



6500 EIs
STRINGING MACHINE
2 POINT MOUNTING



OWNER'S MANUAL

Issue 1 - July 2006

6500 EIs

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LIMITED WARRANTY

GAMMA SPORTS ("GAMMA") warrants to the original purchaser that the GAMMA stringing machine ("EQUIPMENT") purchased is free from defects in materials and workmanship for a period of five (5) years from the date of original purchase for mechanical parts (excluding electronic parts and string clamps), and for a period of one (1) year from the date of purchase for electronic parts and string clamps. Should any defects develop under normal use within the specified time periods, GAMMA will at its option, repair or replace the defective EQUIPMENT provided it is returned to GAMMA prepaid at the purchaser's expense. This warranty does not apply to any damage or defect caused by negligence, abuse, misuse, unauthorized alteration, shipping, handling, or part wear and tear as a result of normal use.

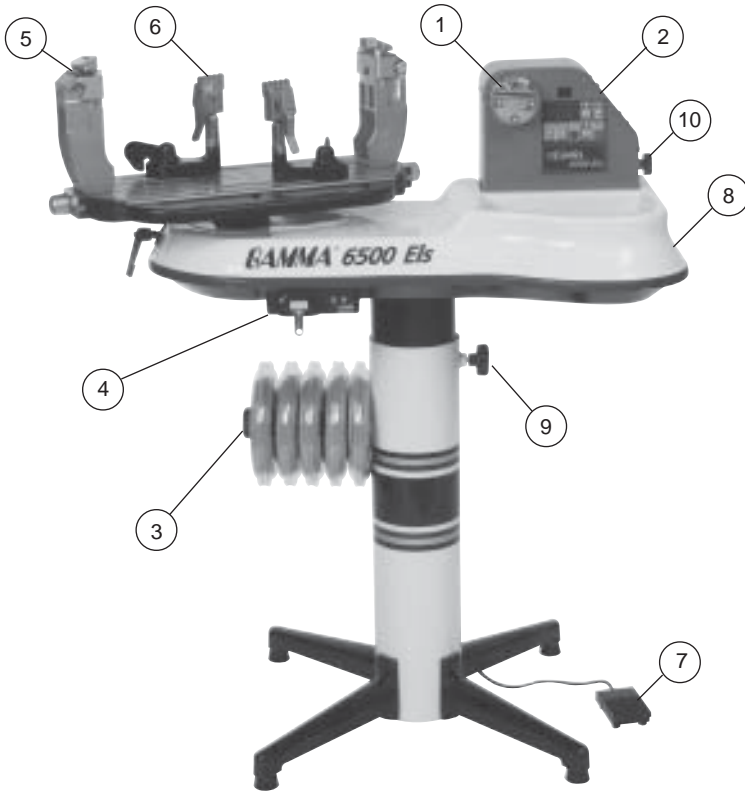
Routine maintenance, adjustment, and cleaning required to ensure proper operation are the responsibility of the purchaser and are not covered under the terms of this warranty. These include, but are not limited to: String Clamp adjustment, as described on page 12, cleaning of String Clamps, as described on page 18, and cleaning of String Gripper, as described on page 18.

GAMMA's obligation under this warranty is limited to repair or replacement of defective EQUIPMENT, and no one is authorized to promise any other liability. GAMMA shall in no event be liable for any incidental or consequential damages.

To return defective EQUIPMENT, a return authorization (RA#) must be obtained from a GAMMA customer service representative by calling 1-800-333-0337. The RA# must be marked on the outside of the shipping carton being returned. All returns must be shipped prepaid by the customer to GAMMA. Please retain the original shipping carton and packing materials for any future shipments.



6500 Els KEY PRODUCT FEATURES



1. Electric Constant Pull String Tensioner w/ Diamond Coated String Gripper (10-90 lbs tension range in 0.5 lbs increments)
2. Control Panel w/ Calibration, Lbs/Kgs, Pulling Speed & String Length Functions
3. String Reel Holder
4. Electronic String Length Meter
5. 2-Point Self-Centering Mounting System (4 point support)
6. Quick Action Swivel, String Clamps w/ Diamond Coating
7. Convenient Foot Actuated Tensioner Switch
8. Fiberglass Cover w/ Integrated Tool Trays (70 sq. in. of storage area)
9. Height Adjustable from 39" to 46" (can also be used on table top)
10. 110 V / 220 V Compatibility



6500 EIs

UNPACKING INSTRUCTIONS & CONTENTS

Instructions for Unpacking and Preparing for Assembly

The 6500 EIs is shipped in three cartons, a large carton for the stringing machine and accessories, a medium carton with the turntable and mounting system and a smaller carton for the post and base legs. **Please save the cartons and packing materials for possible shipments in the future.** Gamma Sports cannot be responsible for machines that are not returned, in their original, undamaged packaging. The tools you will need to assemble the 6500 EIs are provided with the machine. Due to the weight of the tensioner unit, you may need the assistance of someone to help lift the tensioner unit out of the carton.

Once the cartons are opened, remove all inner cartons and check to be sure that all parts are present and accounted for.

Contents of Base & Leg Carton

- (1) Lower Post
- (1) Upper Post with Flange Plate
- (4) Legs
- (1) Locking Knob Screw
- (4) M8 x 25 Flat Head Screws
- (4) M8 x 30 Cap Screws
- (1) String Reel Holder (M8 Threaded Pin), (1) Knob, (10) Spacers, & (2) M8 Washers
- (1) Box Wrenches – 6 & 12 mm

Contents of Turntable & Mounting System Carton

- (1) Turntable
- (2) Mounting Stands w/ Frame Hold Downs
- (2) String Clamp Heads

Contents of Large Master Carton (including accessory cartons packed inside)

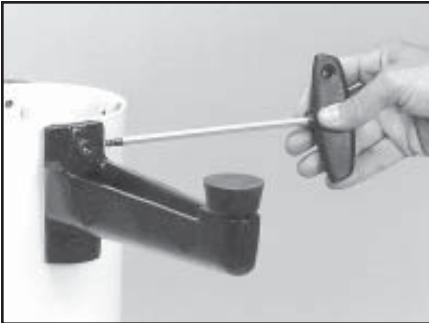
- (1) Stringer Assembly Unit w/ Tensioner Module
- (1) Power Cord w/ Ground Pin
- (4) Rubber Feet w/ Screws
- (1) Foot Pedal Tensioner Switch
- (1) Face Plate for String Length Meter & (2) Spare String Length Meter Clamp Pads
- (1) Tool Kit (contains side cutter, bent nose pliers, needle nose pliers)
- (1) Straight Stringers Awl & (1) Pathfinder Specialty Awl
- (1) Starting Clamp
- (2) Composite Badminton Floating Clamps
- (1) 9 pc L-Hex Wrench Set
- (1) 17mm socket
- (1) Gripper/Clamp Cleaning Stone

ASSEMBLY INSTRUCTIONS



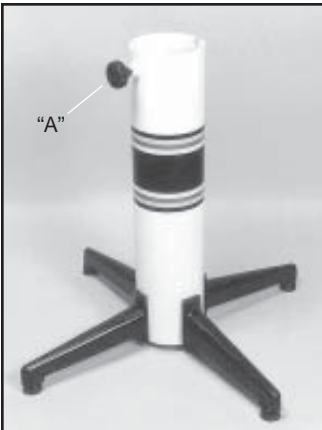
Base Leg Assembly

The stringing machine uses a four leg base design. The legs must be assembled to the support post before use. Remove the lower column support, the upper column support, four (4) legs, four (4) socket head cap screws and four (4) flat head cap screws from the small shipping carton.



Base Leg Assembly (Cont.)

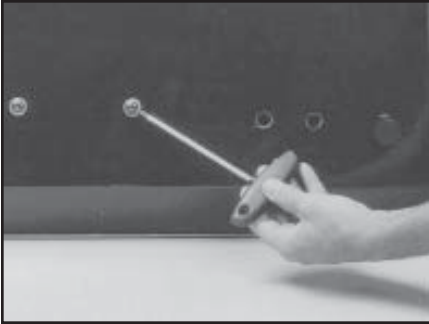
Align the holes in the leg flange with the matching holes in the lower column support post. Secure the leg with one FLAT HEAD cap screw through the upper hole, and one SOCKET HEAD cap screw through the bottom hole. Repeat this procedure for the three remaining legs.



Base Leg Assembly (Cont.)

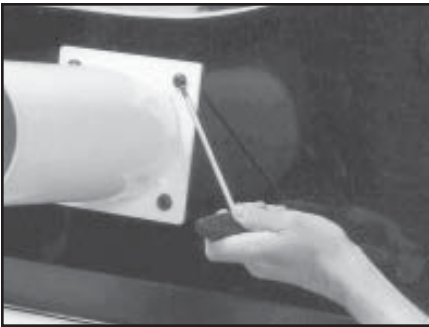
To complete the base stand, screw the height adjustment locking knob ("A") into the side of the support column. The locking knob should not protrude beyond the inside of the support column at this time.

ASSEMBLY INSTRUCTIONS



Stand Upper Post Installation

Remove the four (4) button head cap screws from the base of the assembly.



Stand Upper Post Installation (cont.)

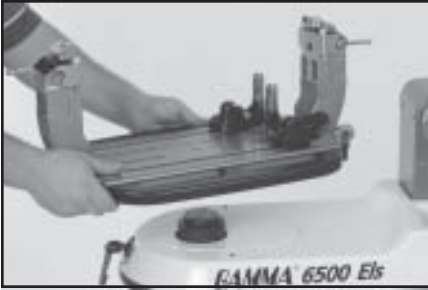
With the height adjustment cap screw on the upper post facing the left side of the tensioner, align the four (4) holes in the upper post flange with the holes in the tensioner base. Secure the flange to the base with the four cap screws.



Height Adjustment

The height of the machine is adjustable from 39" to 46". To change the height, remove the socket head cap screw from its current position and place it in the appropriate hole to set the desired height of the machine.

ASSEMBLY INSTRUCTIONS



Installing the Turntable

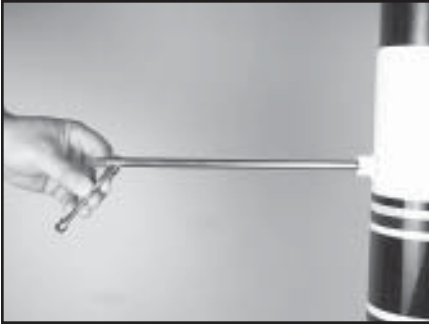
Remove the nuts from underneath of the turntable and leave the screws in position. Align the four (4) holes in the center of the turntable with the four (4) holes on the turntable pin. Tighten them securely with the 6mm allen wrench.



Clamp Head Installation

The post of the string clamp head and the tube of the string clamp base are treated with grease to provide protection against corrosion during shipping. Remove any excessive grease with a clean cloth prior to use. The post and tube may also be cleaned with isopropyl alcohol. After this type of thorough cleaning, the post and tube should be treated with a light coating of machine oil to protect the surfaces against corrosion and to ensure smooth operation.

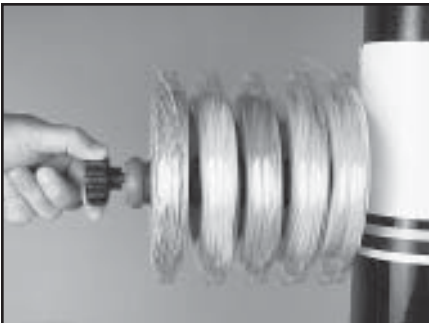
STRING REEL HOLDER INSTALLATION



The string reel holder pin is an 8 mm rod with threads on both ends, and flat surfaces machined on one end. Thread the end of the pin without the flat surfaces into the threaded boss on the right side of the lower column support. Using the M6 open end wrench positioned on the flat surfaces, securely tighten the pin to the lower column support.



The string reel holder can hold up to 5 reels of string (depending on the size of the string reel). Before placing the first reel on the pin, slide two M8 washers over the pin and slide them to the boss on the lower column support. After the first reel is placed onto the pin, place two spacers between each reel to provide enough space between reels and allow them to turn freely without rubbing against one another. (To provide a smooth feed to the String Length Meter, place the reels on the pin so the string spools off the reel from the underside of the reel.)



After the last reel is installed, place the remaining spacer(s) on the pin and attach the threaded knob to the end of the pin.

SLM FACE PLATE INSTALLATION



Remove the tape covering the opening on the front side of the bottom cover to expose the string length meter.



Position the face plate assembly over the opening in the bottom cover, and align the two countersunk end holes of the face plate with the threaded attachment holes in the front of the string length meter. With the two flat head machine screws, secure the face plate assembly to the string length meter.



To check for proper alignment, lift the top clamp of the face plate assembly and insert a section of racquet string at least 12 inches long into the entrance hole of the face plate. Continue feeding the string section into the string length meter, until it appears through the exit hole. If the entrance or exit holes appear to be blocked, loosen the attachment screws and adjust the position of the face plate assembly until the section of string exits the face plate. After the face plate is properly aligned, tighten the flat head screws.

POWER CONNECTION AND CONTROLS

Instructions for Power Connection (Refer to Figure 1)

CAUTION ! Before connecting to the power supply, check the voltage supply switch setting located on the side panel as shown in Figure 1. To change from 115 volts service to 230 volt service simply slide the switch fully to the top or to the bottom until "115V" or "230V" appears on the switch plate.

The acceptable range of input voltages for the "115 V" setting is between 110 V and 120 V @ 60 Hz and for the "230 V" setting, between 220 V and 240 V @ 50 to 60 Hz. If you have any question regarding the input voltage supply for your area, please ask your electric utility company.

To install the power cord, insert the female end of the power cord into the Power Cord Socket located on the side panel and plug the male end into a grounded power outlet.

When using extension cords, use grounded heavy duty extension cords rated for 15 AMP service. To connect the foot pedal switch, insert the 2 pin male connector located at the end of the foot pedal switch cord into the two pin receptacle located on the back panel. Tighten the connector with the sleeve nut located on the foot pedal switch connector.

After checking to be certain that the machine is set for the correct input voltage, switch on the machine by pressing the Lighted On-Off Power Switch on the side panel.

WARNING! FOR INDOOR USE ONLY. TO BE USED BY ADULTS OR UNDER ADULT SUPERVISION ONLY. NEVER OPEN UNIT WITH POWER CONNECTED

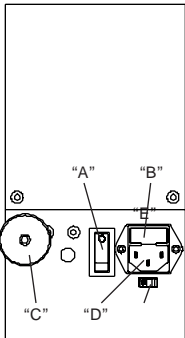


Figure 1 - Side Panel

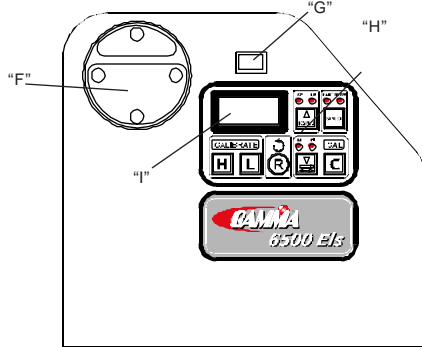


Figure 2 - Front Panel

Figure 1

- "A" - Lighted On-Off Power Switch
- "B" - Sliding Fuse Holder w/ Spare Fuse
- "C" - Tension Adjustment Knob
- "D" - Power Cord Socket
- "E" - 115V / 230V Switch

Figure 2

- "F" - Split Drum String Gripper
- "G" - Tensioning Button
- "H" - Control Panel
- "I" - LED Display

Figure 3

- "J" - 2 Pin Foot Pedal Switch Socket

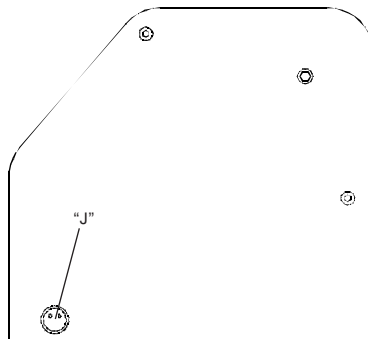
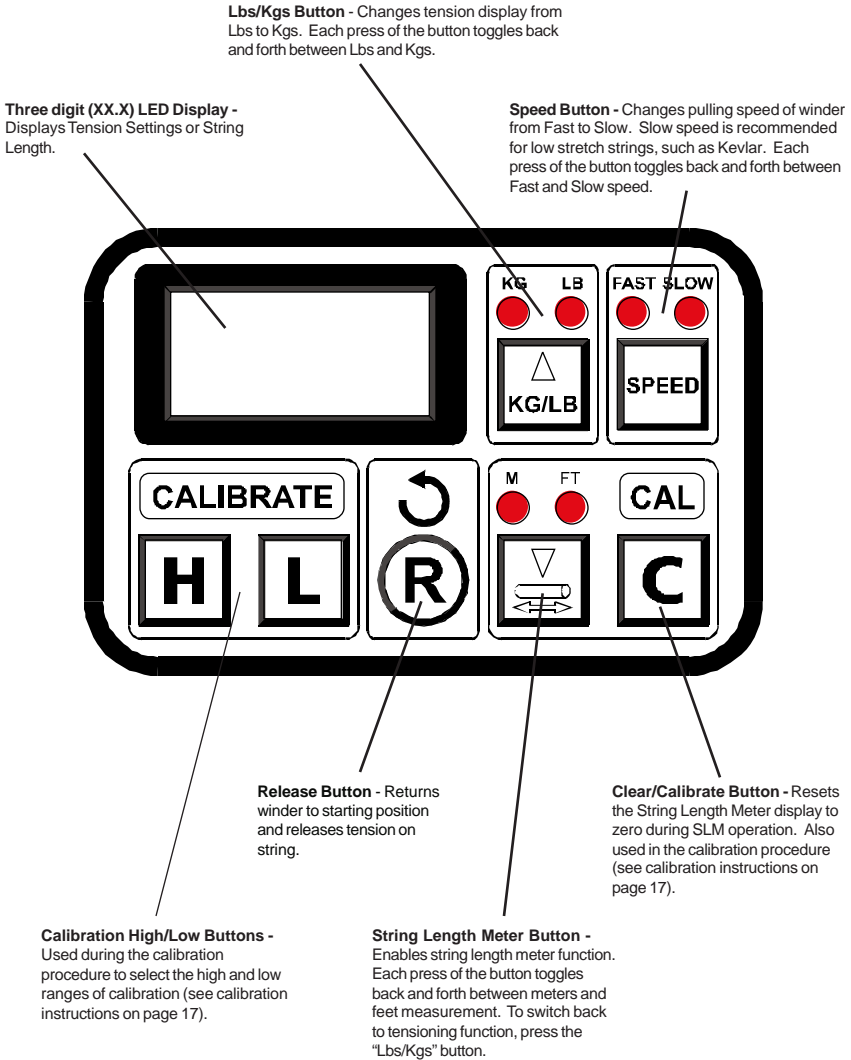
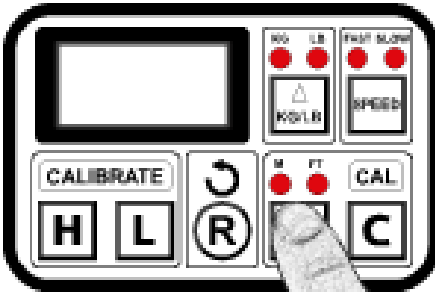


Figure 3 - Back Panel

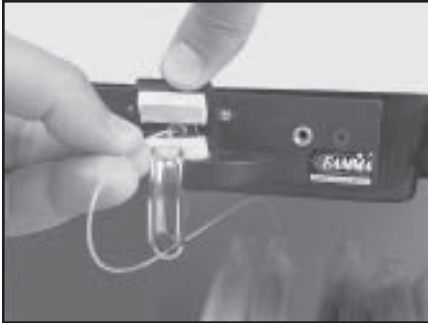
CONTROL PANEL FUCTIONS AND FEATURES



STRING LENGTH METER OPERATION



To enable the String Length Meter (SLM) function, press the String Length function key on the keypad. When the String Length button is pressed, one of the Red LED indicators below “M” or “FT” will light up to indicate that the SLM function is enabled. Pressing the String Length button will toggle between “M” and “FT” to set the measurement units for either Meters (“M”) or Feet (“FT”). Measurements are displayed in 0.1 increments.



To measure out a length of string from a reel (sets can also be measured) insert one end of the string through the string guide grommet (from the backside). While lifting the clamp pad, insert the string through the entrance hole of the face plate until it appears at the exit hole and release the clamp pad. (The clamp pads will prevent debris from entering the SLM.)

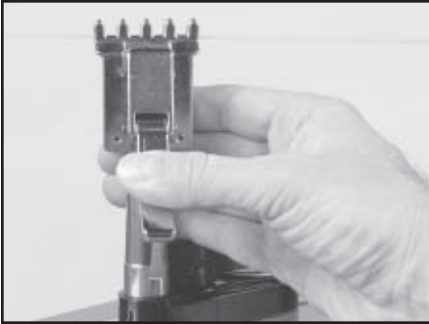


When the end of the string appears out of the exit hole, press the “C” button on the keypad to “Zero” the SLM, and the length of string measured will be measured from the point on the string located at the edge of the exit hole. Pull the end of the string in a slow steady fashion and the SLM will begin measuring the length of string pulled and indicate the measurement on the LED display. When the desired length of string is measured, cut the string at the exit hole.

NOTE : When reaching the end of a length of string, pull the string through

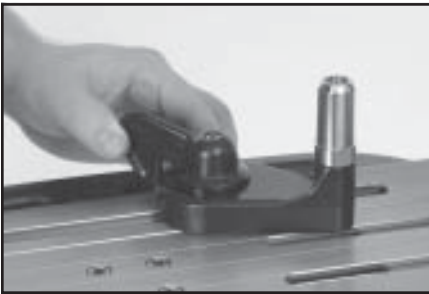
very slowly to avoid inaccurate string measurement. The string length meter was designed to measure strings between 1.10 mm (18 ga) and 1.45 mm (15 ga) at an accuracy of +/- 0.3% of the indicated value and +/- 2 inches (50 mm) absolute. When measuring strings smaller than 1.10 mm (such as badminton strings) the error will be -2.5% of the indicated value (up to 6” short in 40 ft) and +/- 2 inches (50 mm) absolute.

QUICKACTION CLAMP OPERATION



Clamp Head Operation

To clamp a string, lift the clamp head and place the string between the jaws and depress the clamp head lever to secure the string. The clamping pressure applied to the string should be adjusted to provide sufficient pressure to secure the string when subjected to the desired pulling tension. The diamond coated gripper plates provide for increased friction between the clamps and the string to allow for reduced clamping pressure while securing and holding the string under tension.



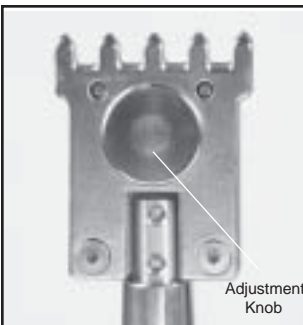
Quick Action Clamp Base Operation

Rotate the Base Locking Lever clockwise to secure the clamp base to the turntable.

Reverse the clamping procedure to unlock the string clamp. The Locking Lever is spring loaded to assist the unlocking of the clamp base.

The Locking Lever should be tightened enough to prevent clamp base slippage on the turntable, when the desired tension is placed on the string. To go from the loose position to the clamped position and back,

generally requires the travel permitted by the clamp base. If the travel is not sufficient to allow smooth operation of, adjust the Clamp Base as outlined in the Clamp Base Adjustment section.



Clamp Head Adjustment

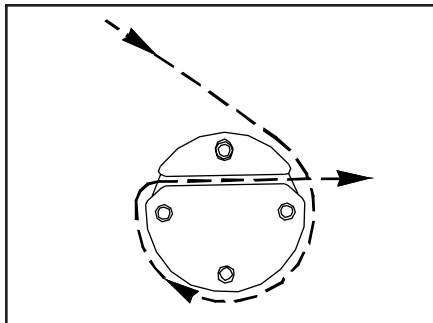
The clamp heads will need minor adjustments according to what string type, construction, and gauge you are using.

To adjust the gap (clamping pressure) between the clamp jaws, insert the string through the racquet as if you were beginning the main strings. Clamp the strings and pull tension. If the string slips through the jaws of the clamp, tighten the clamp by compressing the clamp jaws together by hand while turning the Adjustment Knob, in the clockwise direction. If the clamp leaves impressions or damages the string, it may be excessively tight and should be adjusted by turning the hex screw counter clockwise to

open the gap between the jaws. The clamp jaws must be cleaned periodically to be free from dirt and any residue for them to grip properly.

Note: The string clamps supplied with your stringing machine can accommodate tight string patterns such as badminton. Depending on the string pattern, the clamp may spread the strings slightly which will not compromise the quality of the string job.

STRING GRIPPER OPERATION



String Gripper Operation

To insert the string in the split drum string gripper, wrap the free end of the string clockwise around the gripper drum and position the string between the gripper jaws as shown in the illustration.

The string must pass over the top half of the gripper before being placed between the diamond coated plates of the upper and lower gripper jaws. Excessive slack in the string should be removed before applying tension. As the drum turns and applies tension to the string, the upper jaw is forced down to clamp the string between the jaws.

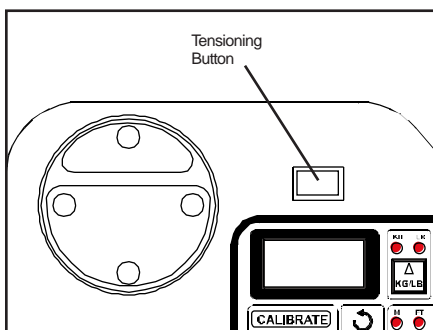
CAUTION ! Never tension a string with your finger between the string and upper gripper jaw as serious injury could result if your finger is caught between the string and upper jaw during tensioning. CHILDREN SHOULD NEVER BE PERMITTED TO OPERATE THIS MACHINE WITHOUT ADULT SUPERVISION.

TENSIONER OPERATION



Setting Tension

The 6500Elz utilizes a rotary adjusting knob along with a digital L.E.D. display to indicate the set tension. To set the tension, rotate the adjustment knob clockwise to decrease, counter-clockwise to increase, until the desired tension is displayed. Aramid fiber and Metallic strings will generally string up tighter than synthetic or natural gut strings, we recommend setting the tension 4-5 lbs. lower than you would for gut.



Tensioning a String

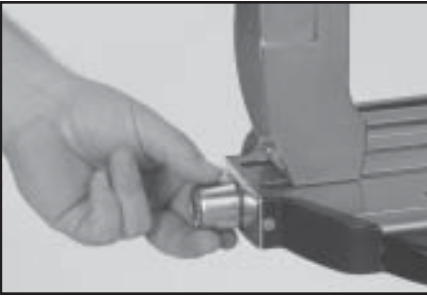
After wrapping the string around the gripper jaws, press the tensioning button switch on the front panel of the machine, or press the foot pedal switch to activate the tensioner. When the tension in the string reaches the tension setting, the LED display will begin to flash, and the string will be ready to clamp off. In the event that one of the keys on the control panel are accidentally pressed while tensioning a string, the tensioner will automatically reverse and release the string being tensioned.

MOUNTING THE FRAME



Adjusting the Inner Racquet Supports

The white racquet supports are adjustable to accommodate all racquets and provide maximum support to the racquet frame. Screw the the pads up or down so they contact the frame at a maxium height without blocking the grommet holes.



Mounting Post Adjustment

Place the racquet frame over the white racquet supports. Screw the the post outward until the racquet supports are positioned on the inside surface of the racquet frame.



Installing the Racquet Hold Down

With the lever in the up position, insert the racquet hold down into the hole in the center of the mounting post.

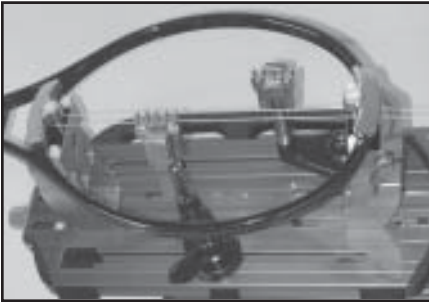
MOUNTING THE FRAME



Securing the Racquet Hold Down

Depress the racquet hold down lever to secure the racquet frame.

STRINGING THE FRAME



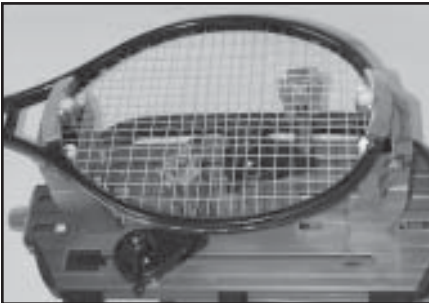
Installing the Main Strings

To begin stringing the main strings, insert the two ends of the string through the two center holes at the appropriate end of the frame and continue through the center holes on the opposite end of the racquet.

Secure one of the strings using a string clamp and insert the free end into the string gripper.

string from tensioner, and proceed to thread string into next sets of holes. After the last main strings are pulled, tie-off the strings at the appropriate hole specified by the racquet manufacturer.

When tension is applied to the string, clamp off the tensioned section of string, release



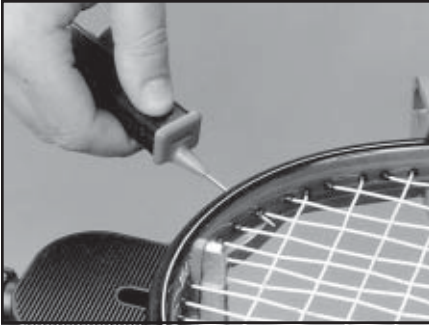
Installing the Cross Strings

Weave the cross strings over and under the main strings being careful to alternate the weave direction of each consecutive cross string so as to be opposite of the previously installed cross string.

Once the final cross string is tensioned and clamped, tie off at the appropriate hole specified by the racquet manufacturer.

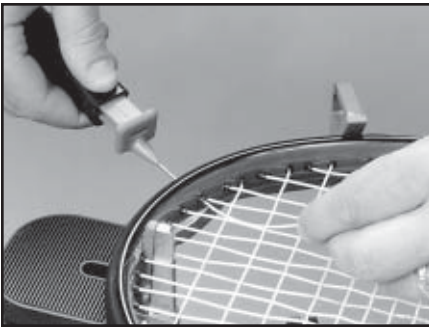
Remove the strung racquet by loosening the shoulder supports and support slides in small increments until the racquet is free from the mounting system.

PATHFINDERAWL OPERATION



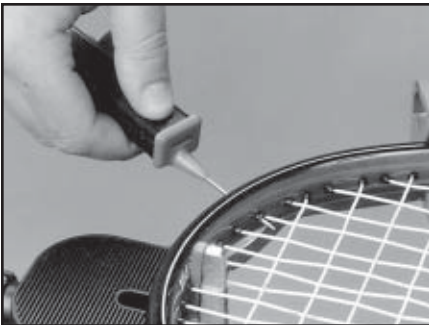
The machine includes the Pathfinder stringing awl which creates a pathway between or around strings to make inserting a string through tight grommets easier and quicker.

Insert the awl through the grommet hole in the same manner as for traditional awls. The Pathfinder awl must be in the closed position before insertion.



Once the awl is inserted, pull the handle of the awl outward while holding the tip section in place, leaving the outer sheath in the grommet hole.

Insert the end of the string into the center of the sheath.



While holding pressure on the string, slowly pull the sheath out of the grommet hole to leave the end of the string exposed.

TENSIONER CALIBRATION

Each stringing machine has been checked and calibrated at the factory using accurate load sensing devices to ensure that the machine pulls at the correct tension. However, if you suspect that your machine is not pulling at the correct tension, or if you would like to check the pulling tension using a tension calibration device, you may do so.

To adjust the calibration of the 6500 Els machine :

- 1 - Set the tension so the display reads 30.0 lbs and turn off the machine.

CAL

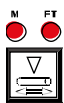
C

- 2 - Turn on the machine while pressing the “C” button, and continue holding the “C” button until the winder stops turning.

L

- 3 - Press the “L” button (the LED will be flashing with 30.0 displayed).

- 4 - Apply tension to a tension calibrator.



- 5 - Adjust the display to match the maximum reading observed on the calibrator using the button with the yellow “UP Triangle” (Lbs/Kgs button) or the button with the yellow “DOWN Triangle” (String Length Meter button).

Note : There will be a range of tension from the maximum tension at which the tensioner stops pulling, to the minimum tension at which the tensioner starts pulling again, for a given tension setting. The difference between the maximum and minimum can vary between 2-4 lbs depending on the string and calibration device used to calibrate the machine. Therefore, we recommend that the tension setting of the machine be calibrated based on the maximum reading to ensure consistency in the calibration procedure, which is also the method used at the factory.

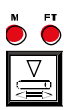
L

- 6 - Press the “L” button (display will stop flashing)

- 7 - With the calibrator still attached, increase the tension by turning the knob until the calibrator shows approximately 70 lbs. (Note: display will stay on 30.0)

H

- 8 - Press the “H” button (the LED will be flashing with 70.0 displayed)



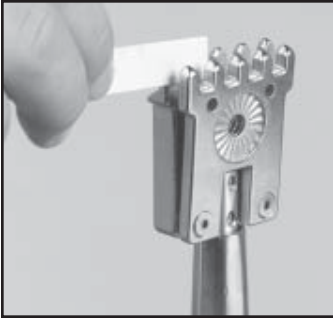
- 9 - Adjust the display to match the reading on the calibrator using the button with the yellow “UP Triangle” (Lbs/Kgs button) or the button with the yellow “DOWN Triangle” (String Length Meter button).

H

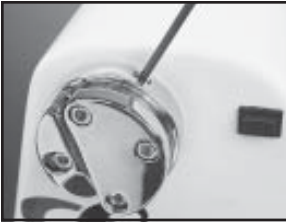
- 10 - Press the “H” button (display should stop flashing)

If you have any problems with calibration of the machine, call the machine service department of GAMMA Sports at 1-800-333-0337 for assistance.

CLEANING INSTRUCTIONS



To thoroughly clean the diamond coated surfaces of the clamp heads, remove the adjustment knob screw to expose the inside surfaces of the clamps. Using the cleaning stone provided with your machine (you can also use a small tooth brush or a sharpening stone for knives), scrub the diamond coated plates until all debris is removed. Clean any dust or residue with a damp cloth and re-assemble the clamp head.

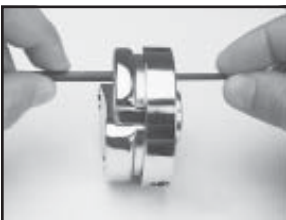


To thoroughly clean the diamond coated surfaces of the string gripper jaws, remove the gripper drum from the motor shaft by loosening the drum attachment screw located at 5 o'clock on the side surface of the gripper drum, and sliding the gripper drum off the shaft.

Note: To provide easier access to the attachment screw, press the tensioning button switch to rotate the gripper drum. When the screw is positioned at the top of the drum, switch the power off on the machine to stop the gripper drum from turning and remove the screw.



Remove the gripper jaws from the gripper drum by removing the 4 cap screws that attach the jaws to the drum. When removing the grippers, take care to not loose the compression springs inside the cavities of the lower gripper jaw. With the gripper jaws removed from the drum, using the cleaning stone provided with your machine (you can also use a small tooth brush or a sharpening stone for knives), scrub the diamond coated plates until all debris is removed. Clean any dust or residue with a damp cloth and wipe down the gripper drum surfaces to remove any residue as well.



To re-assemble the gripper jaws to the drum, fit the springs over the spring retainers of the upper jaws and fit the upper jaw to the lower jaw. While holding the jaws together position them onto the drum and align the holes in the jaws to the holes in the drum. Re-attach the jaws to the drum with the cap screws. The hole in the drum for attachment of the upper jaw has a small set screw inserted into the hole from the back side of the drum. This set screw was adjusted at the factory to provide the proper engagement of the upper jaw screw with the drum. When tightened the upper jaw should slide

freely up and down. To tighten the upper jaw screw, place a hex wrench in the small set screw located on the back side to hold it in place when the attachment screw on the front side is tightened.

TROUBLESHOOTING TIPS

PROBLEM

SOLUTION

String slips in clamps

- Adjust gap between jaws
- Clean clamp jaws

String slips in string gripper

- Clean gripper jaws
- Make sure string is wrapped over upper gripper jaw before inserting between gripper jaw plates

String clamp slips on base

- Clean base of clamp and turntable glide bars

Electrical system does not function

- Check power source / voltage setting
- Check power cord connection
- Check fuse
- Call Gamma Sports customer service

To check fuse, remove the power cord and pull the fuse holder straight out. Remove the fuse from the clips and examine it. If it is burned out, replace it with the spare fuse and replace the fuse holder in its socket. Supply power to the machine and check for proper operation. If problems persist, contact Gamma Sports Customer Service at 1-800-333-0337

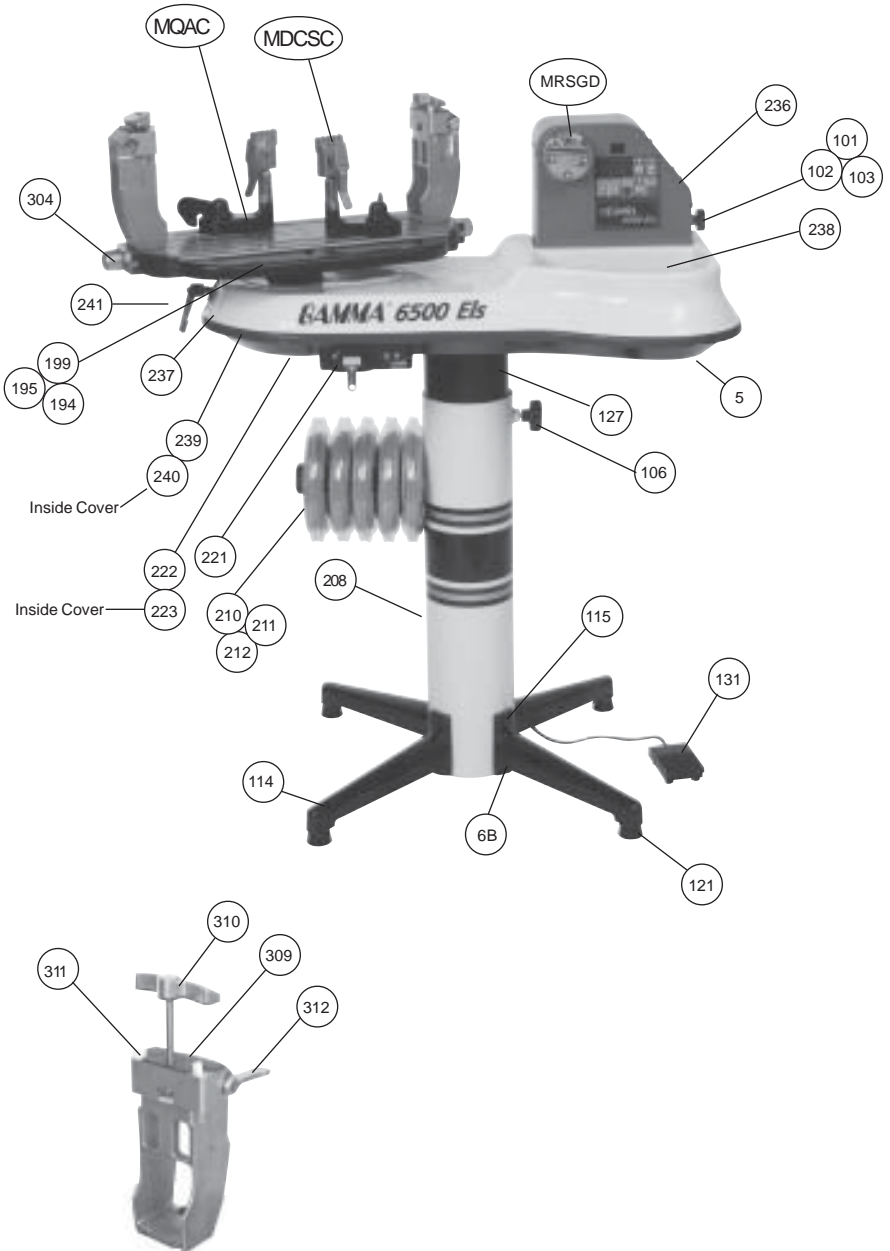
Gripper will not release string

- Press & hold the Release Button

LED Display flickers or displays erratic values

- Check the 115v/230v Voltage Setting Switch for proper position

PARTS SUMMARY



PARTS LIST

PART#	DESCRIPTION
6B	CAP SCREW - M8 x 30
37	GRIPPER CAP SCREW SET
101	AC POWER CORD
102	FUSE HOLDER CAP
103	FUSE
106	LOCKING KNOB SCREW
114	SHORT LEG
115	FLAT HEAD CAP SCREW-M8 x 25
121	LEVELING FOOT
127	FLANGED UPPER SUPP COLUMN
128	FRP BASE FOOT
131	FOOT PEDAL SWITCH
194	TT BRAKE PAD
195	TT BRAKE PAD FLAT HEAD SCREW
199	FLANGED TT PIN
203	FLANGED TT PIN CAP SCREW
208	LOWER COLUMN (w/RH REEL HOLD)
210	REEL HOLDER BOLT
211	REEL HOLDER SPACER
212	REEL HOLDER KNOB
221	SLM CLAMP PADS
222	SLM FACE PLATE
223	SLM
236	6500 TENSIONER MODULE
237	6500 FRP TOP COVER
238	6500 TRAY PAD
239	6500 FRP BOTTOM COVER
240	6500 FRAME (CASTING)
241	6500 TT BRAKE LEVER
243	GRIPPER DRUM BACK PLATE
289	TT HANDLES
304	SC TT KNOB
308	SC TT
309	2 PT PADS
310	2 PT HOLD DOWN
311	2 PT RQT SUPPORTS
312	2 PT LEVER
MDCSC	STRING CLAMP
MRS GD	ROTATIONAL GRIPPER JAW
MQAC	QA CLAMP BASE-SHORT

SPARE PARTS & TOOLS (NOT PICTURED)

PART#	DESCRIPTION
109	NEEDLE NOSE PLIERS
110	BENT NOSE PLIERS
171	CUTTING PLIERS
194	TT BRAKE PAD
206	17MM SOCKET
221	SLM CLAMP PADS
224	6MM OPEN END WRENCH
251	LONG HEX WRENCH SET
MA	STRINGER SAWL
MBFC	BAD. FLYING CLAMP SET
MPG	STARTING CLAMP
MPS	GRIP/CLAMP CLEAN. STONE
MPSA	PAHTFINDERAWL