



Cleveland Equipment

CE-551TB **SEMI AUTOMATIC UNIFORM CARTON SEALER** **OPERATION MANUAL**



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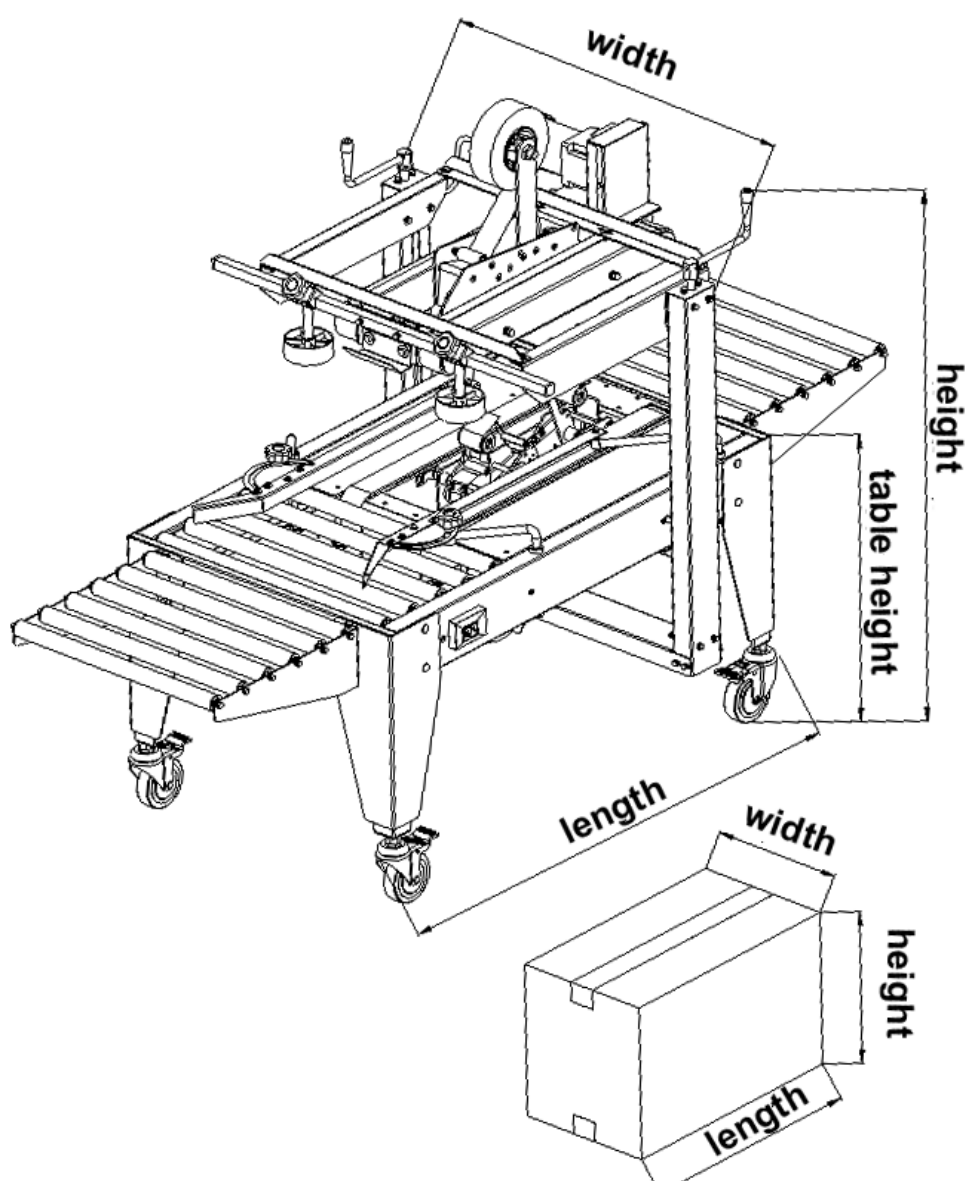
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1. Specification and Technical Data

Model	SIZE (mm)				WEIGHT (kg)	CARTON SIZE		
	length	width	height	Table height		length	width	height
CE-551TB-2inch Tape	1073	755	930-1435	Adjustable 580-780	113	150-∞	160-500	110-500
CE-551TB-3inch Tape	1073	755	930-1435	Adjustable 580-780	113	150-∞	185-500	130-500

The tape width: 2" (45mm) or 3" (78mm)





2. Installation

2.1. Assemble casters and adjust the table height (Refer to right figure)

2.1.1. Assemble casters:

Screw into NUT A and fasten NUT B the brake casters.

2.1.2. Adjust table height

The table height can be adjusted by stretching out four legs

Methods:

1. use the wrench to loosen the two screws
2. Stretch in/out the legs to required height
3. Use the wrench to tighten the two screws

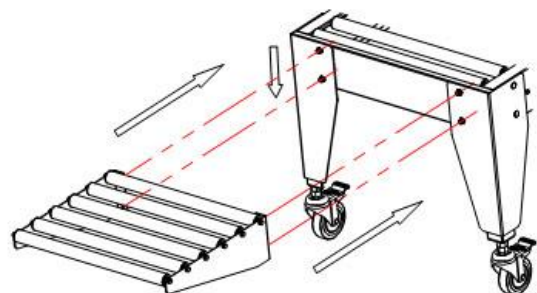
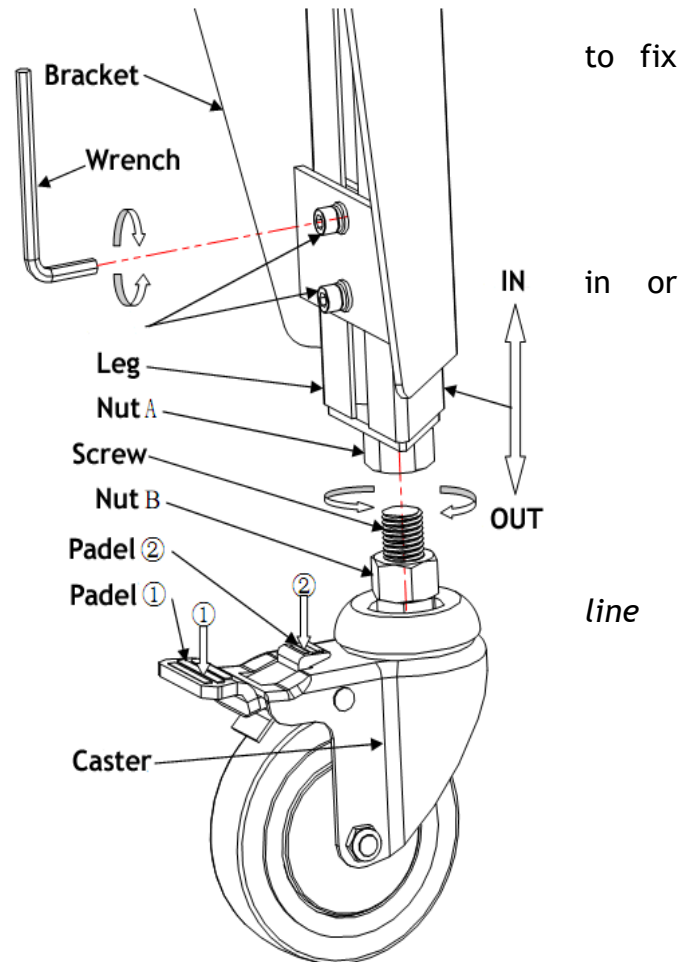
2.2. Move and fix the machine in a production

Fix Method: Lock pedals ① of the brake caster.

Move Method: Unlock pedals ② to move the machine.

2.3 Install infeed/outfeed conveyor

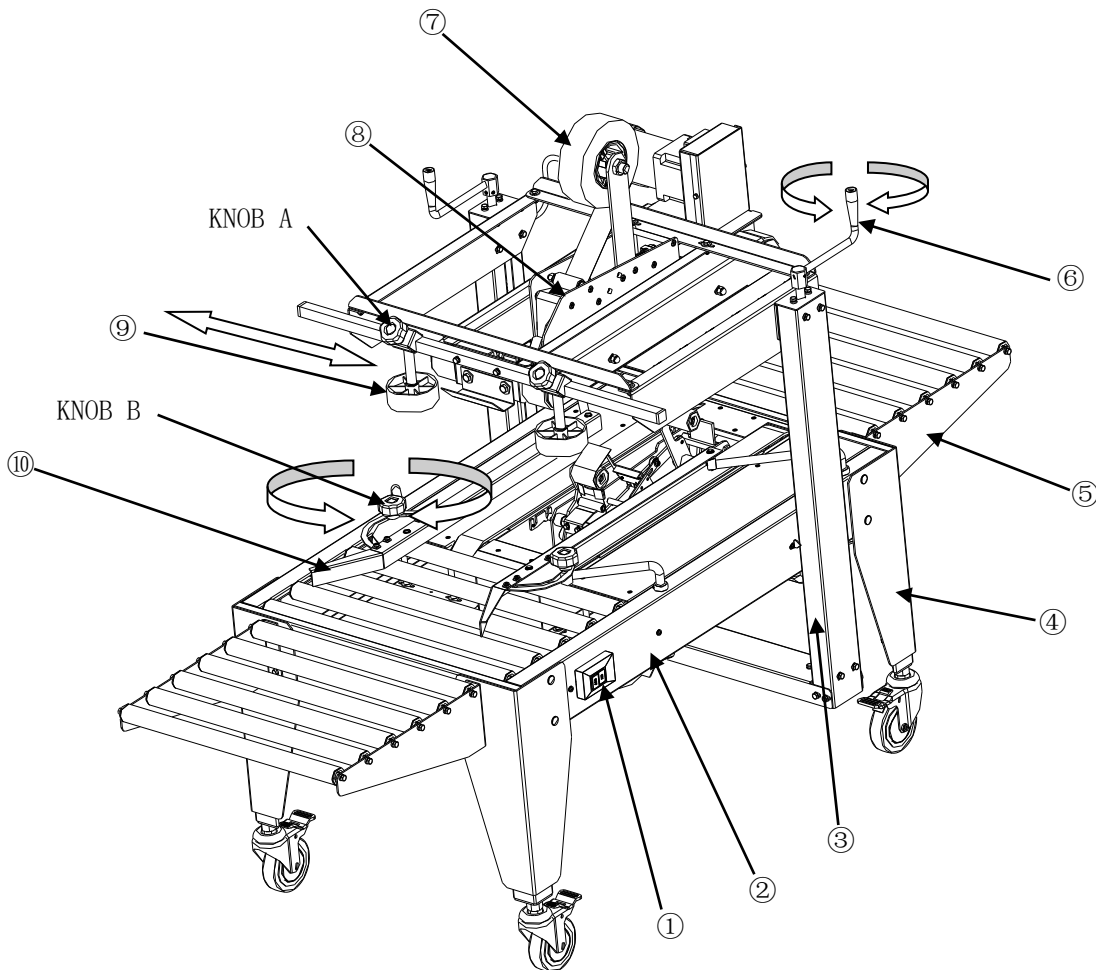
Attach the infeed/outfeed conveyors
To each end of a machine body.





2.4. Spare parts description

NO.	Description	NO.	Description
1	Controls	5	Infeed/outfeed conveyor
2	Machine body	6	Height adjustment crank
	Adjustment crank	8	Tape head
3	Side Post	7	Tape
4	Leg	9	Side Compression roller
		10	Width Adjustment Rails





2.5. Height and width adjustment(refer to above figure)

Width Adjustment to Center box in position.

Adjustment method:

- a. Loosen Knobs A, move left and right compression rollers ⑨.

Adjust height by turning hand crank ⑥ located on top of vertical support post until top belts touch box.

- b. Put boxes on table in center position.
- c. Loosen Knobs B on width adjustment rails.
- d. Move inward and center box into position and tighten height adjustment.

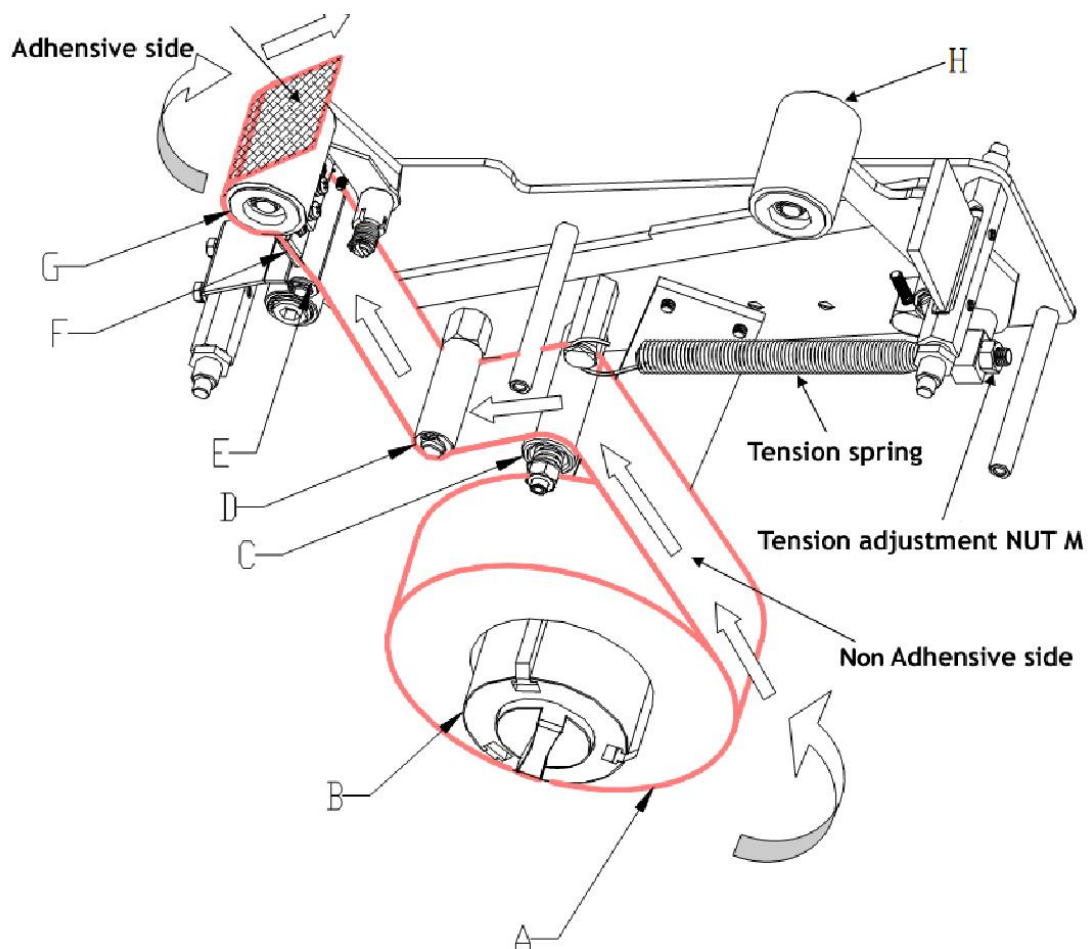


2.6. Tape head adjustment

2.6.1. Tape loading and winding

- Put tape [A] onto the tape head [B].
- Pull out the tape, wind the tape around irreversible roller [C].
- Wind the tape around the brass roller.
- Wind through front embossed roller [E], through Knife guard plate F and Front rubber roller G (refer to below figure)

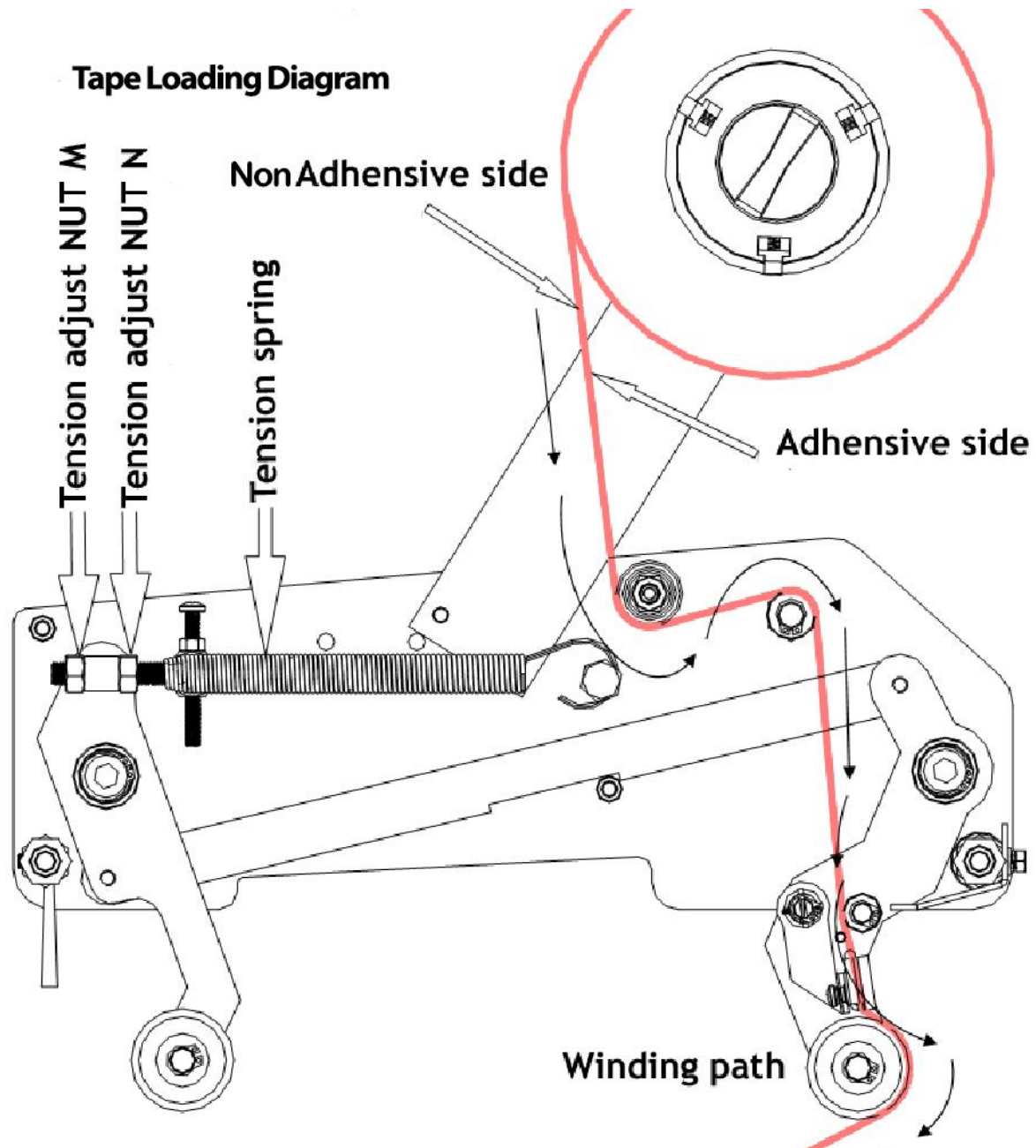
Remark: During the threading, the adhesive side is outward facing the tension spring.





2.6.2 Tension adjustment

- a. Purpose: Make sure the tape adheres on box firmly without wrinkles.
- b. Principle: Keep the taping speed is proportional to the belts speed.
- c. Method: Loosen tension lock nut [N], tighten or loosen tension adjustment nut [M] until you get required tension, fasten tension nut [N].



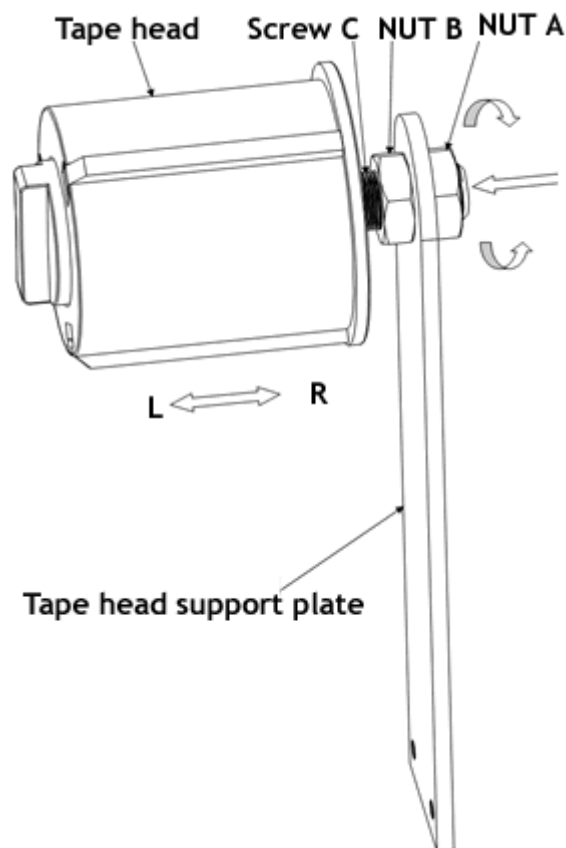


2.6.3. Regulate the tape in the center of a box.

- Use OPP adhesive tape
- If the tape is off center of the box, adjust Nut [A],[B] clockwise or anti-clockwise
- Refer to below figure.

Move to left: Screw out Nut [A], move the lock screw [C] left, tighten Nut [B];

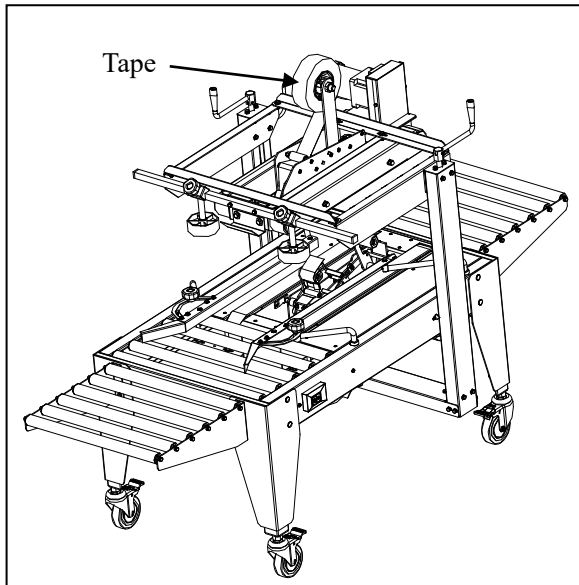
Move to right: Screw in Nut [B], move the lock screw [C] right, tighten Nut [A];



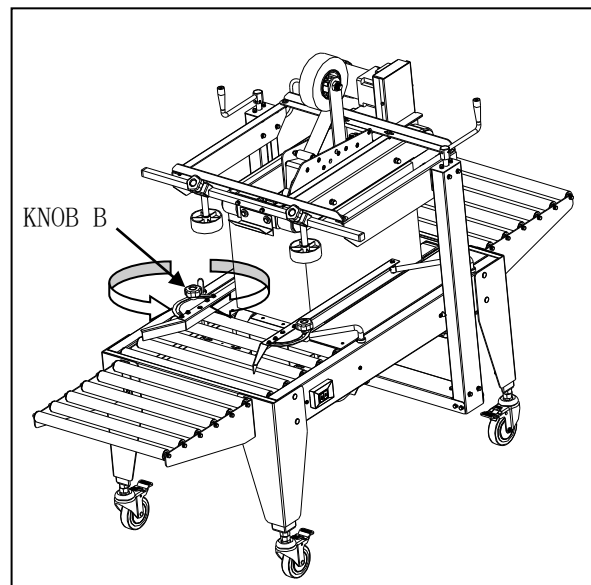


3. Operation

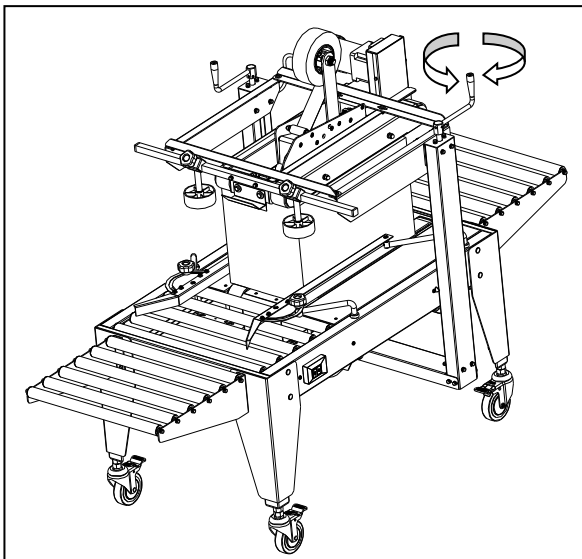
1) load tape onto tape head



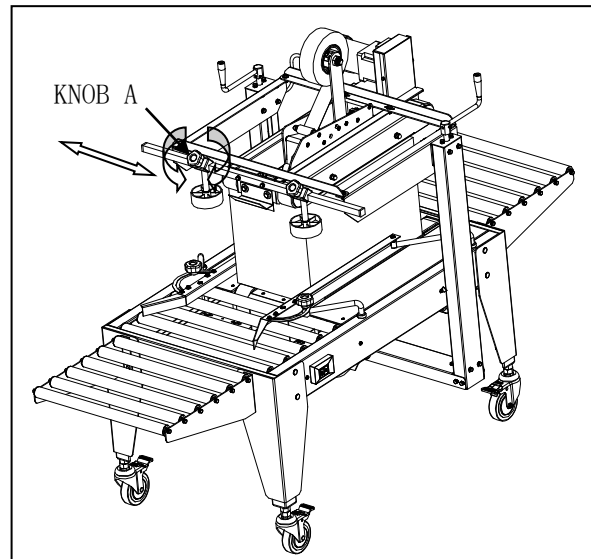
2) adjust width guider rail



3) adjust height



4) adjust side guide roller





4. Troubleshooting

1	Tape cannot be cut off	Knife is not sharp enough Knife tip is jammed with adhesive	Replace with a new knife Clean the knife with solvent
2	A trailing of tape after cut off motion	Unsmooth motion of knife holder due to Choke Knife holder extension spring fatigue	Check if the knife holder screw are loose. Lubricate when necessary. Replacement
3	Tap is not fully adhering to the box	Main spring too loose The roller shafts which the tape runs over are not effective due to accumulated tape adhesive Tape wheel adjustment nut is too tight	Tighten the main spring Lubricate roller shaft
4	Box chocked on the way	Improper box height adjustment Main spring too tight on tape head	Readjust the height Loosen the main spring
5	Tape broken during sealing on box	Knife protrudes too far	readjust the knife position
6	Tape cannot travel smoothly	tape adhesion is not even The roller shafts which the tapes runs over are not effective due to accumulated tape adhesive Irreversible roller is not effective Tape loaded incorrectly Tape wheel adjustment nut is too tight	Replace with a new tape roll lubricate roller shaft Replacement Correct tape loading Loosen it
7	Tape is off center on the application	both guide wheels have uneven pressure on the box	re-adjust the distance between both guide wheels
8	Curious noise while in sealing	Bearings covered with dust	Clean and lubricate
9	Tape end wrinkling on the carton	Tape wheel assembly is too tight Inside tape wheel assembly with sharp edges & dust Tape dose not travel smoothly Knife is not sharp enough or is jammed with tape adhesive The knife holder is not functioning smoothly Bronze roller(irreversible roller) is not functioning	Loosen tape wheel assembly spring Remove tape wheel washer sharp edges and keep it clean. Grease the tape wheel. Lubricate the roller shafts which the tape runs over Clean the knife with alcohol or solvents Check and lubricate to ensure that it functions smoothly. Adjust the knife holder's spring tension Replace it



4.1 Tape Wrinkles

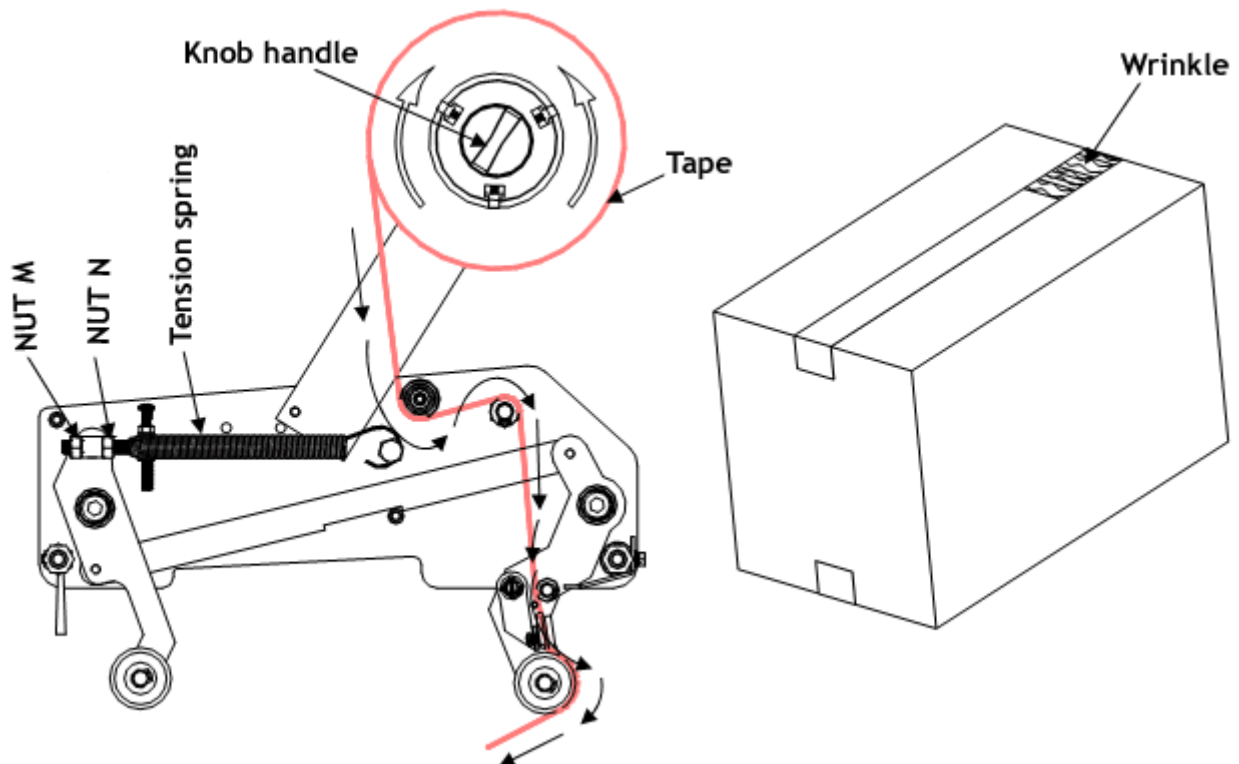
Tape tail is wrinkling on the box. Please follow below to adjust the tape head

1. Turn Knob clockwise
2. Adjust Nut [N],[M] to make sure Main tension spring has proper tension

Remark:

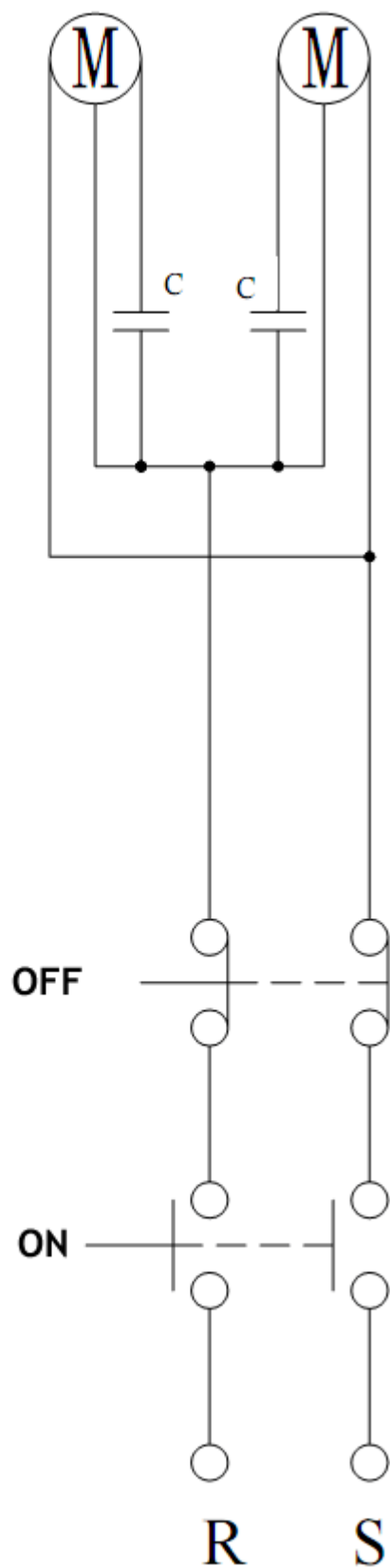
1. Switch off before you repair or adjust
2. Blade must be clean and lubricated before using
3. After using for a while, adjust belt tighter if needed

5.





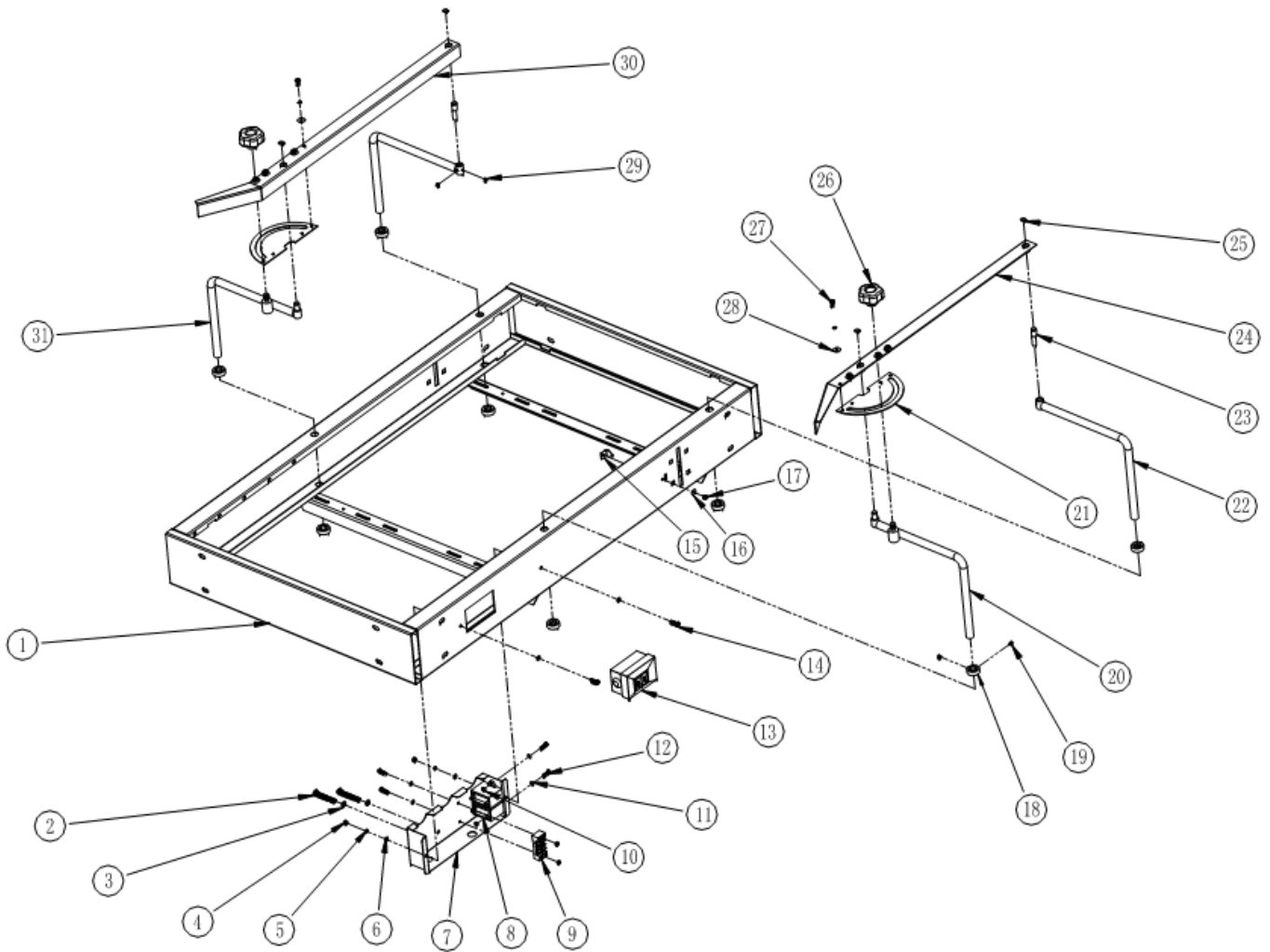
Electrical schematic





6. Spare parts

6.1 Machine Frame Bottom

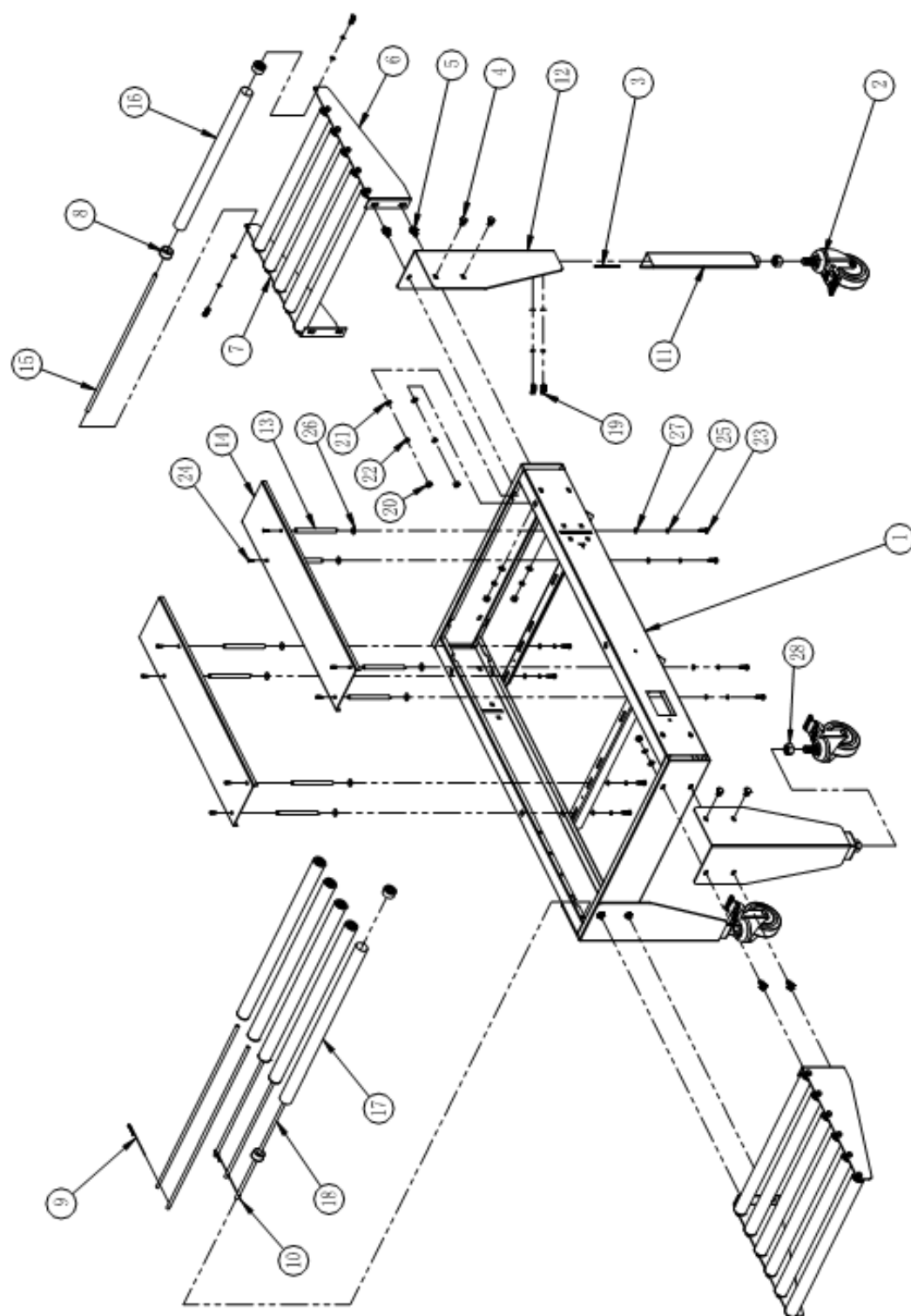




NO.	PARTS NO.	QTY	PARTS NAME
1	XT9037-HJT-102	1	box machine welding parts
2	GBT818 -M6x50	2	screw
3	GBT97.1-D6	2	Washers
4	GBT6170-M5	2	Nut
5	GBT93-D5	10	Washers
6	GBT97.1-D5	4	Washers
7	XT9037-10-122	1	Domestic electrical switch box extension
8	CBB61	2	Electric capacity6Uf±5%500VAC 50HZ
9	TB-1504L	1	Terminal Blocks600V15A4P
10	GBT6170-M4	4	Nut
11	GBT97.1-D4	4	Washers
12	GBT818- M4x16	4	screw
13	KE215	1	Pressure button switch LAK-10 500V2.2KW
14	GBT818-M5x16	2	screw
15	XT9036-10116	1	Pin
16	GBT96-D4	1	Washers
17	GBT818-M4x6	1	Screw
18	XT9037-10-115	8	Limited ring
19	GBT77-M5x6	16	Screw
20	XT9037-HJT-104L	1	The former welding rod cases
21	XT9037-10-119	2	Width guide pad
22	XT9037-HJT-103	2	The latter welding rod cases
23	XT9037-10-118	2	Adjustble axle
24	XT9037-10-120L	1	Left guide welding parts
25	GBT894.1-D9	4	Ring
26	XT9037-30-117	2	Handle pressed screw
27	GBT818-M5x10	8	Screw
28	GBT96-D5	8	Washers
29	GBT77-M5x5	4	Screw
30	XT9037-10-120R	1	Right guide pad pieces
31	XT9037-HJT-104R	1	Right welding rod cases



6.2 Machine Frame-Top

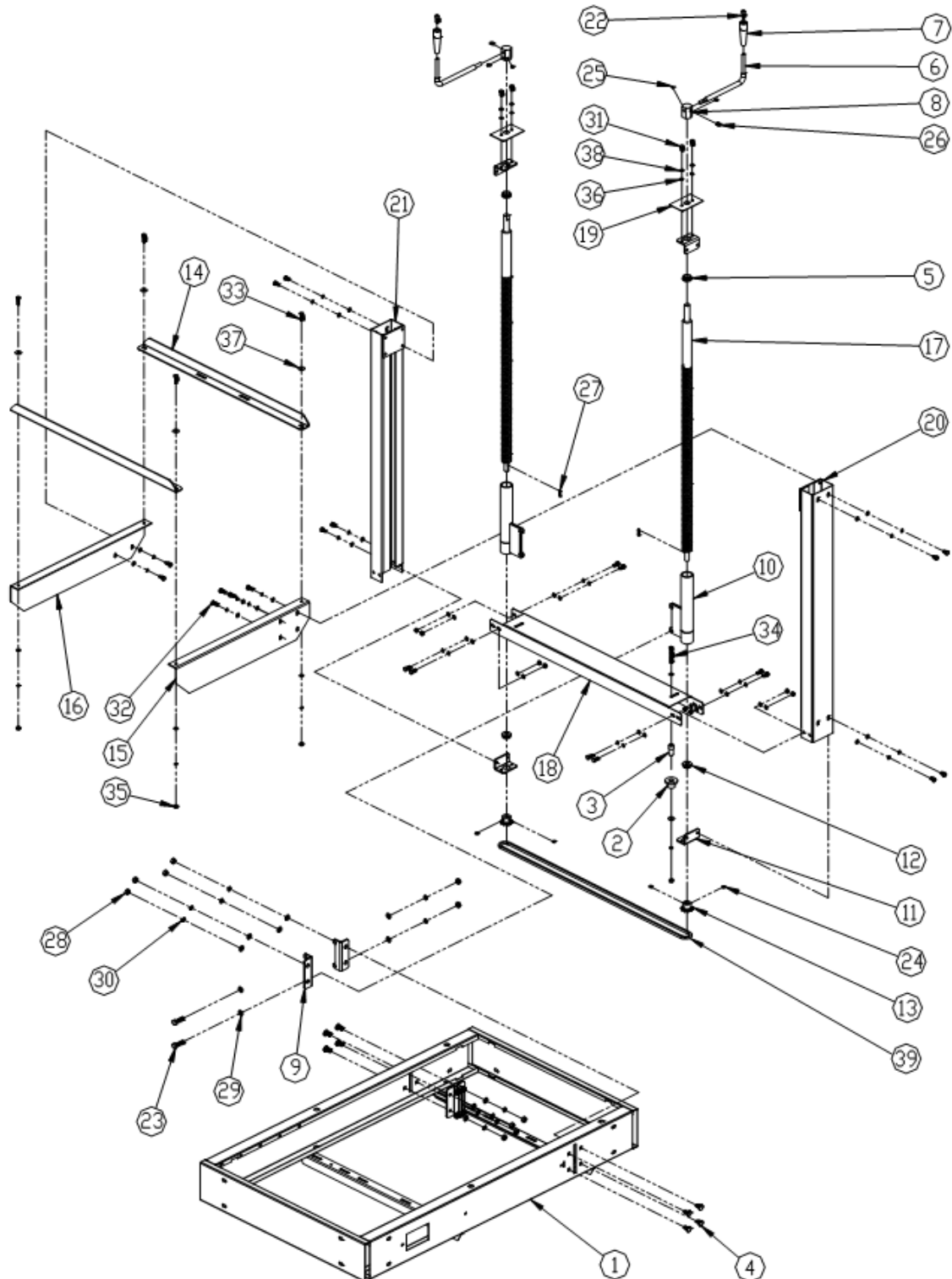




NO.	PARTS NO.	QTY	PARTS NAME
1	XT9037-HJT-102	1	box machine welding parts
2	XT9036-10-100	4	Break caster
3	XT9036-10-104	4	Feet fixed block
4	XT9036-10-118	8	box dedicated screw
5	XT9036-10-119	8	long frame screws
6	XT9036-50-100-01	2	right lengthened frame
7	XT9036-50-100-01	2	the left lengthened frame
8	XT9036-50-102	34	Plastic bushing
9	XT9037-50-106S	1	R-type bolt 100
10	XT9037-50-106L	1	R-type bolt 170
11	XT9036-HJT-100	4	legs welding pieces
12	XT9036-HJT-101	4	frame welding parts
13	XT9037-10-110	8	Supporting bar
14	XT9037-10-111	2	Box frame cover pad
15	XT9037-50-101	12	long frame drum axis
16	XT9037-50-102	12	long frame drum
17	XT9037-50-104	5	Box long drum
18	XT9037-50-105	5	Box long drum axis
19	GBT70.1--M6x16	8	Screw
20	GBT6170-M8	16	Nut
21	GBT97.1-D8	16	Washers
22	GBT93-D8	16	Washers
23	GBT5783-M6X20	32	Screw bolt
24	GBT819- M4X12	8	screw
25	GBT93-D6	40	Shells pad
26	GBT96-D6	8	Flat pad
27	GBT97.1-D6	40	Flat pad
28	GBT6170-M16	4	nut



6.3 Machine Post

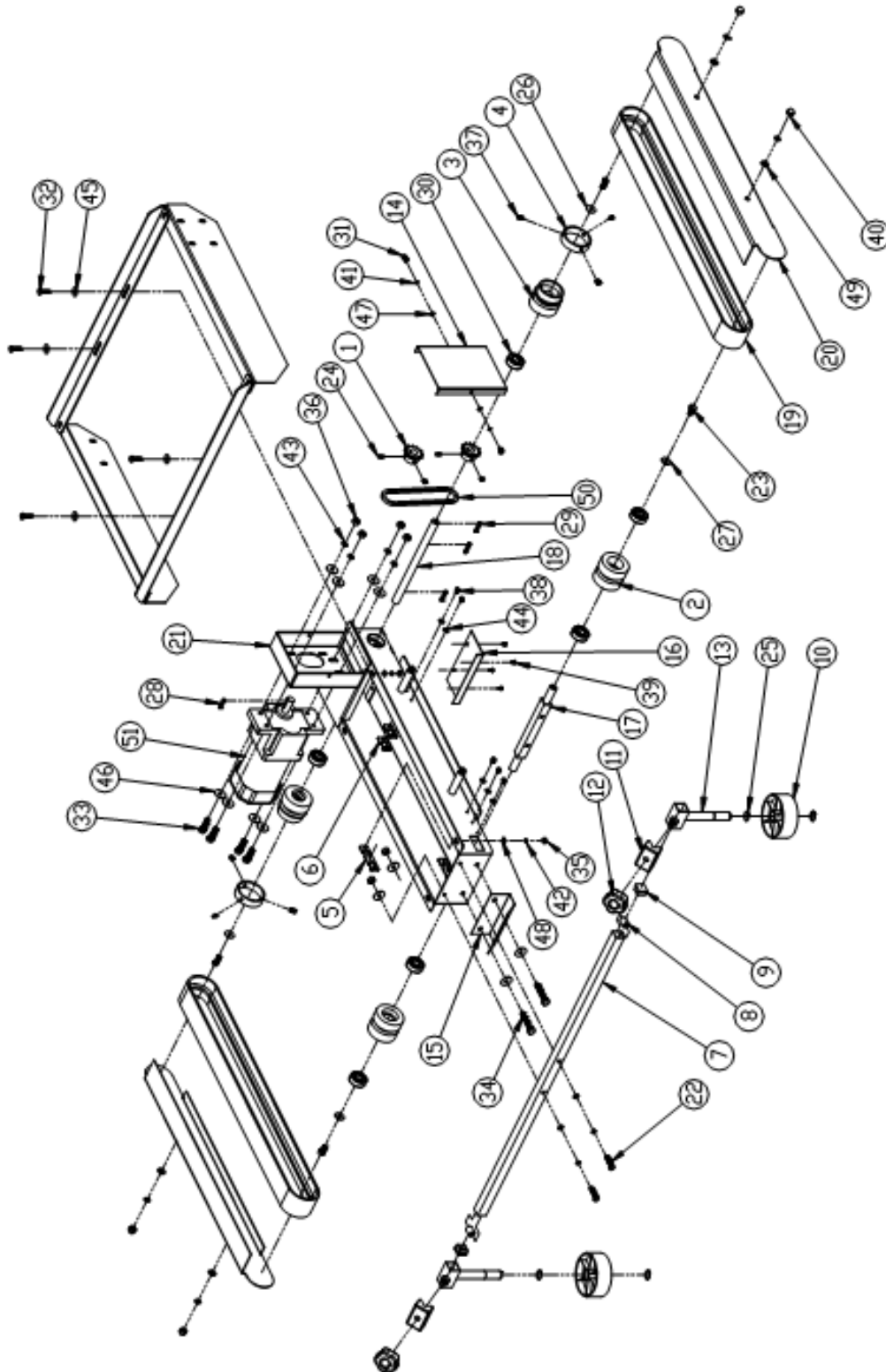




NO.	PARTS NO.	QTY	PARTS NAME
1	XT9037-HJT-102	1	Box frame welding machine parts
2	XT9037-40-114	1	By wheels
3	XT9037-40-113	1	By wheels shaft
4	XT9036-10-118	8	frame special screw
5	XT9036-20-101	2	bushing
6	XT9037-40-115	2	Handle knob
7	XT9037-40-116	2	Handle crank arm
8	XT9037-40-117	2	Handle fixed sets
9	GB12613	4	Nut fixed pedals
10	XT9036-30-102	2	Screw plot
11	XT9036-30-105	4	Screw bolt block
12	XT9036-20-101	2	Copper set
13	XT9036-20-104	2	Volume chainRS35 Z=12
14	XT9037-20-118	2	On angle iron frame
15	XT9037-20-119	1	fixed on the frame plate(left)
16	XT9037-20-119	1	fixed on the frame plate(right)
17	XT9037-40-104	2	Column screw post
18	XT9037-40-110	1	sprocket cover
19	XT9037-40-112	2	column cover
20	XT9037-HJT-112	1	column welding pieces(left)
21	XT9037-HJT-112	1	column welding pieces(right)
22	GBT70. 1-M6x16	2	Screw
23	GBT5783-M8x30	4	Screw
24	GBT77-M5x6	4	Screw
25	GBT77-M6x6	4	Screw
26	GBT77-M6x10	2	Screw
27	GBT1069-J4x20	2	Key
28	GBT6170-M8	12	Nut
29	GBT97. 1-D8	16	Washers
30	GBT93-D8	12	Washers
31	GBT5783-M6X12	12	Screw bolt
32	GBT5783-M6X16	16	Screw bolt
33	GBT5783-M6X20	4	Screw bolt
34	GBT5783-M6X45	1	Screw bolt
35	GBT6170-M6	13	Nut
36	GBT93-D6	33	Shells pad
37	GBT96-D6	5	Flat pad
38	GBT97. 1-D6	41	Flat pad
39	06B-156	1	Chain 06B-156



6.4 Driving Parts - Top Drive





NO.	PARTS NO.	QTY	PARTS NAME
1	XT9036-20-104	2	Chain 06B Z=12
2	XT9036-20-123	2	The latter wheel
3	XT9036-20-124	2	The main wheel
4	XT9036-20-125	2	The main wheel sets
5	XT9036-40-106	2	Up posted with a fixed block
6	XT9036-40-106-2	2	Up posted with a fixed block
7	XT9036-40-107	1	Side roller guide rod
8	XT9036-40-108	2	Side roller guide rod iron washer
9	XT9036-40-109	2	Side roller guide rod bushing
10	XT9036-40-112	2	Side roller
11	XT9036-40-113	2	Side roller fixed block
12	XT9036-40-114	2	Handle pressed screw
13	XT9037-HJT-110	2	posted with browser frame welding parts
14	XT9037-20-108	1	Motor cover
15	XT9037-20-115	1	Up guide pad
16	XT9037-20-116	1	Up cover pad
17	XT9037-30-100	1	Drive axle
18	XT9037-30-101	1	Active axle
19	XT9037-30-107	2	Belts
20	XT9037-30-109	2	Up belts cover
21	XT9037-HJT-108	1	120W motor welding parts
22	GBT5783-M6x30	2	screw
23	GBT5783-M8x16	2	Screw
24	GBT77-M5x8	4	Screw
25	GBT894.1-D17	4	Ring
26	GBT96-D6	2	Washer
27	GBT96-D8	2	Washer
28	GBT1096-J-5X25	1	Flat key
29	GBT1096-J-5X28	3	Flat key
30	GBT276-6202ZE	6	Bearing
31	GBT5783-M5X10	2	Screw bolt
32	GBT5783-M6X20	6	Screw bolt
33	GBT5783-M8X30	4	Screw bolt
34	GBT5783-M8X50	2	Screw bolt
35	GBT6170-M6	4	Nut
36	GBT6170-M8	6	Nut
37	GBT77-M6X10	6	Screw
38	GBT818-M4X8	10	Screw
39	GBT819-M4X8	4	Screw
40	GBT923-M8	4	Nut
41	GBT93-D5	2	Shells pad
42	GBT93-D6	6	Shells pad
43	GBT93-D8	8	Shells pad
44	GBT96-D4	10	Flat pad
45	GBT96-D6	4	Flat pad
46	GBT96-D8	12	Flat pad
47	GBT97.1-D5	2	Flat pad
48	GBT97.1-D6	6	Flat pad
49	GBT97.1-D8	4	Flat pad
50	06B-41	1	Chain 06B-41
51	5IK120-C-F;5GU1:15	1	motor



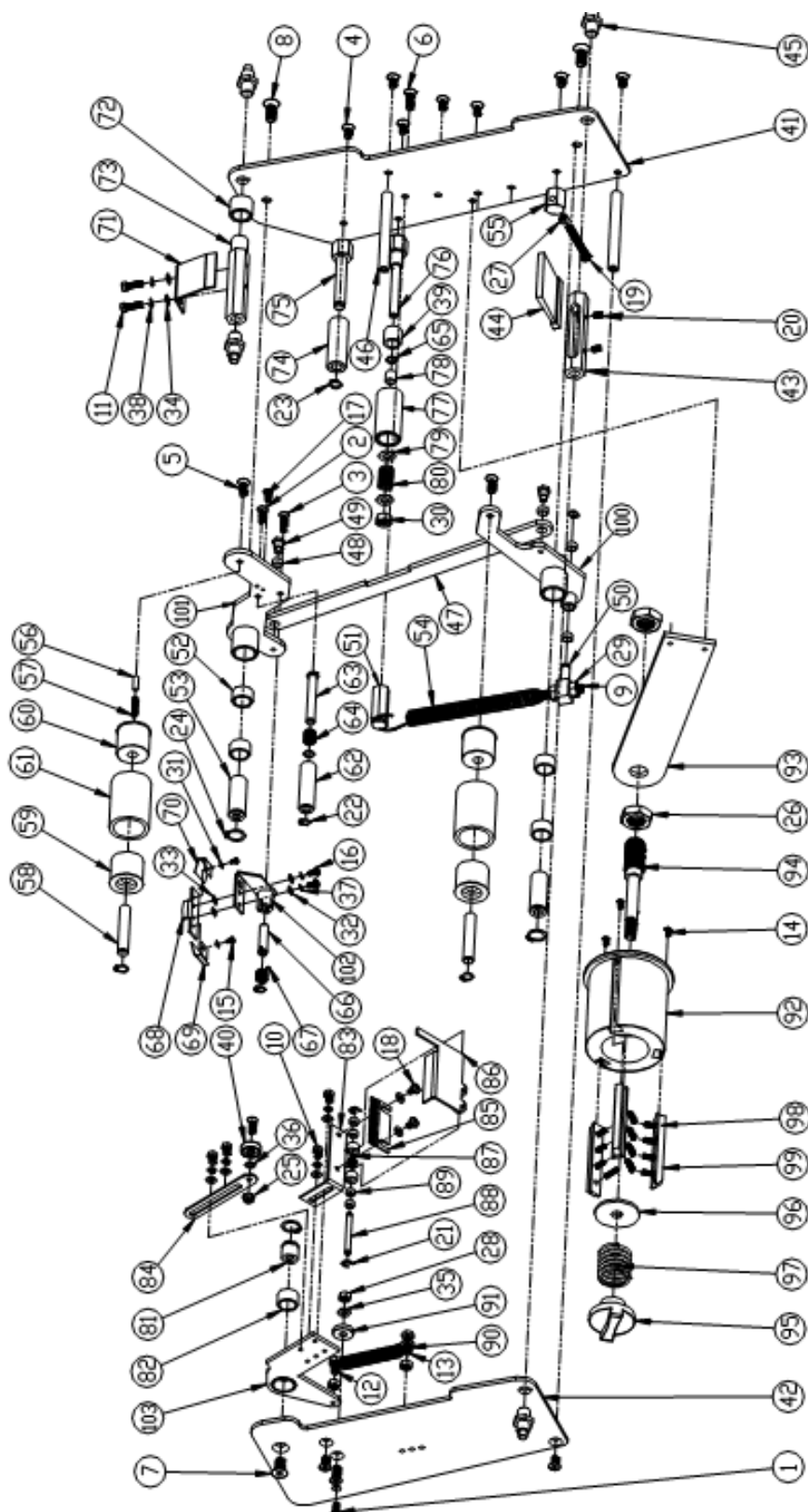


6.4 Driving Part-Bottom Drive

NO.	PARTS NO.	QTY	PARTS NAME
1	XT9036-20-104	2	Chain 06B Z=12
2	XT9036-20-123	2	The latter wheels
3	XT9036-20-124	2	The main drive wheel
4	XT9036-20-125	2	Main transmission kits
5	XT9037-20-102	2	Posted with a fixed block
6	XT9037-20-102-2	2	Posted with a fixed block
7	XT9037-20-108	1	The motor cover
8	XT9037-20-110	1	The latter plate
9	XT9037-20-111	1	The former plate
10	XT9037-30-100	1	Drive axle
11	XT9037-30-101	1	Active axle
12	XT9037-30-107	2	Belt
13	XT9037-30-108	2	The belt cover
14	XT9037-HJT-102	1	Box welding machine parts
15	XT9037-HJT-106	1	Welding parts of motor blocks
16	GBT5783-M8x16	2	Screw bolt
17	GBT77-M5x8	4	Screw
18	GBT96-D6	5	Washers
19	GBT96-D8	5	Washer
20	GBT1096-J-5X25	1	Flat keys
21	GBT1096-J-5X28	3	Flat keys
22	GBT276-6202ZE	6	Bearing
23	GBT5783-M5X10	2	Screw bolt
24	GBT5783-M6X20	6	Screw bolt
25	GBT5783-M8X30	4	Screw bolt
26	GBT5783-M8X50	2	Screw bolt
27	GBT6170-M6	4	Nut
28	GBT6170-M8	4	Nut
29	GBT77-M6X10	6	Screw
30	GBT818-M4X8	8	Screw
31	GBT819-M4X8	6	Screw
32	GBT923-M8	4	Nut
33	GBT93-D5	2	Shells pad
34	GBT93-D6	4	Nut
35	GBT93-D8	10	Shells pad
36	GBT96-D4	8	Flat pad
37	GBT96-D6	4	Flat pad
38	GBT96-D8	8	Flat pad
39	GBT97.1-D5	2	Flat pad
40	GBT97.1-D6	4	Flat pad
41	GBT97.1-D8	6	Flat pad
42	06B-51	1	Chain 06B-51
43	5IK120-C-F;5GU1:15	1	Motor



6.5 Tape head

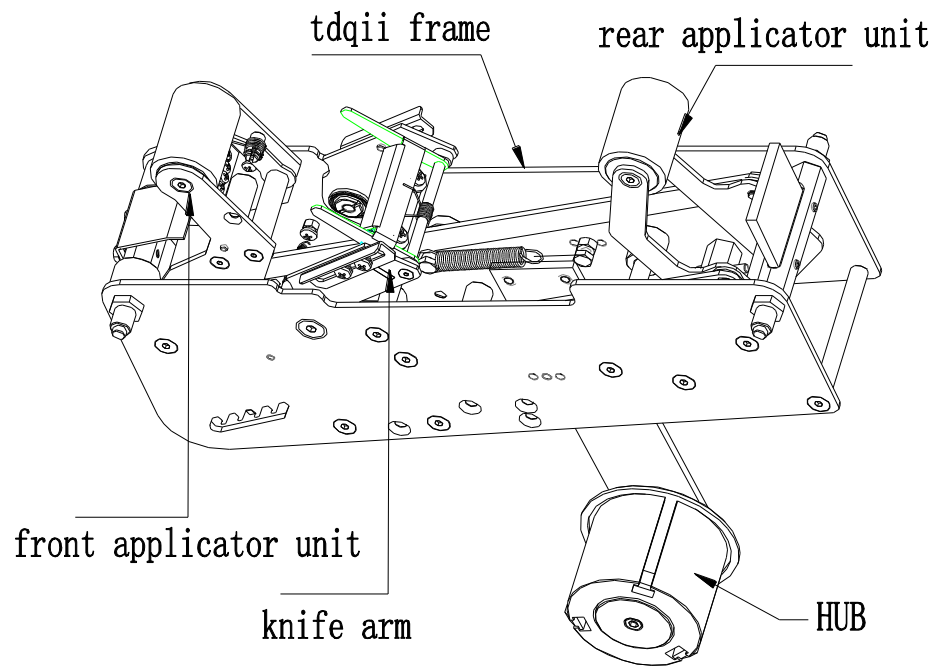




NO.	PARTS NO.	QTY	PARTS NAME
1	GBT70D3-LD-M4-12	1	Screw
2	GBT70D3-LD-M5-16	2	Screw
3	GBT70D3-LD-M5-20	1	Screw
4	GBT70D3-LD-M6-12	9	Screw
5	GBT70D3-LD-M6-16	3	Screw
6	GBT70D3-LD-M6-20	1	Screw
7	GBT70D3-LD-M8-16	1	Screw
8	GBT70D3-LD-M8-20	2	Screw
9	GBT70D1-LD-M8-50-11	1	Screw
10	GBT5783-LS-M6x12	4	Screw bolt
11	GBT5783-LS-M6x12	2	Screw bolt
12	GBT5783-LS-M6x12	1	Screw bolt
13	GBT5783-LS-M6x12	1	Screw bolt
14	ODPS-M3-8	3	Screw
15	GBT818-LD-M3-5	2	Screw
16	GBT818-LD-M4-8	2	Screw
17	GBT818-LD-M4-10	1	Screw
18	GBT818-LD-M5-8	2	Screw
19	GBT818-LD-M5-50	1	Screw
20	GBT77-LD-M5-8	2	Screw
21	ETW-5	2	Ring
22	GBT894D1-DQ-8	3	Ring
23	GBT894D1-DQ-10	3	Ring
24	GBT894D1-DQ-16	3	Ring
25	GBT6177-LM-M5	1	nut
26	OMZL-M18-1	2	Nut
27	GBT6170-LM-M5	1	Nut
28	GBT6170-LM-M6	3	Nut
29	GBT6170-LM-M8	2	Nut
30	OMZL-M8	1	Nut
31	GBT97D1-QP-3	2	Washer
32	GBT97D1-QP-4	2	Washer
33	OQDP-4-H06	2	Washer
34	GBT97D1-QP-5	8	Washer
35	GBT97D1-QP-6	2	Washer
36	OQDP-6-H06	1	Washer
37	GBT93-QT-4	2	Washer
38	GBT93-QT-5	6	Washer
39	OZDX-HF1216	1	One-way bearing
40	GBT276-ZC-635ZZ	1	Bearing
41	BT201	1	Right panel
42	BT202	1	Left panel
43	BT203	1	Brush pillar
44	BT204	1	Brush
45	BT205	4	Brush screw pillar
46	BT206	2	Round pillar
47	BT207	1	Link
48	BT208	4	Swing rod after rod bushing
49	BT209	2	Dedicated link screw
50	BT211	1	Extension spring pendulum stroke after column
51	BT213	1	Extension spring rod column
52	BT212	4	Copper sets in fixed rod
53	BT215	2	Fixed swing rod sets axis
54	BT216	1	Swing rod long spring
55	BT217	1	Fixed block

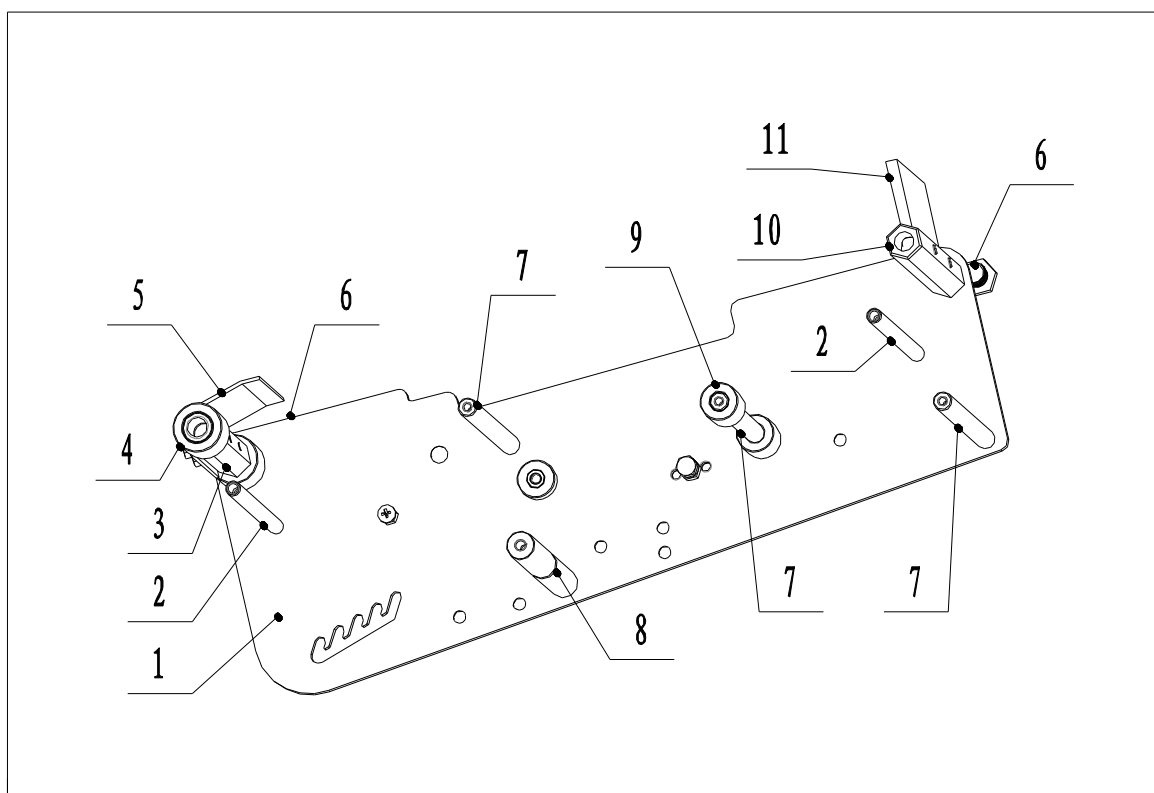


NO.	PARTS NO.	QTY	PARTS NAME
56	BT220	1	Fixed axis
57	BT221	1	Positioned spring
58	BT222	2	Rubber wheel axis
59	BT223	2	Rubber wheel
60	BT224	2	Positioned rubber wheel
61	BT225	2	Rubber wheel sets
62	BT226	1	Former embossed round
63	BT228	1	Former flower axle
64	BT229	1	Former flower axle spring
65	BT230	2	Former flower axle washer
66	BT231	1	Retaining shaft with stent
67	BT232	1	Retaining shaft spring
68	BT234	1	Cover fixed panels
69	BT236	1	Fixed film(right)
70	BT237	1	Fixed film(left)
71	BT237-2	1	Guide plate
72	BT238	1	Bar sets
73	BT239	1	Fixed rod
74	BT240	1	Idler pulley
75	BT241	1	Idler wheel
76	BT242	1	One-way bearing
77	BT243	1	One-way wheel
78	BT244	1	One-way bushing
79	BT245	2	One-way washer
80	BT247	1	One-way spring
81	BT251	1	Cutter support shaft
82	BT252	1	Cutter support shaft bushing
83	BT253	1	Cutter block
84	BT254	1	Regulating boards
85	BT255	1	Cutter
86	BT256	1	Cutter cover
87	BT257	1	Cover spring
88	BT258	1	Cover shaft
89	BT259	4	Cover sleeve
90	BT260	1	Cutter spring
91	BT261	1	Cutter wheel
92	BT263	1	Tape block
93	BT264	1	Tape block fixed pedals
94	BT265	1	Tape block fixed rod
95	BT266	1	Knob handles
96	BT268	1	Tightened spring pads
97	BT269	1	Tightened spring
98	BT270	12	Pressed spring
99	BT271	3	Pressed tablets
100	BTH21	1	The latter spring rod welding
101	BTH22	1	The former welding
102	BTH23	1	Retaining frame welding
103	BTH24	1	Cutter support welding



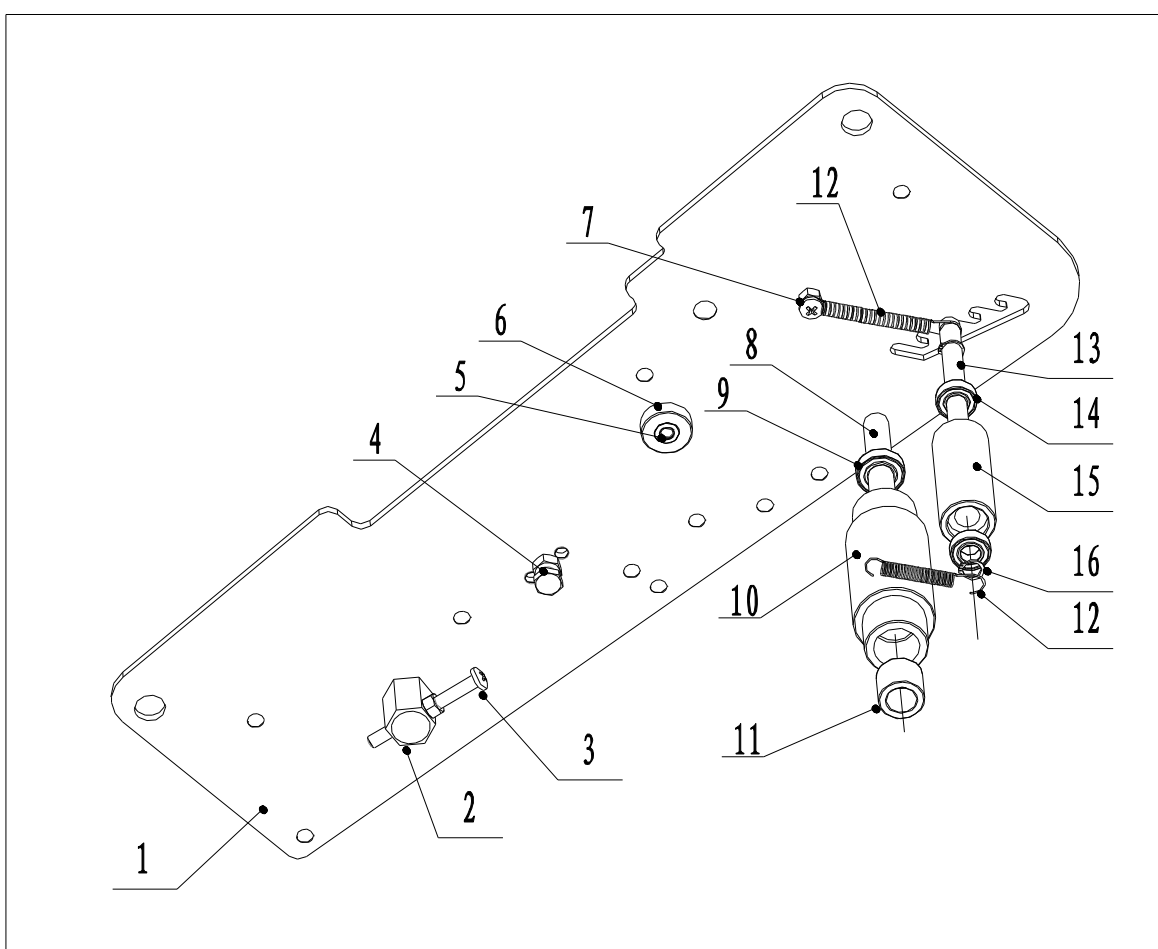


No	Part No.	Part Name	No	Part No.	Part Name
1	TDQII-101	Left and right wall board	7	TDQII-102	round support
2	TDQII-117-02	axis	8	TDQII-133	tension spring support
3	TDQII-106	fixing pole	9	TDQII-156	block wheel
4	TDQII-107	noise elimination cover of swing pole	10	TDQII-103	brush support
5	TDQII-108	Guide board	11	TDQII-104	brush
6	TDQII-105	fixing screw			





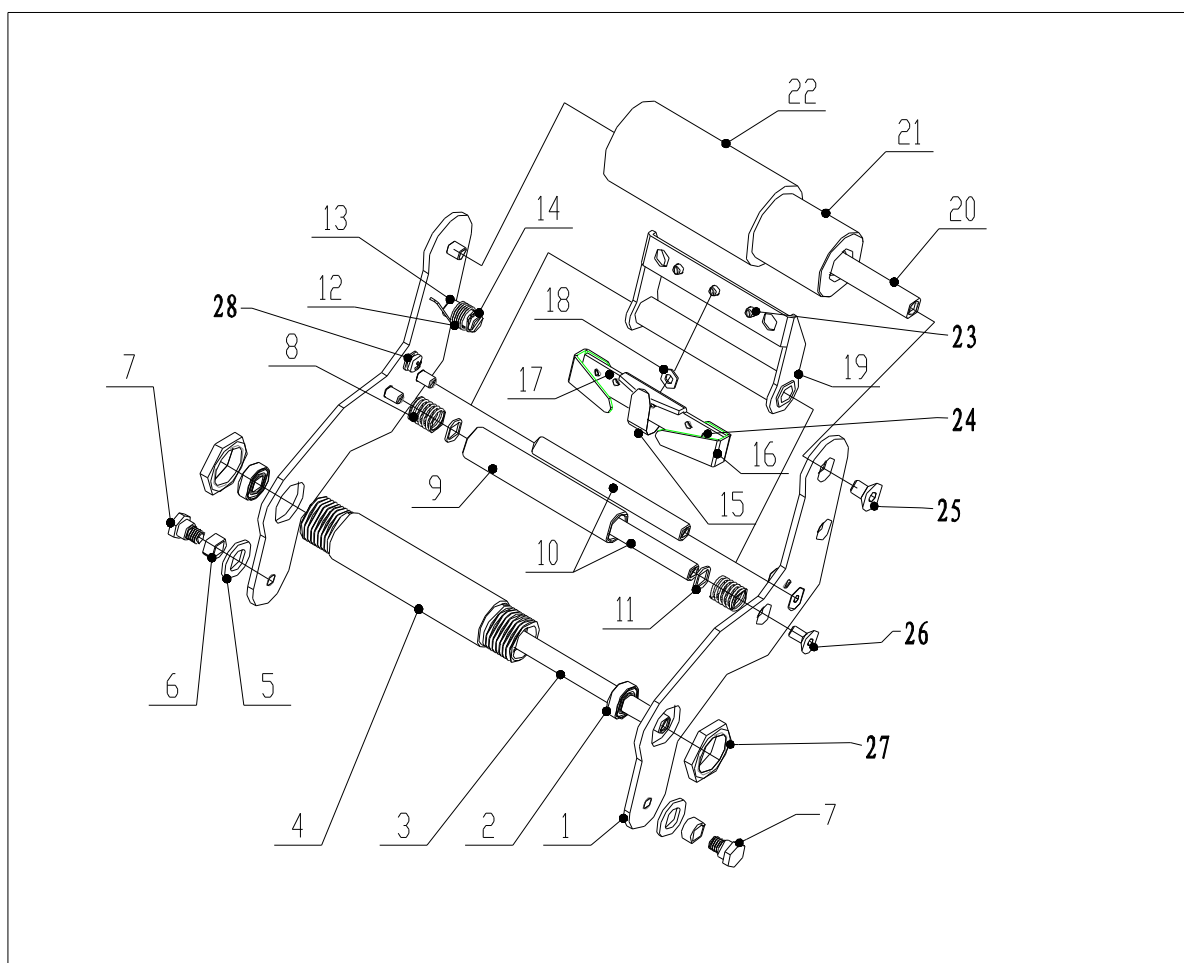
No	Part No.	Part Name	No	Part No.	Part Name
1	TDQII-101	left and right wall board	9	61800-Z	bearing
2	TDQII-135	adjusting block of swing pole	10	TDQII-109	single way wheel
3	M5*50(GB/T 818)	screw	11	HF1216	single way bearing
4	M6*12(GB/T5783)	nut	12	TDQII-111	idler wheel spring
5	M6*10 (GB/T70.3)	screw	13	TDQII-113	idler wheel axles
6	TDQII-145	block wheel	14	688	bearing
7	M5*10(GB/T 823)	screw	15	TDQII-112	idler wheel
8	TDQII-110	single way axles	16	GB/T 894.2	d0=8 washer





Front tapping part figure

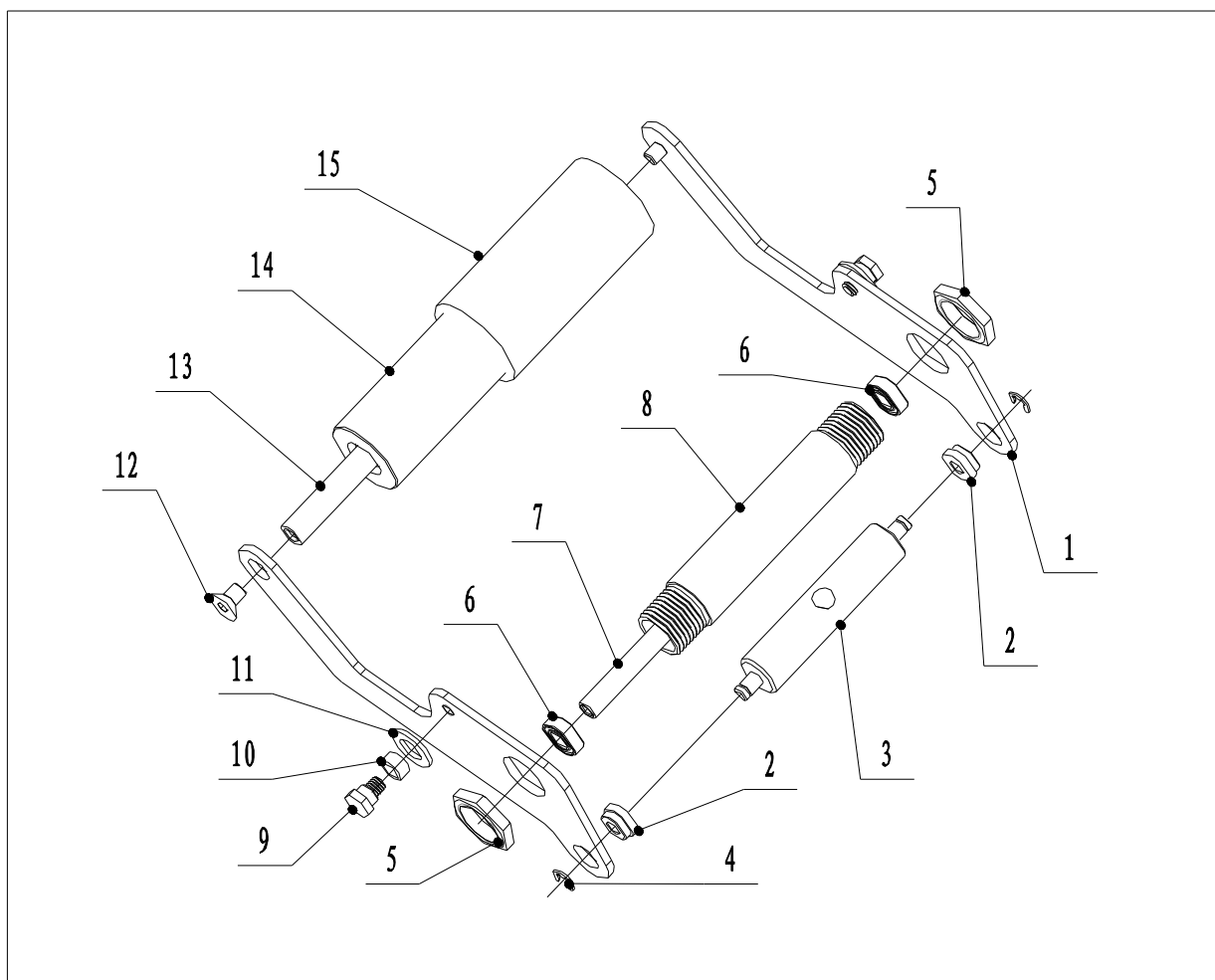
No	Part No.	Part Name	No	Part No.	Part Name
1	TDQII-114	Front swing pole	15	TDQII-129-01	spring piece
2	61801-Z	bearing	16	TDQII-130	fixing piece
3	TDQII-117-02	swing pole axes	17	TDQII-129	fixing board
4	TDQII-117	swing pole fixing cover	18	GB/T 848	M5 flat washer
5	GB/T 848	M10 small washer	19	TDQII-125(126)	supporting assembly
6	P10*8*5(GB12613)	axles cover	20	TDQII-118	plastic wheel axles
7	TDQII-132	screw	21	TDQII-119	plastic wheel of swing pole
8	TDQII-123-01	spring	22	TDQII-120	plastic wheel cover
9	TDQII-123	front knurling wheel	23	M4X6:GB/T 823	screw
10	TDQII-124	axles of front knurling wheel	24	M3*3:GB/T 823	screw
11	TDQII-123-02	spring plastic pad	25	M6X10:GB/T70.3	screw
12	TDQII-128	spring	26	M5X10:GB/T70.3	screw
13	TDQII-127	tension spring shaft	27	M20*1.5	nut
14	GB/T 894.2	d0=8 washer	28	M4X6:GB/T 823	screw





Rear tapping part figure

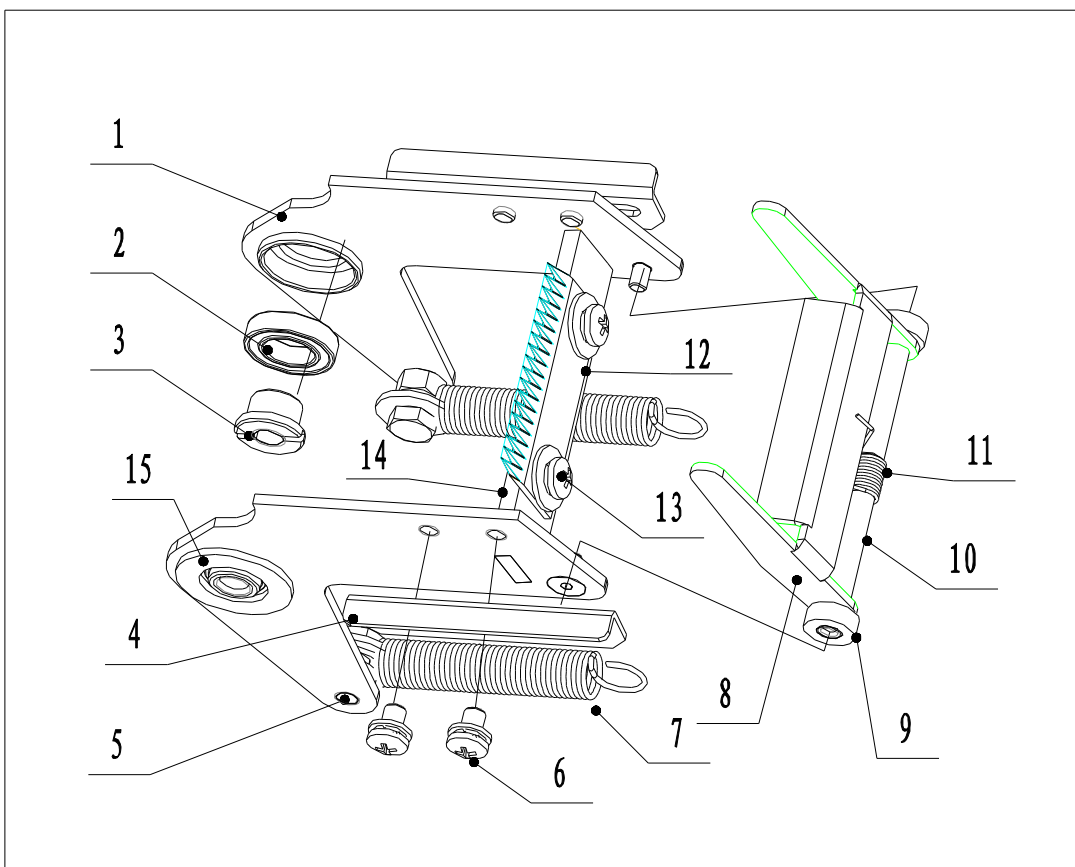
No	Part No.	Part Name	No	Part No.	Part Name
1	TDQII-115	rear swing pole	9	TDQII-132	connecting pole-use screw
2	TDQII-122-01	shaft cover6*12*6	10	P10*8*5(GB12613)	shaft cover
3	TDQII-122	swing pole spring adjusting pole	11	GB/T 848	M10 small washer
4	ETW5.0	open washer—ETW5.0	12	M6X10:GB/T 70.3	screw
5	M20*1.5	nut	13	TDQII-118	plastic wheel axes
6	688	bearing	14	TDQII-119	swing pole plastic wheel
7	TDQII-117-02	swing pole axes	15	TDQII-120	plastic wheel cover
8	TDQII-117	swing pole fixing cover			





Knife rest figure

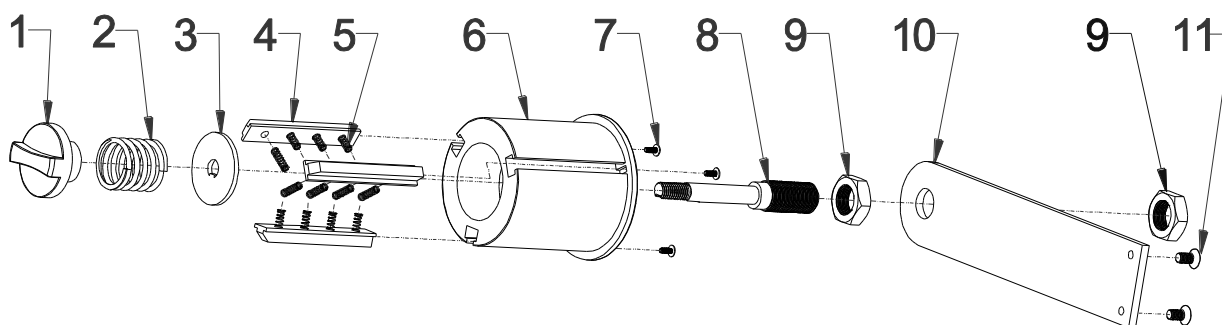
No	Part No.	Part Name	No	Part No.	Part Name
1	TDQII-HJT-102	knife rest welding figure	9	TDQII-143	cover bush
2	61801-Z	bearing	10	TDQII-142	cover axes
3	TDQII-138	knife rest axes	11	TDQII-144	cover tension spring
4	TDQII-137	knife rest adjusting piece	12	TDQII-140	knife
5	M6*12(GB/T5783)	bolt	13	M5X8(GB/T 818)	screw
6	M5X8(GB/T 818)	screw	14	TDQII-139	knife seat
7	TDQII-146	knife tension spring	15	TDQII-116	knife rest cover
8	TDQII-141	knife cover			





Tape support figure

No	Part No.	Part Name
1	BT266[NF010A]	knob
2	BT269[FA001A]	Compression spring
3	BT268[HA010B]	spring washer
4	BT271	compression piece
5	BT270	compression piece spring
6	BT263[TH402A]	tape support
7	0DPS-M3-8	screw
8	BT265[TH403A]	fixing pole of tape support
9	OMZL-M18-1D5	nut
10	BT264[TH401A]	fixing board of tape support
11	GBT70D3-LD-M6-12	screw





7. Features:

1. Easy to operate and simple to maintain and noiseless.
2. Easy adjustment for width and height of carton.
3. Strong construction and sturdy.
4. Breaker switch
5. Emergency Stop

8. Procedures:

Method of the machine to be in use and operation

1. Install tape on tape head.
2. Top and Bottom flaps must be folded before feeding.
3. Adjust the driving belts with the adjustment crank handle until the carton width was folded by both side belt just suitable.
4. Press the ON switch. The machine will start to run and seal the carton.
5. Present box to belts.

9. Maintenance:

Lubrication:

Lubrication all the moving parts on the tape head with light oil or grease every two months.

Check:

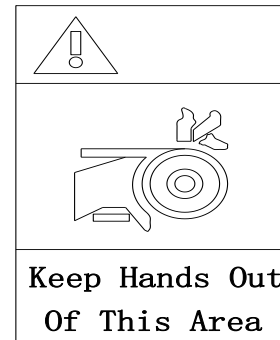
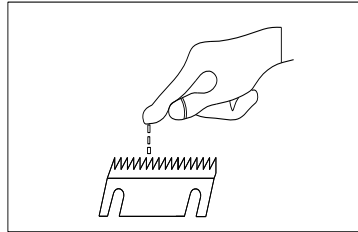
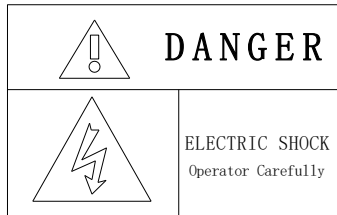
Check all the moving bolts nuts and belts every two months. If found loose tighten then right away.



10. Notes

Limitations of carton case are as following:

1. Carton case with plastic coating on the surface is unusable.
2. Carton case must be dry (wet carton case is unable to seal with tape)
3. Carton case must not put any kind of dust or dirt on the surface.
4. Deformed carton case is unable to seal with tape particularly the waving curved flap must not be used.



Limitations of tape are followings:

1. Deformed core's tape must not be used.
2. Deformed winding tape (gearing dishing or gapping) must not be used.
3. The tape made of cloth must not be used.
4. The tape which is uneven width or thickness must not be used.
5. The tape which has a scratch and it is cause for some accident of the sealing machine.
6. The tape which is passed a half year after made up had better use.

11. Warranty Period:

One year from ship date. Warranty covers parts only. Excludes wear items including but not limited to belts, springs and cutting blades.

Shipping to and from Cleveland Equipment for repair is the responsibility of the buyer.

Notice: Product information and specifications are subject to change without notice.