



# X-STRINGER

## X-ST STRINGING MACHINE



### OWNER'S MANUAL

Issue 2 - October 2009



# X-STRINGER

## GAMMA X-ST OWNER'S MANUAL

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### LIMITED WARRANTY

GAMMA Sports (GAMMA) warrants to the original purchaser that the X-STRINGER 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 any electrical parts and string clamps), and for a period of one (1) year from the date of purchase for any electrical 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 13, tension calibration, as described on page 11, Tensioner Brake adjustment, as described on page 12, and clamp base locking nut adjustment, as described on page 13..

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. 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. GAMMA will not be responsible for machines which are not sent in the original undamaged packaging.

# FEATURES



## MACHINE FEATURES

- ❖ Manual Spring Tension Winder (11-89 lbs range)
- ❖ Patented Roller Guide for Maximum Accuracy and Consistency
- ❖ Professional Six Point “Quick Mount” Racquet Mounting System - Accommodates All Racquets Without Adapters
- ❖ Parallel Jaw Gripper w/ Diamond Dust Coated Gripping Surfaces
- ❖ Professional Dual Action, Rotating, Diamond Dust Coated, Fixed String Clamps
- ❖ High Strength Extruded Aluminum Frame with Durable Anodized Finish and Convenient Padded Tool Tray
- ❖ Unique Internal Drawer System for Storing Tools and Adaptors

# ASSEMBLY INSTRUCTIONS



## Turntable Installation

To install the turntable remove the four nuts underneath holding the mounting bolts in place. Position the turntable over the turntable pin and align the bolts with the holes in the flange. Secure them with the included allen wrench.

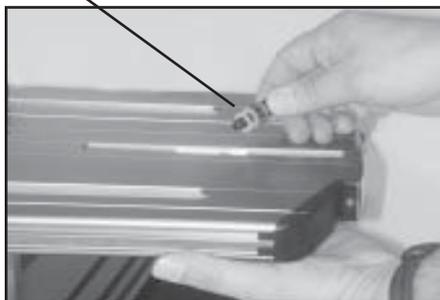
Note: When purchased with the optional floor stand, it is most convenient to attach the base to the floor stand at this point. See instructions provided with the optional floor stand.



## Support Post Installation

To install the support posts you must first remove the mounting bolt from the mounting plate that sets inside the central cavity of the turntable. There are large holes stamped on the underside of the turntable that allow you to support the mounting plate with your fingers while removing the mounting bolt.

Remove and Discard Plastic Washers



## Support Post Installation (con't)

After removing the mounting bolt, remove and discard the plastic washers that are installed for shipping purposes.

# ASSEMBLY INSTRUCTIONS



## Support Post Installation (cont'd)

Place the support post onto the central slot of the turntable. With your fingers placed through the large hole in the underside of the turntable, press the mounting plate against the inside top surface of the turntable while aligning the hole in the support post with the hole in the mounting plate and fix them with the mounting bolt. Repeat procedure on to attach the support post on the opposite side of the turntable.



## String Clamp Installation

The post of the string clamp and 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.



## Installing the Tensioner

Remove the button head screw and washer located at the end of the tensioner bar with the 3 mm hex wrench provided. Slide the tensioner onto the bar, being careful to align the bar with all of the bearings and the drive gear with the gear track. Replace the screw and washer into the end of the tensioner bar.

**Note:** The tensioner bar is equipped with a tensioner travel stop to limit travel of the tensioner along the bar.

# ASSEMBLY INSTRUCTIONS



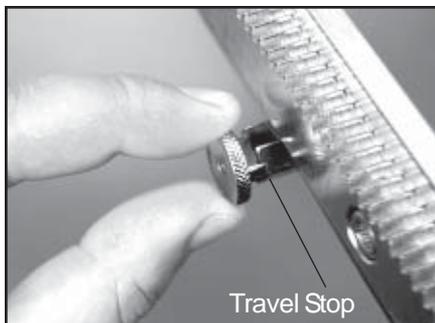
## Setting the Gripper Jaw Spacing

The gripper jaws of the tensioner are adjustable to accommodate varying string gauges.

If the string slips through the gripper jaws while pulling tension, rotate the gripper jaw adjustment screw counter-clockwise.

If the string is damaged while pulling tension, rotate the gripper jaw adjustment screw clockwise.

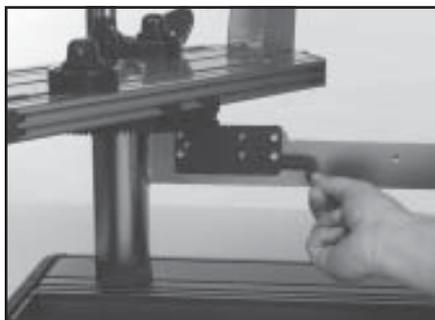
The jaws will be properly adjusted when there is enough pressure to securely grip the string without causing damage to the string.



## Tensioner Travel Stop

The tensioner bar is equipped with a tensioner travel stop to limit travel of the tensioner along the bar and prevent contact between the tensioner and the racquet mounting system while stringing. The travel stop is located about midpoint along the tensioner bar below the gear track.

To disengage the stop, pull and hold the knob, rotate 90 degrees and release. To engage the stop, repeat the above procedure until the travel stop pin protrudes beyond the opposite surface of the tensioner bar.



## Turntable Brake

The turntable may be locked in any position. Flip the lever down to lock the turntable brake and flip the up to release the turntable brake.

# MOUNTING THE FRAME



## Adjusting the Frame Support Posts

Loosen the lock bolts of the frame support posts and space them apart with the frame support slides separated by the approximate length of the racquet head. Although it is not required, it is good practice to center the support posts on the turntable. Lock one of the posts in position by tightening the lock bolt and position the other post until the frame support slide is positioned near the inside surface of the racquet frame. Securely tighten the lock bolt of the second support post.

**Caution:** To avoid racquet damage, the center posts should not contact the racquet prior to locking down the support posts.



## Tightening the Frame Supports

Tighten the Frame Support Slides by turning the adjustment knob clockwise until snug against the racquet frame and slight resistance is felt.

**Caution:** Overtightening the Center Supports will stretch the head of the racquet and could cause racquet damage.



## Frame Shoulder Support Adjustment

Being sure the shoulder supports are free to swivel in their mountings, simultaneously rotate the shoulder support adjustment knobs clockwise until both shoulder supports gently and squarely contact the frame.

# MOUNTING THE FRAME



## Securing the Frame Shoulder Clamps

Lock the shoulder supports in position by turning the knob at the base clockwise.

Repeat the adjustment procedure for the remaining support post.

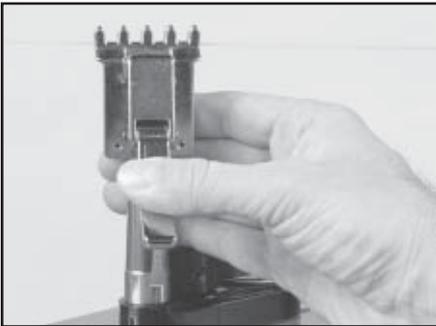
Re-tighten all of the frame supports in the same order as before.

*Do not overtighten any of the supports as racquet damage may occur.*

The supports should be tightened to the point where the racquet frame will not move

in the mounting system when the handle is grasped and attempts are made to move it. Should any supports lose contact with the frame while stringing, they should be re-tightened.

# STRINGING THE FRAME



## String Clamp Operation

The string clamps are a dual action design where the string clamp and clamp base operate independently of one another.

To clamp a string, lift the clamp head and place the string between the jaws and depress the string clamp 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.



## Clamp Base Operation

To lock the string clamp base to the turntable, rotate the clamp base locking lever clockwise. To release the string clamp base from the turntable, rotate the clamp base locking lever counter-clockwise.

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 rotation permitted by the slot in the clamp base.

# STRINGING THE FRAME



## Getting Started

To begin stringing the main strings, thread the two ends of the string through the two center holes at the appropriate end of the frame and continue through the opposite center holes. Thread one end of the string through the adjacent grommet hole and pull excess by hand.

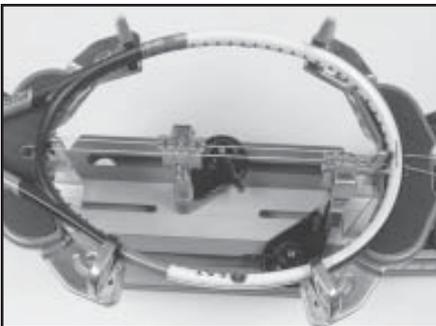
Secure one of the strings using a string clamp.



## Pulling Tension

Wrap the loose section of string once around the roller guide and insert the string between the diamond dust coated string gripper plates. Pull the string perpendicular to the gripper plates while slowly rotating the tensioner crank clockwise until the brake lever pops out of the latching block. The string is now tensioned and can be clamped in place with the remaining fixed clamp.

Repeat the above steps until all main strings are installed. Tie off ends of main strings as per racquet manufacturers recommendations.



## Clamping the First Main String

Secure the tensioned main string using the remaining fixed clamp. Repeat the procedure for all of the remaining main strings and tie off following the racquet manufacturers recommendations.

Follow the manufacturer's recommended stringing pattern for one or two piece stringing. This will determine the starting point for the cross strings. If applicable, tie the first cross string using an appropriate starting knot.

# STRINGING THE FRAME



## Weaving the Cross Strings

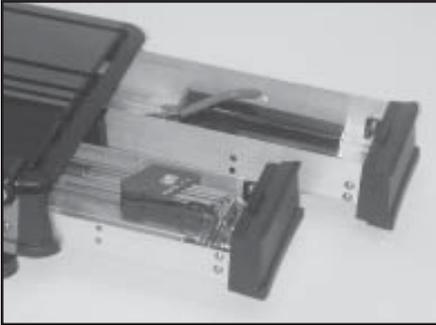
Weave the cross strings over and under the main strings being careful to alternate the weave direction of each consecutive cross string so as to be opposite of the previously installed cross string.



## Completing the String Job

Once the final cross string is tensioned and clamped, tie off at the appropriate hole specified by the racquet manufacturer. Remove the frame from the mounting system by loosening the shoulder supports and frame supports.

# ADDITIONAL FEATURES



## Storage Drawers

There are two storage drawers located in the base of the machine. The drawers open from the right end of the base and lock into the end cap with a spring loaded latch.



To open the drawers push the latch down and slide the drawer out. To close the drawer simply slide the drawer back inside the base and it will automatically lock into place.



## Cutting Block

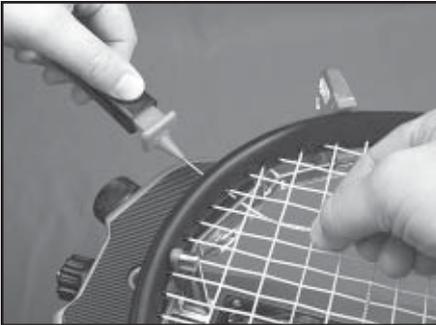
A cutting block is provided to provide a surface for cutting a point on the strings using a razor blade cutter.

# PATHFINDER AWL



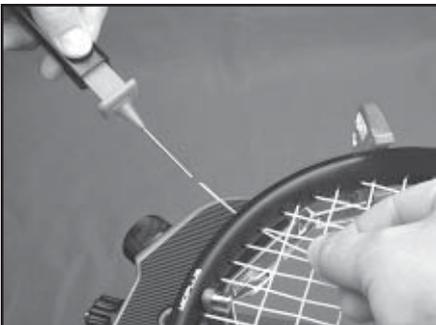
The stringing machine includes the Pathfinder stringing awl which creates a pathway between or around strings to make inserting a string through tight grommets easier and quicker.

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.



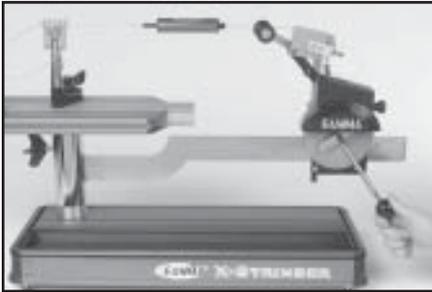
Once the awl is inserted, pull the handle of the awl outward while holding the tip section in place, leaving the outer sheath in the grommet hole.

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.

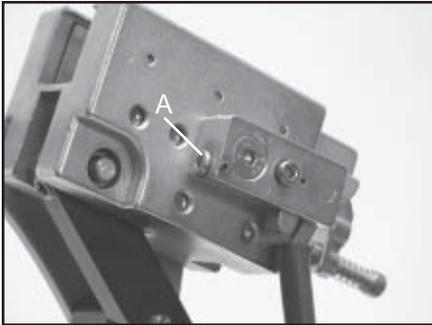
# MAINTENANCE & ADJUSTMENTS



## Tension Calibration Procedure

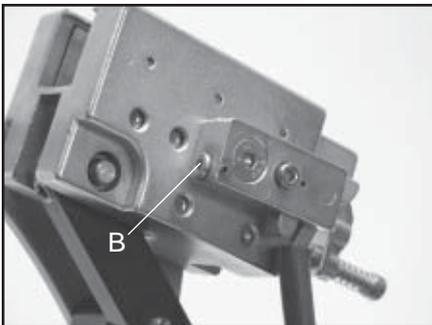
### Step 1

Set the tension to 60 lbs. as indicated by the linear scale and rotary knob. Place the string on one end of a tension calibrator into a string clamp and secure. Place string located on the other end of the calibrator into the string tensioner and apply tension. If the brake lever releases before 60 lbs. or after 60 lbs., the tension head should be calibrated as follows.



### Step 2

Loosen the 1.5 mm locking set screw (A) located on the side of the latching block as shown. The set screw is used to hold the adjustment screw in place.

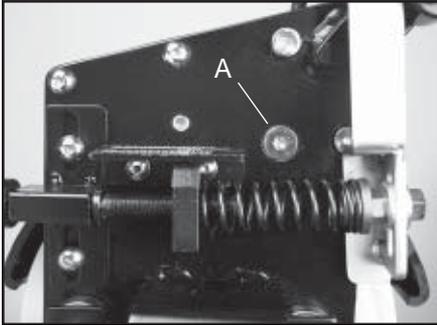


### Step 3

If the lever releases before 60 lbs., using the supplied L-shaped hex wrench, turn the adjustment screw (B) located on the left side of the latch block counter-clockwise to increase the engagement of the brake release latch with the brake lever. Repeat step 1 and adjust until the correct tension is indicated on the calibrator.

If the tension indicated in step 1 is greater than 60 lbs., turn the adjustment screw clockwise to reduce the engagement of the brake release latch with the brake lever. Repeat step 1 and adjust until the correct tension is indicated on the calibrator.

# MAINTENANCE & ADJUSTMENTS



A - Lock Bolt

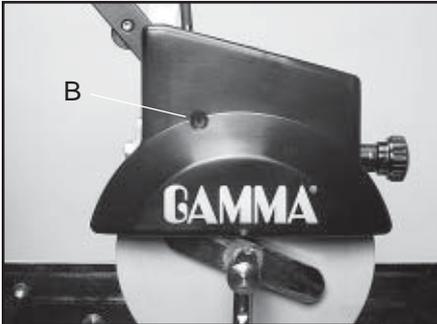
## Adjusting the Tensioner Brake

### Step 1

After stringing many racquets, the brake of the tensioner may need to be adjusted.

With the brake lever engaged, loosen the lock bolt located on the back side of the tensioner frame with the 4mm hex wrench.

Note: The lock bolt should only be loosened enough to be turned by hand and must not be removed completely.

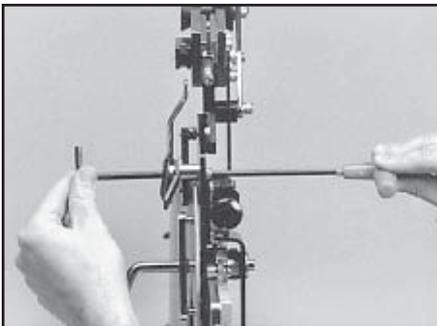


B - Brake Lever Adjustment Bolt

## Adjusting the Tensioner Brake

### Step 2

With the lock bolt loosened and the brake lever engaged in the latch, insert the 6 mm hex wrench through the hole in the tensioner cover and into the (B) brake lever adjusting bolt.



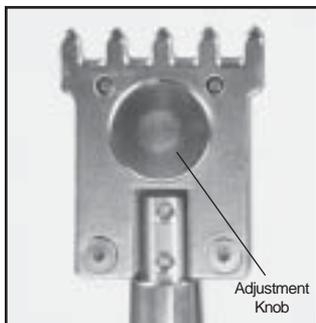
## Adjusting the Tensioner Brake

### Step 3

To tighten the braking mechanism, turn the brake lever adjusting bolt counter clockwise by about 1/8 turn. Retighten the lock bolt on the back side of the tensioner frame and check for brake tightness. The tensioner should move freely along the track with the brake lever engaged and should hold tension with the brake lever released. If more adjustment is needed, repeat steps above until properly adjusted.

Note: Cover Removed For Clarity

# MAINTENANCE & ADJUSTMENTS



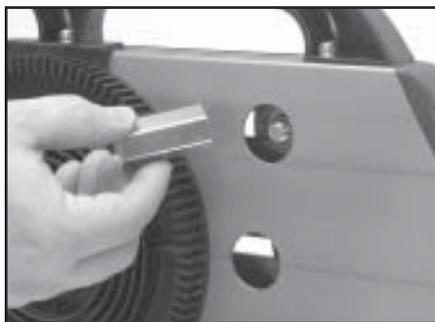
## Adjusting the String Clamp Jaw Spacing

The string clamps 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 Adjustment Knob counter clock-

wise to open the gap between the jaws. The clamp jaws should be cleaned periodically to be free from dirt, oil, and any string coating for them to grip properly. Knife sharpening stones are excellent for removing build-up on the diamond coated surfaces and are available.

**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 clamps specifically designed for badminton racquets are also available.



## Clamp Base Locking Nut Adjustment

In the event the Locking Lever rotation is insufficient to ensure smooth operation of the clamp base, very minor adjustments to the Clamp Base Locking Nut can be made with the supplied 17mm socket. Tighten or loosen the locking nut in very small increments to provide more clamping pressure or running clearance as needed.



## Quick Action Clamp Base Removal

Quick Action clamp bases can be removed from the turntable for maintenance or cleaning by removing clamp stop located at the end of the slot in the turntable. To remove the clamp stop, remove the two screws holding the clamp stop in place from the underside of the turntable. Lift the clamp stop out of the slot, slide the clamp base to the end of the slot and lift it out. Replace the clamp base and clamp stop in reverse order.

# TROUBLESHOOTING TIPS

## **PROBLEM**

## **SOLUTION**

|  |  |
|--|--|
| String slips in clamps   | <ul style="list-style-type: none"><li>- Adjust gap between clamp jaws</li><li>- Clean clamp jaws</li></ul>                                   |
| String slips in gripper  | <ul style="list-style-type: none"><li>- Adjust gripper jaw spacing</li><li>- Clean gripper jaws</li></ul>                                    |
| String clamp base slips on turntable                           | <ul style="list-style-type: none"><li>- Clean bottom of clamp &amp; glide bar with alcohol</li><li>- Adjust clamp base locking nut</li></ul> |
| Tensioner slips on Tensioner Bar after brake lever is released | <ul style="list-style-type: none"><li>- Clean tensioner brake disc</li><li>- Adjust tensioner brake lever</li></ul>                          |
| String tension too tight or too loose                          | <ul style="list-style-type: none"><li>- Check tension using a tension calibrator, adjust machine calibration if necessary</li></ul>          |

## **CARE & CLEANING**

With time and use, the clamping surfaces of your machine may become oily or dirty and result in string or clamp slippage while stringing. Periodic cleaning of the String Clamps, String Clamp Base, and String Gripper is recommended. Knife sharpening stones work well for cleaning the diamond coated string clamping surfaces. Cleaning with a solvent such as isopropyl alcohol and a mild abrasive tool such as a toothbrush also works well to remove oily or greasy build up.

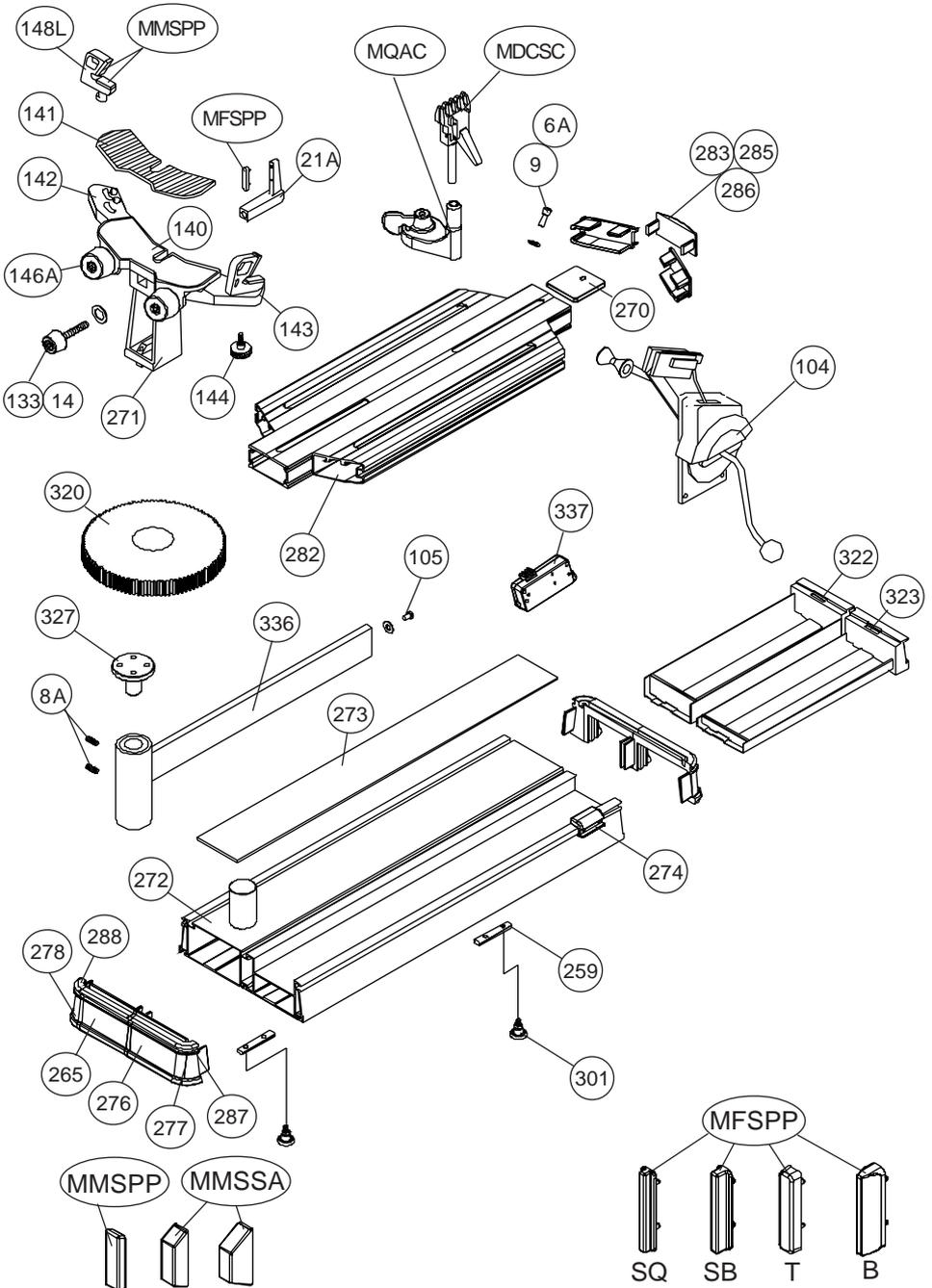
# PARTS LIST

| <b>PART #</b> | <b>DESCRIPTION</b>    | <b>PART #</b> | <b>DESCRIPTION</b>        |
|---------------|-----------------------|---------------|---------------------------|
| 6A            | CAP SCREW-M8          | 336           | TENSIONERBAR              |
| 8A            | SET SCREW             | 337           | BRAKE BOX (ST)            |
| 9             | WASHER-M8             | MDCSC         | METAL STRING CLAMP        |
| 14            | WASHER-M10            | MQAC          | TALL QA BASE CLAMP        |
| 21A           | FRAME SUPPORT SLIDE   |               |                           |
| 104           | TENSIONER ASSEMBLY    |               |                           |
| 105           | RETAINER SCREW        |               |                           |
| 133           | FRM SUPP SCREW & KNOB | 71            | 6MMT-HANDLE HEX WRENCH    |
| 140           | MTNG STAND TOP PLATE  | 98            | BOX WRENCH- 10MM          |
| 141           | MTNG STAND PAD        | 109           | NEEDLE NOSE PLIERS        |
| 142           | SUPPORT ARM- LEFT     | 110           | BENT NOSE PLIERS          |
| 143           | SUPPORT ARM- RIGHT    | 171           | DIAGONAL CUTTERS          |
| 144           | SUPPORT LOCK KNOB     | 196           | 17MM SOCKET               |
| 146A          | ARM ADJ KNOB & SCREW  | 251           | HEX WRENCH SET            |
| 148L          | SHOULDER V-CLAMP      | MA            | STRINGERS AWL             |
| 148R          | SHOULDER V-CLAMP      | MFSPP         | FRAME SUPP PADS           |
| 203           | TT SCREWS             |               | SQUASH (SQ)               |
| 259           | SLIDE BRACKET         |               | SHORT BADMINTON (SB)      |
| 265           | DRAWER END CAP        |               | TENNIS (T)                |
| 270           | SUPP MOUNTING PLATE   |               | BADMINTON (B)             |
| 271           | SUPPORT POST          | MMSPP         | TENNIS SHLDER SUPP PADS   |
| 272           | BASE                  | MMSSA         | SHLDER SUPP PADS (L TO R) |
| 273           | TRAY PAD              |               | RACQUETBALL               |
| 274           | CHOP BLOCK            |               | BADMINTON                 |
| 276           | DRAWER END CAP        | MPSA          | PATHFINDER AWL            |
| 277           | BASE CORNER CAP       |               |                           |
| 278           | BASE CORNER CAP       |               |                           |
| 282           | TURNTABLE             |               |                           |
| 283           | TT END CAP            |               |                           |
| 285           | TT END CAP- RIGHT     | MBFC          | BAD FLOATING CLAMP        |
| 286           | TT END CAP- LEFT      | MDCSC         | FIXED BAD STRING CLAMP    |
| 287           | BASE END CAP          | MGSMC         | MACHINE COVER             |
| 288           | BASE END CAP          | MPG           | STARTING CLAMP            |
| 301           | RUBBER FEET           | MPS           | POLISHING STONE           |
| 320           | BRAKE RING            | MPXFS         | FLOOR STAND               |
| 322           | LARGE DRAWER          | MTC           | CALIBRATOR                |
| 323           | SMALL DRAWER          | SGSM          | STRINGER'S MAT            |
| 327           | TURNTABLE PIN         |               |                           |

## TOOLS & ACCESSORIES

## OPTIONAL TOOLS & ACCESS

# PARTS DRAWING



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