



Cleveland Equipment

CE-30 /CE-30F

Automatic Sealing Machine

Operation Manual



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Thank you for your purchase! This manual describes the basic structure, use method, and operational precautions to facilitate the safe and correct use of the machine and also improve the service life. Please read the manual carefully before using the machine.

The CE series sealing machine is used to seal various cartons using 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.

Safety Precautions

- Please read the instructions carefully before operating.
- Operator shall not place any spare parts around the machine while the machine is running.
- Please read the instructions carefully before conducting any repair and/or maintenance.
- Please turn off the power source and air source during the handling of tapes and normal maintenance or repair.

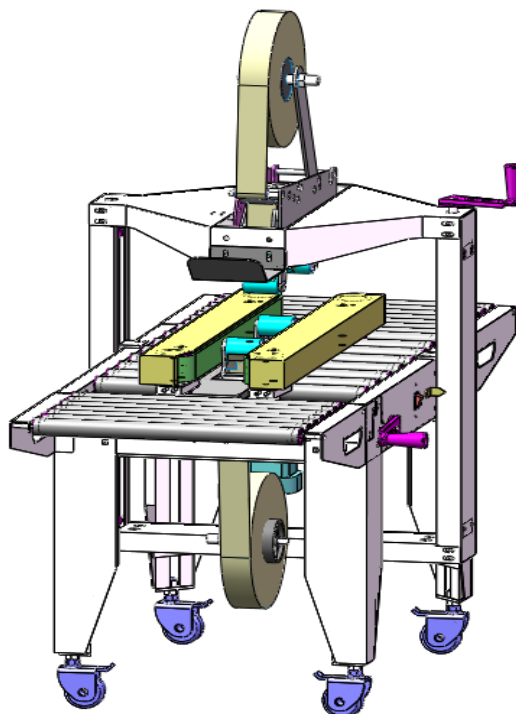


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1. Features of the Machine



This machine offers automatic sealing machine functions, stand-alone operation, economic and efficient, and is an ideal sealing machine. The main parameters are as follows:

Sealing width:	3.14" ~ 11.81"
Sealing height:	3.14" ~ 11.81"
Sealing length:	5.11" ~ ∞
Height of table board:	23.5" ~ 29.5" in.
Overall dimension:	28" L x 21" W x 59" H excluding front and rear roller racks)
Sealing speed:	about 20 cartons/min* (*the length of carton is less than 550)
Applicable power source:	1100v 60HZ
Applicable tape:	2"
Weight of machine:	199 lb



2. Machine Structure and Adjustment Description

(See Figure 1):

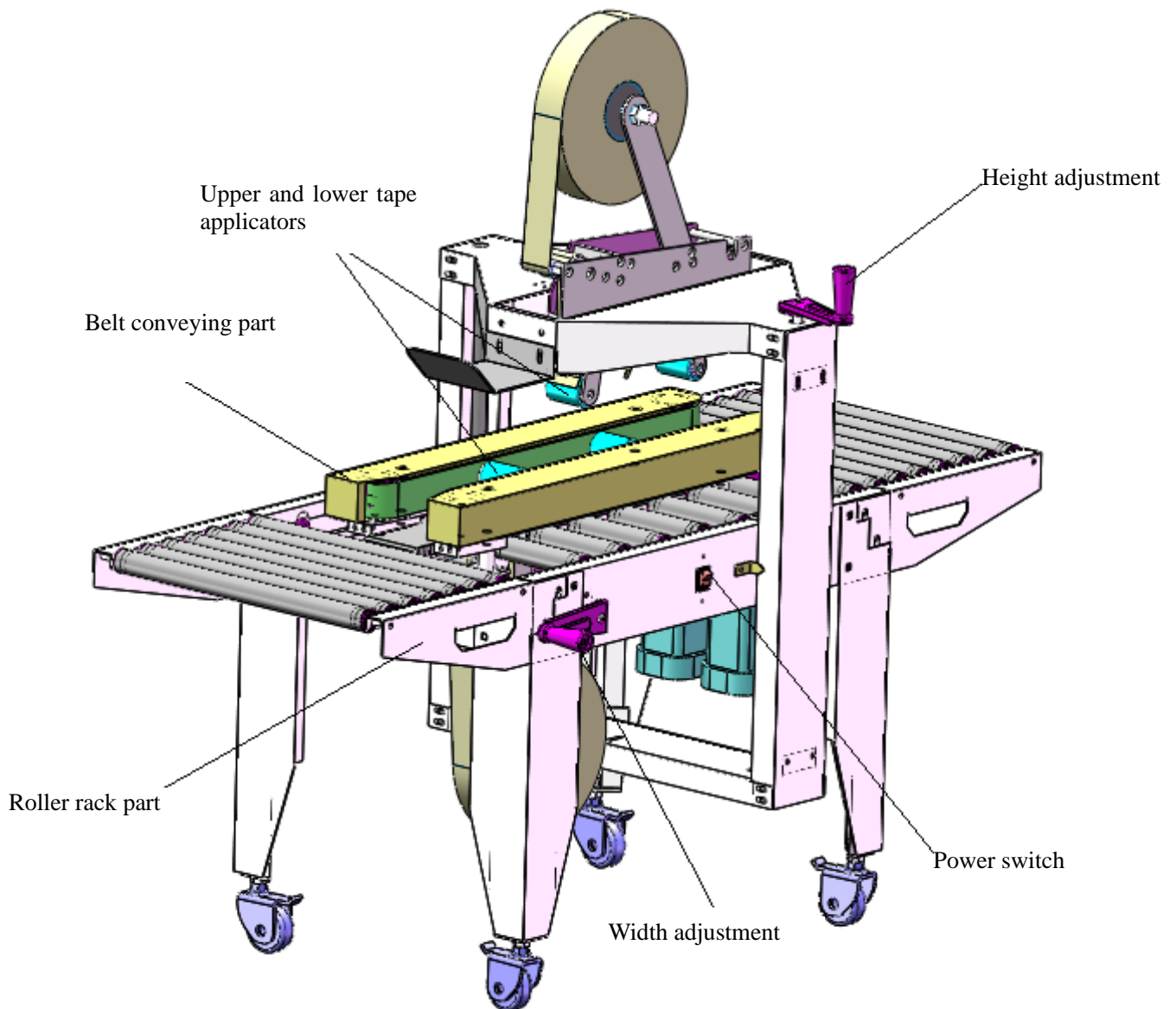


Figure 1



3. Operation Process of the Machine

3.1 Fold the top flaps of the packed carton manually, then feed the box into the sealing machine. Measure the width W and height H of the folded carton, adjust the width of the driving belt of the machine to the same as width W of the carton with the width adjusting handle and then adjust the upper bracket height of the machine to the same height H as the carton with the height adjusting handle. (See Figure 2):

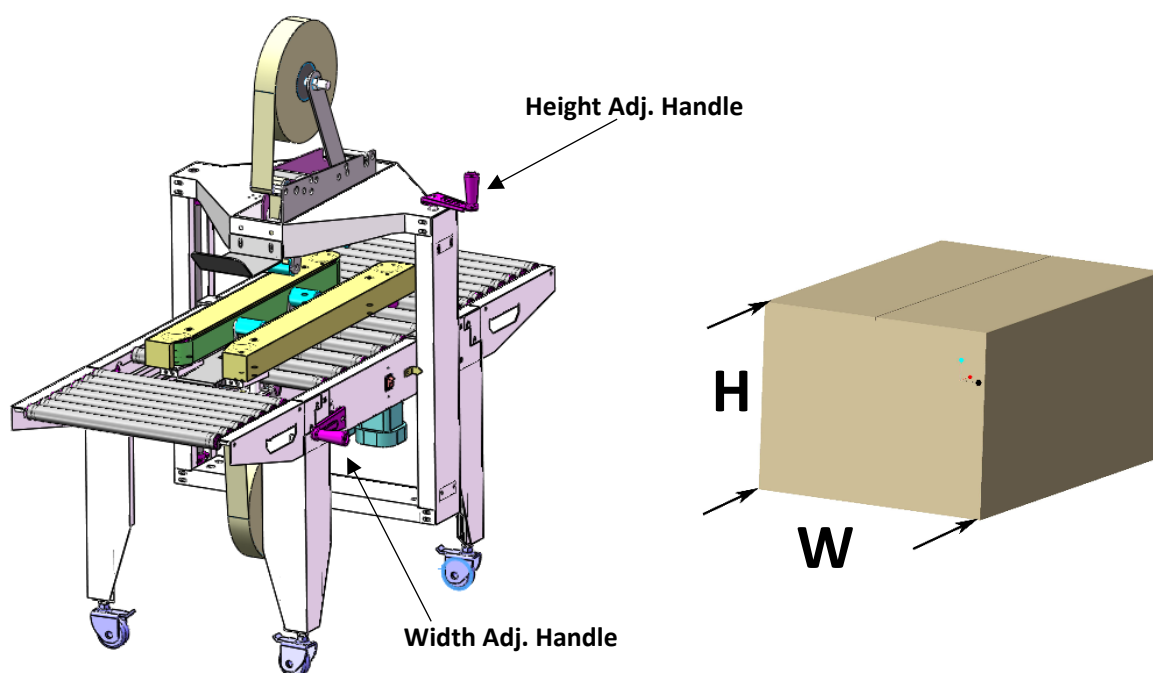
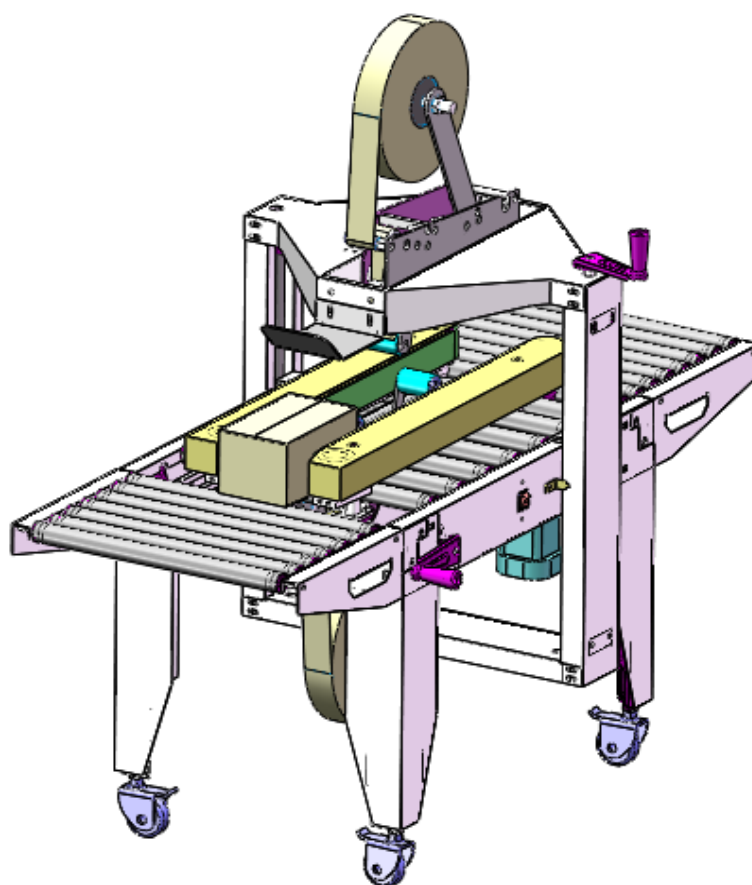


Figure 2



3.2 (See Figure 3): Turn on the power switch of the machine, feed the folded cartons into the sealing machine one by one to test fitting. Then complete upper and lower tape head of the cartons being driven on the driving belt.

Figure 3





4 Operation and Adjustment of Tape Head

4.1 First, put the new tape roll onto the tape mandrel, as shown in the figure. Next, pull out the tape to bypass the knurled rotary sleeve and then bypass the shaft sleeve along the line. Lastly, bypass the knurled rotary shaft and pass the tape through the black inner sleeve and go out, as shown in the figure below. During the whole process, make sure the adhesive face of the tape is outward. (See Figure 4):

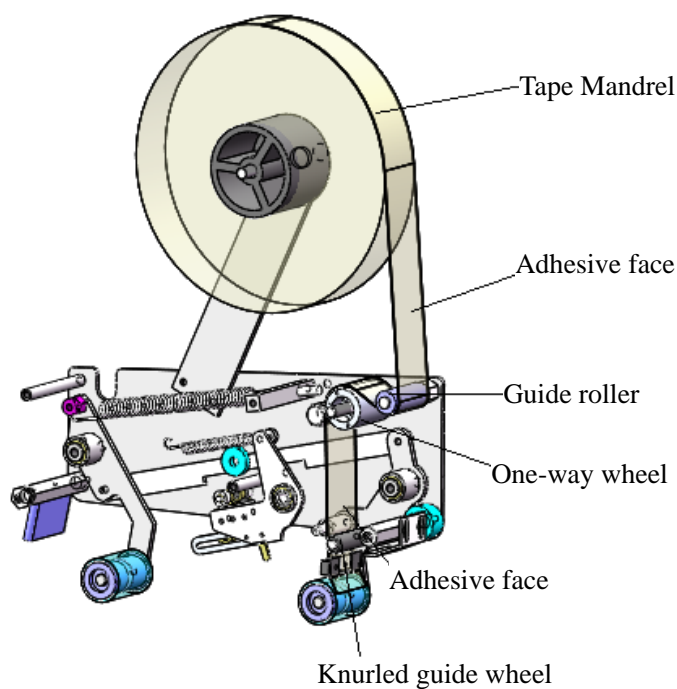


Figure 4



4.2 Threading diagram

(see Figure 5):

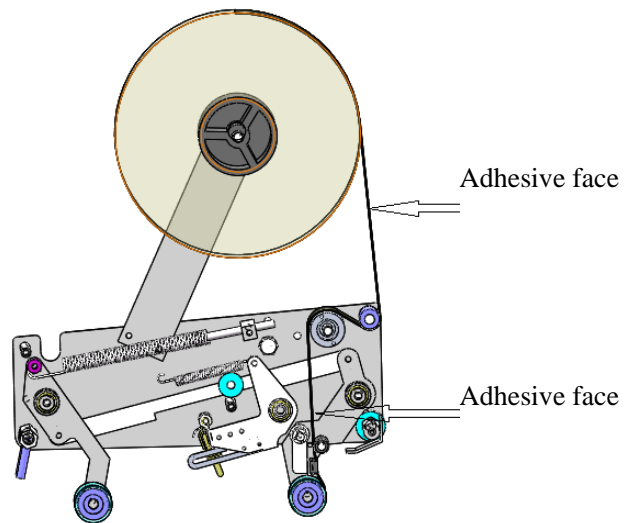


Figure 5



4.3 Adjustment of tape location

(see Figure 6):

If the tape is not on the center line of the carton, please adjust according to the figure below. Loosen the M18 nut, then turn the locking screw to adjust the tape location.

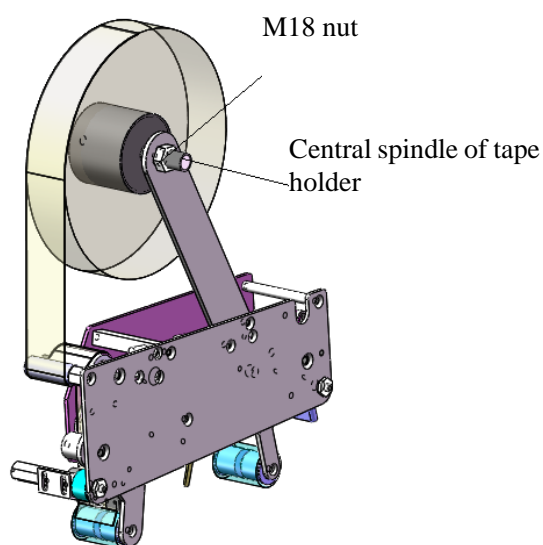


Figure 6



4.4 Adjustment of tape tension

(see Figure 7):

Adjust the front and rear locations of the fixed axle, as shown in the figure. Tighten or loosen the long spring of the swing rod to control the tension that the rollers are exerting.

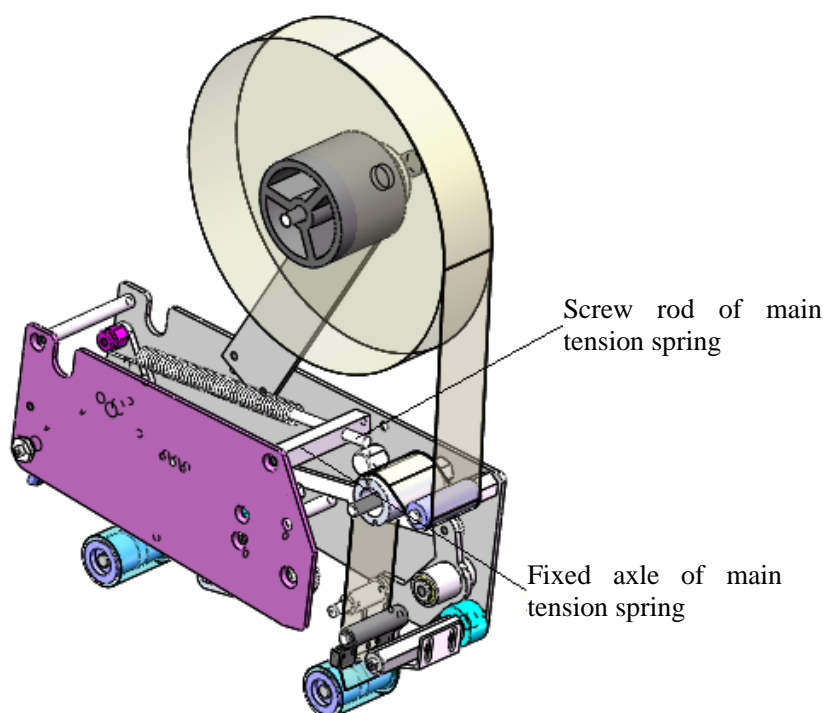


Figure 7



Troubleshooting Guide

Abnormalities	Causes	Removal method
Tape cannot be cut off.	The blade is not sharp or the tape film jams at the point of cutting.	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 head 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 and the rebounding speed of the rear wheel cannot fit the belt speed.	Fasten the main tension spring screws
The carton gets stuck and cannot move when arriving at the middle of the machine.	The main tension spring is too tight and the front wheel gets stuck in the middle.	Loosen the main tension spring of the tape pulley.
The tape is likely to drop out.	The one-way roller is defective.	Replace the 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 head, as shown in Figure 7.



5. Circuit Diagram

(see Figure 8):

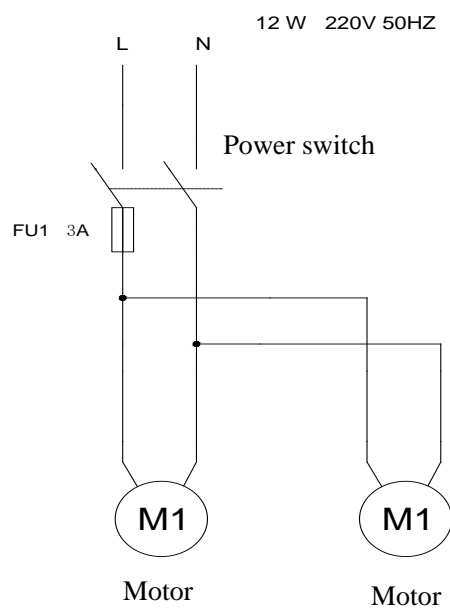


Figure 8



6. Exploded View

6.1 Machine body

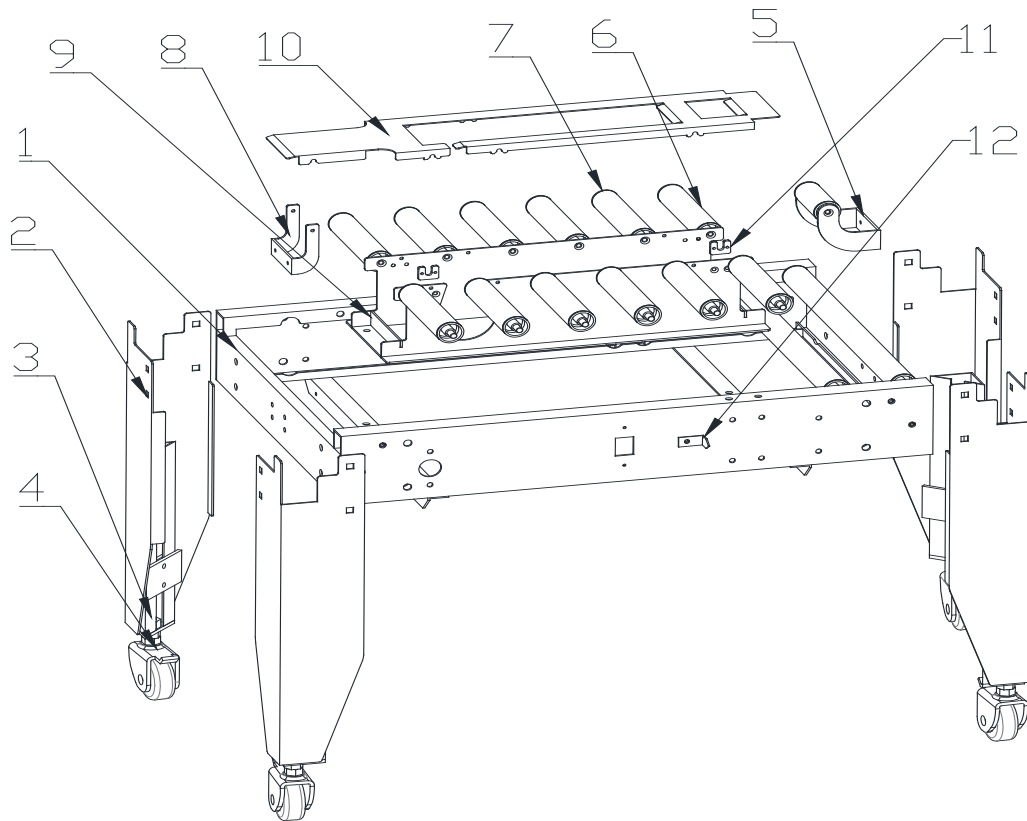














Figure 9



Parts List

S/N	Graph	Model	Name	Quantity
1		GPA30-151-0	Frame	1
2		GPA30-154-0	Undercarriage	4
3		GPA30-155-0	Adjusting undercarriage	4
4		GPA30- caster 4 cun (cun: a Chinese length unit)	Casters	1
5		GPA30-152	Rear short roller rack	1
6		GPA30-104	φ32*83 roller	12
7		GPA30-142	Roller wheel	28
8		GPA30-158	Small support plate	1
9		GPA30-156-0	Lower cutter rack	1
10		GPA30-159	Lower mandrel cover plate	1
11		GPA30-TY- single U- shaped cleat	Single U-shaped cleat	4
12		GPA30-481	Pointer	1



6.2 Lifting parts

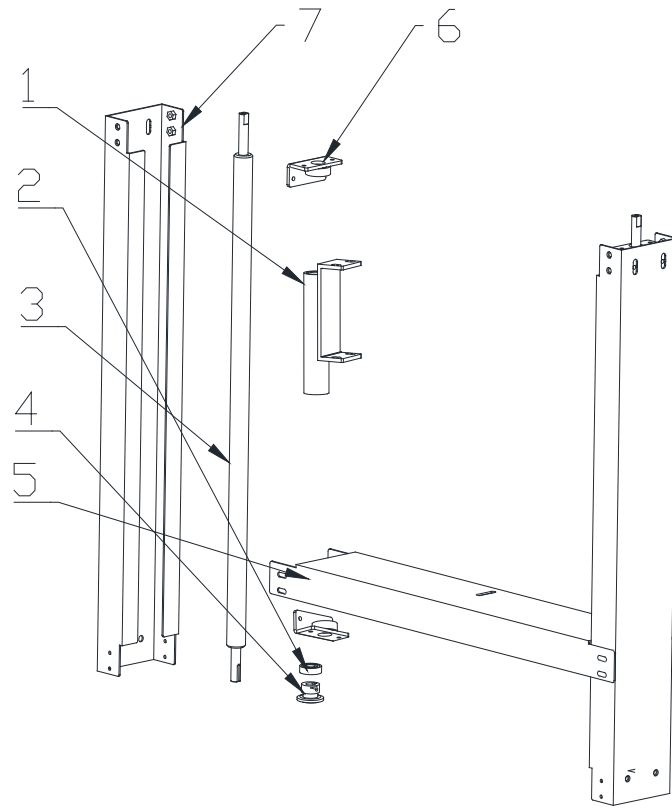









Figure 10



Parts List

S/N	Graph	Model	Name	Quantity
1		GPA30-456-0	Lifting threaded tube	2
2		GPA30- Bearing 6001	Bearing 6001	4
3		GPA30-402	Lifting threaded axle	2
4		GPA30-404	3/8-inch and 12-tooth chain wheel	2
5		GPA30-455	Chain cover	1
6		GPA30-406	Lifting bearing seat 1	2
7		GPA30-451	Pillar	2



6.3 Upper mandrel mounting rack

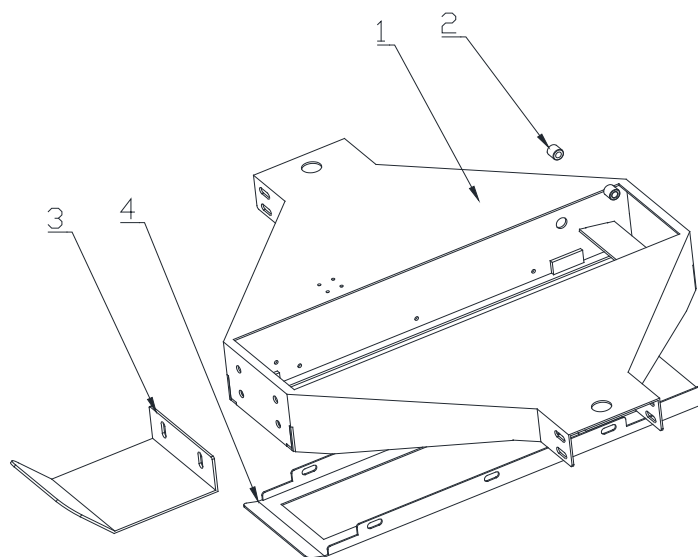






Figure 11

Parts List

S/N	Graph	Model	Name	Quantity
1		GPA30-453-0	Upper mandrel mounting rack	1
2		GPA30-403	Upper cutter rack mandrel fixed leg	2
3		GPA30-454	Upper cutter rack front guide plate	1
4		GPA30-457	Upper cutter rack lower blanking plate	1



6.4 Driving belt (See Figures 12 & 13):

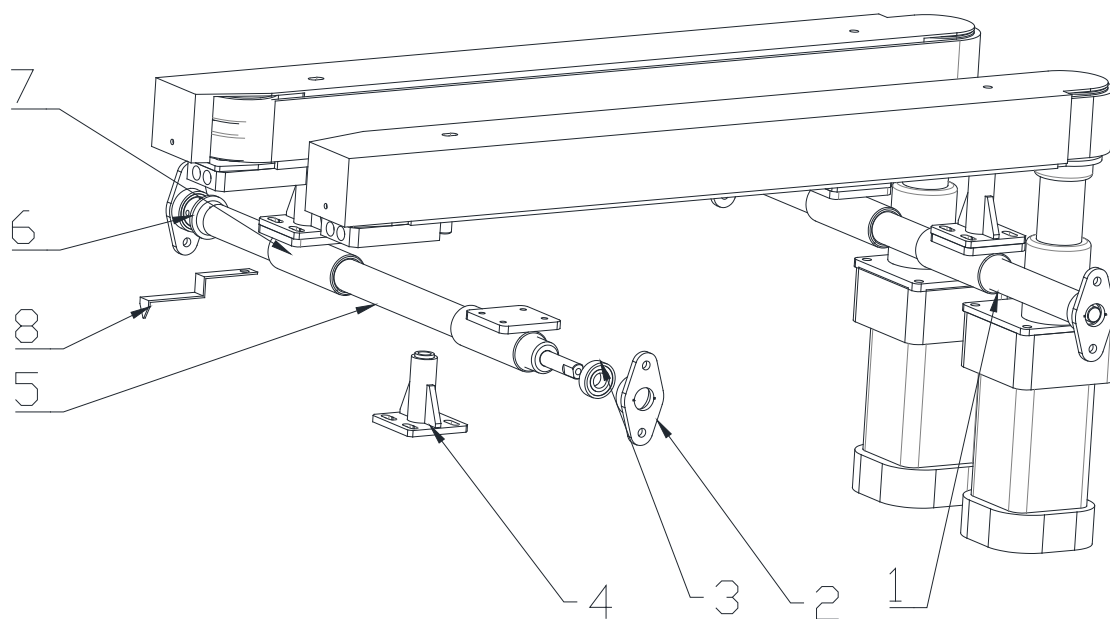


Figure 12

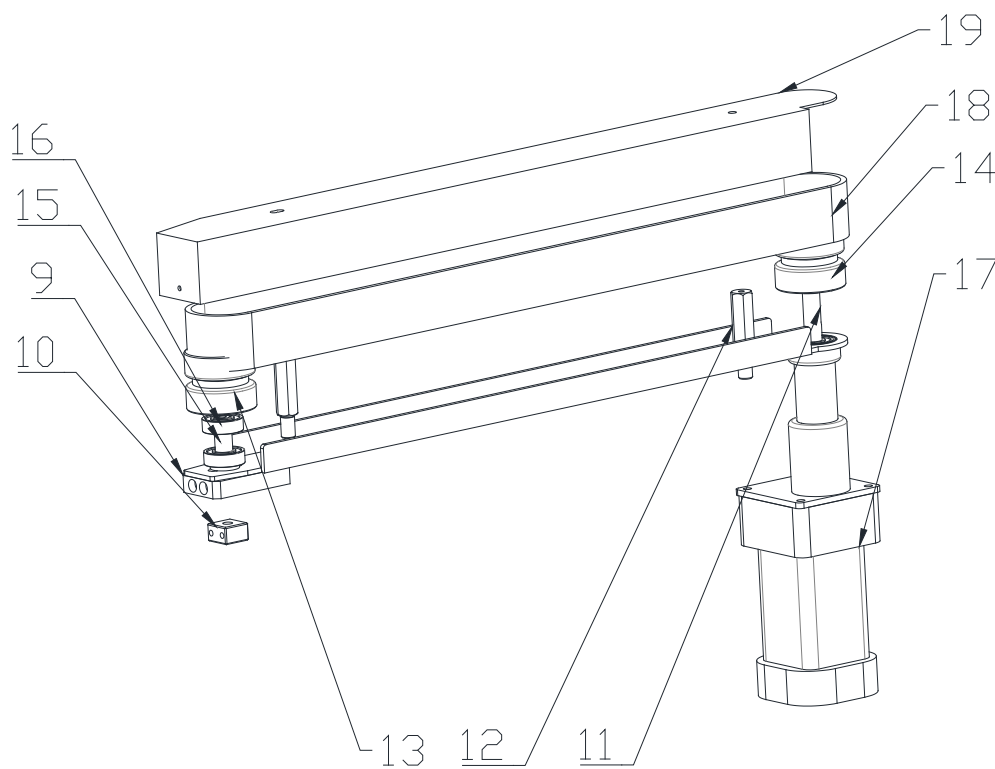


Figure 13



Parts List

S/N	Graph	Model	Name	Quantity
1		GPA30-201	Left and right threaded rods (rear)	1
2		GPA30-251-0	Rhombus bearing seat	4
3		GPA30- Bearing 6001	Bearing 6001	4
4		GPA30-253-0	Belt supporting seat	4
5		GPA30-202	Left and right threaded rods (front)	1
6		GPA30-404	3/8-inch and 12-tooth chain wheel	2
7		GPA30-252-0	Left and right threaded tube	4
8		GPA30-480	Left and right adjusting pointers	1
9		GPA30-254-0	Belt seat	1
10		GPA30-204	Belt adjusting block	1
11		GPA30-205	Driving shaft A	1
12		GPA30-206	Belt cover support pillar	2
13		GPA30-241	Driven wheel	1
14		GPA30-242	Driving wheel	1
15		GPA30-203	Driven shaft	1
16		GPA30- Bearing 6202	Bearing 6202	4
17		GPA30-VTV motor YN90-120-JB15G15	VTV motor	1
18		GPA30- Belt 1450Lx48wT5	Belt	1
19		GPA30-255	Belt cover	1



6.5 Tape sticker (see Figure 14):

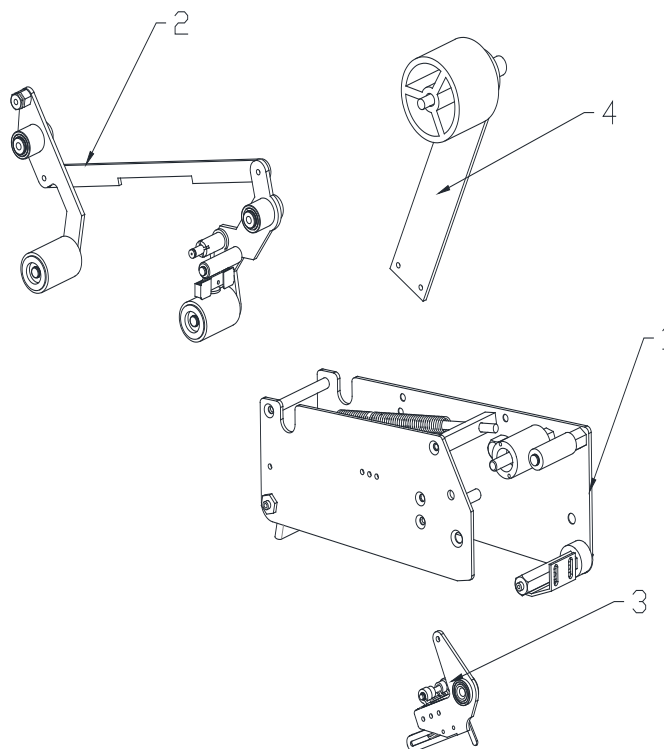


Figure 14

Parts List

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



6.5.1 The tape sticker mandrel rack (See Figure 15):

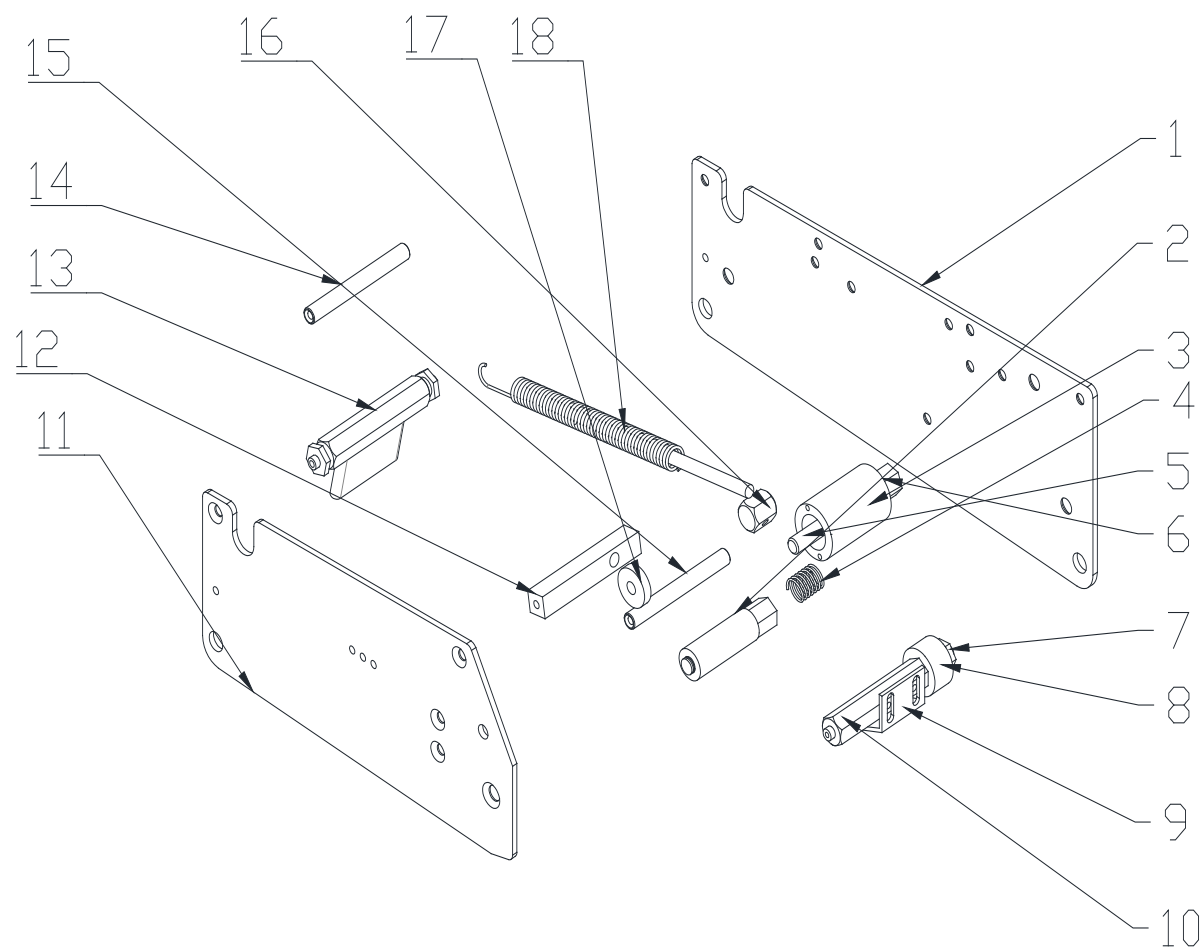
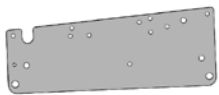






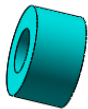


Figure 15



Parts List (see Figure 15)

S/N	Graph	Model	Name	Quantity	Remarks
1		GPA30 2-cun old mandrel - 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		dh-01-06	One-way wheel pressure spring	1	
5		GPA30 2-cun old mandrel - One-way small knurl wheel axle T2-03	One-way small knurl wheel axle of mandrel	1	
6		GPA30 2-cun old mandrel - One-way bearing T2-02	One-way bearing HF1616 of mandrel	1	
7		GPA30 2-cun old mandrel - Hexagonal threaded axle T2-21	Hexagonal threaded axle of mandrel	1	
8		GPA30 2-cun old mandrel - Mandrel catch wheel T3-22AG1	Mandrel catch wheel	1	
9		GPA30 2-cun old mandrel -	Mandrel front guide plate	1	



S/N	Graph	Model	Name	Quantity	Remarks
		Front guide plate T2-050A			
10		GPA30 2-cun old mandrel - Front pivot axle T2-006	Front pivot axle of mandrel	1	
11		GPA30 2-cun old mandrel - Right panel	Right panel of mandrel	1	
12		GPA30 2-cun old mandrel - Square locking axle of main tension spring	Square locking axle of main tension spring of mandrel	1	
13		GPA30 2-cun old mandrel - Brush set	Mandrel brush set	1	
14		GPA30 2-cun old mandrel - Panel locked axle	Mandrel panel locked axle	1	
15		GPA30 2-cun old mandrel - Panel locked axle	Mandrel panel locked axle	1	
16		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	
17		GPA30 2-cun old mandrel - Mandrel catch wheel T3-22BG1	Mandrel catch wheel	1	
18		GPA30 2-cun old mandrel - Tension spring	Mandrel tension spring	1	



6.5.2 The tape sticker swing arm (See Figure 16):

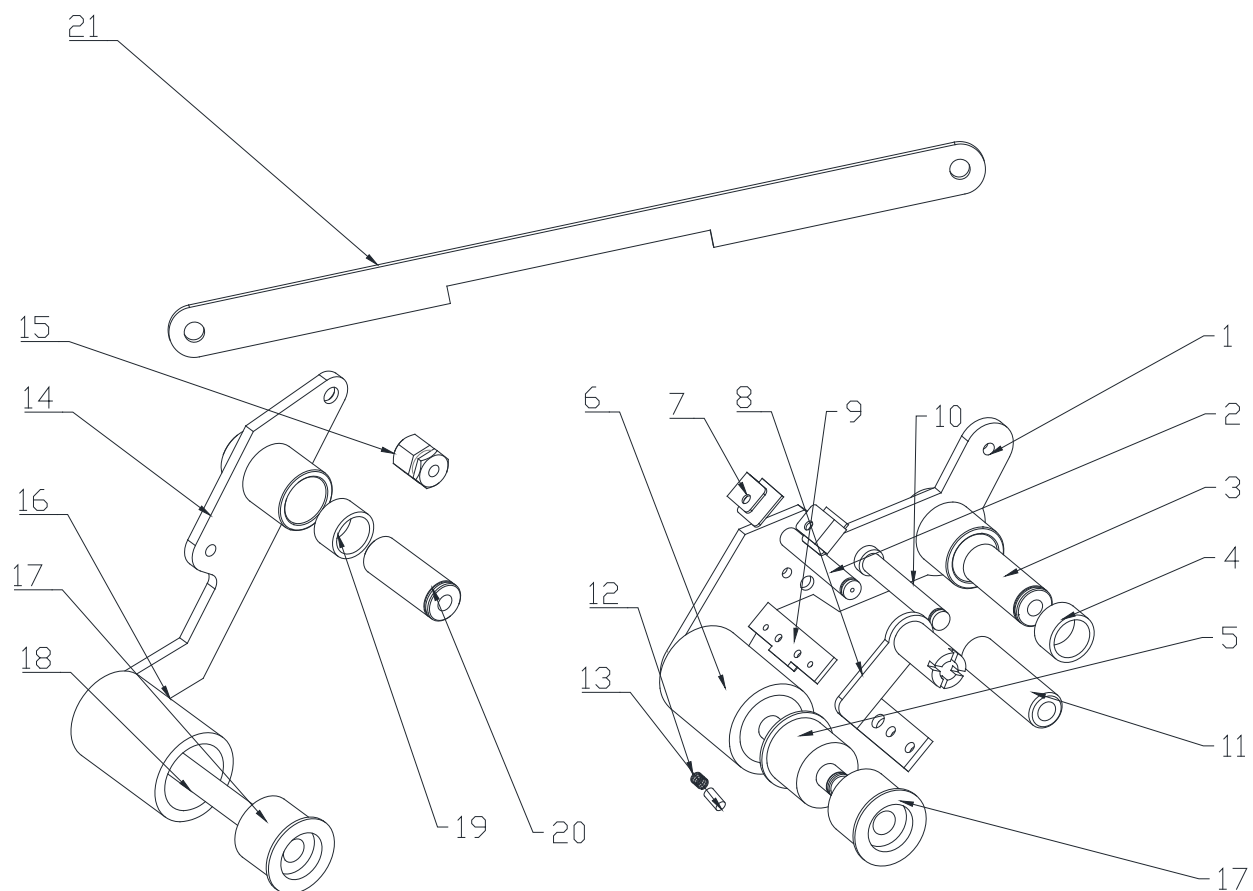










Figure 16



Parts List

S/N	Graph	Model	Name	Quantity
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 - Pored chock plug T2-28-2	Pored chock plug	1
6		GPA30 2-cun old mandrel - Black rubber FX02A-15	Front rubber wheel 2-cun	1
7		GPA30 2-cun old mandrel - Cleat (right) T2-27	Mandrel cleat	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 - Knurling guide wheel axle T2-04	Mandrel knurling guide wheel axle	1
11		GPA30 2-cun old mandrel - Knurling guide wheel T2-02	Mandrel knurl guide wheel	1
12		dh-01-09	Pressure spring	1
13		T2-28-4	Copper rod	1



S/N	Graph	Model	Name	Quantity
14		GPA30 T2 2-cun old mandrel - Rear swing arm assembly welding	Mandrel rear swing arm assembly welding	1
15		GPA30 2-cun old mandrel - Locking hexagonal axle T3-19 of main tension spring	Locking hexagonal axle of mandrel main tension spring	1
16		GPA30 2-cun old mandrel - Black rubber wheel FX02A-01-14-3	Rear rubber wheel 2-cun	1
17		GPA30 2-cun old mandrel - Non-porous chock plug T2-28-2	Non-porous chock plug	3
18		GPA30 2-cun old mandrel - Central spindle of tape sticker wheel T2-05E	Central spindle of mandrel tape sticker wheel	1
19		GPA30 2-cun old mandrel - Forward and backward swing cutter copper bush T3-101	Forward and backward swing cutter copper bush of mandrel	2
20		GPA30 2-cun old mandrel - T3-15 forward and backward swing fixed axle	Forward and backward swing fixed axle of mandrel	1
21		GPA30 2-cun old mandrel - T3-Connecting rod T2-005	Mandrel connecting rod	1



6.5.3 The cutter part (See Figure 17):

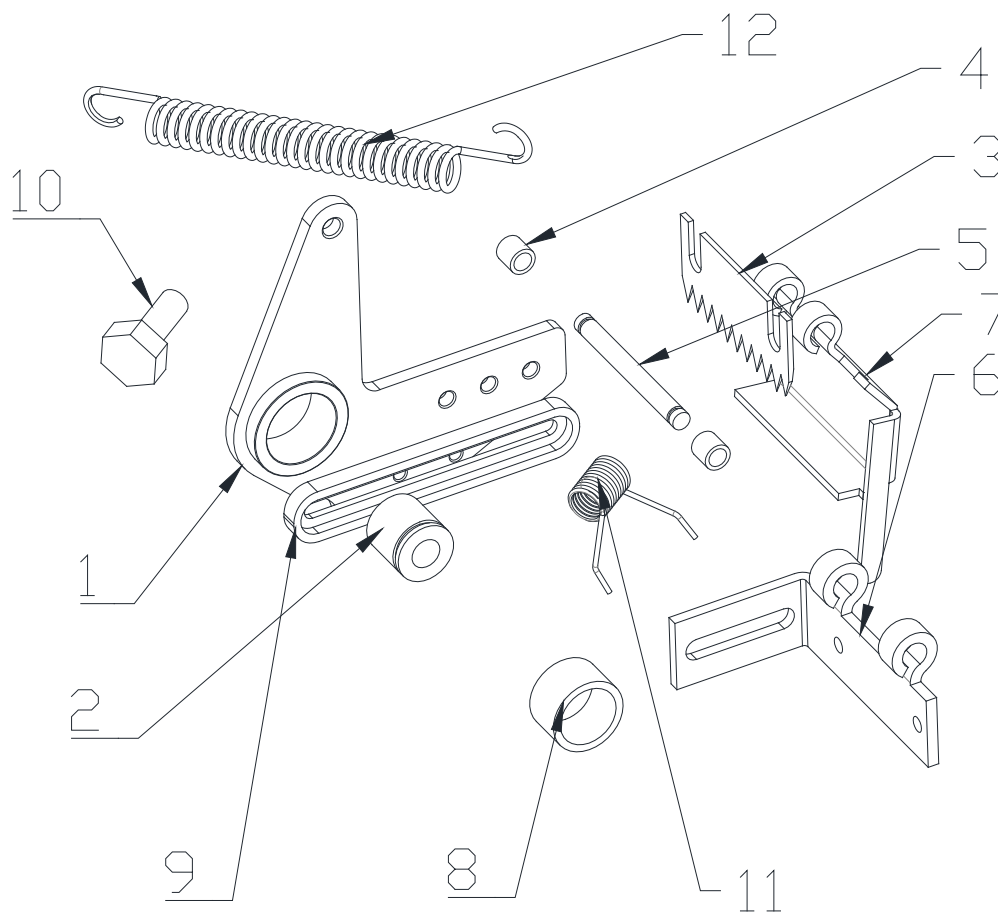












Figure 17



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 - Cutter cover central spindle 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	
10			M6 screws	2	
11		dh-01-08	Cutter cover torsion spring	1	
12		dh-01-03	Cutter tension spring	1	



6.5.4 The tape holder (See Figure 18):

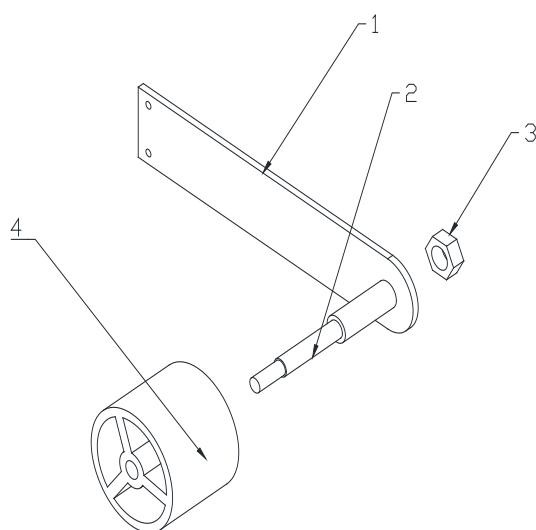






Figure 18

Parts List

Table 13

S/N	Graph	Part No.	Name	Quantity
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