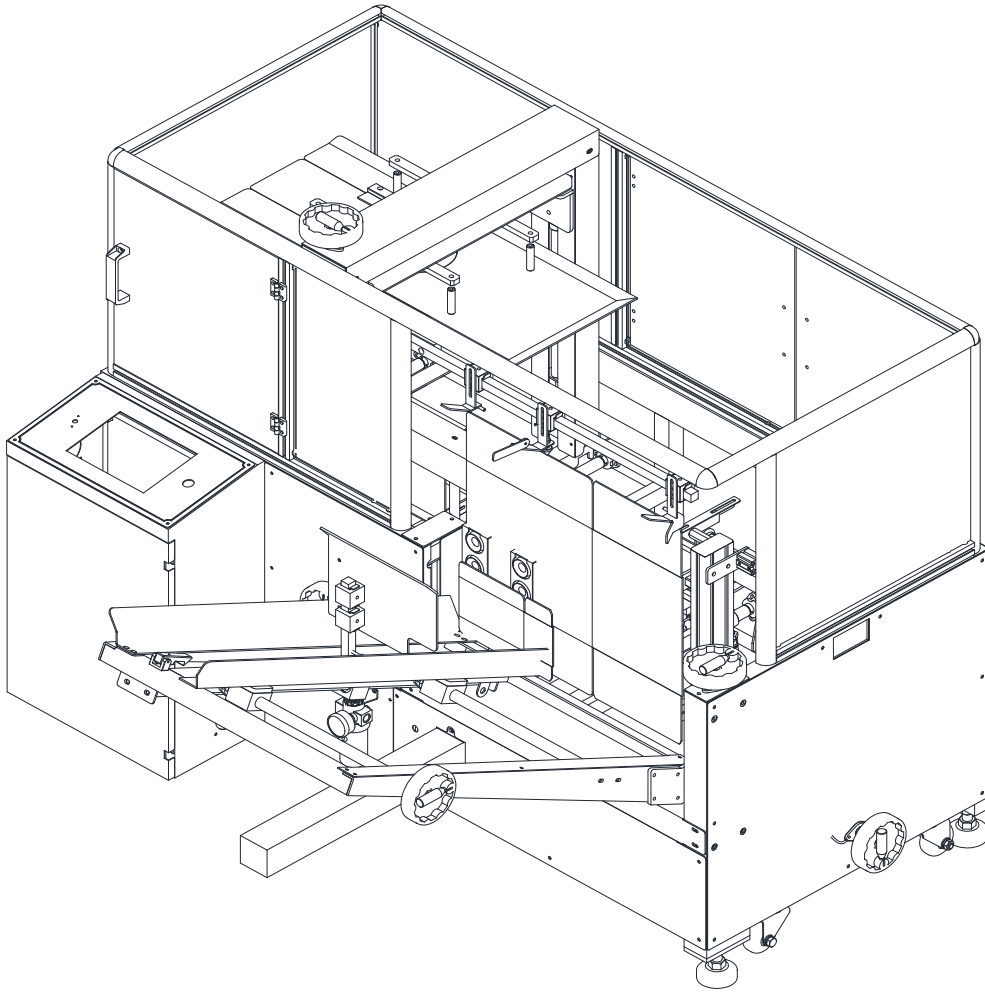


Automatic Erecting Machine

Operation and Maintenance Manual

CE-15



- ※ Before using the machine, please read the manual carefully
- ※ We reserve right to change technologies without prior notice

Preface

Thank you for purchasing the carton automatic sealing machine of our company.

The manual mainly describes its basic structure, use method and operation precautions to facilitate the safe and correct use of the machine and improves the service life of the machine. Please read the manual carefully before using the machine and confirm the manual is delivered to the final user. Please confirm that the manual is delivered to the final user, and the contents in the manual will be changed due to technical update without prior notice

GPK series sealing machine is a machine used to seal various cartons using OPP tape as the main material. The machine is characterized by its simple structure, convenient operation and easy maintenance, and is widely applied in various industries, achieving the ideal effects of beauty and efficiency.

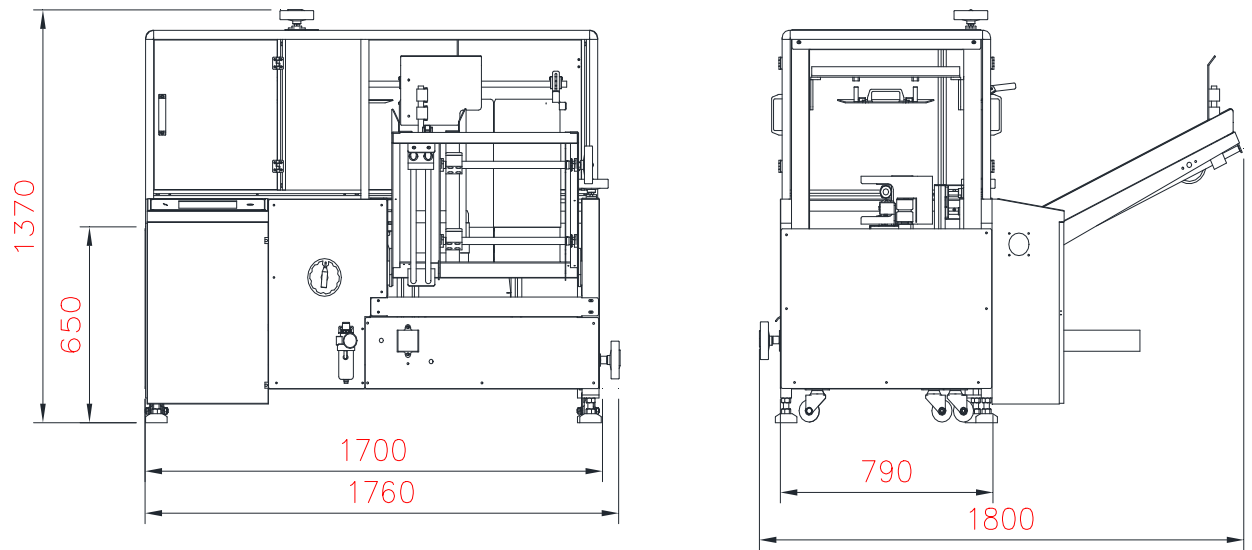
Safety Precautions

- I. Operator must read the instructions carefully before operating the machine;
- II. The operator shall not place the body parts at the running location of the machine when operating the machine;
- III. The maintenance personnel must read the instructions carefully before conducting repair and maintenance;
- IV. Please turn off the power source, air source during the handling of tapes and normal maintenance or repair;
- V. Untrained personnel shall not operate the machine at will.

Contents

1 Feature and overall dimension of the machine:	- 4 -
2. Machine Structure and Adjustment Description	- 5 -
3. Operation Process of the Machine	- 6 -
3.1 Description of adjustment and operation of mechanical parts ..	- 6 -
3.2 Description of adjustment and operation of electrical control parts	- 12 -
3.3 Description of adjustment and operation of pneumatic control parts	- 16 -
4. Operation and Adjustment of Tape Sticker	- 24 -
4.4 Adjustment of tape tension:	- 26 -
5. Exploded View	- 28 -

1 Feature and overall dimension of the machine:



The machine is a product of series semi-automatic sealing machines with automatic cover-folding and bottom sealing functions, stand-alone operation, economic and efficient, and is an ideal sealing equipment. The main parameters are as follows:

Unpacking ability: 12 cartons/min

Sealing width: 80mm~250mm

Sealing height: 100mm~250mm

Sealing length: 180mm~350mm (the minimum specifications cannot co-exist)

Overall dimension: L1770 mm ×W1730 mm ×H1370 mm

Applicable power source: 220V 50Hz

Power consumption: 400W

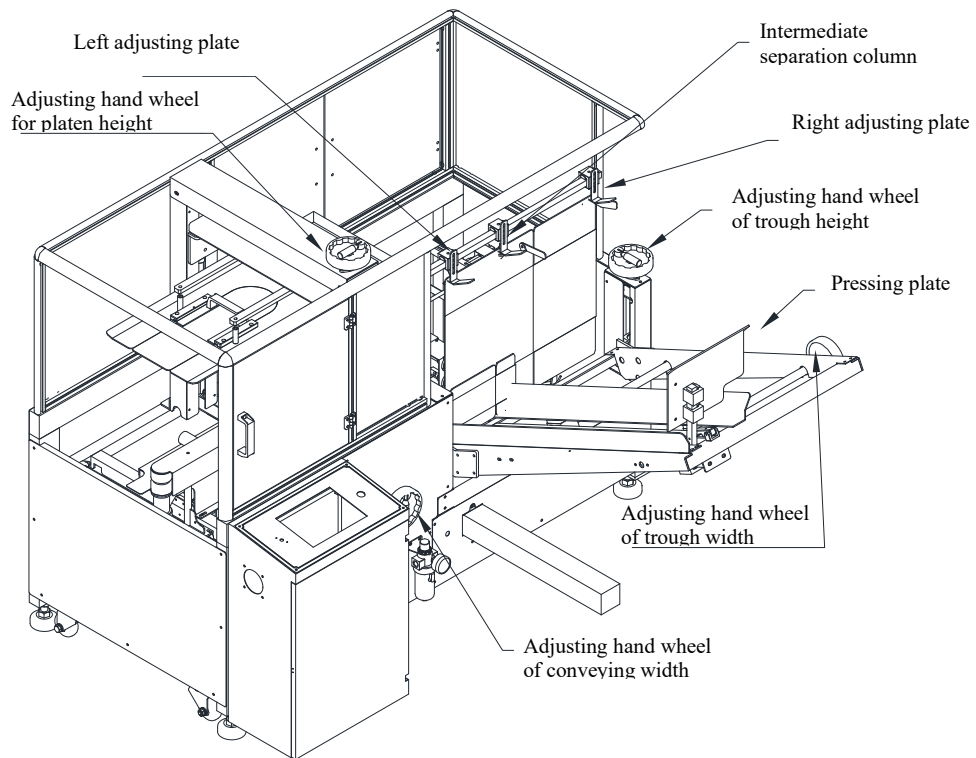
Pneumatic supply: 6kg/cm²

Applicable tape: 48 mm

Weight of machine: 450kg

2. Machine Structure and Adjustment Description

(See Figure 1):



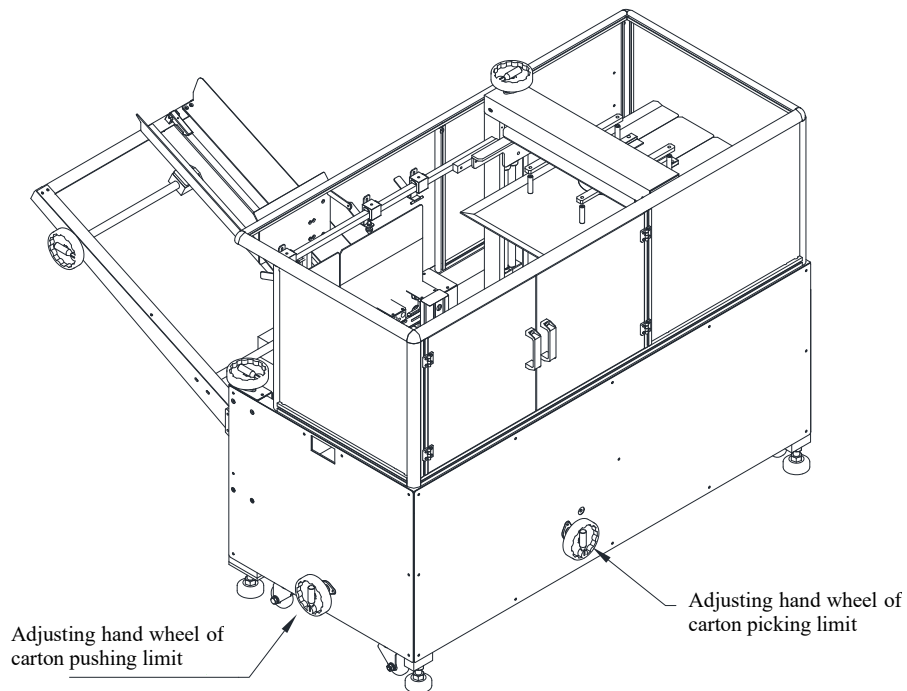


Figure 1

3. Operation Process of the Machine

3.1 Description of adjustment and operation of mechanical parts

- 1) Take a molded carton to be unpacked.
- 2) Rotate the belt width adjusting hand wheel (the belt width narrows down when rotating clockwise, and widens up when rotating anticlockwise) to make the discharging belt width W and the carton width W as shown in Figure 2:

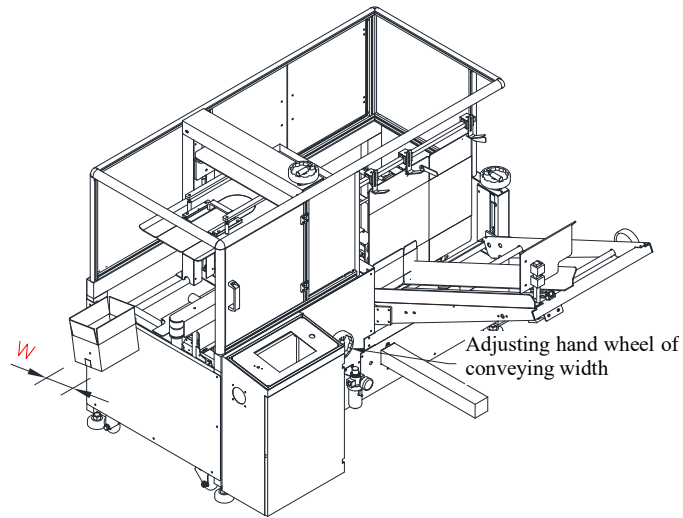


Figure 2

3) Rotate the carton fetching and regulating hand wheel (forward when rotating clockwise, and backward when rotating anticlockwise) to make the sucker face parallel with the belt face when the sucker is at the limit position. As shown in Figure 3:

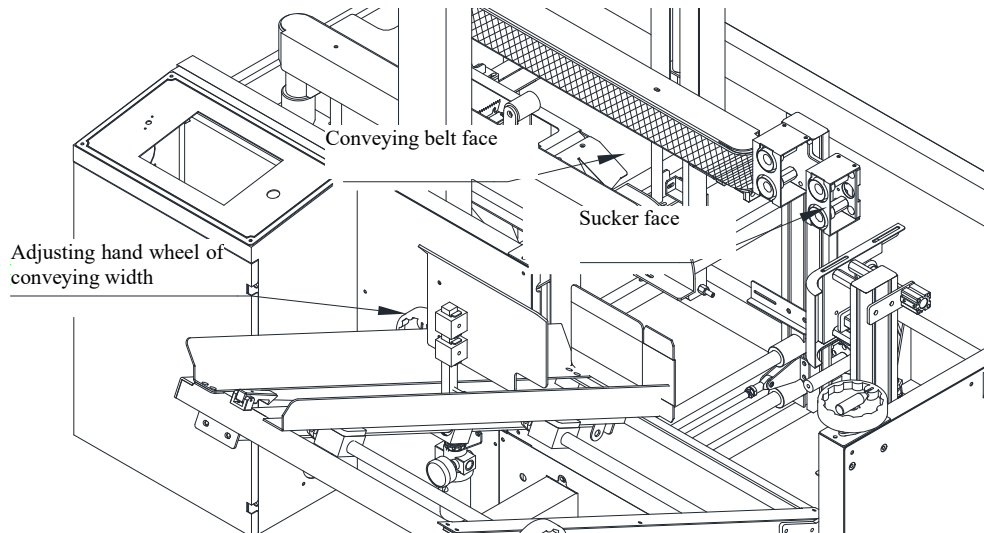


Figure 3

4) Take a folded carton, place it with the lower edge of the stop block as a benchmark, adjust the height and width of the trough to make them be equal to the height and width of the unmolded carton respectively. As shown in Figure 4:

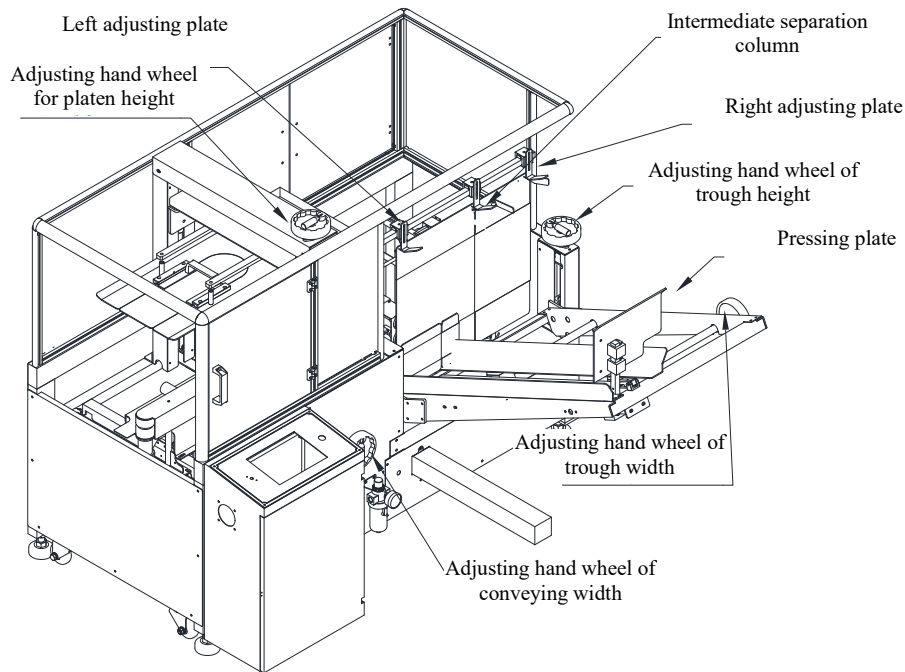


Figure 4

5) Adjust the conical adjusting block to make it in the same line with the folding of the carton. As shown in Figure 5:

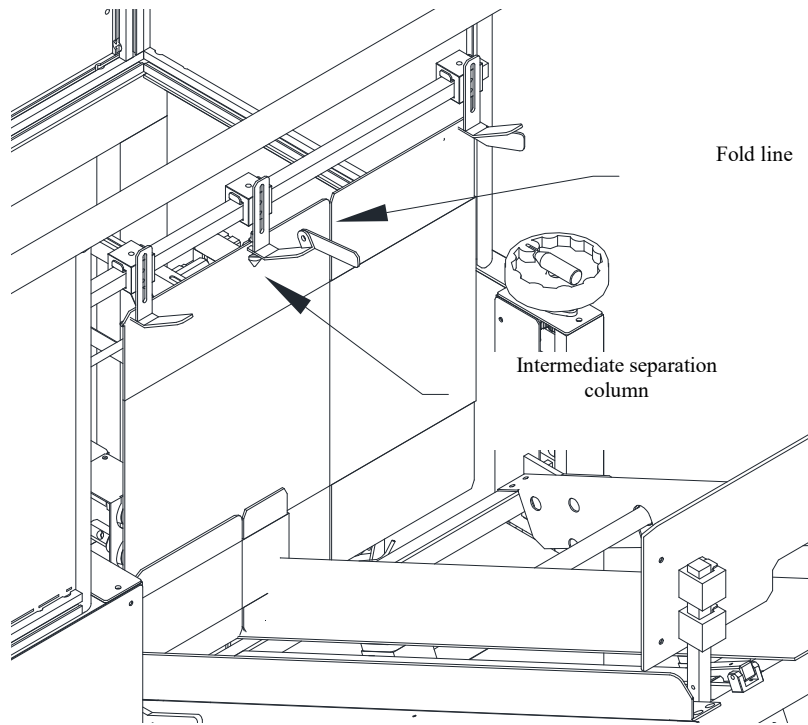


Figure 5

6) Rotate the carton push adjusting hand wheel to adjust to the carton block plate and the separation column adjusting block, with the folding line on the same straight line, as shown in Figure 6:

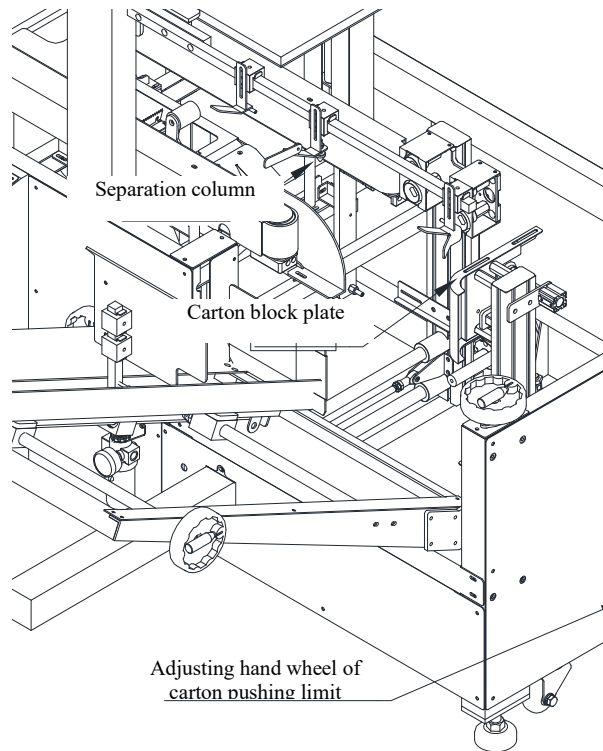


Figure 6

7) Adjust the sucker to a suitable location according to the carton size. As shown in Figure 7:

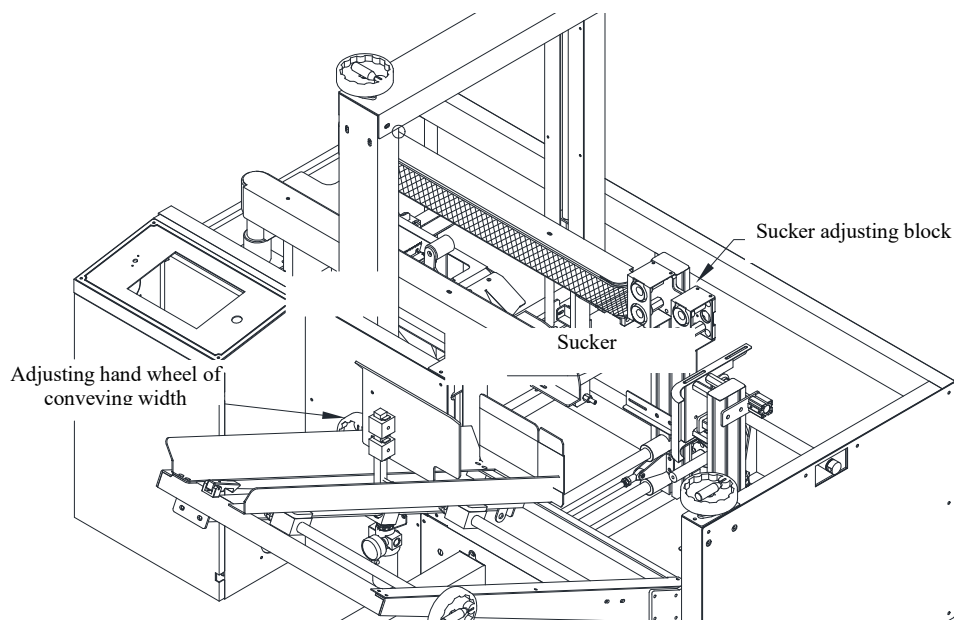


Figure 7

8) Finally put the unmolded carton into the trough and lay down the push plate, so far, the pre-boot mechanical adjustment has been completed. As shown in Figure 8:

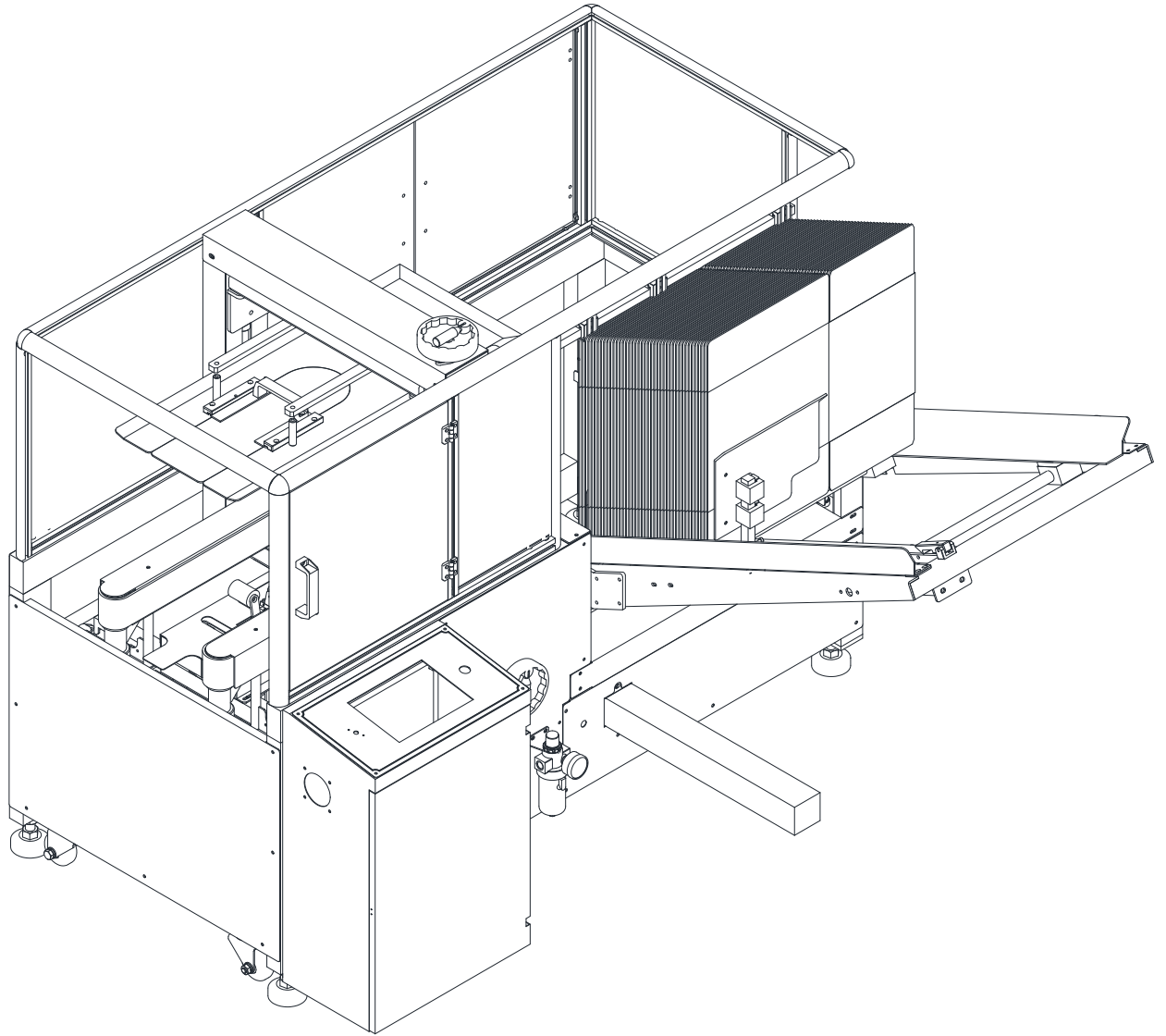


Figure 8

3.2 Description of adjustment and operation of electrical control parts

- 1) Confirm the unpacking machine has been connected with the power source and air source.
- 2) Turn on NFB and power switch in turn, and confirm the emergency stop button is in non-pressed status. As shown in Figure 9:

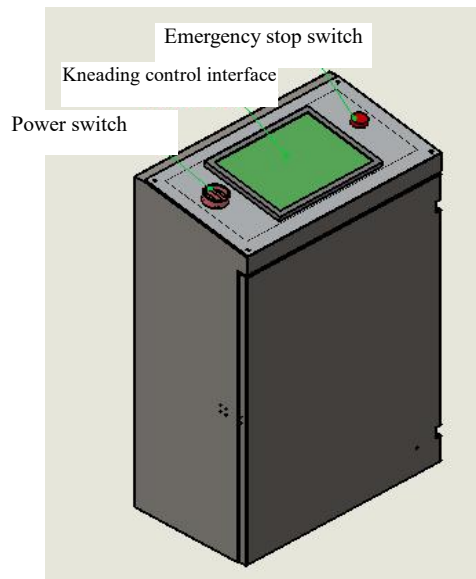


Figure 9

- 3) After startup, the screen display is as shown in Figure 10:



Figure 10

4) The main screen is as shown in Figure 11:

Auto/manual: the manual/automatic status switching and display,

count: Display the batch and total quantities of unpacked cartons, press Reset to return to zero.

Unpack continuously: Press Continuous in automatic status, the machine will conduct continuous unpacking operation.

unpack one carton: Conduct unpacking operation for one time.

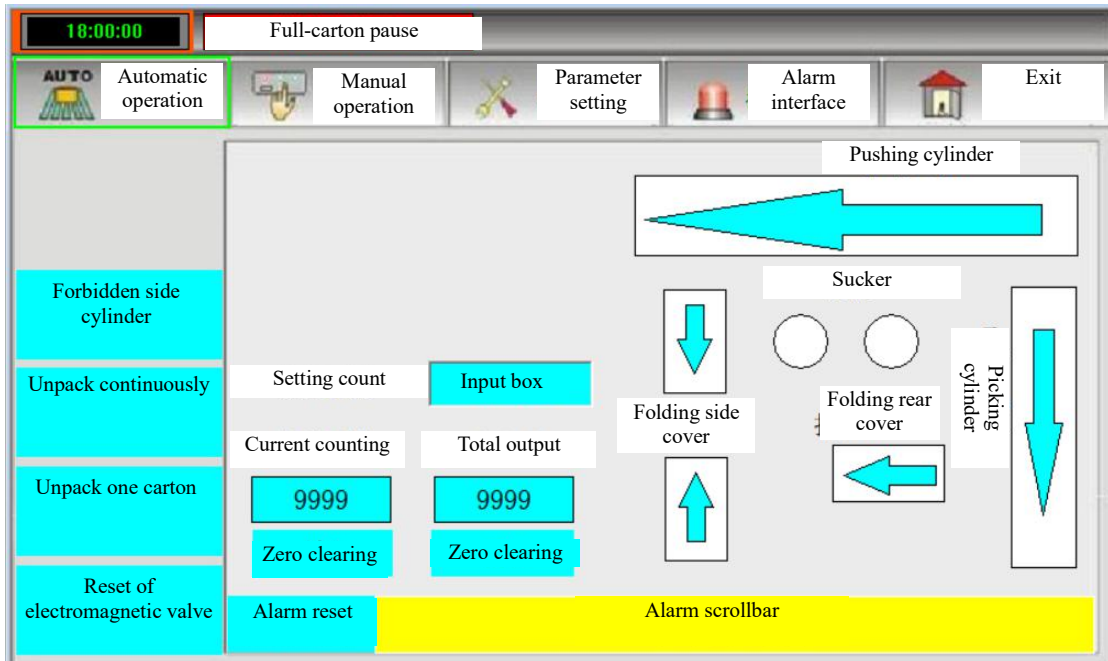


Figure 11

5) Manually click to execute relevant operations, as shown in Figure 12:

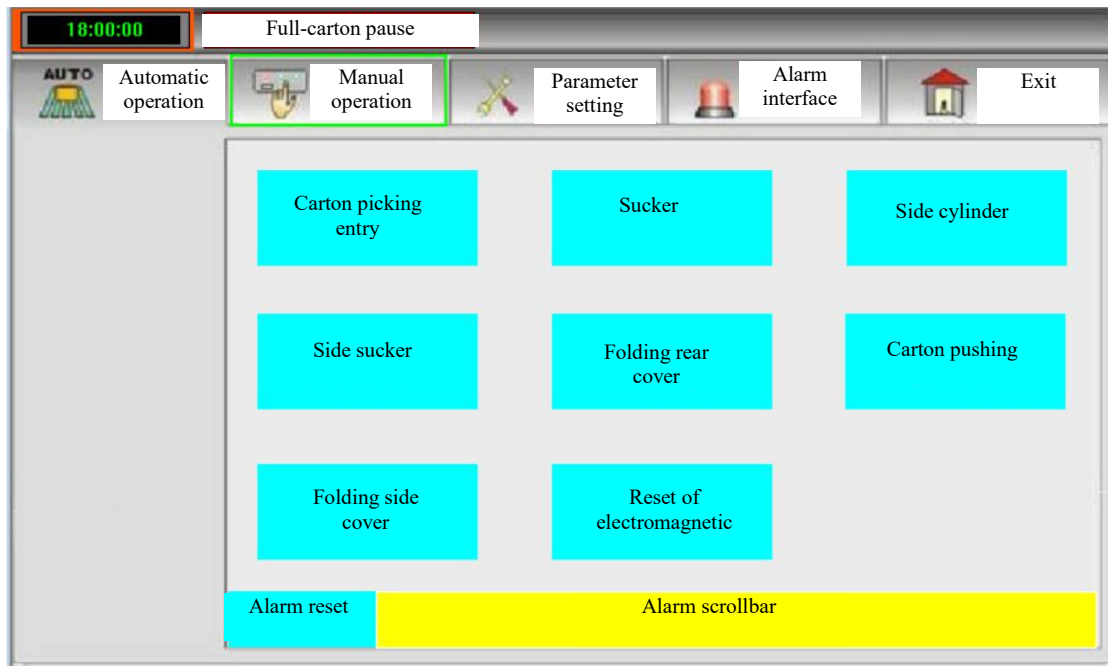


Figure 12

6) Screen setting.

Basic setting, as shown in Figure 13:

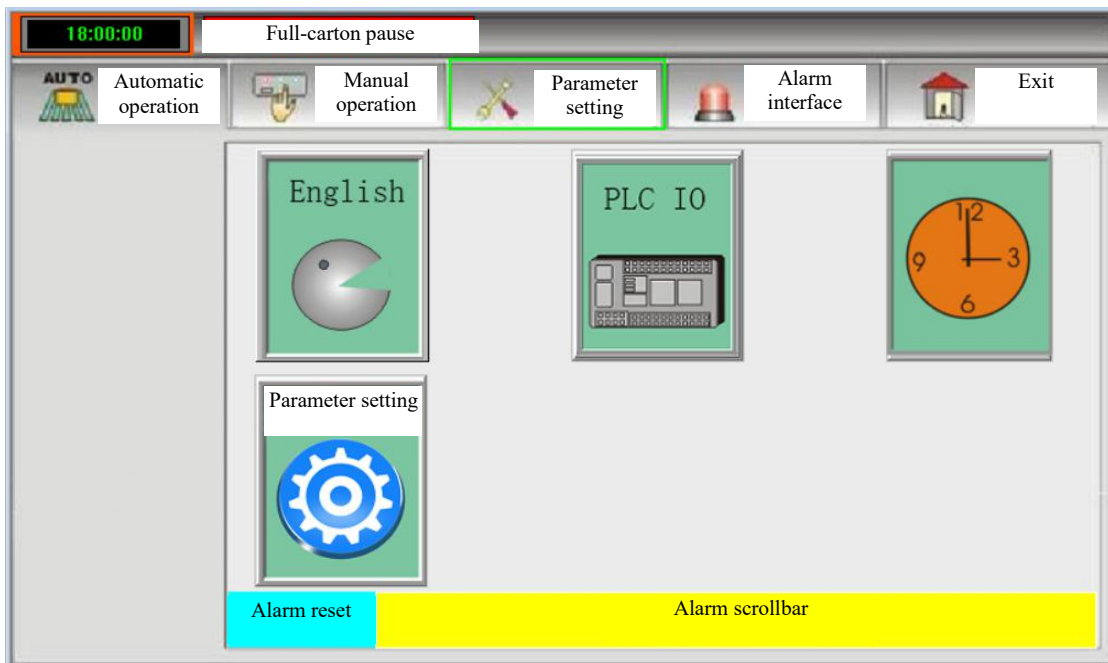


Figure 13

1. Click the first icon to switch between Chinese and English.
2. Click the second icon to view I/O.
3. Click the third icon to set time.
4. Click the fourth icon to set advanced parameters.

Advanced settings are as shown in Figure 14.

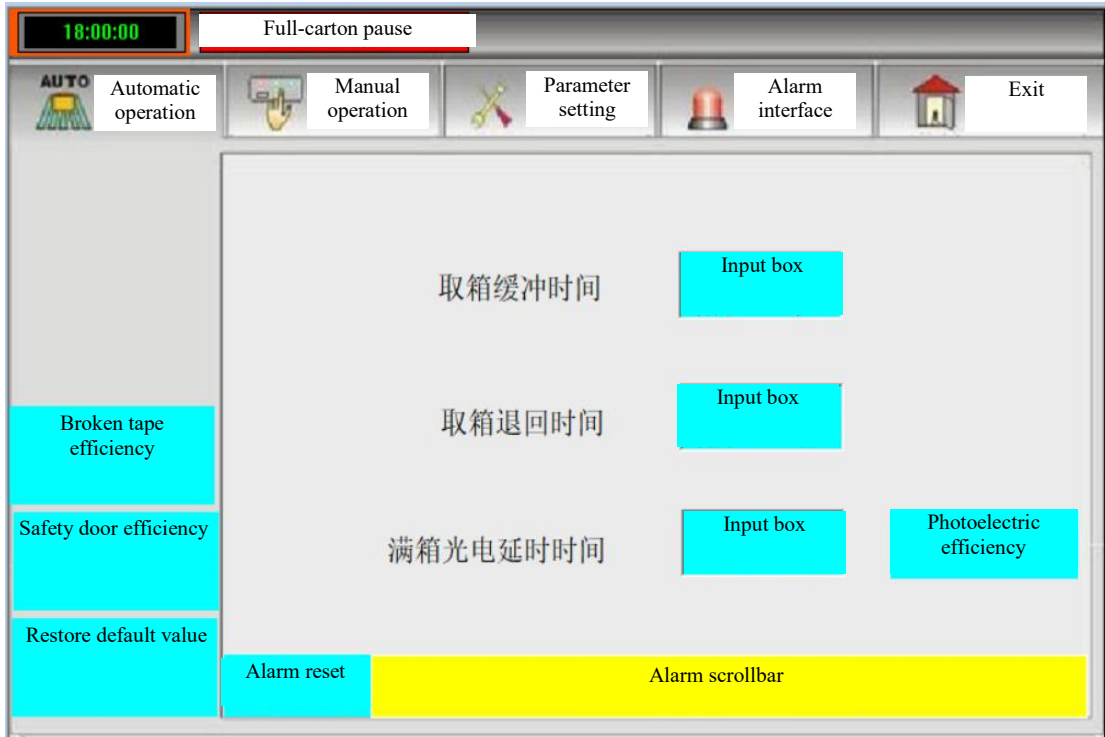


Figure 14

8) The alarm screen is as shown in Figure 17.

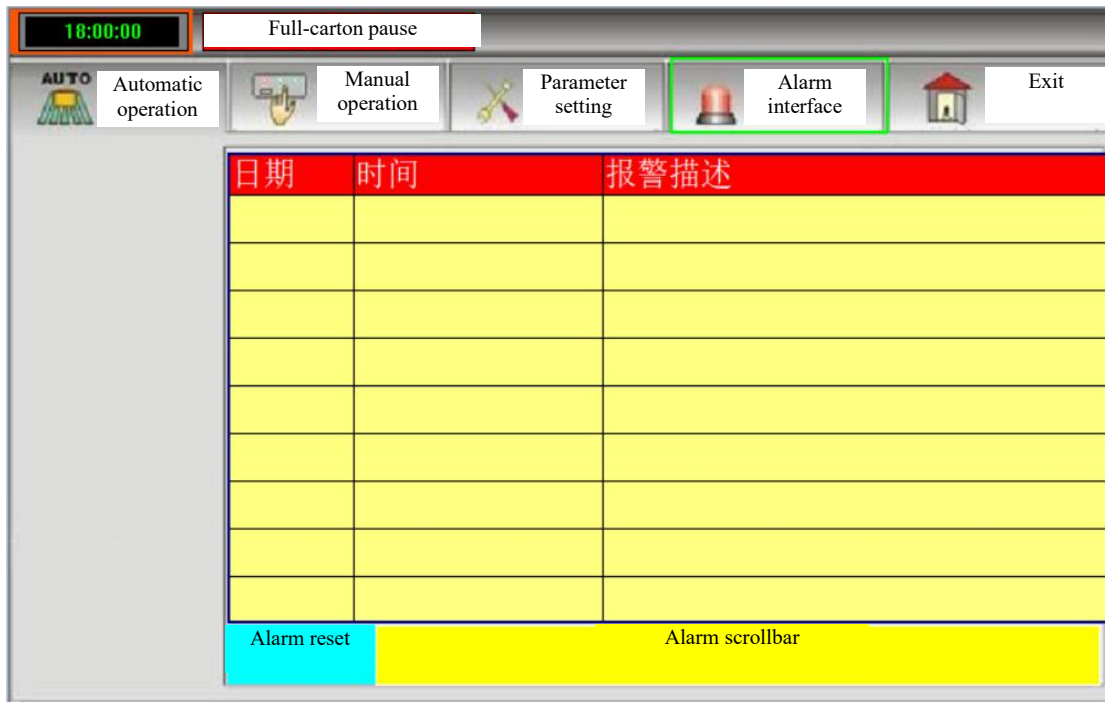


Figure 17

3.3 Description of adjustment and operation of pneumatic control parts

1) The air pressure threading is as shown in Figure 18:

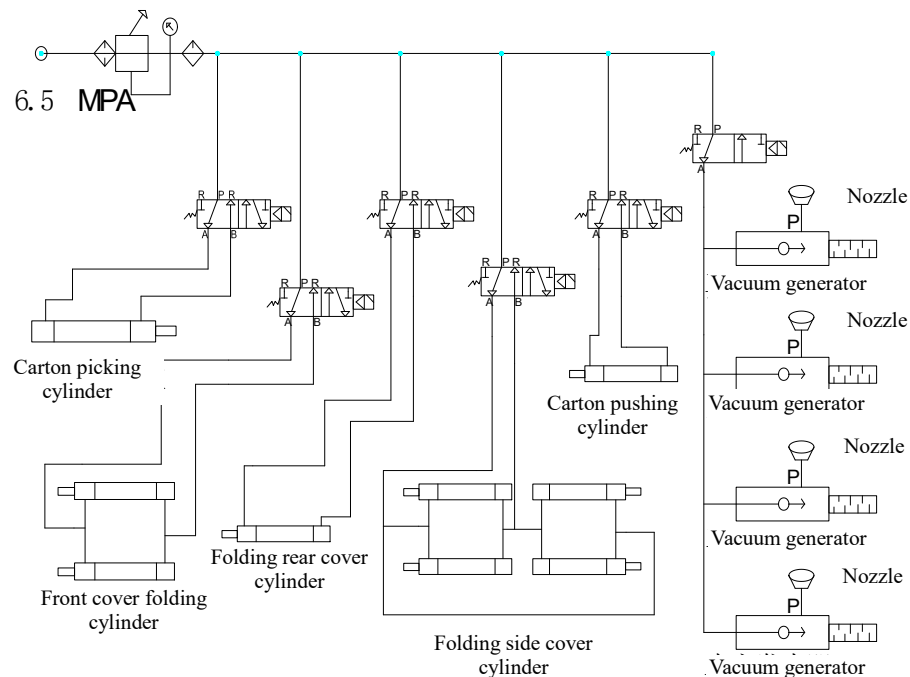


Figure 18

- A. The cleanness of the air source is the most important for the user and maintenance of pneumatic components.
- B. Supply sufficient air source to confirm the action of the components, and set the pressure within 5 - 6kg/cm².
- C. Pneumatic cylinder: Frequently wipe the moving axle to prevent dust entering the piston and generating leakage.
- D. Maintenance of air pressure pipeline; If there is a need to disassemble the parts of air pressure pipelines for maintenance, check whether there is any pipe-bending phenomenon occurred in gas pipe, if any, make it straight immediately for fear of choking.
- E. Sucker: keep the sucker clean and prevent oil stain. The vacuum

generator must be cleaned once every week.

F. Three-point combination:

1. Inspect to see whether the oil is sufficient, if not, please add the special pneumatic oil, the oil concentration shall not be too dense;

* Please do not add other alternative oils at will to prevent pneumatic circuit being blocked or having fault.

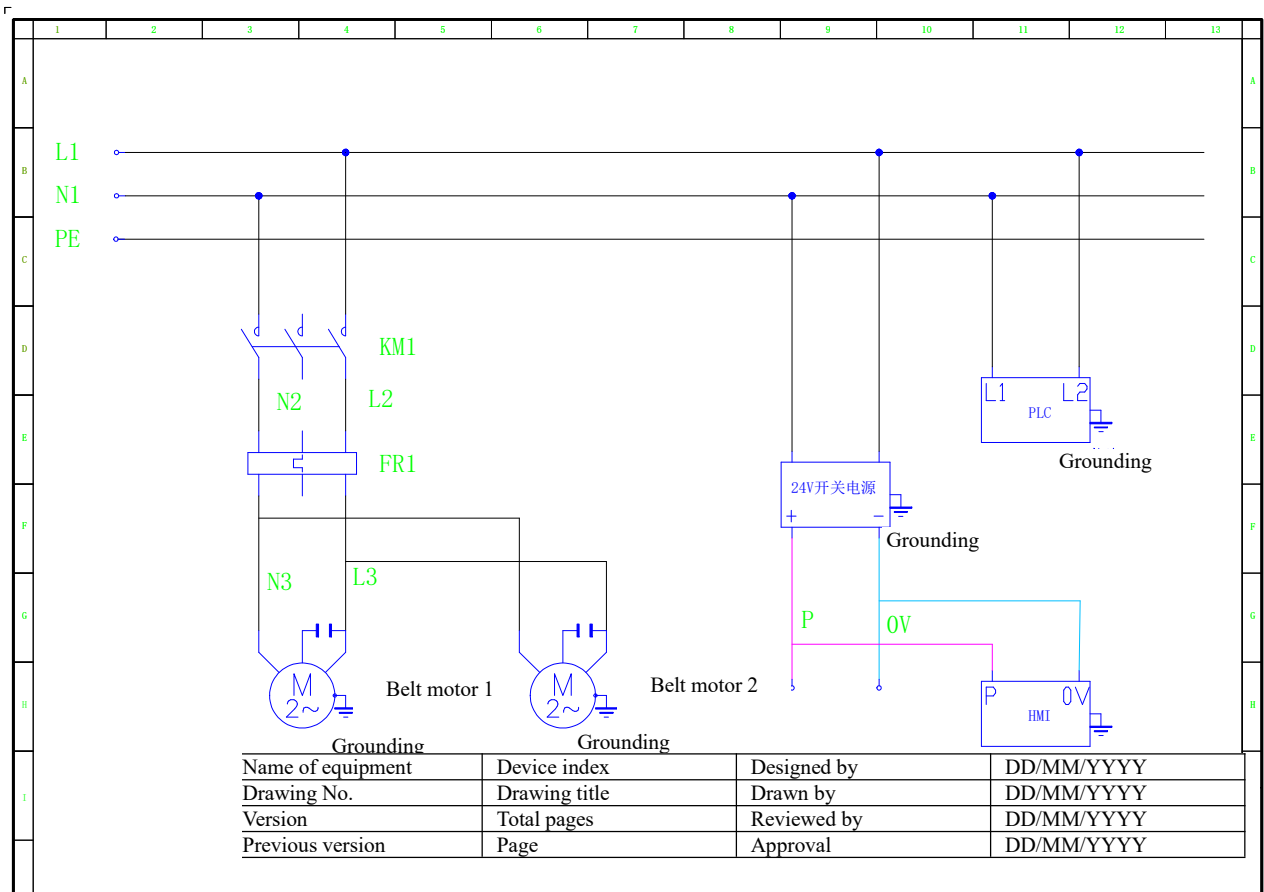
2. Inspect the filter cup to see whether the water is deposited too much, if so, drain off;

3. Use the pressure adjustment button to adjust the air pressure to 5-6kg/cm².

H. During shutdown or maintenance, use the blow-off valve to exhaust the residual air in the circuit for personnel security.

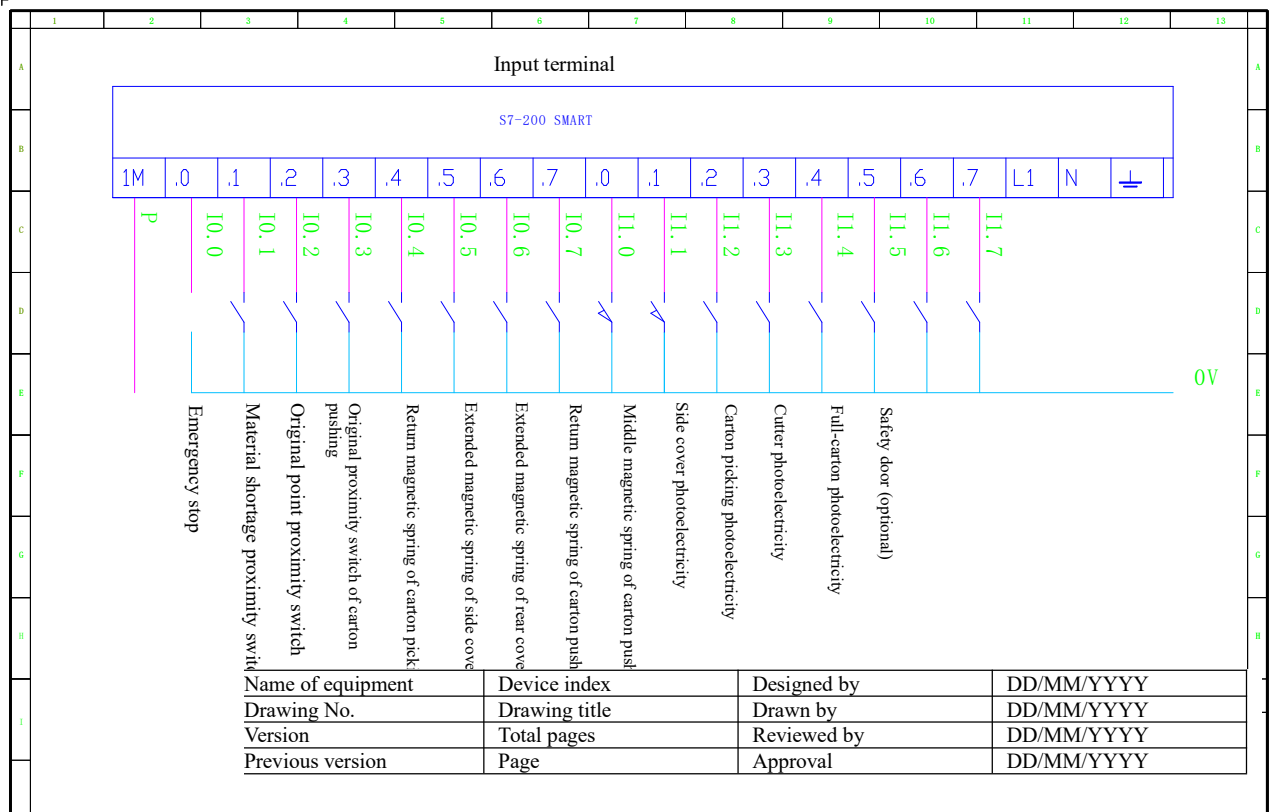
2) Electric control diagram

As shown in Figure 19:

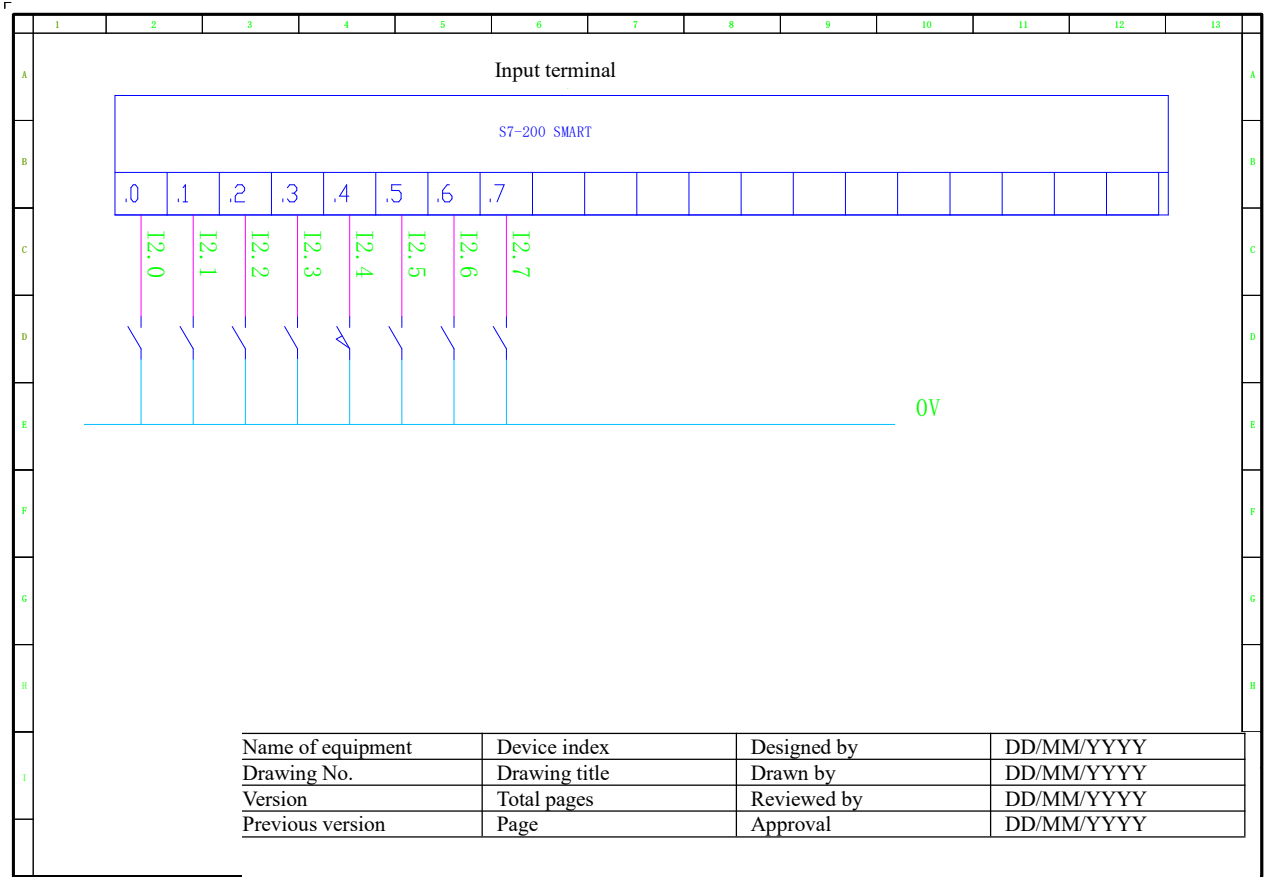


Name of equipment	Device index	Designed by	DD/MM/YYYY
Drawing No.	Drawing title	Drawn by	DD/MM/YYYY
Version	Total pages	Reviewed by	DD/MM/YYYY
Previous version	Page	Approval	DD/MM/YYYY

WI-7. 5. 1-042-14A

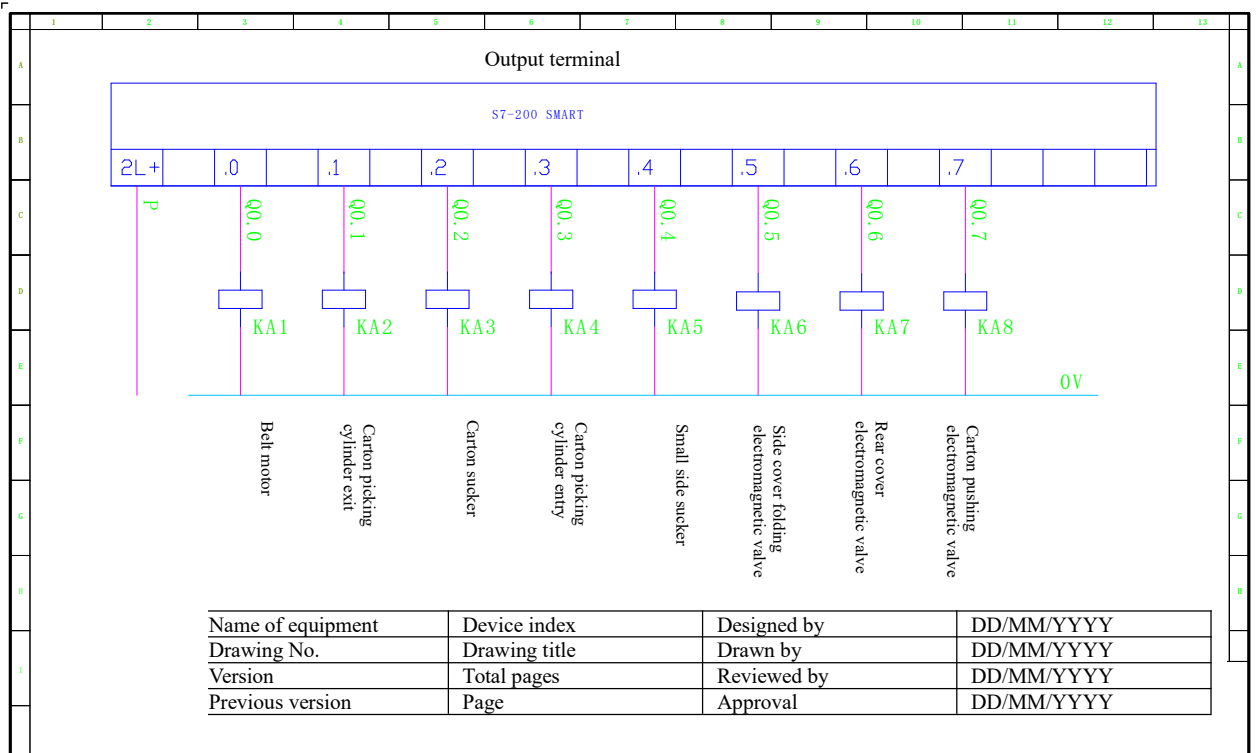


WI-7. 5. 1-042-14A

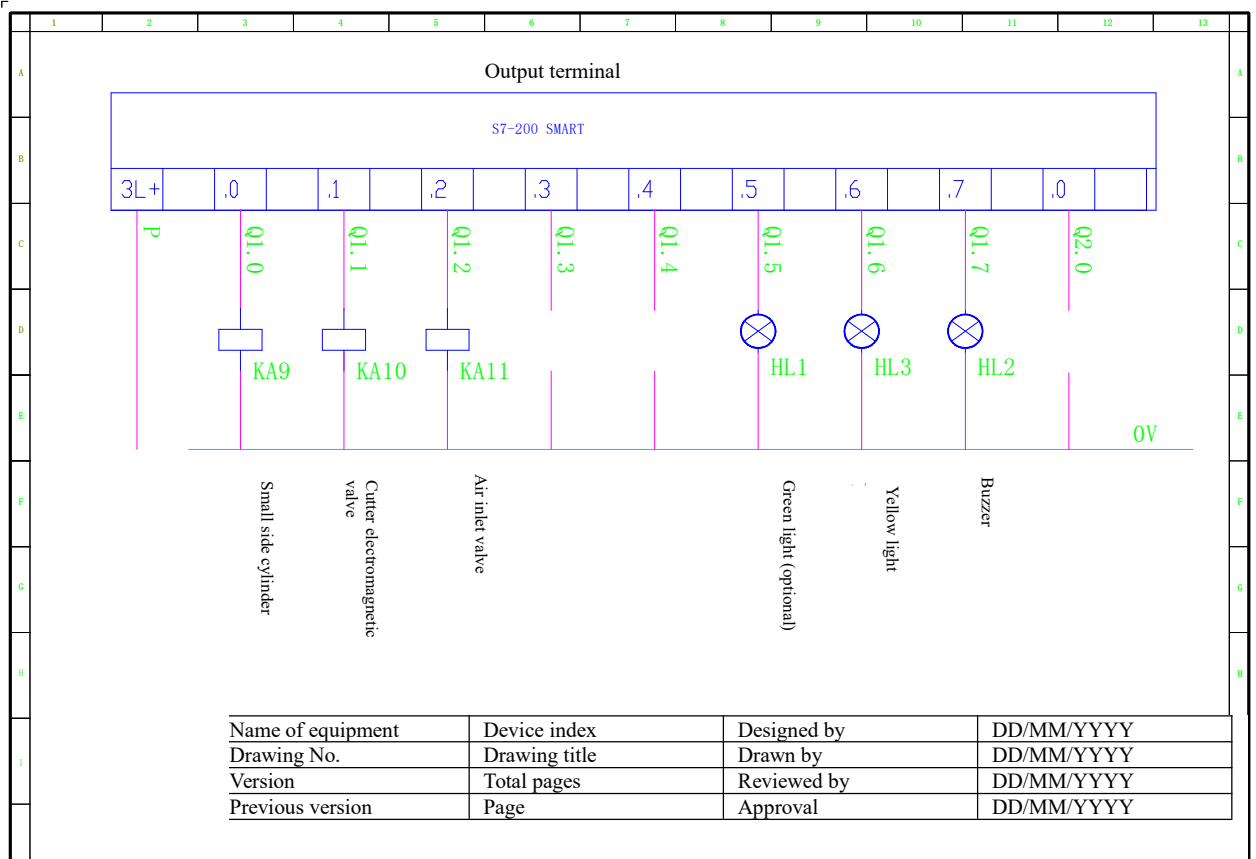


Name of equipment	Device index	Designed by	DD/MM/YYYY
Drawing No.	Drawing title	Drawn by	DD/MM/YYYY
Version	Total pages	Reviewed by	DD/MM/YYYY
Previous version	Page	Approval	DD/MM/YYYY

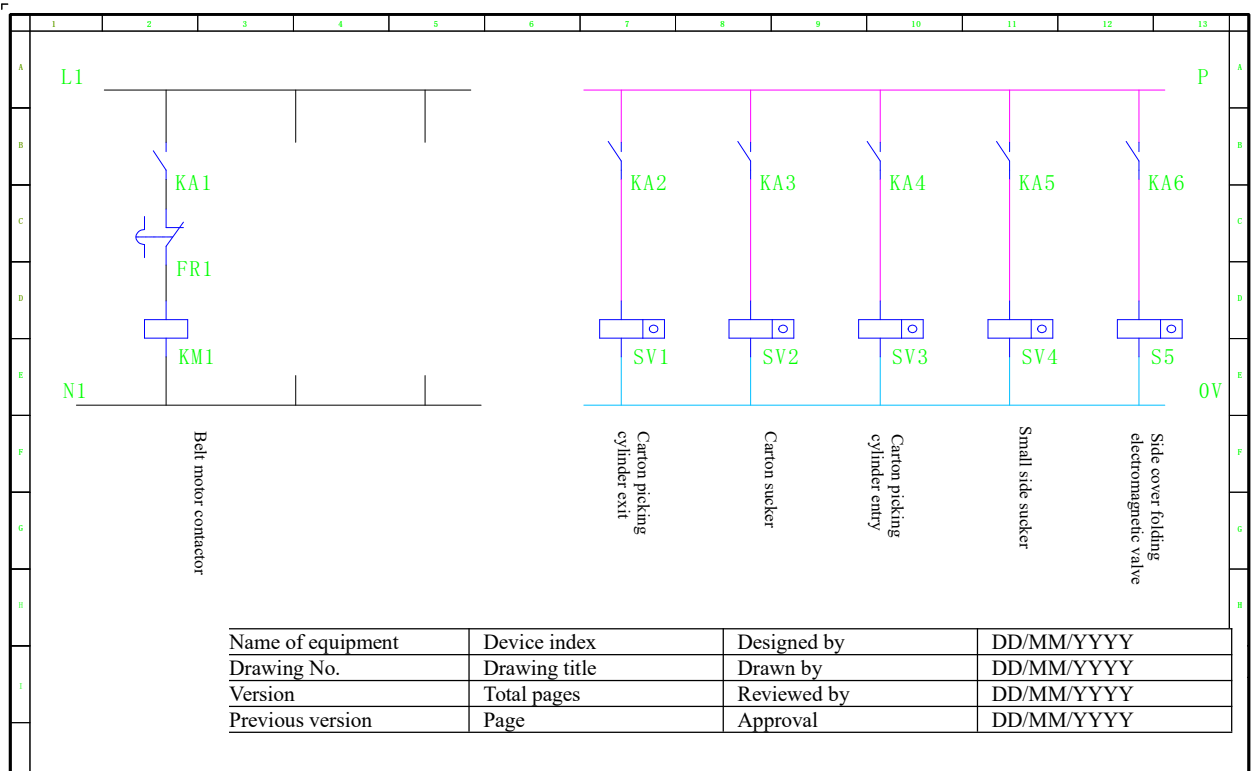
WI-7. 5. 1-042-14A



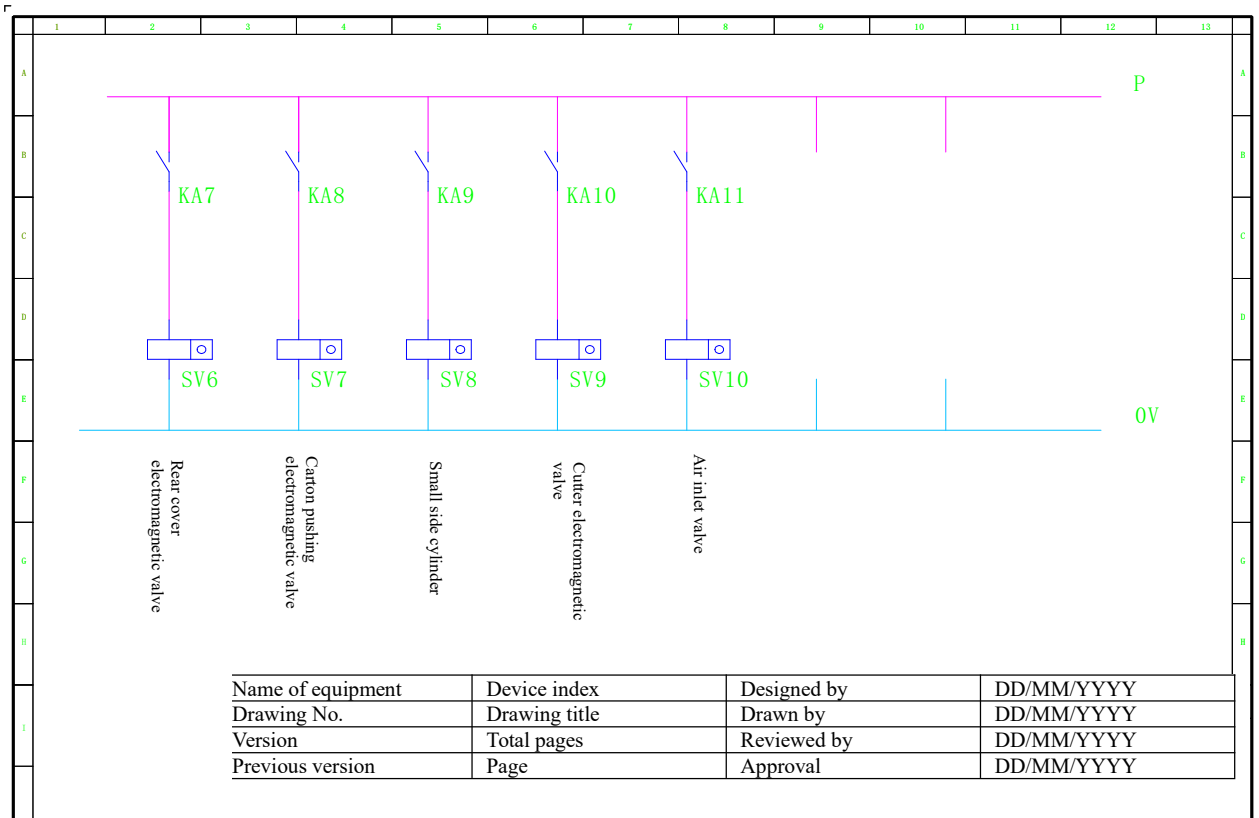
WI-7. 5. 1-042-14A



WI-7. 5. 1-042-14A



W1-7. 5. 1-042-14A



WI-7. 5. 1-042-14A

Figure 19

4. Operation and Adjustment of Tape Sticker

4.1 (See Figure 21), firstly, put the new OPP tape coil onto the central spindle, as shown in the figure; secondly, pull out the tape to bypass the knurling rotary sleeve and then bypass the axle sleeve along the line; thirdly, bypass the knurling rotary shaft, finally pass the tape through the black polyformaldehyde inner sleeve and go out, as shown in the figure below. During the whole process, attention shall be paid to that the adhesive face of the tape must be outward.

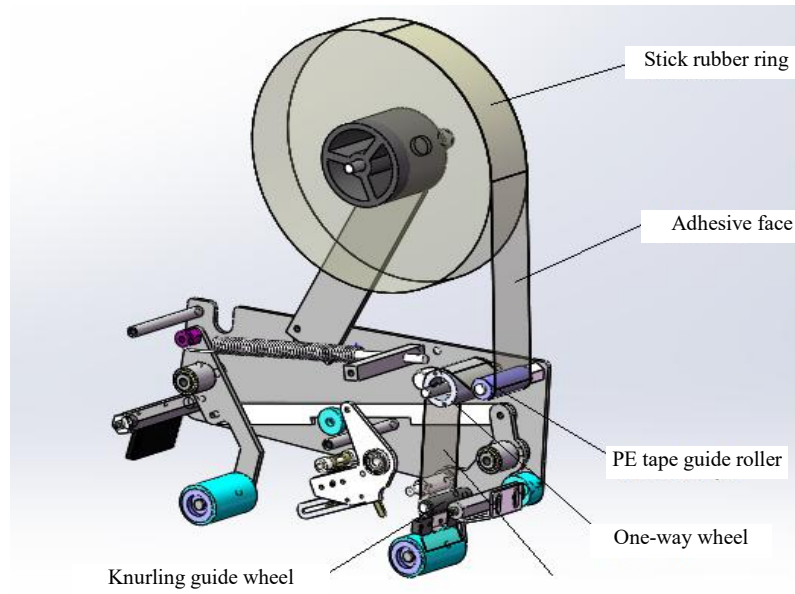


Figure 21

4.2 Threading diagram (see Figure 22):

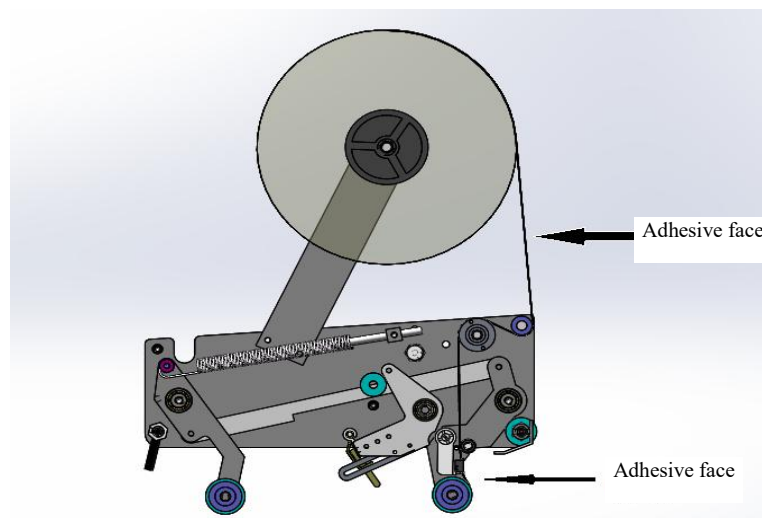


Figure 22

4.3 Tape location adjustment:

If the tape is not on the center line of the carton, please adjust referring to the figure below (see Figure 23): Loosen the nut, then adjust the lock screw to adjust the tape location.

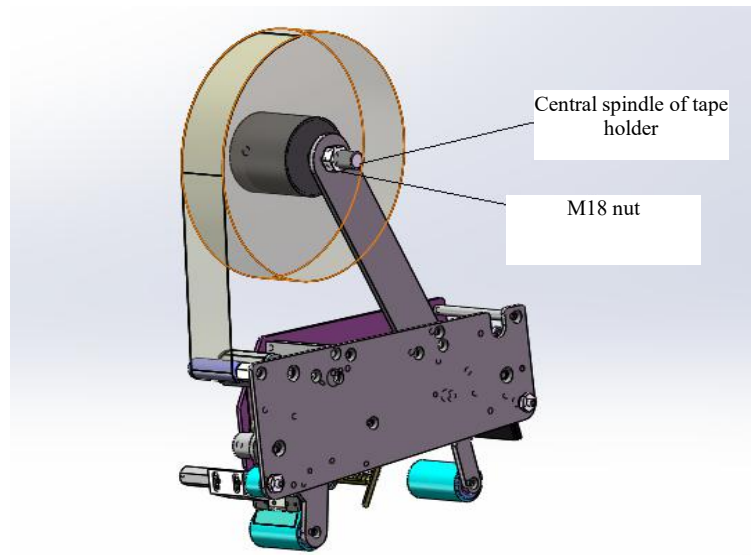


Figure 23

4.4 Adjustment of tape tension:

Adjust the front and rear locations of the fixed axle as shown in the figure (see Figure 24), and change the elastic force of the long spring of the swing rod to control the size of tape tension.

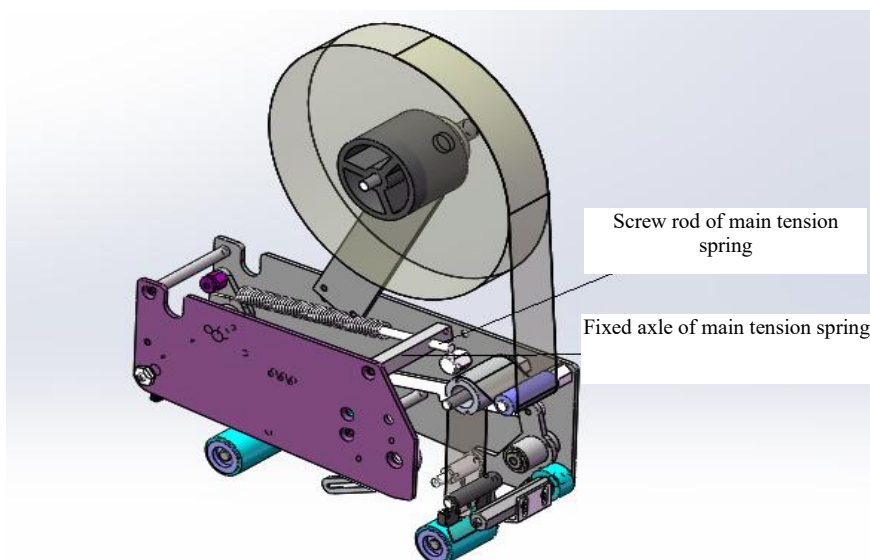


Figure 24

Elimination description of tape sticking abnormalities in sealing

Abnormalities	Causes	Removal method
Tape cannot be cut off.	The blade is nor sharp or the tape film jams the point of cutter.	Replacement of the blade: Wipe clean the blade and add grease
The tape has been cut off, but drags a section.	The cutter holder is jammed, resulting in inflexible action, or the spring is not tight enough.	Inspect the screws on the parts of the tape sticker, or adjust the force of the tension spring.
The tape has been cut off, but does not fit the carton face.	The main tension spring is too loose, the rebounding speed of the rear wheel cannot fit the belt speed.	Moderately fasten the main tension spring screws
The carton gets stuck and cannot move when arriving at the middle.	The main tension spring is too tight, and the front wheel gets stuck in the middle.	Moderately loosen the main tension spring of the tape pulley.
The tape is likely to drop out.	The one-way roller loses efficiency.	Replace for a new one-way roller.
The rear body of the sealed carton deflects and the cover corners intersect.		Before sealing the carton, the carton covers of both sides after folding the cover flat shall be aligned and parallel with the carton body before being pushed into the sealing machine for sealing.
After sealing, the tap on the rear segment of the carton has wrinkles or is not smooth.		Adjust the increased tension of the fixed axle on the tape sticker, as shown in Figure 7.

5. Exploded View

5.1 Main body mechanism, as shown in Figure 25 and Table 1:

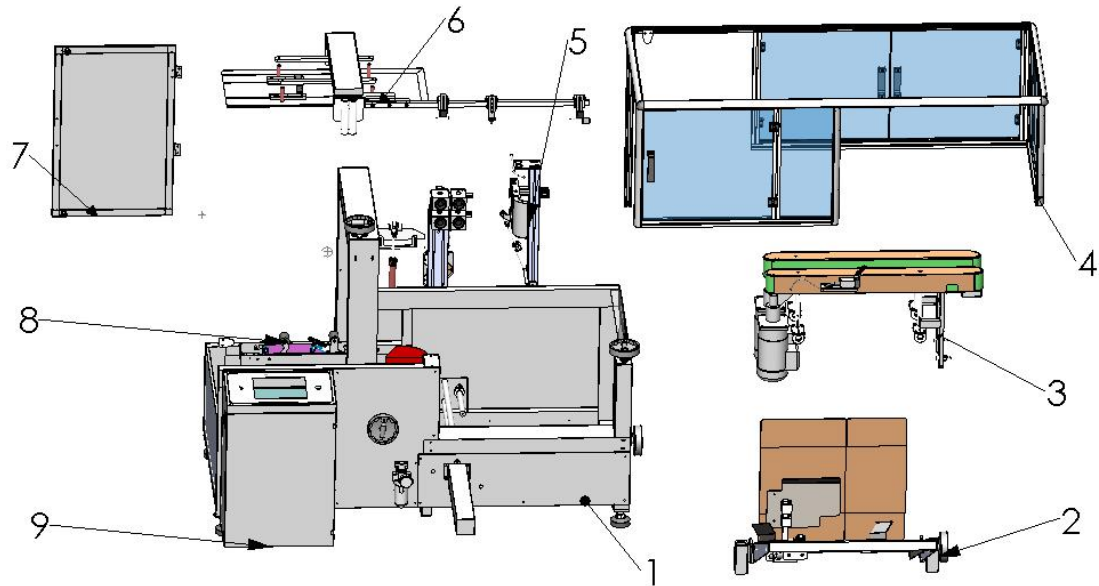


Figure 25

Parts List (Table 1)

S/N	Part No.	Name	No.	Quantity	Remarks
1		Main frame		1	
2		Trough mechanism		1	
3		Belt conveying mechanism		1	
4		Shield		1	
5		Carton picking and molding mechanism		1	
6		Carton pressing and adjusting mechanism		1	
7		Replace the tape door.		1	
8		Tape sticker		1	
9		Electric box		1	

5.2 Main frame and electric box, as shown in Figure 26 and Table 2.

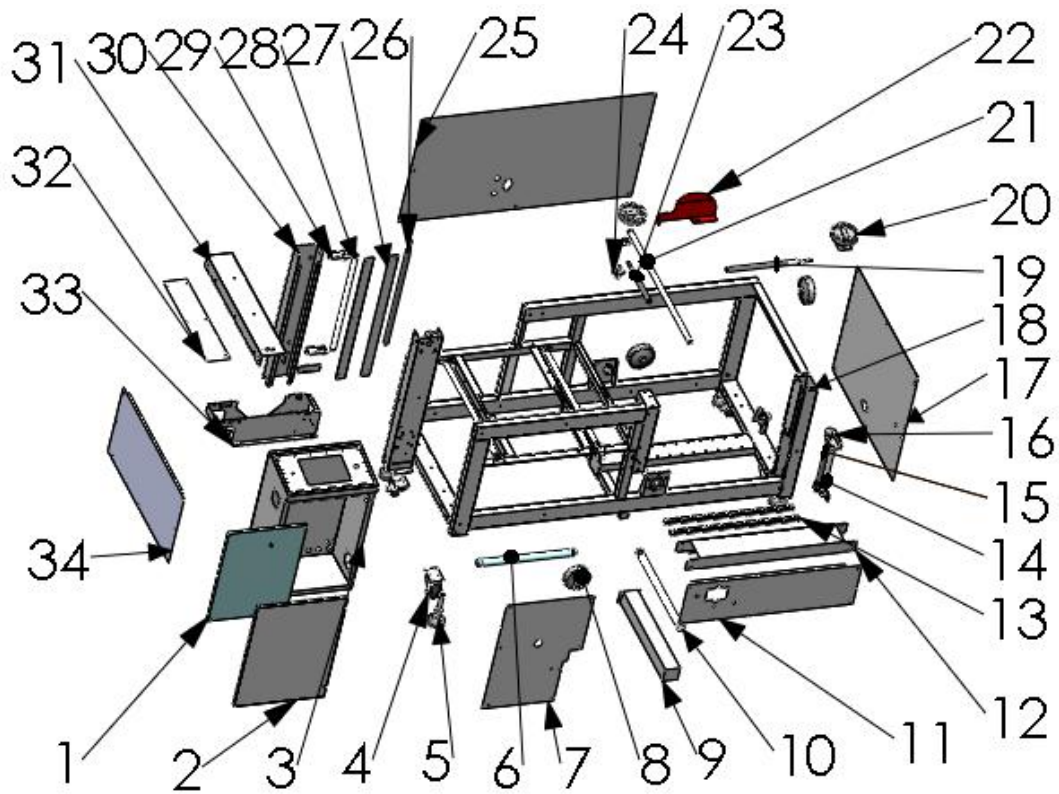


Figure 26

Parts List (Table 2)

S/N	Part No.	Name	No.	Quantity	Remarks
1	KL25-715	Switch panel		1	
2	KL25-716	Electric box door		1	
3	KL25-714	Electric box		1	
4		Casters	110H*73*42	41	
5		Foot cup	M20*120	4	
6		Cylinder	MAC32*400	1	
7	KL25-107	Cover plate		1	
8		Hand wheel	Internal corrugated hand wheel 12*125	5	
9	KL25-109	Cover plate		1	
10		Cylinder	MAC32*450	1	
11	KL25-108	Cover plate		1	
12	KL25-215	Chain cover		1	
13		Guide rail	HGR20R640H	2	
14	KL25-203	Trough guide rod		2	
15	KL25-201	Left and right lifting screw of trough		2	

16	GPK40L-00-001A	Gear	Modulus 1 teeth 50 axis 12	2	
17	KL25-110	Blanking plate		1	
18	KL25-101	Main frame		1	
19	KL25-310A	Carton block adjusting screw		1	
20	GPK40L-00-002	Gear	Modulus 1 teeth 18 axis 12	2	
21	KL25-307	Guide shaft		2	
22	KL25-105	Front cover plate folding		1	
23	KL25-310	Carton picking adjusting screw		1	
24	Bearing	KFL001, KFL002		4/10	
25	KL25-111	Rear blanking plate		1	
26	KL25-618	Lifting threaded rod		2	
27	KL25-608	Cover plate		4	
28	KL25-623	Guide rod		2	
29	KL25-629	Stator		4	
30	KL25-610	Pillar		2	
31	KL25-609	Cover plate		1	
32	KL25-632	Upper cover of Chain		1	
33	KL25-102	Mandrel rack		1	
34	KL25-112	Cover plate on the left side		1	

5.3 Trough mechanism, as shown in Figure 27 and Table 3.

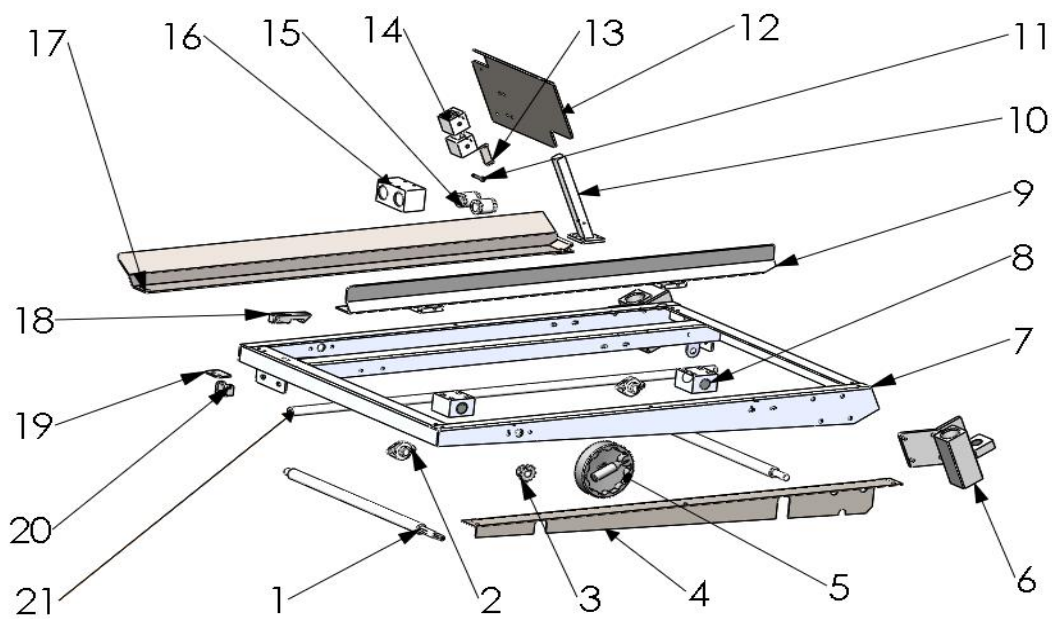


Figure 27

Parts List (Table 3)

S/N	Part No.	Name	Model	Quantity	Remarks
1	KL25-210	Left and right threaded rods of trough		2	
2		Bearing	KFL002	4	
3	KL25-211	Chain wheel	06B12-gear inner hole 15	2	
4	GPK40L-02-020	Small cover plate of rack		1	
5		Internal corrugated hand wheel	12*125	1	
6	GPK40L-02-013	Pillar sliding block of trough		2	
7	KL25-206	Trough rack		1	
8	GPK40L-02-009	Left threaded tube of trough		2	
9	KL25-221	Active guide plate of trough		1	
10	KL25-214	Carton pressing rod		1	
11		Inner hexagonal bolt	M6*30	1	
12	KL25-213	Trough pressing plate		1	
13	GPK40L-04-004	U-shaped gasket		2	
14	GPK40L-07-015	Square adjusting iron		1	
15		Linear bearing	LM20UU	2	
16	GPK40L-02-012	Trough sliding block		1	
17	KL25-220	Trough fixed guide plate		1	
18	KL25-217	Fixed block		1	
19	KL25-219	Cushion block		2	
20	KL25-216	Fixed block		1	
21	KL25-212	Sliding shaft for carton pressing		2	

5.4 Rear cover folding as well as carton picking and feeding mechanism, as shown in Figure 28 and Table 4.

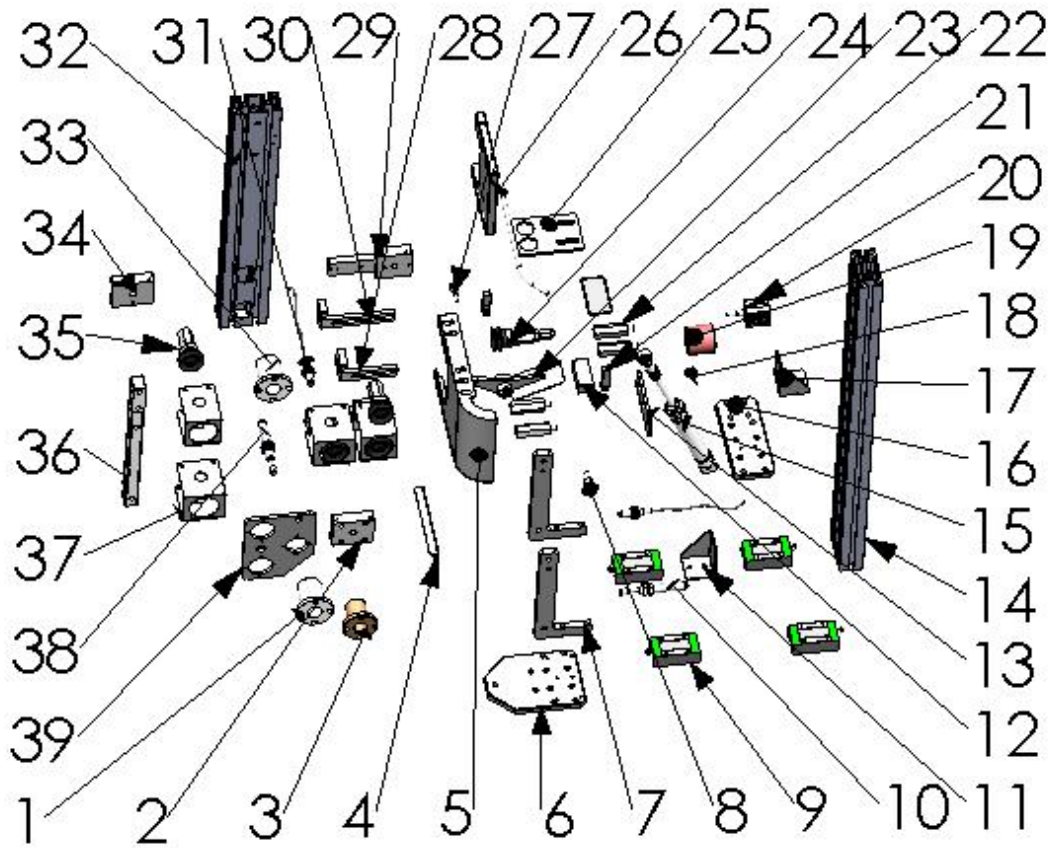


Figure 28

Parts List (Table 4)

S/N	Part No.	Name	Model	Quantity	Remarks
1		Linear bearing	LM25UU	2	
2	KL25-801	Right fixed block		4	
3	KL25-311	Carton picking adjusting nut		1	
4	KL25-417	Support chain fixed block		1	
5	KL25-410	Guide plate		1	
6	KL25-402	Fixed block		1	
7	KL25-404	Fixed block		2	
8	KL25-408	Positioning cylinder joint		1	
9		Sliding block	HGH20CAZAH+ZZ	4	
10		Oil buffer	ACA1420-1	2	
11	KL25-403	Limit block		1	
12	KL25-416	Cushion block		1	
13	KL25-411	Cylinder fixing flat		1	
14	KL25-401	Fixed block		1	

15		Cylinder	MAC25X75SCA	1	
16	KL25-405	Fixed block		1	
17	KL25-406	Buffer fixed block		1	
18		Bearing	6800	6	
19	KL25-311A	Carton block adjusting nut		1	
20		Cylinder	SDA20X10SB1	1	
21	KL25-413A	Right fixed block		2	
22	KL25-407	Carton pushing cylinder joint		4	
23	KL25-415	Folding rear cover plate		1	
24		Vacuum sucker	ZPX40HBN-B01-B10	1	
25	KL25-420	Adjusting plate		1	
26	KL25-409	Fixed plate		1	
27	KL25-419	Shaft center		1	
28	KL25-804	Short fixed block		1	
29	KL25-800	Left movable block		2	
30	KL25-805	Long fixed block		1	
31		Space switch		2	
32	KL25-301G	Fixed block		1	
33		LM25UU		2	
34	KL25-413B	Upper right fixed block		1	
35		Vacuum sucker	ZPX40HBN-B01-B10	4	
36	KL25-316	Height adjusting block		1	
37	KL25-305G	Guard plate		4	
38		Oil buffer	ACA1420-1	2	
39	KL25-309	Fixed block		1	

5.5 Adjusting and conveying mechanism, as shown in Figure 29 and

Table 6:

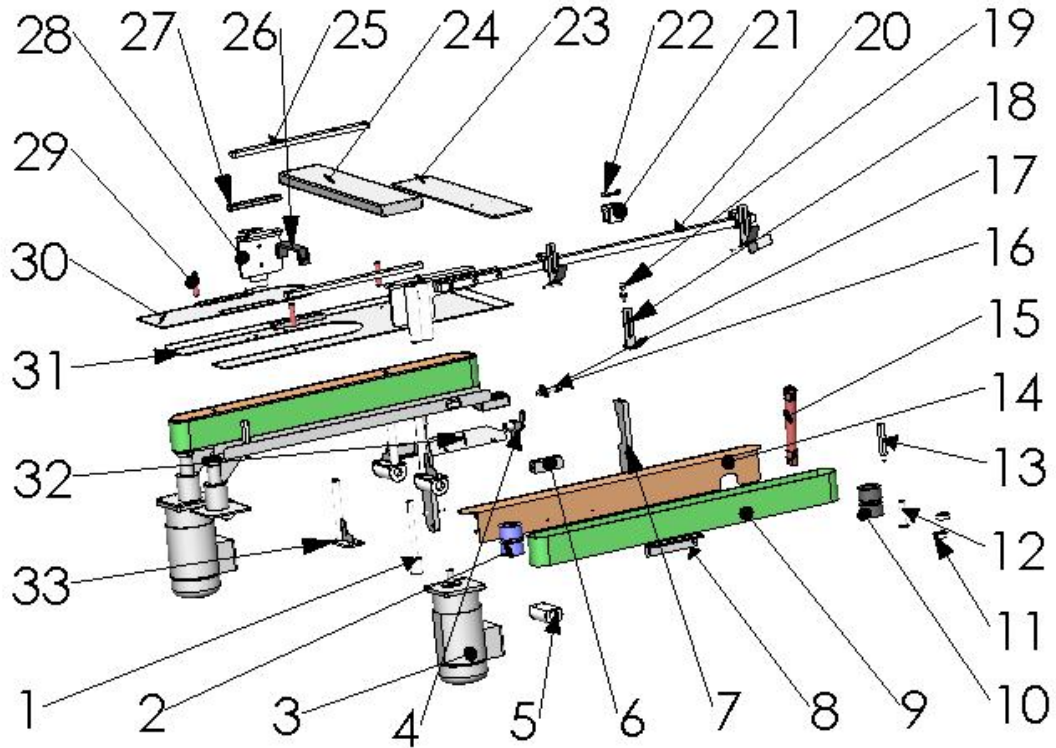


Figure 29

Parts List (Table 6)

S/N	Part No.	Name	Model	Quantity	Remarks
1	GPC50-02-012	Driving shaft		2	
2	GPC50-02-011S	Driving wheel		2	
3		Motor	CV18-100-15-AZ-G1-1D	1	
4	KL25-516	Side cover folding arm		2	
5	KL25-514	Left and right nuts		4	
6	KL25-521	Strengthening plate		2	
7	KL25-517	Fixed block		2	
8	KL25-515	Travel switch		1	
9		Sealing belt	48*1825	2	
10	GPC50-02-014S	Driven wheel		2	

11		Bearing	6202	8	
12	GPC50-02-013	Driven shaft		2	
13	KL25-513	Belt support bar		4	
14	KL25-501	Belt cover		2	
15		Cylinder	MAC25X100SCA	2	
16		Bearing	6800	6	
17	KL25-518	Shaft center		2	
18	KL25-601	Carton blocking sheet		3	
19	KL25-609	Carton blocking pillar		3	
20	KL25-614	Adjusting fixed block		1	
21	KL25-613	Adjusting block		3	
22	KL25-603	Carton blocking sheet		3	
23	KL25-611	Carton pressing plate fixed block		1	
24	KL25-611	Carton pressing plate fixed plate		1	
25	KL25-624	Carton pressing connecting plate		2	
26		Handle	120L	5	
27	KL25-620	Pressing block		2	
28	KL25-617	Nut connecting block		2	
29	GPK40L-07-016	Carton pressing adjusting shaft		4	
30	KL25-621	Pressing plate		1	
31	KL25-612	Upper pressing plate		1	
32	KL25-516	Cover plate on the folding side		1	
33	KL25-505	Driving rack support pillar		4	

5.6 Tape sticker

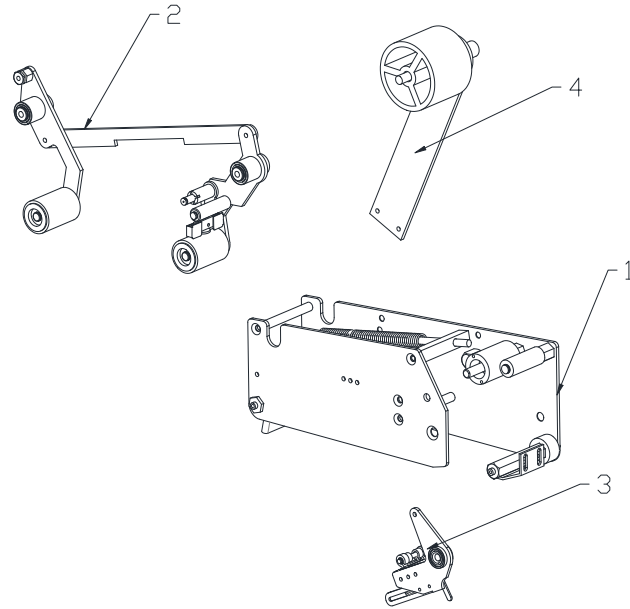


Figure 30

Parts List

S/N	Name	Quantity	Remarks
1	Mandrel rack	1	
2	Swing arm	1	
3	Cutter	1	
4	Tape holder	1	

5.7 tape sticker mandrel

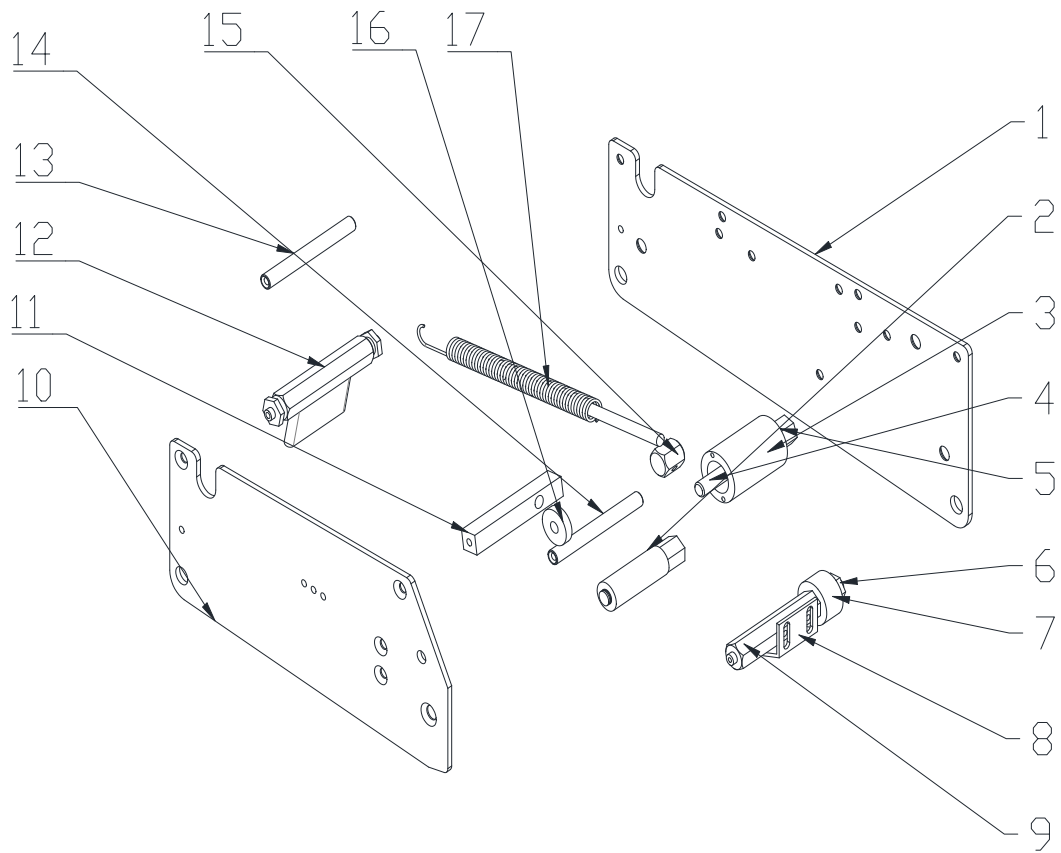
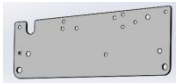
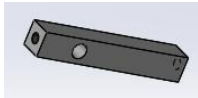




Figure 31

Parts List

S/N	Graph	Model	Name	Quantity	Remarks
1		GPA30 2-cun old mandrel - (cun: a Chinese length unit) Left panel of mandrel (large T2-001G	Left panel (large) of mandrel	1	

2		GPA30 2-cun old mandrel - PE guide wheel set	PE guide wheel set of mandrel	1	PE guide wheel shaft and PE guide wheel
3		GPA30 2-cun old mandrel - One-way small knurl wheel T2-01	One-way small knurl wheel of mandrel	1	
4		GPA30 2-cun old mandrel - One-way small knurl wheel axle T2-03	One-way small knurl wheel axle of mandrel	1	
5		GPA30 2-cun old mandrel - One-way bearing T2-02	One-way bearing HF1616 of mandrel	1	
6		GPA30 2-cun old mandrel - Hexagonal threaded axle T2-21	Hexagonal threaded axle of mandrel	1	
7		GPA30 2-cun old mandrel - Mandrel catch wheel T3-22AG1	Mandrel catch wheel	1	
8		GPA30 2-cun old mandrel - Front guide plate T2-050A	Mandrel front guide plate	1	
9		GPA30 2-cun old mandrel - Front pivot axle T2-006	Front pivot axle of mandrel	1	
10		GPA30 2-cun old mandrel - Right panel	Right panel of mandrel	1	

11		GPA30 2-cun old mandrel - Square locking axle of main tension spring	Square locking axle of main tension spring of mandrel	1	
12		GPA30 2-cun old mandrel - Brush set	Mandrel brush set	1	
13		GPA30 2-cun old mandrel - Panel locked axle	Mandrel panel locked axle	1	
14		GPA30 2-cun old mandrel - Panel locked axle	Mandrel panel locked axle	1	
15		GPA30 2-cun old mandrel - Adjusting hexagon prism T2-24 of tape sticker wheel	Adjusting hexagon prism T2-24 of mandrel tape sticker wheel	1	
16		GPA30 2-cun old mandrel - Mandrel catch wheel T3-22BG1	Mandrel catch wheel	1	
17		GPA30 2-cun old mandrel - Tension spring	Mandrel tension spring	1	

5.8 Tape sticker swing arm

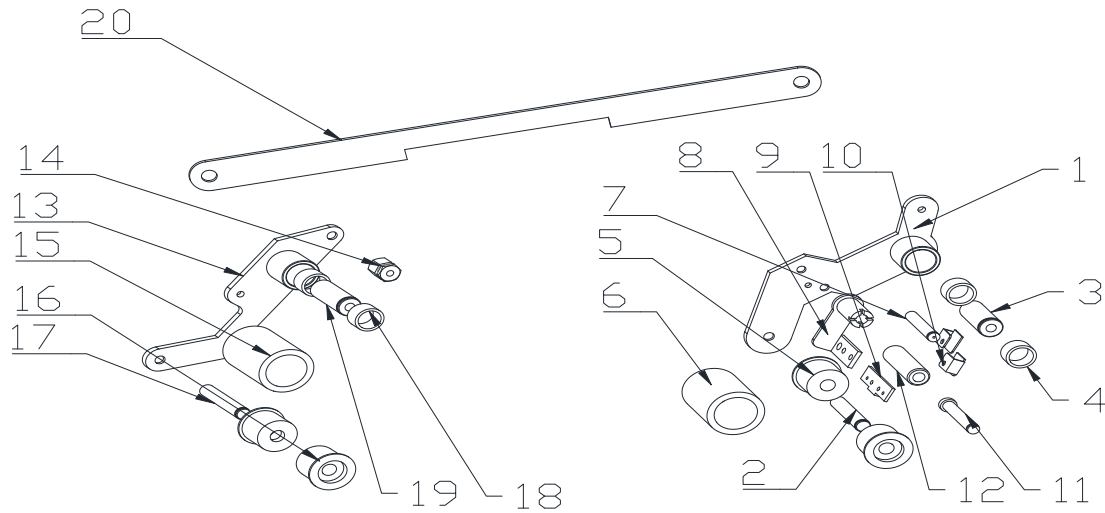

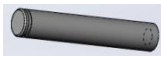

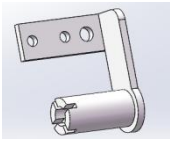


Figure 32

Parts List

S/N	Graph	Model	Name	Quantity	Remarks
1		GPA30 T2 2-cun old mandrel - Front swing arm assembly welding	Mandrel front swing arm assembly welding	1	
2		GPA30 2-cun old mandrel - Central spindle of tape sticker wheel T2-05E	Central spindle of mandrel tape sticker wheel	1	
3		GPA30 2-cun old mandrel -T3- 15 forward and backward swing fixed axle	Forward and backward swing fixed axle of mandrel	1	

4		GPA30 2-cun old mandrel - Forward and backward swing cutter copper bush T3-101	Forward and backward swing cutter copper bush of mandrel	2	
5		GPA30 2-cun old mandrel - Non-porous chock plug T2-28-2	Non-porous chock plug of mandrel	2	
6		GPA30 2-cun old mandrel - Rubber wheel FX02-01-14-3	Mandrel rubber wheel	1	
7		GPA30 2-cun old mandrel - U-shaped tape guide seat shaft T3-12	U-shaped guide seat shaft of mandrel	2	
8		GPA30 2-cun old mandrel - 2-cun tape support rack assembly weldment	2-cun tape support rack assembly weldment of mandrel	1	
9		GPA30 2-cun old mandrel - Tape top plate T2-008	Mandrel tape top plate	1	
10		GPA30 2-cun old mandrel - Cleat (right) T2-27	Mandrel cleat (right)	2	
11		GPA30 2-cun old mandrel - Knurling guide wheel axle T2-04	Mandrel knurling guide wheel axle	1	
12		GPA30 2-cun old mandrel - Knurling guide wheel T2-02	Mandrel knurling guide wheel	1	

13		GPA30 T2 2-cun old mandrel - Rear swing arm assembly welding	Mandrel rear swing arm assembly welding	1	
14		GPA30 2-cun old mandrel - Locking hexagonal axle T3-19 of main tension spring	Locking hexagonal axle of mandrel main tension spring	1	
15		GPA30 2-cun old mandrel - Rubber wheel FX02-01-14-3	Mandrel rubber wheel	1	
16		GPA30 2-cun old mandrel - Non-porous chock plug T2-28-2	Non-porous chock plug of mandrel	2	
17		GPA30 2-cun old mandrel - Central spindle of tape sticker wheel T2-05E	Central spindle of mandrel tape sticker wheel	1	
18		GPA30 2-cun old mandrel - Forward and backward swing cutter copper bush T3-101	Forward and backward swing cutter copper bush of mandrel	2	
19		GPA30 2-cun old mandrel -T3- 15 forward and backward swing fixed axle	Forward and backward swing fixed axle of mandrel	1	
20		GPA30 2-cun old mandrel -T3- Connecting rod T2-005	Mandrel connecting rod	1	

5.9 Cutter

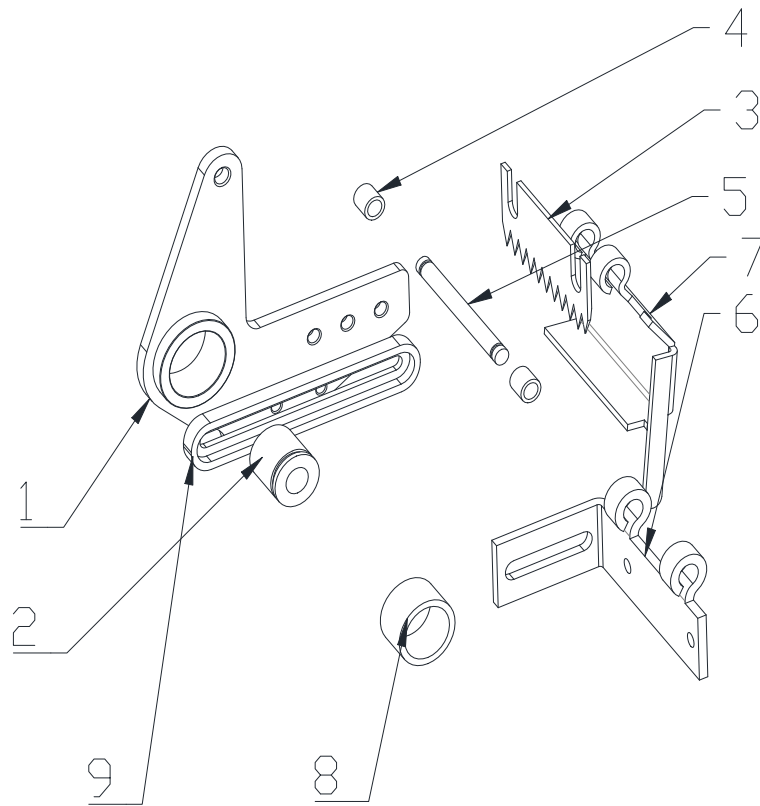

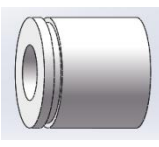
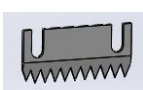
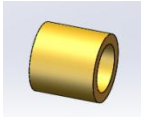

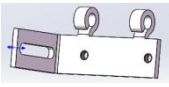
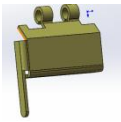
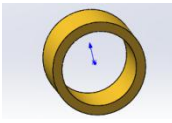
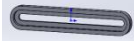


Figure 33

Parts List

S/N	Graph	Model	Name	Quantity	Remarks
1		GPA30- mandrel cutter seat T3-012G	Mandrel cutter seat	1	
2		GPA30 2-cun old mandrel - Cutter seat fixed axle T3-17	Cutter seat fixed axle	1	
3		GPA30 2-cun old mandrel - 2-cun old blade	2-cun old blade	1	

4		GPA30 2-cun old mandrel - Cutter cover copper bush T2-05B	Cutter cover copper bush	2	
5		GPA30 2-cun old mandrel - <i>Cutter cover central spindle</i> T2-05A	Cutter cover central spindle	1	
6		GPA30 2-cun old mandrel - Cutter rack T2-06-01	Cutter rack	1	
7		2-cun old mandrel, 2-cun cutter cover T2-06G	2-cun cutter cover	1	
8		GPA30 2-cun old mandrel - Forward and backward swing cutter copper bush T3-101	Forward and backward swing cutter copper bush	1	
9		GPK40-611B		1	

5.10 Tape holder

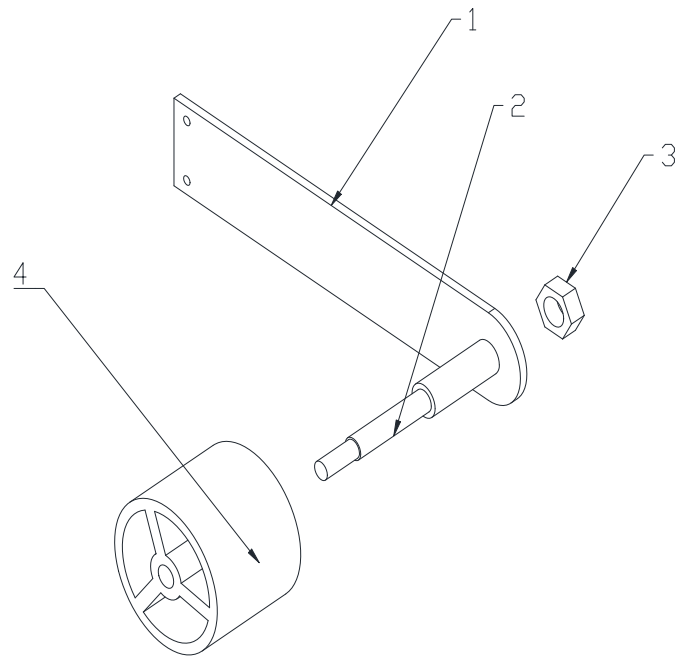






Figure 34

Parts List

S/N	Graph	Model	Name	Quantity	Remarks
1		GPA30 2-cun old mandrel - Tape holder support chip T3-010	Tape holder support chip	1	
2		GPA30 2-cun old mandrel - Tape holder fixed axle T3-25	Tape holder fixed axle	1	
3		GPA30 2-cun old mandrel - Tape holder fixed nut T3-20	Tape holder fixed nut	1	
4		GPA30 2-cun old mandrel - Tape holder (round) and tensioning block Annex FX3A-10	Tape holder (round) and tensioning block	1	