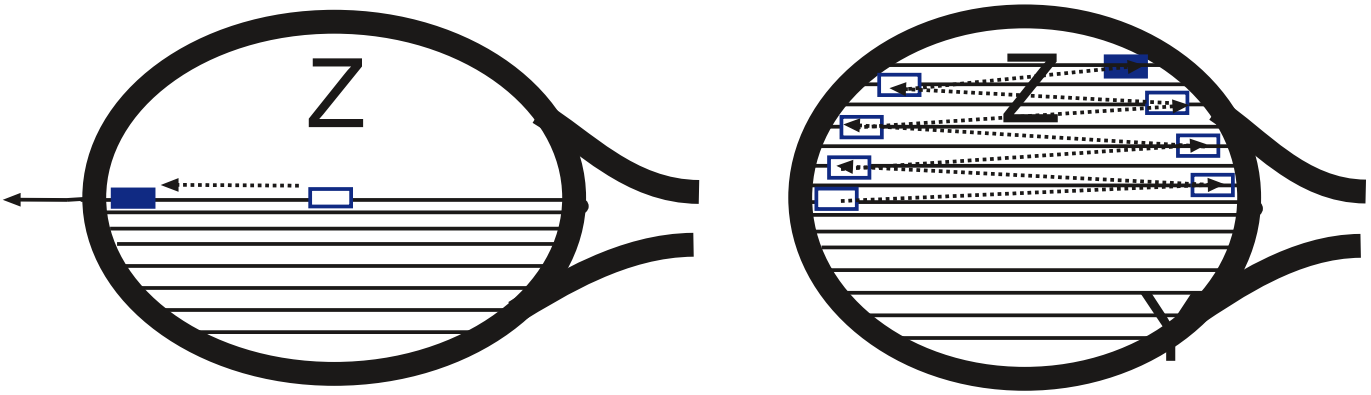
Pull with a forward movement + tightening at the end.




If you don't have special pliers, you can also twist the string on a piece of round wood (while doing so, you must make sure that the string does not get tangled). We recommend making two knots in a row on one string, one opposite the other. After closing the knot, release the Y pliers, which will not be used for a while.

ATTENTION! Before you start pulling the strings, make sure the knot function is not active (N1 button)

Re-tension the first vertical string from the Z side (fixed in the middle of the Z pliers), release the Z pliers, block the string again with the same pliers. From this point on, continue with only the Z pliers for all strings of the Z side.



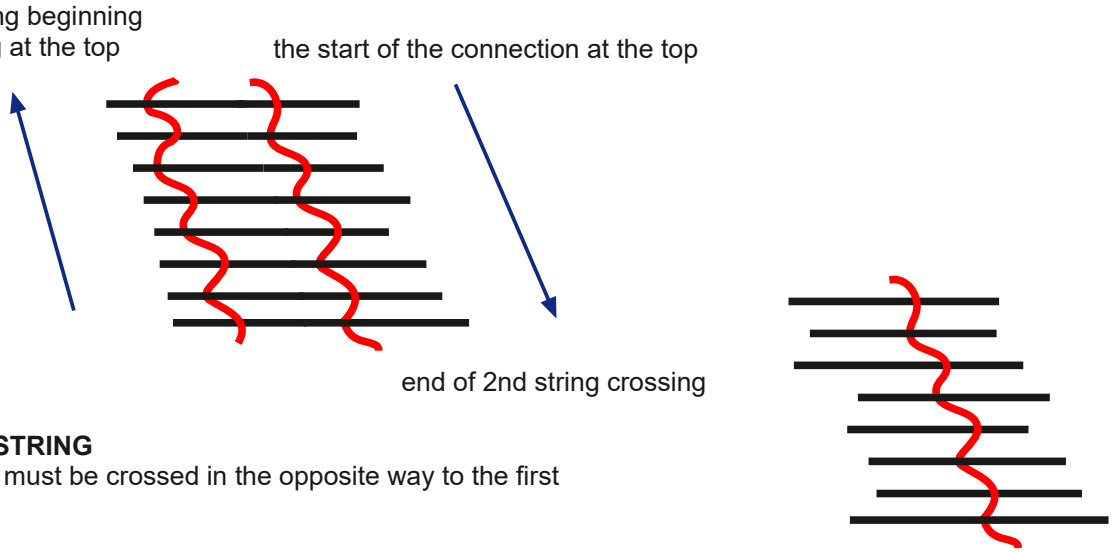

ATTENTION! After closing all the vertical strings, we recommend checking the 6 clamps that fix the racket. The racket is under concentric thrust, so it is necessary to adjust the fixation to changes in the shape of the racket.

After you are done with the vertical strings of the Z side, go over the first horizontal zig zag see the picture below.


After you zig zag over the string, pull it with the counterweight arm, release the Z pliers and fix the string just stretched with the Y pliers from the Y side. Now use both pliers, relatively halfway between them, to fix the stretched strings.

**BASIC NOTICE**

For the first horizontal string only, you can choose to cross it with the first vertical string, below or above. All the following must be crossed against each other at the joint with the previous string (see the picture below)

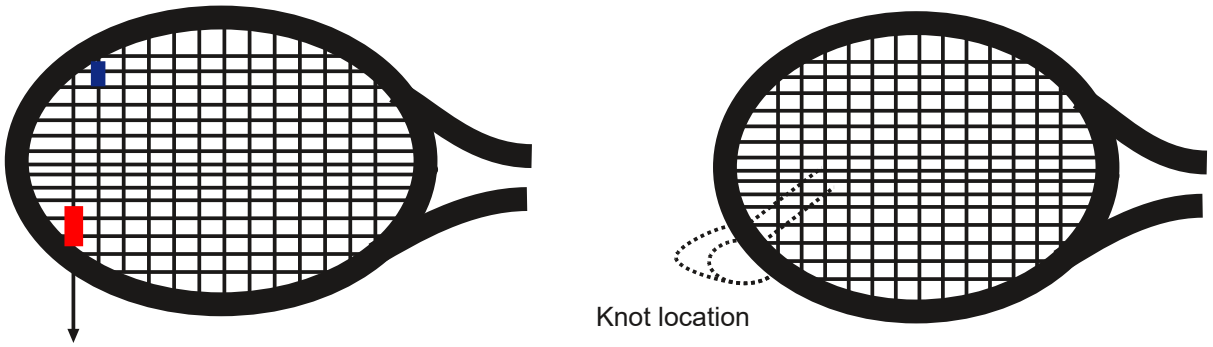



**NOTICE FOR EACH STRING**

The last vertical string must be crossed in the opposite way to the first

After pulling and stretching all the horizontal strings, make sure that:
- the vertical strings were alternately crossed
- when fixing and releasing the strings, work with the pliers in two positions Y and Z
- you can close the string with a final knot.

- increase the pull of the last string by 2kg using the knot function (N1)
- pull the knot the right way (holes for double passage are always located in the crease of the racket)




The string pattern is closed. Now release the string with the pliers and remove the racket from the fixation.

Loosen the independent clamps one by one:
- head center
- 4 lateral

If you do not want to work any further, switch off the machine (button A1).
When you are not using the machine, do not leave it ON for a long time.