



# Cleveland Equipment

## CE-554TS

Semi-Automatic Carton Sealing Machine

### Operation Manual



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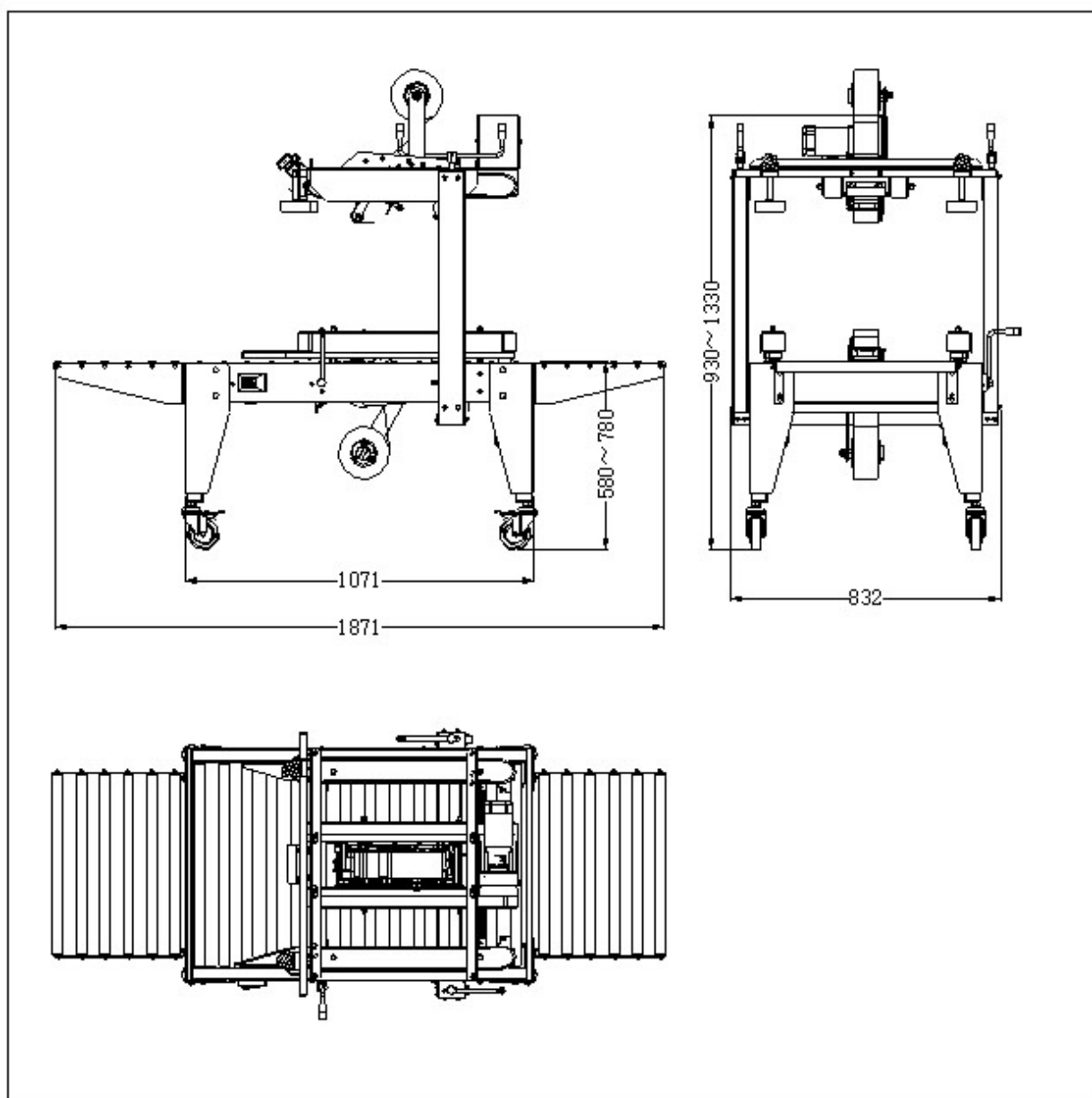
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## 1. Specification

| Model       | Machine size(mm) |      |               |                         | Machine weight(kg) | Box size(mm) |         |         |
|-------------|------------------|------|---------------|-------------------------|--------------------|--------------|---------|---------|
|             | L                | W    | H(Adjustable) | Table height            |                    | L            | W       | H       |
| CE554TS5050 | 1071             | 832  | 930~1330      | (Adjustable)<br>580~780 | 120                | 150~∞        | 150~500 | 110~500 |
| CE554TS6060 |                  | 932  | 930~1430      |                         | 135                |              | 150~600 | 110~600 |
| CE554TS7070 |                  | 1032 | 930~1530      |                         | 150                |              | 150~700 | 110~700 |

Tape width:48~75mm ; Sealing speed:15M/min; Power:1 $\phi$ , 220VAC,50HZ。





## 2. Assembly and Adjustment

### 2.1 Wheel Assembly

Assembly brake wheel and adjust the table height (refer to right picture)

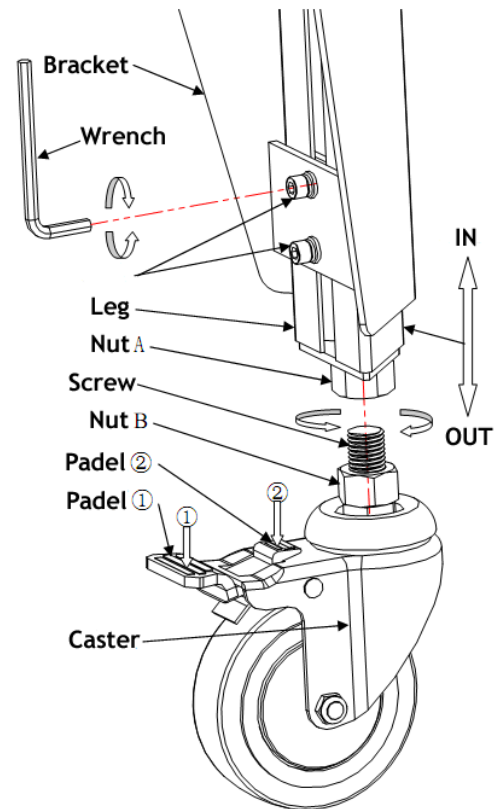
#### 2.1.1 Assembly brake caster:

Screw caster into leg nut A; fasten nut B,

#### 2.1.2 Table Height Adjustment

Adjust the leg length to make machine even on the ground.

Method: Loose screws, IN or OUT the legs to the suitable length, fasten the screws again.



### 2.2 Move the machine

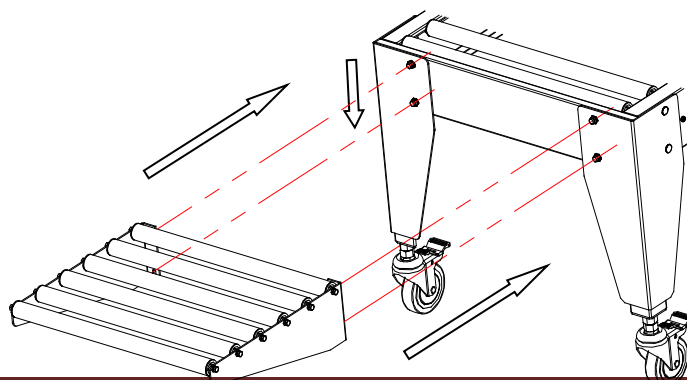
Fix a machine in a production line

Method: Stepping down pedal (1) to brake the caster; Stepping down pedal (2) to move the machine.

### 2.3 Out-feed and in-feed rollers

Install out-feed and in-feed rollers. (Refer to below figure).

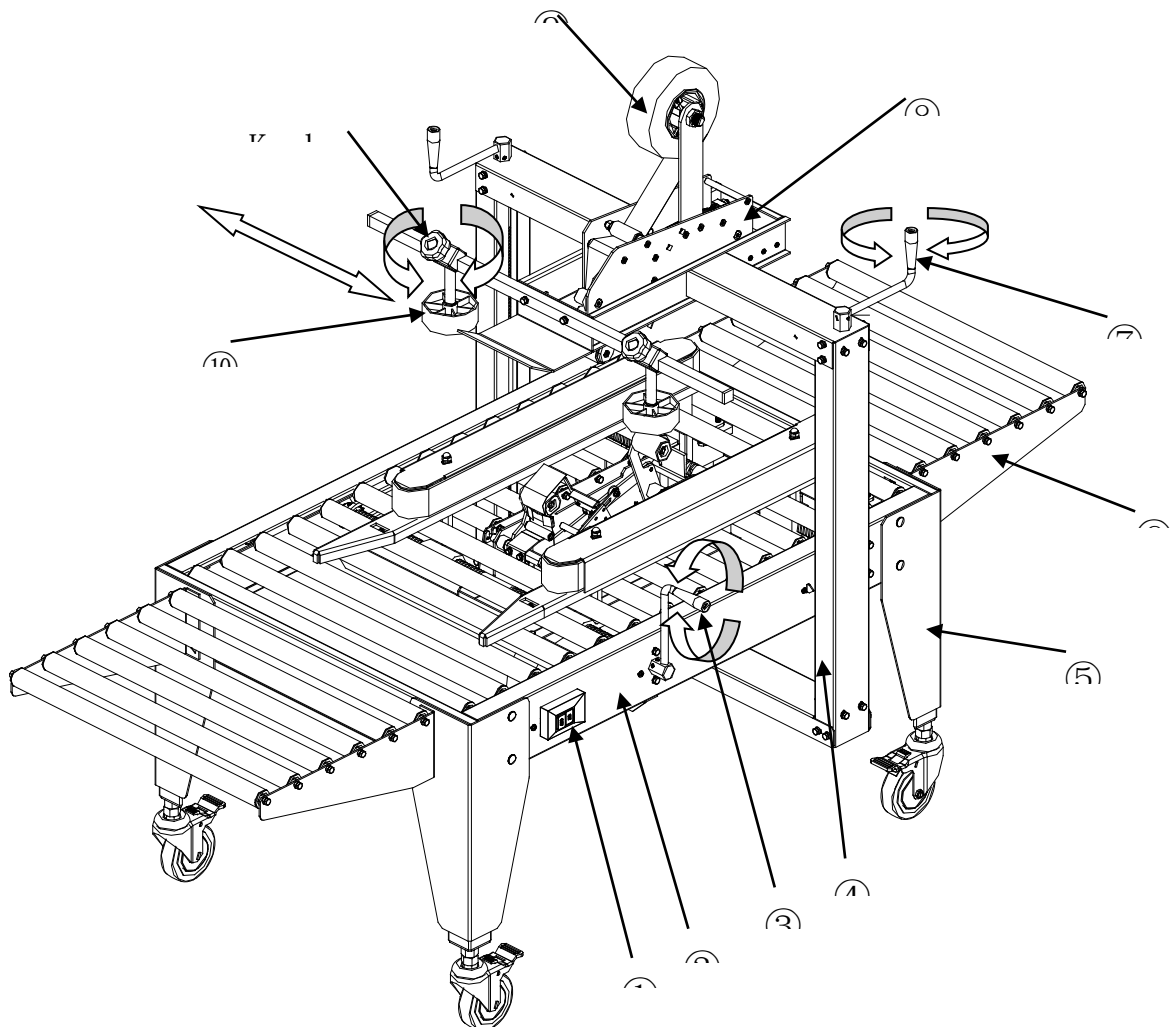
Hang rollers on machine body.





## 2.4 Machine parts

| NO | Description                   | NO | Description                    |
|----|-------------------------------|----|--------------------------------|
| 1  | ON OFF switch                 | 6  | In-feed /out-feed roller       |
| 2  | Machine body                  | 7  | Height adjustment crank handle |
| 3  | Width adjustment crank handle | 8  | Tape head                      |
| 4  | Tower frame                   | 9  | tape                           |
| 5  | Leg frame                     | 10 | Guide wheel                    |





## 2.5 Box Adjustment:

### **Box width/height adjustment:**

***Loosen the guide wheel fixing knob A.***

- Move the guide wheel directly with your hands until the distance between guide wheels is about 30-50mm wider than the width of the box.
- Adjust the distance between the side belts by crank (3) until it is 30-50mm wider than the box.
- Adjust the height by crank (7) until it is 30-50mm higher than the box
- Place a box onto the roller conveyor in proper position with the top and bottom covers folded.
- Adjust crank (3) until side belts press against both sides of the box.
- Adjust crank (7) until top belt press against top side of the box.
- Move the guide wheels so that they touch both sides of the box
- Tighten the guide wheel fix knobs.

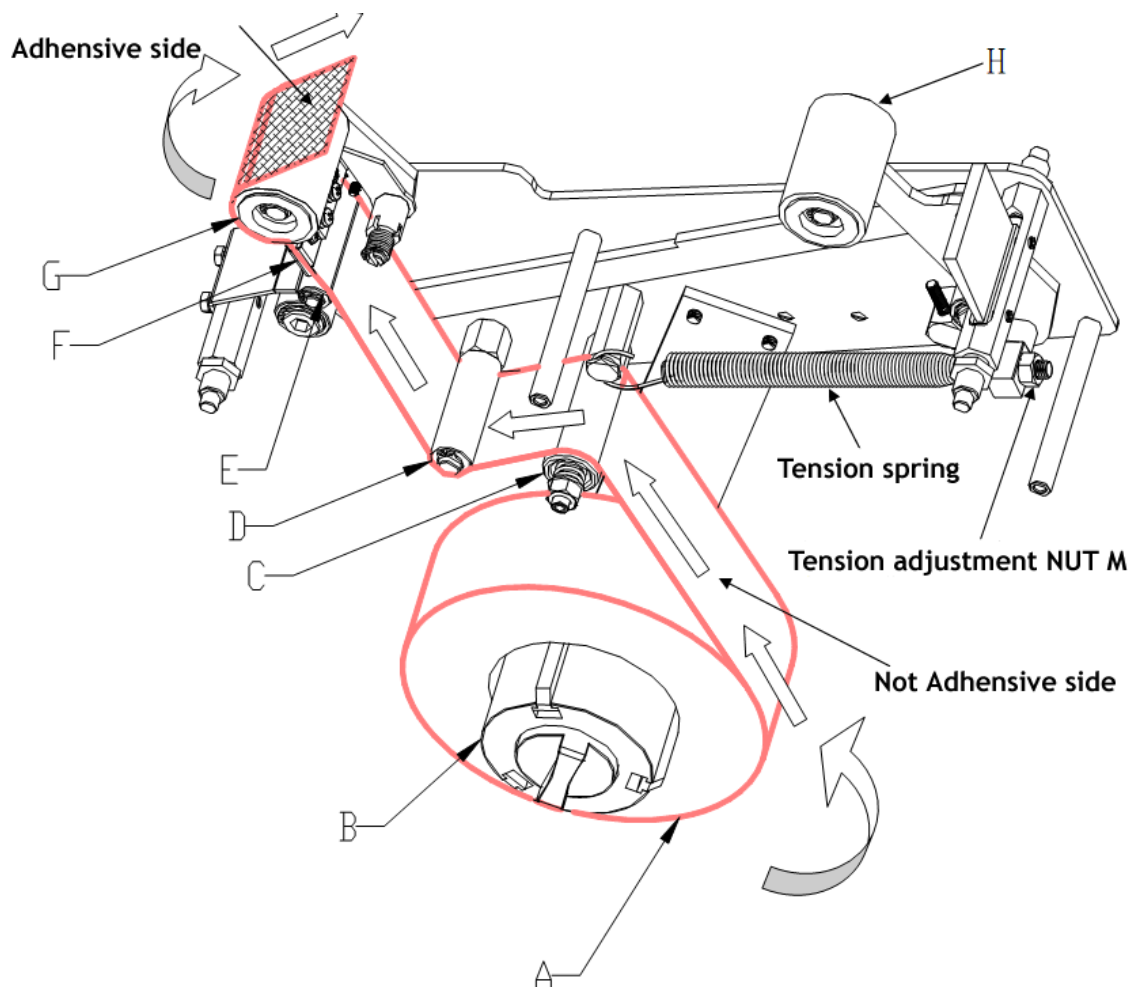


## 2.6 Tape Installation

### 2.6.1 Installing tape

- 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.
- d. 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.

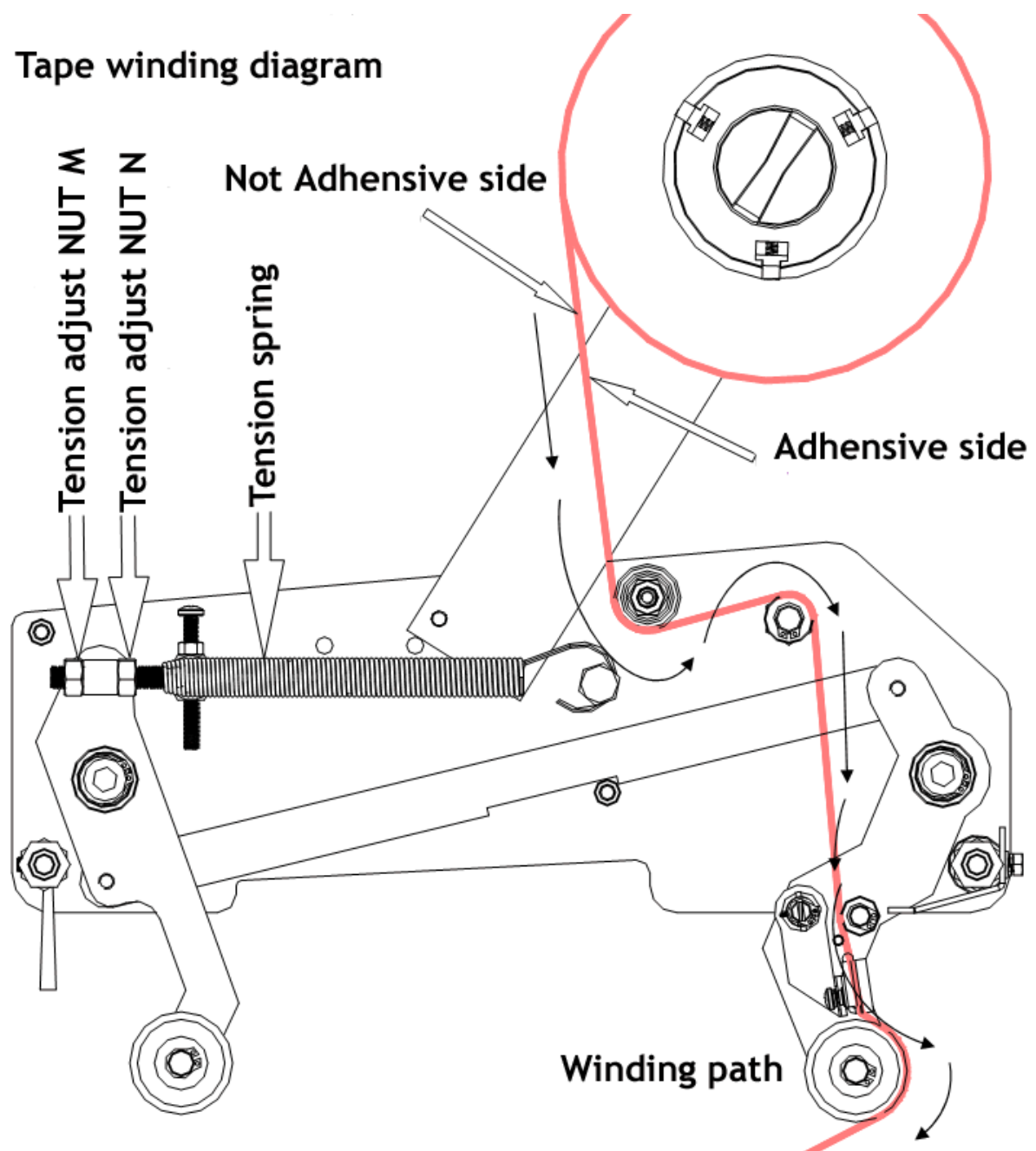




### 2.6.2 Tension Adjustment

- (1) Purpose: Make sure the tape adhere on box firmly without wrinkles.
- (2) principle: Keep the taping speed is proportional to the belts speed.
- (3) Method: Loosen tension lock nut N, fasten or loosen tension adjustment nut M until get required tension, fasten tension nut N.

**Tape winding diagram**



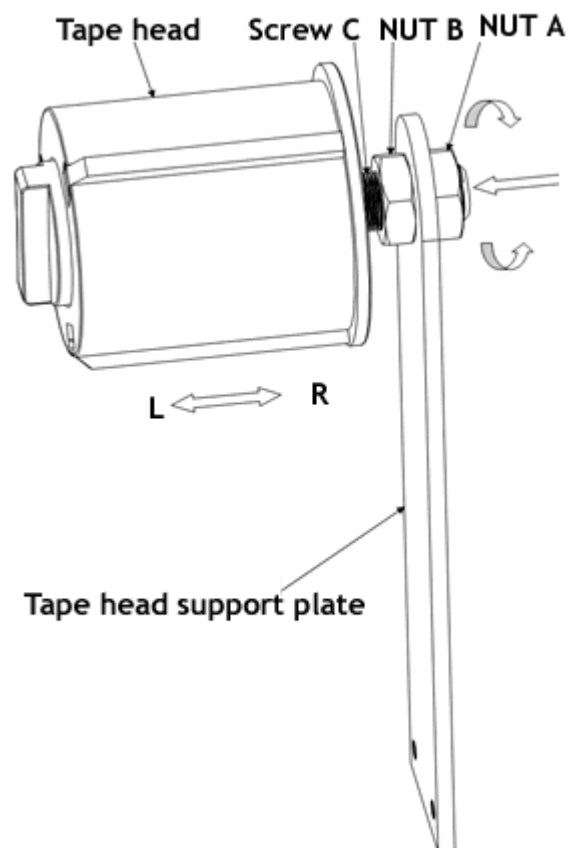


### 2.6.3 Put tape roller in the center of tape holder

- (1) Use OPP adhesive tape
- (2) If the tape is off the center of the box, clockwise or anti-clockwise adjust Nut A,B
- (3) Method (refer to below figure)

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

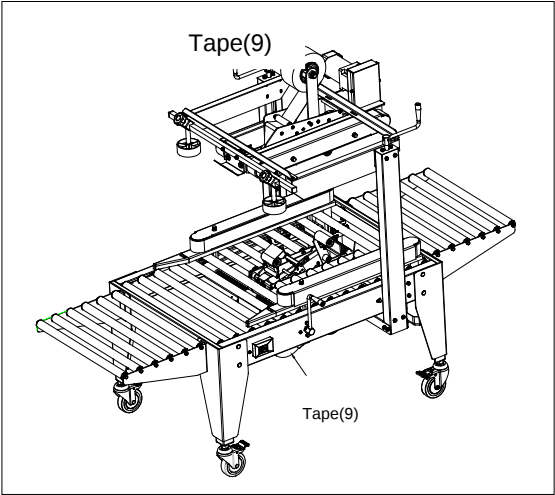
Move to right: Screw in Nut B, move the lock screw C right, fasten nut A;



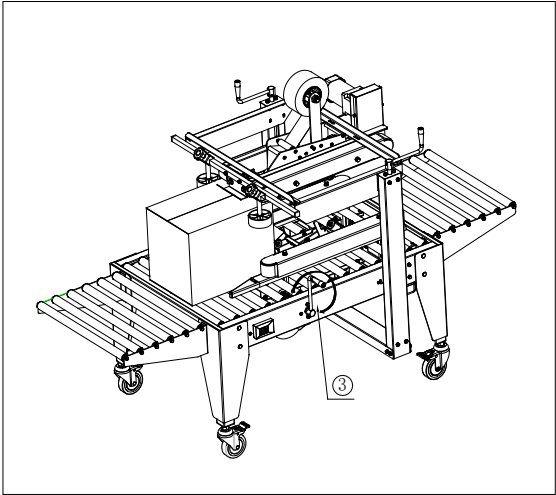


3. Operation procedure

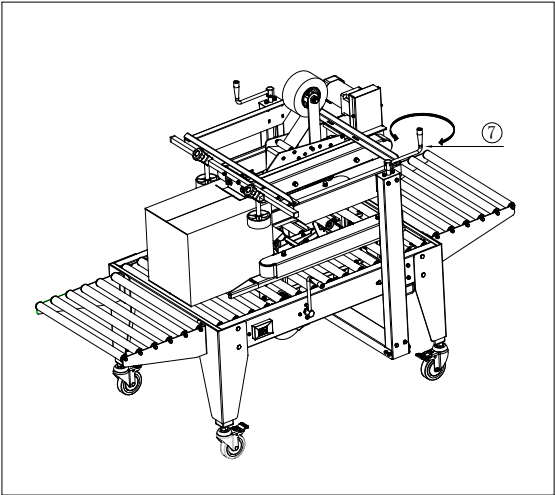
Install tape (9) onto tape head



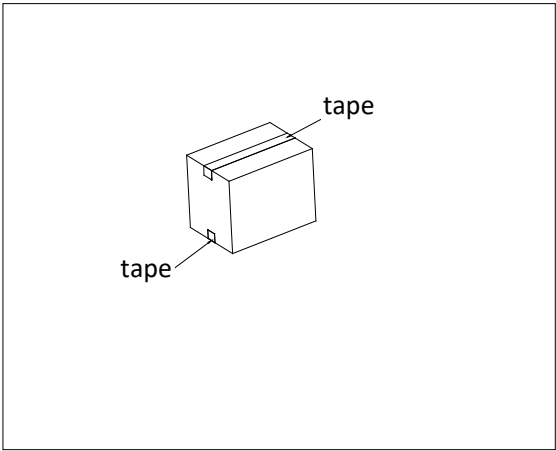
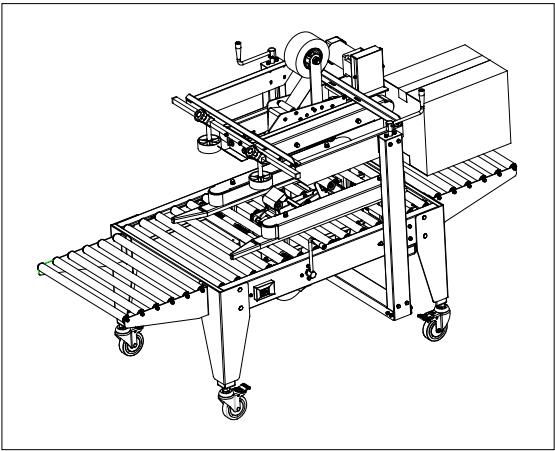
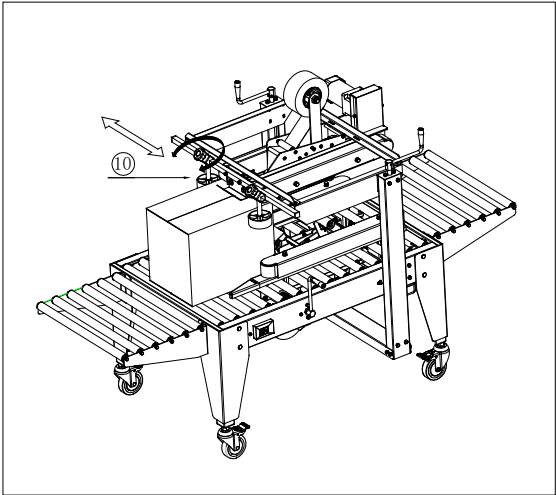
Adjust the width by crank (5)



Adjust the height by crank (7)



Adjust the side wheels(10) to close box





#### 4. Trouble shooting

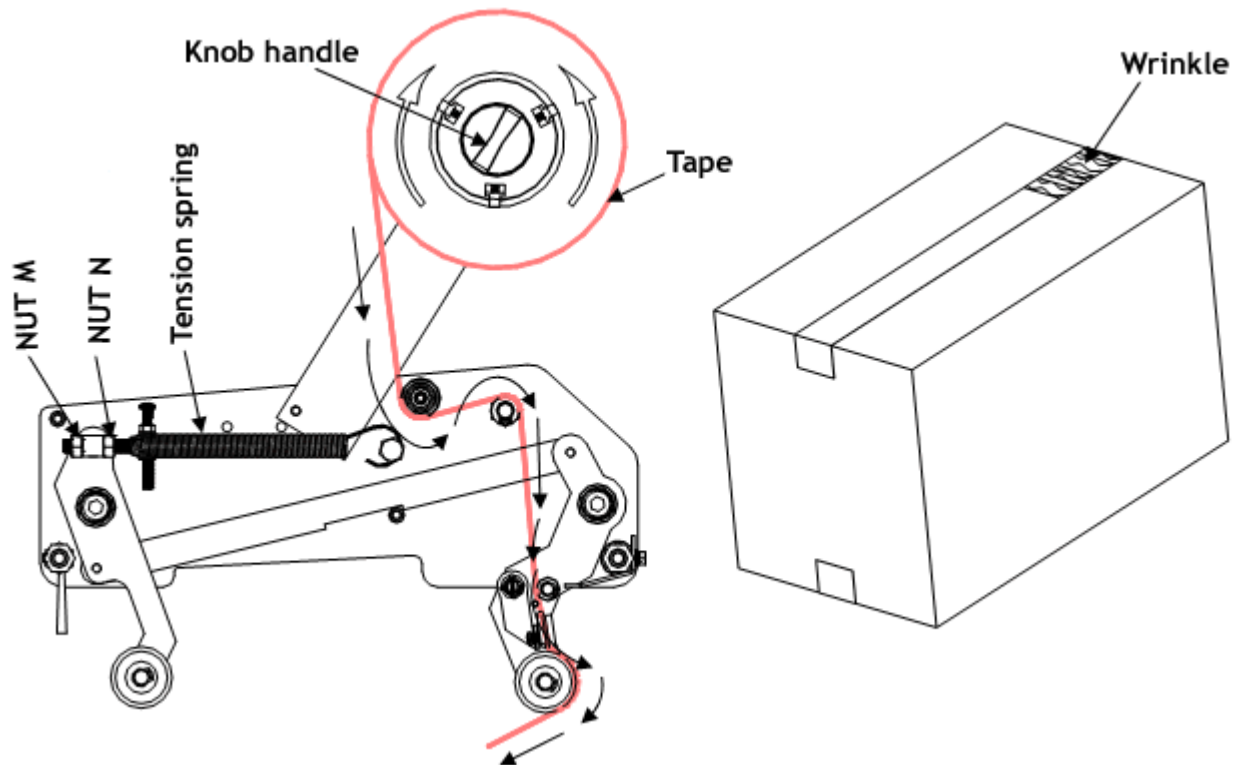
|   | Trouble                                 | Causes                                                                                                                                                                                                                                                                                                                                                                                     | Remedy                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|---|-----------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Tape cannot be cut off                  | <ul style="list-style-type: none"> <li>*Knife is not sharp enough</li> <li>*Knife tip is jammed with adhesive</li> </ul>                                                                                                                                                                                                                                                                   | <ul style="list-style-type: none"> <li>*Replace with a new knife</li> <li>* Clean the knife with volatile solvent</li> </ul>                                                                                                                                                                                                                                                                                                                             |
| 2 | A trailing of tape after cut off motion | <ul style="list-style-type: none"> <li>*Unsmooth motion of knife holder due to Choke</li> <li>*Knife holder extension spring fatigue</li> </ul>                                                                                                                                                                                                                                            | <ul style="list-style-type: none"> <li>* Check if the knife holder screw are loose. Lubricate when necessary.</li> <li>* Replacement</li> </ul>                                                                                                                                                                                                                                                                                                          |
| 3 | Tap is not fully adhering to the box    | <ul style="list-style-type: none"> <li>*Main spring too loose</li> <li>*The roller shafts which the tape runs over are not effective due to accumulated tape adhesive</li> <li>*Tape wheel adjustment nut is too tight</li> </ul>                                                                                                                                                          | <ul style="list-style-type: none"> <li>* Tighten the main spring</li> <li>* Lubricate roller shaft</li> </ul>                                                                                                                                                                                                                                                                                                                                            |
| 4 | Box chocked on the way                  | <ul style="list-style-type: none"> <li>*Improper box height adjustment</li> <li>* Main spring too tight</li> </ul>                                                                                                                                                                                                                                                                         | <ul style="list-style-type: none"> <li>*Readjust the height</li> <li>*Loosen the main spring</li> </ul>                                                                                                                                                                                                                                                                                                                                                  |
| 5 | Tape broken during sealing on box       | <ul style="list-style-type: none"> <li>*Knife protrudes too far</li> </ul>                                                                                                                                                                                                                                                                                                                 | <ul style="list-style-type: none"> <li>*readjust the knife position</li> </ul>                                                                                                                                                                                                                                                                                                                                                                           |
| 6 | Tape cannot travel smoothly             | <ul style="list-style-type: none"> <li>*tape adhesion is not even</li> <li>*The roller shafts which the tapes run over are not effective due to accumulated tape adhesive</li> <li>*Irreversible roller is not effective</li> <li>* Tape loaded incorrectly</li> <li>*Tape wheel adjustment nut is too tight</li> </ul>                                                                    | <ul style="list-style-type: none"> <li>* Replace with a new tape roll</li> <li>*lubricate roller shaft</li> <li>*Replacement</li> <li>* Correct tape loading</li> <li>*Loosen it</li> </ul>                                                                                                                                                                                                                                                              |
| 7 | Tape is off center on the application   | <ul style="list-style-type: none"> <li>*both guide wheels have uneven pressure on the box</li> </ul>                                                                                                                                                                                                                                                                                       | <ul style="list-style-type: none"> <li>*re-adjust the distance between both guide wheels</li> </ul>                                                                                                                                                                                                                                                                                                                                                      |
| 8 | Curious noise while in sealing          | <ul style="list-style-type: none"> <li>*Bearing set covered with dust</li> </ul>                                                                                                                                                                                                                                                                                                           | <ul style="list-style-type: none"> <li>*Clean and lubricate</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                   |
| 9 | Tape end wrinkling on the carton        | <ul style="list-style-type: none"> <li>*Tape wheel assembly is too tight</li> <li>*Inside tape wheel assembly with sharp edges &amp; dust</li> <li>*tape dose not travel smoothly</li> <li>* Knife is not sharp enough or is jammed with tape adhesive</li> <li>* The knife holder is not functioning smoothly</li> <li>*Bronze roller (irreversible roller) is not functioning</li> </ul> | <ul style="list-style-type: none"> <li>* Loosen tape wheel assembly spring</li> <li>* Remove tape wheel washer sharp edges and keep it clean. Grease the tape wheel.</li> <li>*Lubricate the roller shafts which the tape runs over</li> <li>*Clean the knife with gasoline or alcohol (volatile solvents)</li> <li>* Check and lubricate to ensure that it functions smoothly. Adjust the knife holder's spring tension</li> <li>*Replace it</li> </ul> |



#### 4. Trouble shooting

Tape end 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

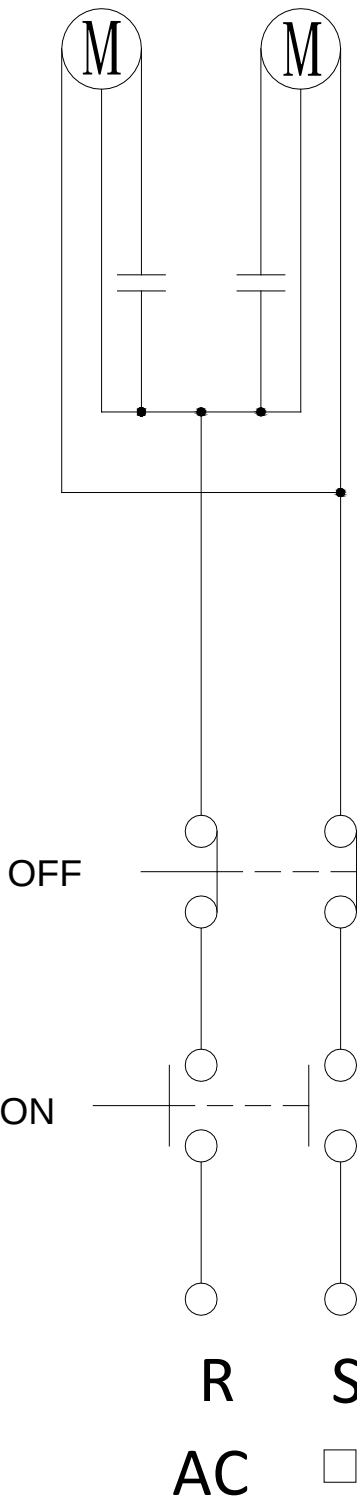


Remark:

1. Switch off before repair or adjust
2. Blade must be clean up and lubricate before using
3. After using for a while, adjustable belt a little bit tighter



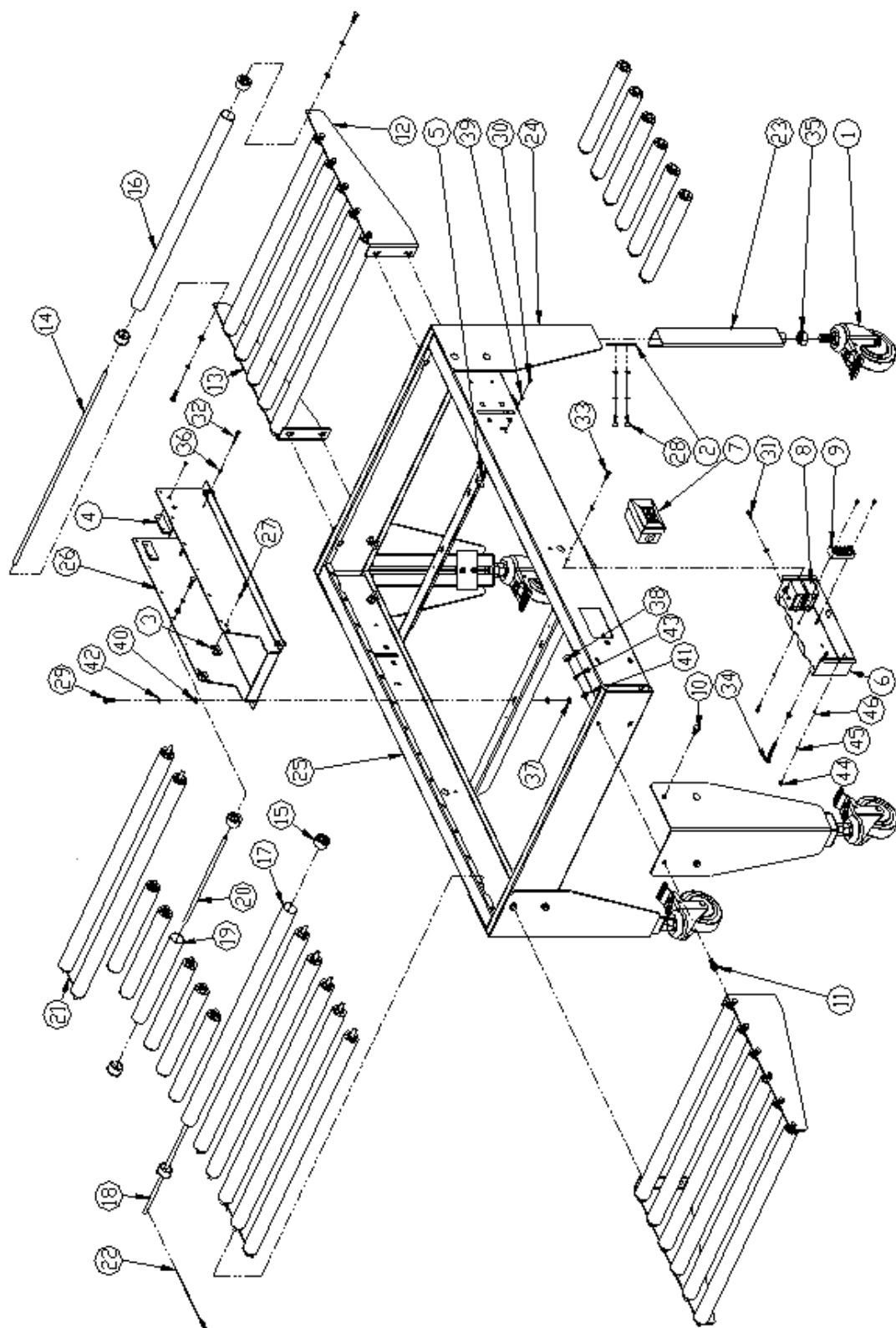
5. Electrical Schematic





## 6. Parts Index / Diagrams

### 6.1 Machine frame



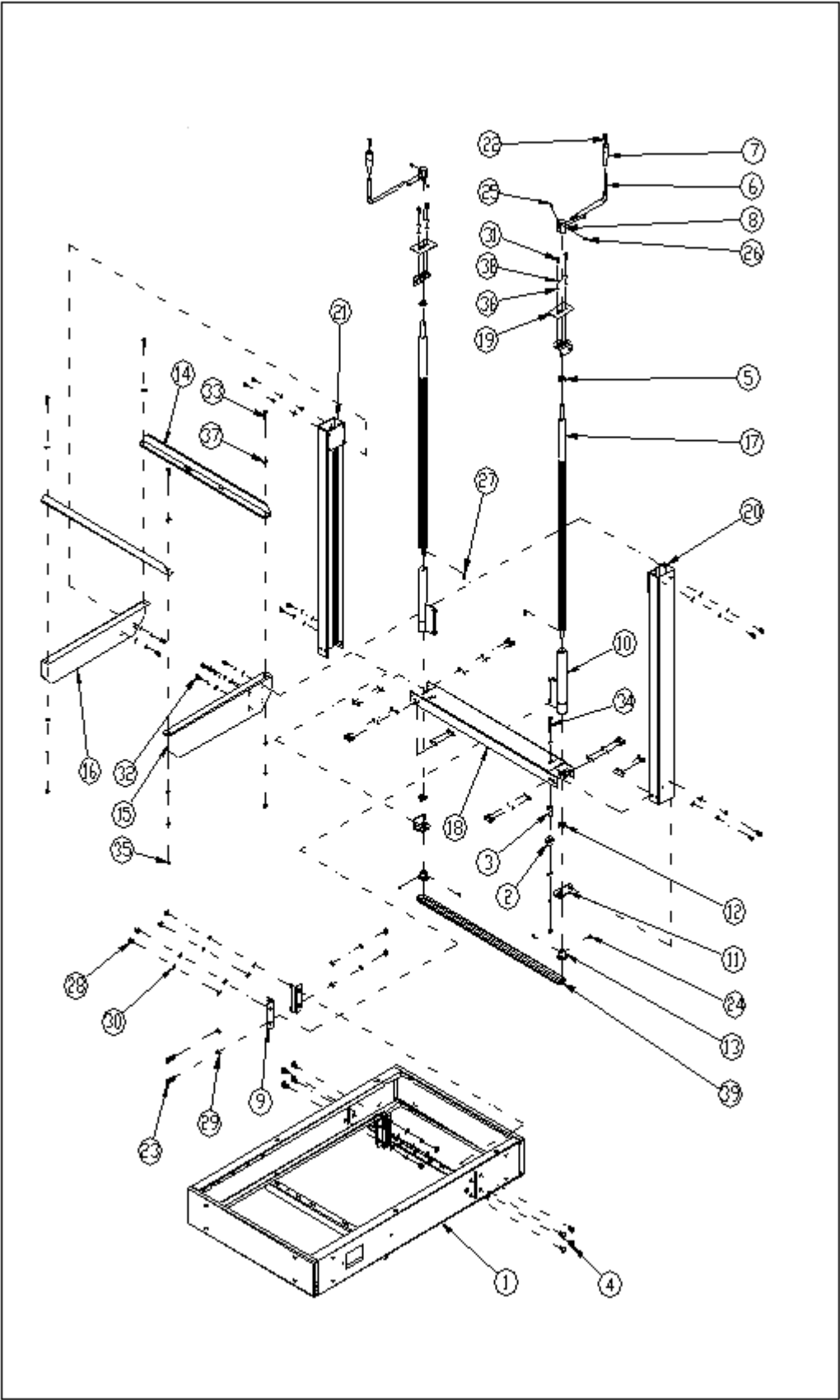


## 6.1 Machine frame parts

| No | Part No              | QTY | description                    |
|----|----------------------|-----|--------------------------------|
| 1  | 965501000 (PA00111)  | 4   | Brake caster                   |
| 2  | 965501040 (A2504A)   | 4   | Leg fix block                  |
| 3  | 965501131            | 2   | Bottom tap head fix plate 1    |
| 4  | 965501132            | 2   | Bottom tap head fix plate 2    |
| 5  | 965501160 (A2507B)   | 1   | Indicator                      |
| 6  | 965501170            | 1   | Motor box                      |
| 7  | 965501171            | 1   | LAK-10 on/off switch 500V2.2KW |
| 8  | 965501172            | 2   | Capacitor 6uF±5%500VAC50Hz     |
| 9  | 965501173            | 1   | Terminal connection 600V15A4P  |
| 10 | 965501180 (SJ816F)   | 8   | Frame screw                    |
| 11 | 965501190            | 8   | Roller screw                   |
| 12 | 965505000 (A1507A)   | 2   | Out-feed roller                |
| 13 | 965505002 (A1507B)   | 2   | In-feed roller                 |
| 14 | 965505010 (A1508A)   | 12  | Roller shaft                   |
| 15 | 965505020 (A1509A)   | 64  | Roller cover                   |
| 16 | 965505030 (A1510A)   | 12  | Out-feed/ in-feed roller       |
| 17 | 965505040 (A1514A)   | 8   | Frame long roller              |
| 18 | 965505050 (A1513A)   | 8   | Frame long roller shaft        |
| 19 | 965505060 (A1512A)   | 12  | Frame short roller             |
| 20 | 965505070 (A1511A)   | 12  | Frame short roller shaft       |
| 21 | 965505080 (FD001A-1) | 1   | R pin100                       |
| 22 | 965505081 (FD001A-2) | 2   | R pin 170                      |
| 23 | 965580000 (A1503A)   | 4   | Leg post                       |
| 24 | 965580010 (A1502A)   | 4   | Leg bracket                    |
| 25 | 965580020 (A1101A)   | 1   | Frame                          |
| 26 | 965580030            | 1   | Bottom tape head support       |
| 27 | GBT70D3-LD-M4x6      | 8   | screw                          |
| 28 | GBT70D1-LD-M6x16     | 8   | screw                          |
| 29 | GBT5783-LS-M6X20     | 40  | bolt                           |
| 30 | GBT818-LD-M4x6       | 2   | screw                          |
| 31 | GBT818-LD-M4x16      | 4   | screw                          |
| 32 | GBT818-LD-M4x30      | 2   | screw                          |
| 33 | GBT818-LD-M5x16      | 2   | screw                          |
| 34 | GBT818-LD-M6x50      | 2   | screw                          |
| 35 | GBT6170-LM-M16       | 4   | Nut                            |
| 36 | GBT6170-LM-M4        | 6   | Nut                            |
| 37 | GBT6170-LM-M6        | 4   | Nut                            |
| 38 | GBT6170-LM-M8        | 16  | Nut                            |
| 39 | GBT97D1-QP-4         | 5   | washer                         |
| 40 | GBT97D1-QP-6         | 54  | Washer                         |
| 41 | GBT97D1-QP-8         | 16  | washer                         |
| 42 | GBT93-QT-6           | 48  | washer                         |
| 43 | GBT93-QT-8           | 16  | washer                         |
| 44 | GBT6170-LM-M5        | 2   | nut                            |
| 45 | GBT93-QT-5           | 2   | washer                         |
| 46 | GBT97D1-QP-5         | 4   | Plain washer                   |
|    |                      |     |                                |



6.2 Tower



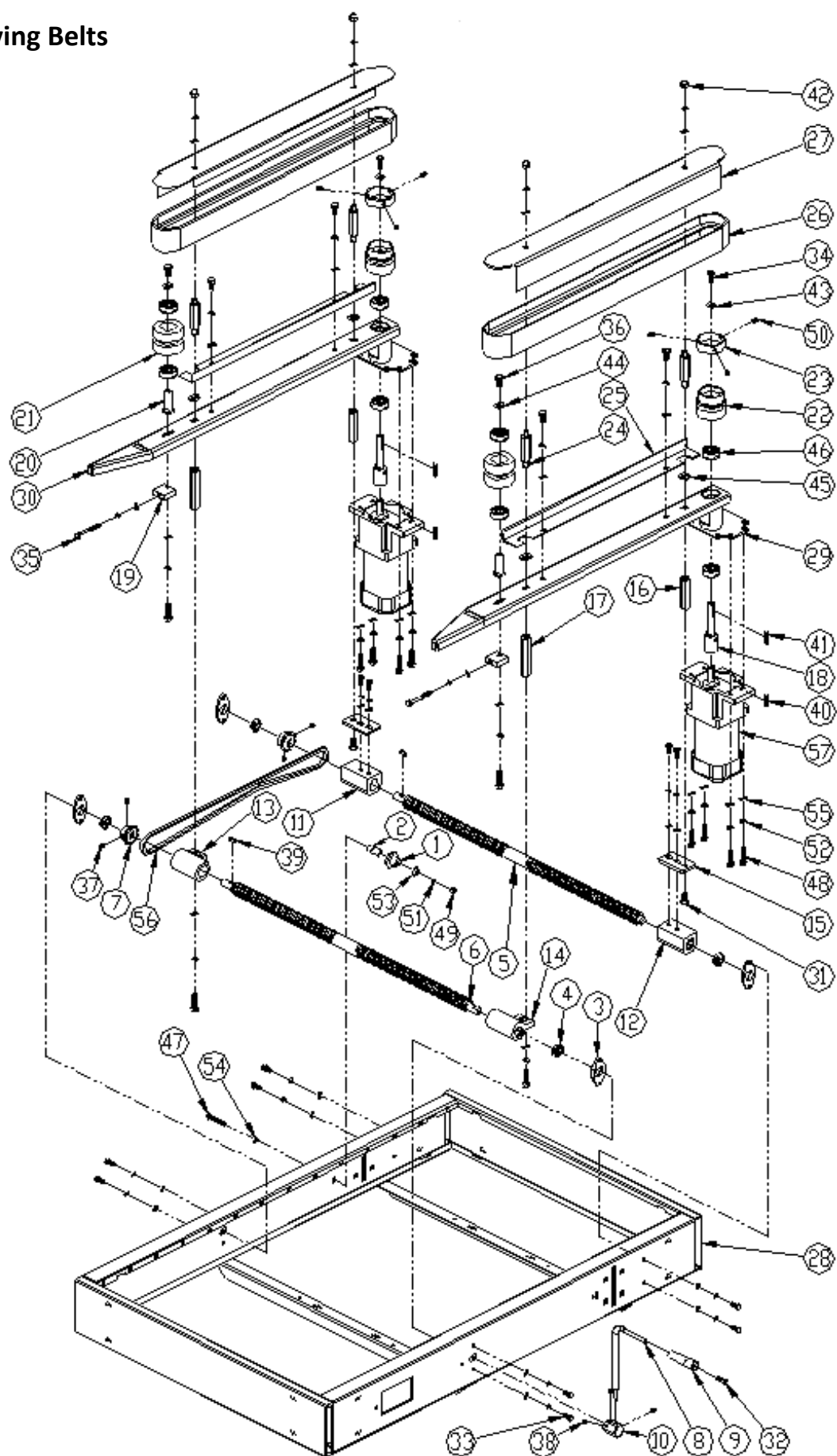


## 6.2 Tower parts list

| NO | Part NO              | QTY | Description                 |
|----|----------------------|-----|-----------------------------|
| 1  | 975580020 (A1101A)   | 1   | Frame                       |
| 2  | 965501140            | 1   | Roller                      |
| 3  | 965501150            | 1   | Roller shaft                |
| 4  | 965501180 (SJ816F)   | 8   | Frame screw                 |
| 5  | 965502010            | 2   | Sleeve                      |
| 6  | 965502050 (A1516A-1) | 2   | Crank                       |
| 7  | 965502060 (A1517A)   | 2   | Crank handle                |
| 8  | 965502070            | 2   | Crank fix house             |
| 9  | 965503000            | 4   | Nut holder                  |
| 10 | 965503010 (A2505B)   | 2   | Spindle support             |
| 11 | 965503050 (A2503C)   | 4   | Screw holder                |
| 12 | 965503060            | 2   | Brass house                 |
| 13 | 965503070 (CB001N)   | 2   | Tower China wheel RS35 Z=10 |
| 14 | 975502180            | 2   | Top frame support           |
| 15 | 975502191            | 1   | Left top frame plate        |
| 16 | 975502192            | 1   | Right top frame plate       |
| 17 | 975504040 (B2504A)   | 2   | Tower screw                 |
| 18 | 975504100 (B2507A)   | 1   | Chain wheel cover           |
| 19 | 975504120 (B2506A)   | 2   | Tower top cover             |
| 20 | 975580121 (B2501A)   | 1   | Left tower                  |
| 21 | 975580122 (B2501A-1) | 1   | Right tower                 |
| 22 | GBT70D1-LD-M6x16     | 2   | bolt                        |
| 23 | GBT5783-LS-M8x30     | 4   | Bolt                        |
| 24 | GBT77-LD-M5x6        | 4   | Bolt                        |
| 25 | GBT77-LD-M6x6        | 4   | Bolt                        |
| 26 | GBT77-LD-M6x10       | 2   | bolt                        |
| 27 | GBT1069-J-4x20       | 2   | Key                         |
| 28 | GBT6170-LM-M8        | 12  | Nut                         |
| 29 | GBT97D1-QP-8         | 16  | ring                        |
| 30 | GBT93-QT-8           | 12  | washer                      |
| 31 | GBT5783-LS-M6X12     | 12  | Bolt                        |
| 32 | GBT5783-LS-M6X16     | 16  | Bolt                        |
| 33 | GBT5783-LS-M6X20     | 4   | Bolt                        |
| 34 | GBT5783-LS-M6X45     | 1   | Bolt                        |
| 35 | GBT6170-LM-M6        | 13  | Nut                         |
| 36 | GBT93-QP-6           | 41  | Plain washer                |
| 37 | GBT96-QP-6           | 5   | Plain washer                |
| 38 | GBT97D1-QT-6         | 33  | Spring washer               |
| 39 | RS35-156             | 1   | Chain RS35-156              |



### 6.3 Driving Belts





### 6.3 Driving belts parts list:

| No | Part NO              | QTY | description                        |
|----|----------------------|-----|------------------------------------|
| 1  | 965501140            | 1   | Nylon roller                       |
| 2  | 965501150            | 1   | Nylon roller shaft                 |
| 3  | 965502000 (A3514A)   | 4   | Screw bolt fixed block             |
| 4  | 965502010            | 4   | BUSHING                            |
| 5  | 965502020 (A3515A)   | 1   | Right screw                        |
| 6  | 965502030 (A3521A)   | 1   | Left screw                         |
| 7  | 965502040 (CB002N)   | 2   | Chain wheel RS35 Z=12              |
| 8  | 965502050 (A1516A-1) | 1   | Crank                              |
| 9  | 965502060 (A1517A)   | 1   | Crank handle                       |
| 10 | 965502070            | 1   | Handle fixed set                   |
| 11 | 965502080 (A3530B)   | 1   | Right adjusted nut(right handed)   |
| 12 | 965502081 (A3528B)   | 1   | Right adjusted nut(left handed)    |
| 13 | 965502090 (A3529B)   | 1   | left adjusted nut ( right handed ) |
| 14 | 965502091 (A3513B)   | 1   | left adjusted nut ( left handed )  |
| 15 | 965502100 (A3511B)   | 2   | Right bottom pillar                |
| 16 | 965502110            | 2   | Right pillar                       |
| 17 | 965502120 (A3512B)   | 2   | Left pillar                        |
| 18 | 965502180 (A3510A)   | 2   | motor shaft                        |
| 19 | 965502200 (A3518A)   | 2   | Tension adjusting plate            |
| 20 | 965502220 (A3517A)   | 2   | Rear driving roller shaft          |
| 21 | 965502230 (A3516A)   | 2   | Rear driving roller                |
| 22 | 965502240 (A3504A)   | 2   | Main driving roller                |
| 23 | 965502250            | 2   | Main driving roller sleeve         |
| 24 | 965502260 (A3507B)   | 4   | Cover support                      |
| 25 | 965502270 (A3527A)   | 2   | Belt side plate                    |
| 26 | 965502280 (RA004H)   | 2   | Belt                               |
| 27 | 965502290 (A3501A)   | 2   | Belt cover                         |
| 28 | 965580020 (A1101A)   | 1   | Machine body frame                 |
| 29 | 965580040 (A3524A)   | 1   | Left motor base                    |
| 30 | 965580042 (A3509A)   | 1   | Right motor base                   |
| 31 | GBT70D3-LD-M8x20     | 2   | bolt                               |
| 32 | GBT70D1-LD-M6x16     | 1   | bolt                               |
| 33 | GBT5783-LS-M6x16     | 12  | bolt                               |
| 34 | GBT5783-LS-M6x20     | 2   | bolt                               |
| 35 | GBT5783-LS-M6x60     | 2   | bolt                               |
| 36 | GBT5783-LS-M8x16     | 6   | bolt                               |
| 37 | GBT77-LD-M5x8        | 4   | bolt                               |
| 38 | GBT77-LD-M6x6        | 2   | bolt                               |
| 39 | GBT1096-J-5x16       | 2   | Key                                |

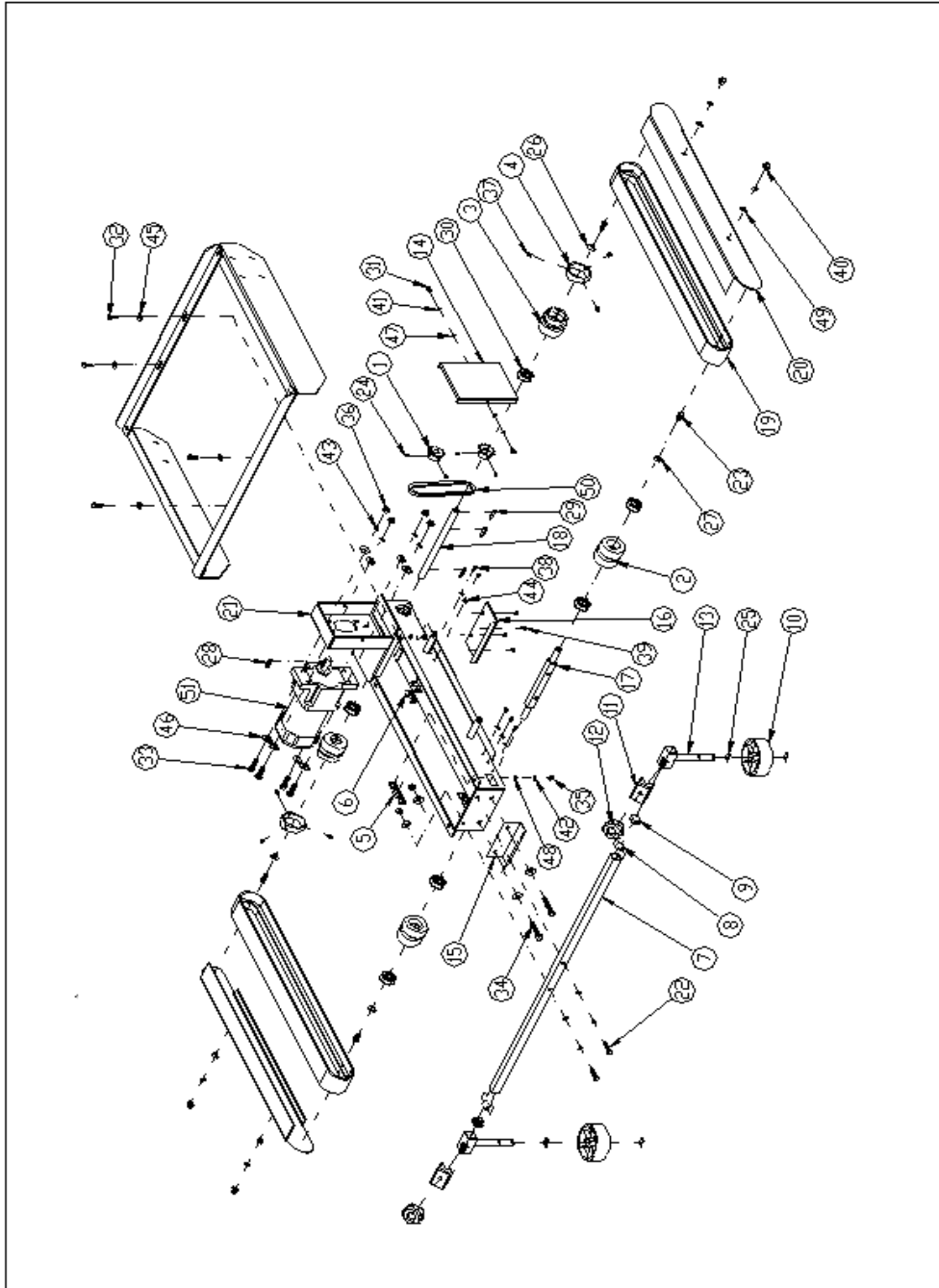


### 6.3 Driving belts parts list:

| No | Part No          | QTY | description    |
|----|------------------|-----|----------------|
| 40 | GBT1096-J-5x25   | 2   | Key            |
| 41 | GBT1096-J-5x28   | 2   | key            |
| 42 | GBT923-LM-M8     | 4   | nut            |
| 43 | OQDP-6-20        | 2   | washer         |
| 44 | OQDP-8-20        | 2   | washer         |
| 45 | OGBT97D1-QP-12   | 4   | washer         |
| 46 | GBT276-ZC-6202ZE | 8   | bearing        |
| 47 | GBT5783-LS-M6x45 | 1   | bolt           |
| 48 | GBT5783-LS-M8x30 | 12  | bolt           |
| 49 | GBT6170-LM-M6    | 1   | nut            |
| 50 | GBT77-LD-M6x10   | 7   | bolt           |
| 51 | GBT93-QT-6       | 15  | Washer         |
| 52 | GBT93-QT-8       | 20  | washer         |
| 53 | GBT96-QD-6       | 1   | Plain washer   |
| 54 | GBT97D1-QP-6     | 15  | Plain washer   |
| 55 | GBT97D1-QP-8     | 20  | Plain washer   |
| 56 | RS35-115         | 1   | Chain RS35-115 |
| 57 | MDG-120          | 2   | Motor          |



## 6.4 Driving Parts - Top Drive





## 6.4 Driving Parts - Top Drive

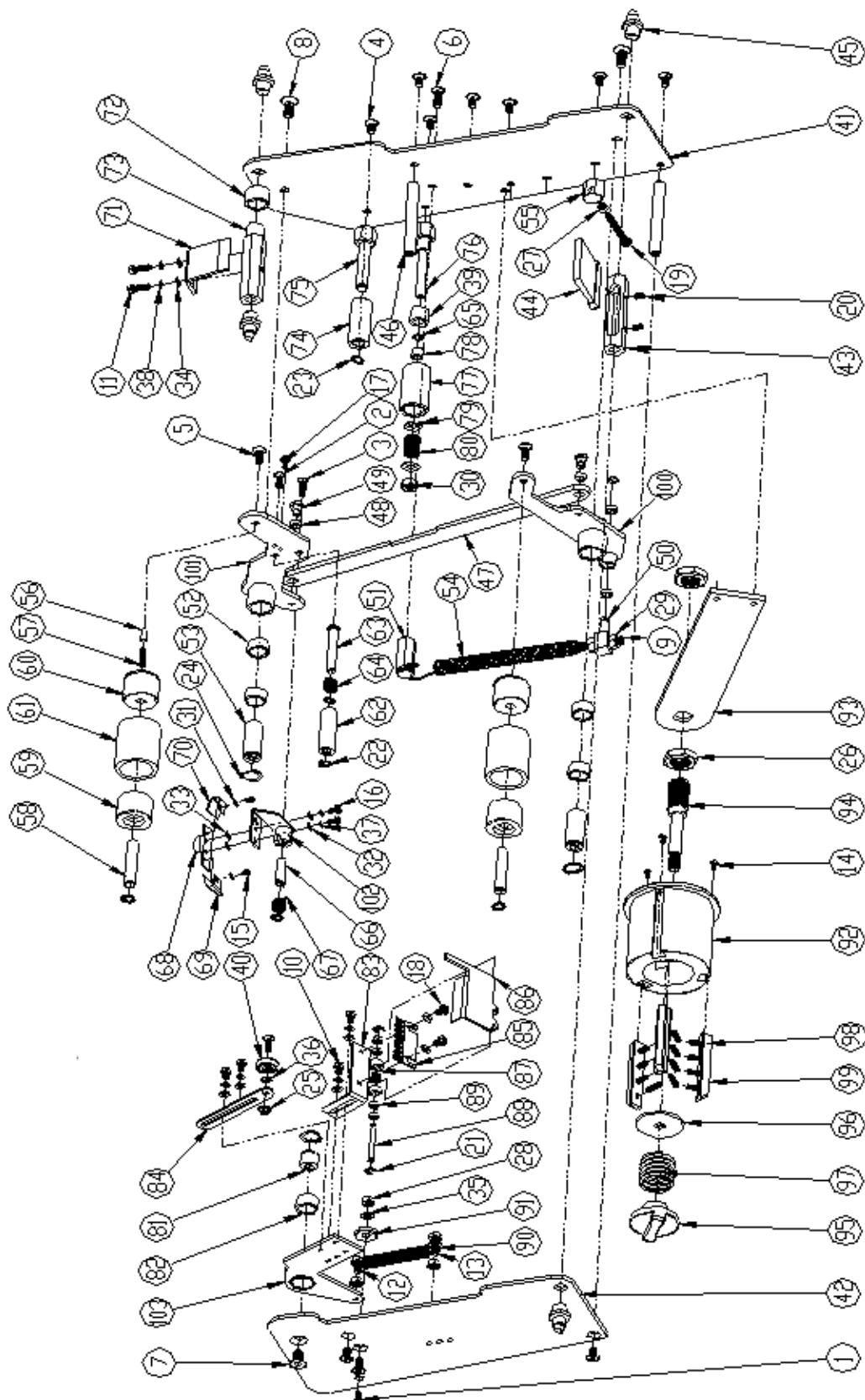
| No | Part No             | QTY | Description                       |
|----|---------------------|-----|-----------------------------------|
| 1  | 965502040 (CB004H)  | 2   | Chain wheel RS35 Z=12             |
| 2  | 965502230 (A3516A)  | 2   | Rear driving roller               |
| 3  | 965502240 (A3504A)  | 2   | Main driving roller               |
| 4  | 965502250           | 2   | Main driving roller sleeve        |
| 5  | 965504061           | 2   | Top tape head fix plate 1         |
| 6  | 965504062           | 2   | Top tape head fix plate 2         |
| 7  | 965504070 (A2510A)  | 1   | Compression roller support        |
| 8  | 965504080 (A2516A)  | 2   | Side roller guide rod iron washer |
| 9  | 965504090 (A2511A)  | 2   | Side roller guide rod bushing     |
| 10 | 965504120 (A2515A)  | 2   | Compression roller                |
| 11 | 965504130 (A2513A)  | 2   | Compression roller block          |
| 12 | 965504140 (A2512A)  | 2   | Handle pressed screw              |
| 13 | 965580080 (A2514A)  | 2   | welding parts side bar            |
| 14 | 975502080 (B3501A)  | 1   | Motor cover                       |
| 15 | 975502150 (B3511A)  | 1   | Top guide plate                   |
| 16 | 975502160 (B3510A)  | 1   | Top cover                         |
| 17 | 975503000 (B3505A)  | 1   | Drive Pulley shaft                |
| 18 | 975503010 (B3507A)  | 1   | Follow Pulley shaft               |
| 19 | 975503070 (RA003H)  | 2   | Belt                              |
| 20 | 975503090 (N23508B) | 2   | Top belt cover                    |
| 21 | 975580080 (B3509A)  | 1   | 120W Motor base                   |
| 22 | GBT5783-LS-M6x30    | 2   | Bolt                              |
| 23 | GBT5783-LS-M8x16    | 2   | Bolt                              |
| 24 | GBT77-LD-M5x8       | 4   | Screw                             |
| 25 | GBT894.1-DQ-17      | 4   | ring                              |
| 26 | 0QDP-6-20           | 2   | washer                            |
| 27 | 0QDP-8-20           | 2   | washer                            |
| 28 | GBT1096-J-5X25      | 1   | Key                               |
| 29 | GBT1096-J-5X28      | 3   | Key                               |
| 30 | GBT276-ZC-6202ZE    | 6   | Bearing                           |
| 31 | GBT5783-LS-M5X10    | 2   | Bolt                              |
| 32 | GBT5783-LS-M6X20    | 6   | Bolt                              |
| 33 | GBT5783-LS-M8X30    | 4   | Bolt                              |
| 34 | GBT5783-LS-M8X50    | 2   | Bolt                              |
| 35 | GBT6170-LM-M6       | 4   | Nut                               |
| 36 | GBT6170-LM-M8       | 6   | Nut                               |
| 37 | GBT77-LD-M6X10      | 6   | screw                             |
| 38 | GBT818-LD-M4X8      | 10  | screw                             |
| 39 | GBT819-LD-M4X8      | 4   | screw                             |



| No | Part No      | QTY | Description   |
|----|--------------|-----|---------------|
| 40 | GBT923-LM-M8 | 4   | Nut           |
| 41 | GBT93-QT-5   | 2   | washer        |
| 42 | GBT93-QT-6   | 6   | washer        |
| 43 | GBT93-QT-8   | 8   | washer        |
| 44 | GBT96-QD-4   | 10  | Plain washer  |
| 45 | GBT96-QD-6   | 4   | Plain washer  |
| 46 | GBT96-QD-8   | 12  | Plain washer  |
| 47 | GBT97D1-QP-5 | 2   | Plain washer  |
| 48 | GBT97D1-QP-6 | 6   | Plain washer  |
| 49 | GBT97D1-QP-8 | 4   | Plain washer  |
| 50 | RS35-41      | 1   | Chain RS35-41 |
| 51 | MDG-120      | 1   | Motor         |



## 6.5 Tape head





## 6.5 Tape head parts

| No | Part No                | QTY | Description           |
|----|------------------------|-----|-----------------------|
| 1  | GBT70D3-LD-M4*12       | 1   | Nut                   |
| 2  | GBT70D3-LD-M5*16       | 2   | Nut                   |
| 3  | GBT70D3-LD-M5*20       | 1   | Nut                   |
| 4  | GBT70D3-LD-M6*12       | 9   | Nut                   |
| 5  | GBT70D3-LD-M6*16       | 3   | Nut                   |
| 6  | GBT70D3-LD-M6*20       | 1   | Nut                   |
| 7  | GBT70D3-LD-M8*16       | 1   | Nut                   |
| 8  | GBT70D3-LD-M8*20       | 2   | Nut                   |
| 9  | GBT70D1-LD-M8*50       | 1   | Nut                   |
| 10 | GBT5783-LS-M5*8        | 4   | Nut                   |
| 11 | GBT5783-LS-M5*16       | 2   | Nut                   |
| 12 | GBT5783-LS-M6*12       | 1   | Nut                   |
| 13 | GBT5783-LS-M6*20       | 1   | Nut                   |
| 14 | GB/T 9074.18 ST3.5×9.5 | 3   | Nut                   |
| 15 | GBT818-LD-M3*5         | 2   | Nut                   |
| 16 | GBT818-LD-M4*8         | 2   | Nut                   |
| 17 | GBT818-LD-M4*10        | 1   | Nut                   |
| 18 | GBT818-LD-M5*8         | 2   | Nut                   |
| 19 | GBT818-LD-M5*50        | 1   | Nut                   |
| 20 | GBT77-LD-M5*8          | 2   | Nut                   |
| 21 | ETW-5                  | 2   | Washer                |
| 22 | GBT894D1-DQ-8          | 3   | Washer                |
| 23 | GBT894D1-DQ-10         | 3   | Washer                |
| 24 | GBT894D1-DQ-16         | 3   | Washer                |
| 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 direction bearing |



| NO | Part No          | QTY | Description                        |
|----|------------------|-----|------------------------------------|
| 40 | GBT276-ZC-635ZZ  | 1   | Bearing                            |
| 41 | BT201 (TH422A)   | 1   | Left plate                         |
| 42 | BT202 (TH411A)   | 1   | Right plate                        |
| 43 | BT203 (TH419A)   | 1   | Brush pillar                       |
| 44 | BT204 (TH420B)   | 1   | Brush                              |
| 45 | BT205 (TH421A)   | 4   | Brush support screw                |
| 46 | BT206 (TH412A)   | 2   | Pillar                             |
| 47 | BT207 (TH440A)   | 1   | Connection bar                     |
| 48 | BT208            | 4   | sleeve                             |
| 49 | BT209 (SJ010F)   | 2   | Connection bar screw               |
| 50 | BT211            | 1   | Extension spring after the column  |
| 51 | BT213            | 1   | Extension spring swing rod columns |
| 52 | BT215            | 4   | Fixed set of kit copper            |
| 53 | BT216 (TH439A)   | 2   | Fixed axis                         |
| 54 | BT217 (FB006C)   | 1   | Long extension spring              |
| 55 | BT220 (TH426A)   | 1   | Fixed block                        |
| 56 | BT221 (TH430)    | 1   | Fixed axis                         |
| 57 | BT222 (FA004A)   | 1   | Positioning spring                 |
| 58 | BT223 (TH433A)   | 2   | Rubber wheel                       |
| 59 | BT224 (TH452A)   | 2   | Tire                               |
| 60 | BT225 (TH452A)   | 2   | Positioning wheel                  |
| 61 | BT226 (TH431A)   | 2   | Rubber wheel sets                  |
| 62 | BT228 (TH429A)   | 1   | Former embosser round              |
| 63 | BT229 (TH428A)   | 1   | Former flower axle                 |
| 64 | BT230 (FA003A)   | 1   | Former flower axle spring          |
| 65 | BT231 (HC008S)   | 2   | Former flower axle washer          |
| 66 | BT232 (TH437A)   | 1   | Retaining shaft with stent         |
| 67 | BT234 (ED005A)   | 1   | Retaining shaft spring             |
| 68 | BT236 (TH434A)   | 1   | Cover fixed panels                 |
| 69 | BT237 (TH441A)   | 1   | Right tape holder                  |
| 70 | BT237-2 (TH435A) | 1   | Left tape holder                   |
| 71 | BT238 (TH408A)   | 1   | Guide plate                        |
| 72 | BT239            | 1   | Bar sets                           |
| 73 | BT240 (TH424A)   | 1   | Holding shaft                      |
| 74 | BT241 (TH405A)   | 1   | Roller                             |
| 75 | BT242 (TH404A)   | 1   | Roller shaft                       |
| 76 | BT243 (TH406A)   | 1   | Irreversible roller shaft          |
| 77 | BT244 (TH407A)   | 1   | Irreversible roller                |
| 78 | BT245            | 1   | Irreversible roller sleeve         |



| No  | Code           | QTY | Description                |
|-----|----------------|-----|----------------------------|
| 79  | BT246 (HS010S) | 2   | Irreversible roller washer |
| 80  | BT247 (FA010A) | 1   | Irreversible roller spring |
| 81  | BT251 (TH413A) | 1   | Blade support shaft        |
| 82  | BT252          | 1   | Blade support shaft sleeve |
| 83  | BT253 (TH423A) | 1   | Blade support              |
| 84  | BT254 (TH415A) | 1   | Blade arm adjustable bar   |
| 85  | BT255 (TH416A) | 1   | blade                      |
| 86  | BT256 (TH417A) | 1   | Blade cover                |
| 87  | BT257 (FD002A) | 1   | Twist spring               |
| 88  | BT258 (TH418A) | 1   | Blade cover shaft          |
| 89  | BT259          | 4   | Blade cover shaft sleeve   |
| 90  | BT260 (FB003A) | 1   | Spring                     |
| 91  | BT261 (TH410A) | 1   | Blade arm cushion          |
| 92  | BT263 (TH402A) | 1   | Tape fixed support         |
| 93  | BT264 (TH401A) | 1   | Tap head fix plate         |
| 94  | BT265 (TH403A) | 1   | Tap head fix shaft         |
| 95  | BT266 (NF010A) | 1   | Adjusting Knob             |
| 96  | BT268 (HA010B) | 1   | Keyed washer               |
| 97  | BT269 (FA001A) | 1   | Spring                     |
| 98  | BT270          | 12  | Compression plate spring   |
| 99  | BT271          | 3   | Compression plate          |
| 100 | BTH21 (TH438A) | 1   | Rear roller arm assly      |
| 101 | BTH22 (TH427A) | 1   | Front roller arm assly     |
| 102 | BTH23 (TH436A) | 1   | Tap support                |
| 103 | BTH24 (TH414A) | 1   | Blade arm                  |



## **7. Features**

- 1) Easy operation, easy maintenance, low noise
- 2) Rigid structure
- 3) Easy to adjust height and width
- 4) International standard, tool kit free with machine
- 5) Roller table could be disassembled.

## **8. Usage**

- 1) Hold tape by hands and install it onto the tape head (adhesive side is outward)  
refer to 2.6.1
- 2) Adjust height and width manually by cranks. Refer to 2.6.3
- 3) Press ON switch, machine is started
- 4) Close the flaps before sealing
- 5) Put box to the entrance

## **9. Maintenance**

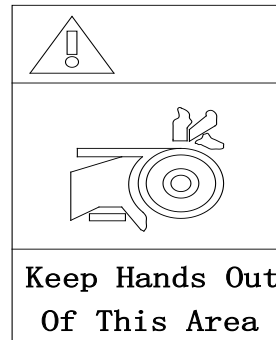
- 1) Lubricate:  
Once a month to oil the every moving parts by greasy
- 2) Inspection:  
Check all screws, nuts and belts once a month. If any loose, please fasten it.



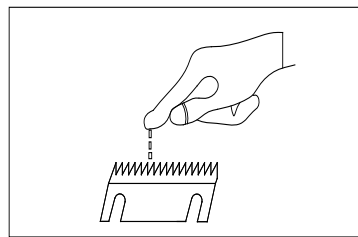
## 10. Precautions

### (1) Safety:

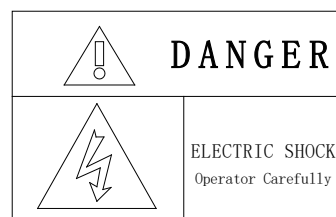
- a. Belts unit is moving parts, please don't touch when machine is running in case of any injury.



- b. Blade is very sharp, when serve the machine, please be careful.



- c. When checking machine, please cut off power.



### (2) Tape and box

- A. Deformed tape or long-stored tape is forbidden to use
- B. Please keep boxes dry (wet boxes are not allowed)