



**Cleveland Equipment**

# **SB-EX-Ran**

**Random Side-Belt Case Taper**  
Operation Manual



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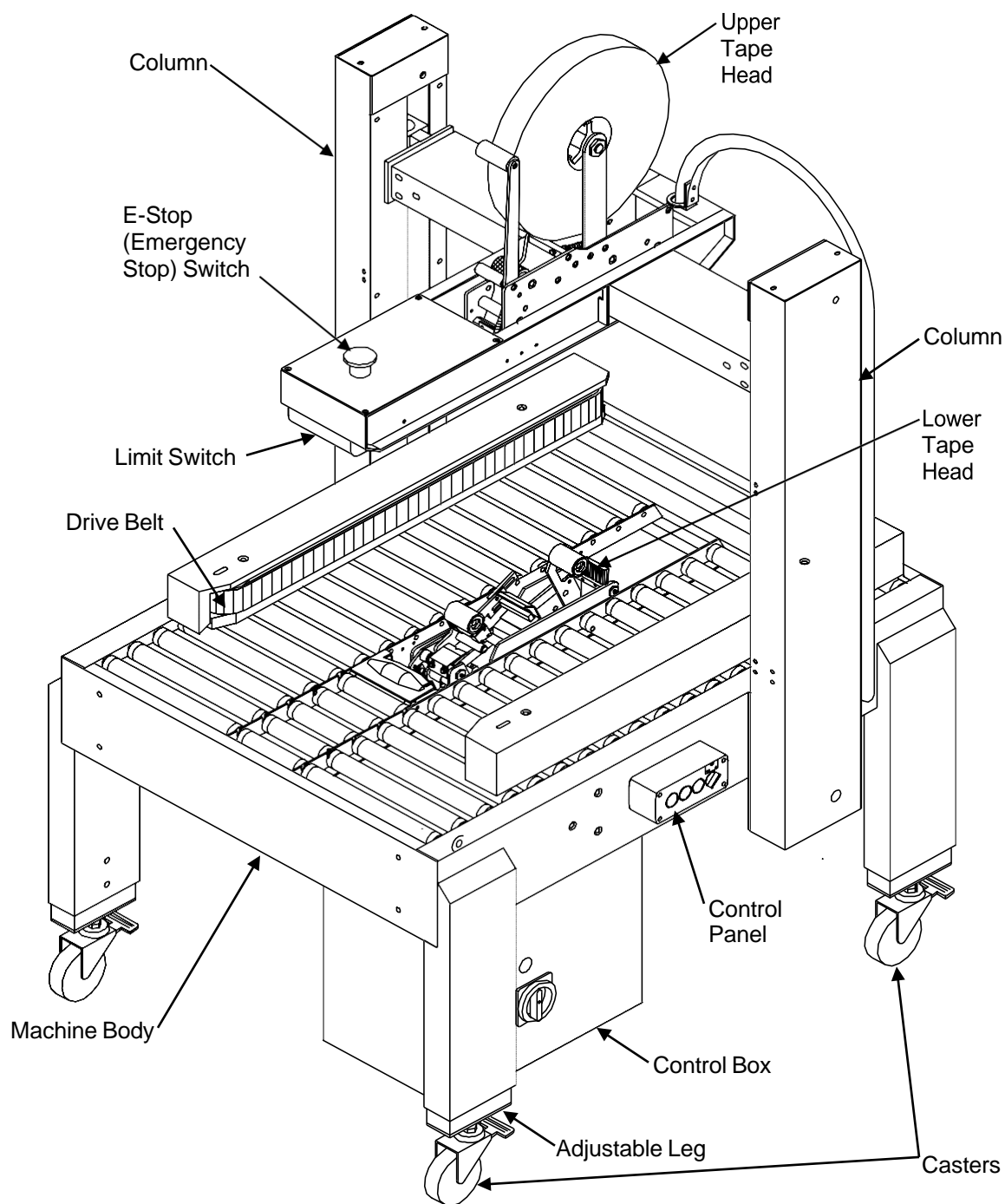


# Safety

## General Safety Precautions

Before installing, operating or servicing this equipment, please read the following precautions carefully:

- This machine is equipped with moving belts. Do not place hands near the rear of this unit when the belts are moving as fingers may be pinched where belts enter the frame. We suggest the use of a roller-type exit conveyor or pack table for your cases. Always remove boxes after they clear the exit end of the machine.
- Observe caution when near the tape applying cartridges or when threading tape. The knife is very sharp, automatically operated and is linked to the wipe down rollers.
- Do not attempt to open or work on the electrical box, junction boxes or other electrical components of the unit without first disconnecting power to the machine. Electrical shock hazard exists if power is not disconnected.
- Do not by-pass any factory-designed safety features such as knife guards, interlocks, switches, etc.
- Do not place hands or body inside the confines of the machine unless the head mechanism is securely fastened, and the electrical supply is shut off.
- Never provide service or clear a box jam when machine is running.
- When feeding a box into the unit, always hold down the box top and present the box to unit. Release hands as soon as the belts begin to take the box.
- Do not wear loose clothing such as ties, scarves, jewelry etc. Long hair should be pulled back and/or covered while operating this machine.





## Specifications

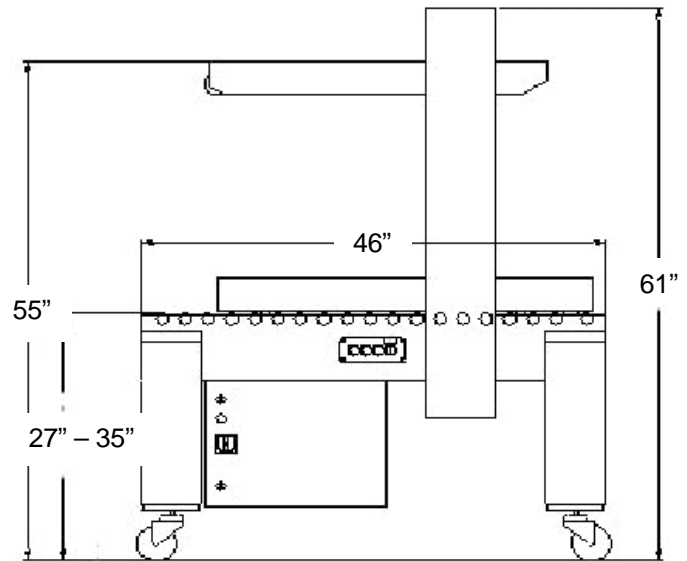
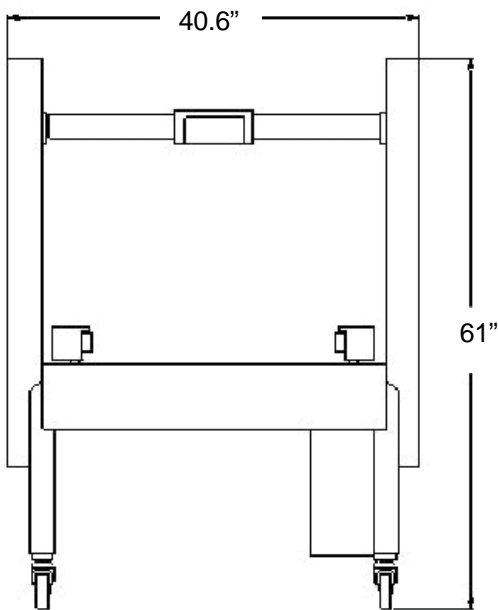
Model	SB-Ex Ran
Tape	1.5" (36mm) or 2" (50mm)
Belt speed	23m/min
Capacity	(L) 4.7in to unlimited (W) 3.9in to 24in (100mm to 610mm) (H) 4.7in to 24in (120mm to 610mm)
Consumption	450W
Machine size	(L) 46in (1160mm) (W) 40.6in (1030mm) (H) 61in (1550mm)
Machine net weight	

## Options

- Stainless Steel
- 3" tape head
- Standard table
- Extend table



## Dimensions





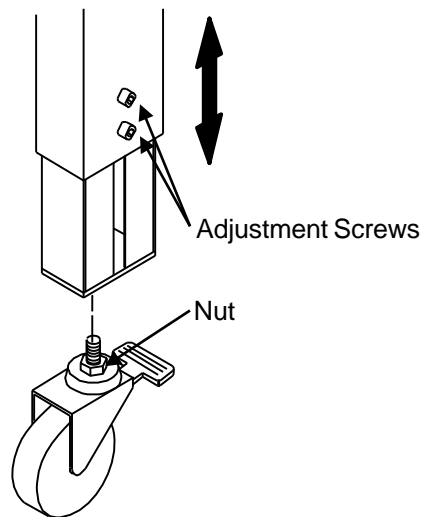
# Installation

Carefully unpack the outer carton. Avoid damaging the machine body.

Remove the shipping bolts that secure the Case Taper to the shipping pallet. Lift the Case Taper off the pallet.

**CAUTION! The SB-EX Ran Case Taper is a very heavy piece of equipment and will require a forklift, floor crane, or several people to move safely off the shipping pallet. Use proper equipment when lifting the case taper and ensure the case taper is secure and will not shift while being moved or during height adjustment or installation of locking casters**

Install the 4 casters on the Case Taper legs. (Please refer to the diagram of casters and assembly hardware below).



**CAUTION! The case taper must be lifted off the floor to install the casters. Use proper equipment when lifting the case taper. Ensure the SB-Ex Ran Case Taper is secure and will not shift while installing the casters or adjusting leg height.**

The locking casters allow the SB-Ex Ran Case Taper to be moved easily over a smooth flat surface. If the unit must be lifted to move it to the desired location, you will need a pallet jack, floor crane, or fork lift to lift it.



## Location Requirements

When installing the SB-Ex Ran Case Taper please be aware of the following considerations:

1. The mounting surface is flat and level.
2. Conveyor or packing table height.
3. Alignment with packaging line.

When the SB-Ex Ran Case Taper is positioned in the operating location you will need access to:

1. The power switch.
2. Height and width adjustments.
3. Tape loading (Both upper and lower tape cartridges).

A packing table may be provided at the in feed end where the packer can fill boxes and close the flaps prior to feeding the boxes into the machine. It is also convenient to have a pack table at the exit end of the taper.

It is essential that the table and conveyor be at the machine bed height.

The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

Mount air pressure regulator to the 3 position switch and connect with air supply.





# Operation

## Loading the Tape Cartridges

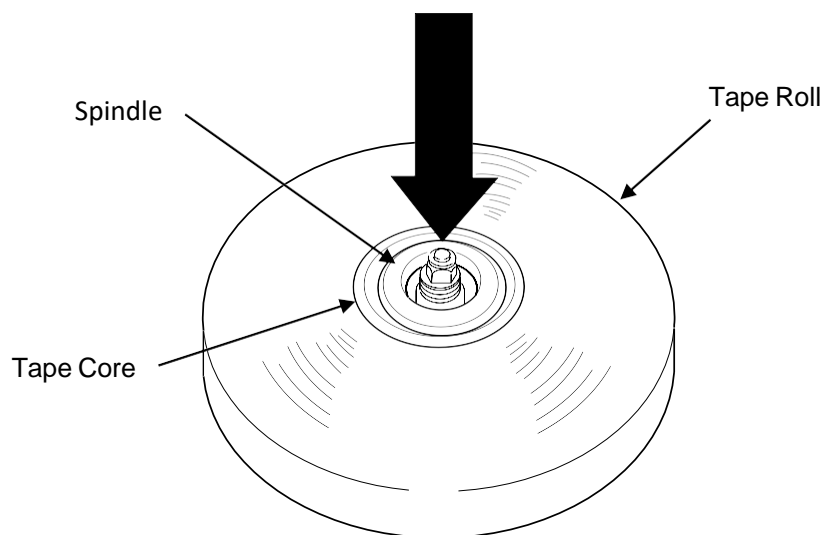
Turn the main power switch to “Off” and disconnect the power.

**CAUTION!** To avoid personnel injury, remove the tape cartridge before loading tape.

**When handling the tape cartridge be careful to avoid contact with the tape cutting blade.**

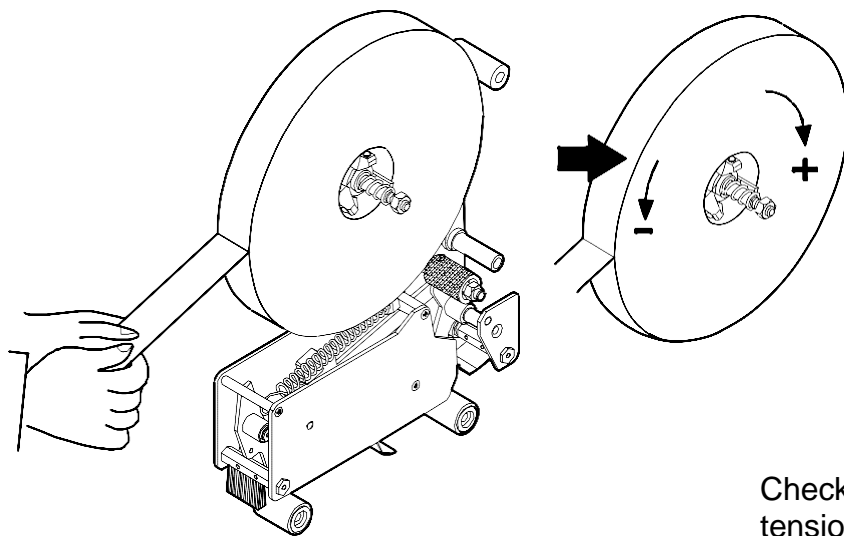
After the taping cartridge has been removed push the tape roll onto the tape core assembly.

**NOTE:** Make sure the tape roll is pushed all the way on the spindle assembly.





## Check Tension



Check the tape for correct tension. Tighten or loosen the tape core holder to adjust tension.

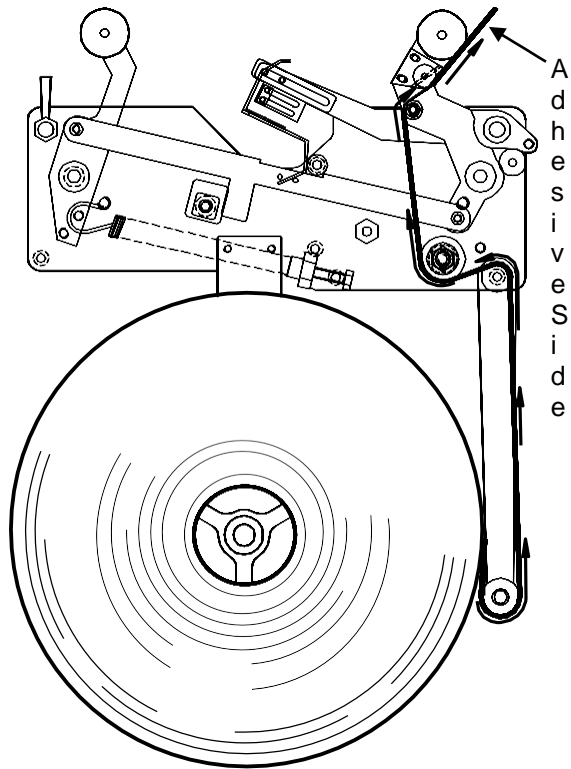
## Thread Tape

Carefully thread the new tape through the rollers in the tape head as shown in the applicable diagram in the Tape Head User Guide provided with the tape head.

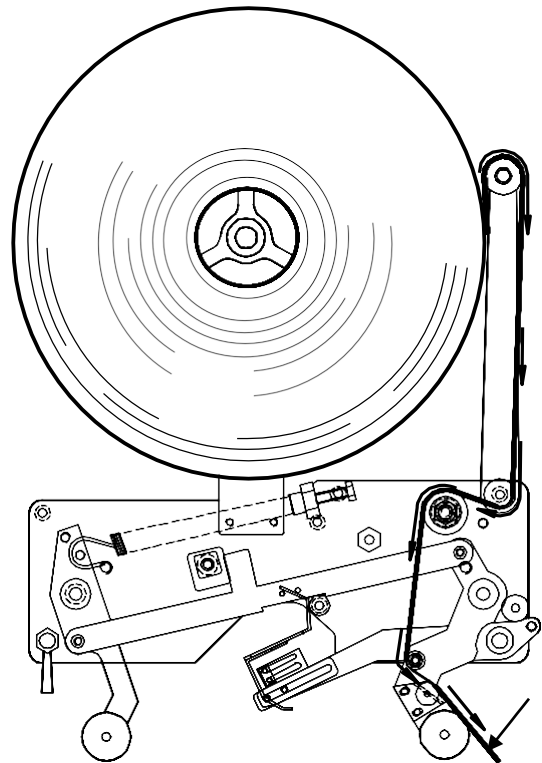
For convenience, diagrams for threading tape in the Eastey-EX Tape Head and EZ-EX Tape Head are provided on the following page. Follow the diagram that applies for your tape head, depending on the tape head model and position on the taper.



### Eastey-EX Tape Head



**Bottom Cartridge**

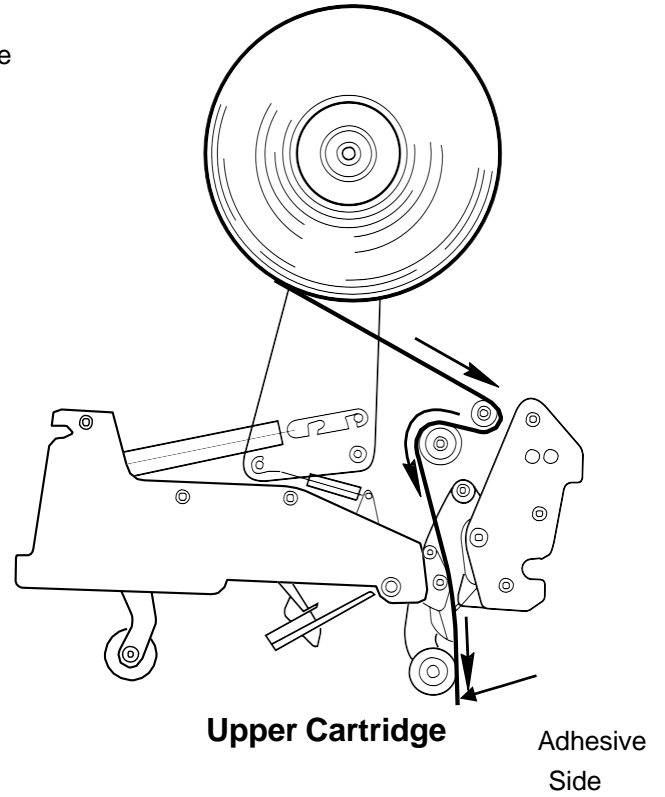
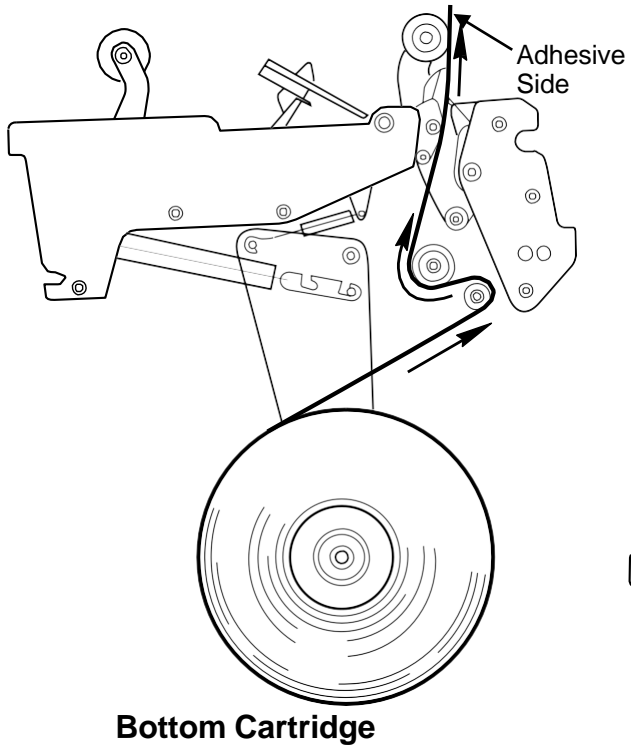


**Upper Cartridge**



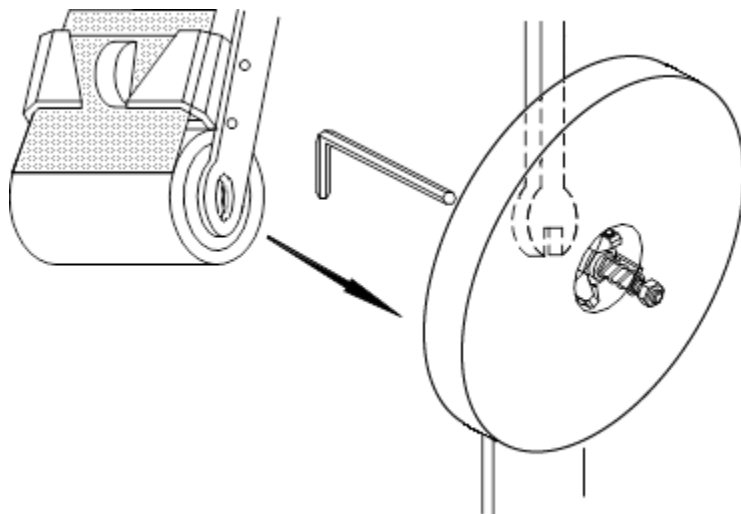
Adhesive Side

## EZ-EX Tape Head





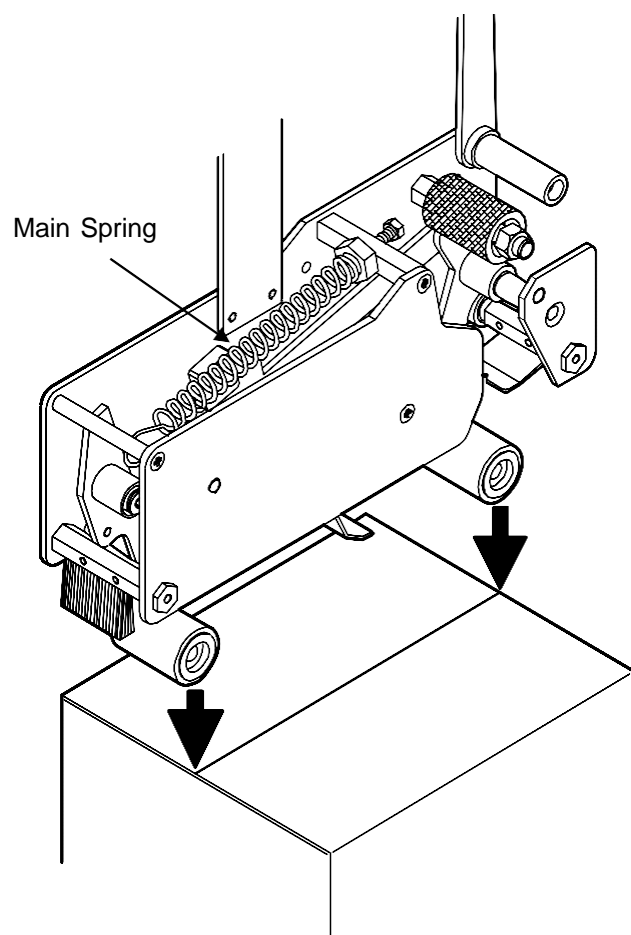
## Center Tape — Eastey-EX Tape Head only



Make sure the tape is centered on all the rollers.

There are several rollers in the tape cartridge where the tape alignment should be checked to verify the tape stays on center as it is being dispensed.

Return the tape cartridge to the operation position.



## Main Spring

For sealing light weight boxes, decrease the main spring tension. For heavier boxes, increase the main spring tension.

When setting tension for the rollers, consider the amount of pressure on the box flaps required to make the seal.

Cartons completely filled to the top with product may require more pressure on top and bottom seams when applying tape than partially-filled cartons, where excessive pressure could possibly crush the carton.



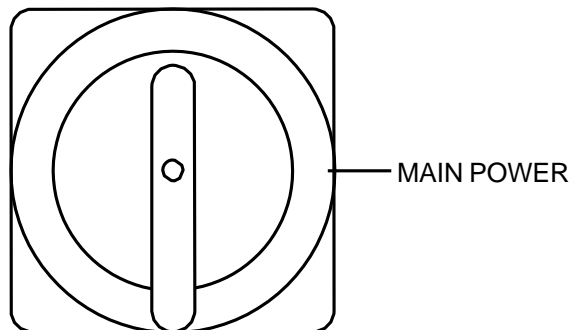
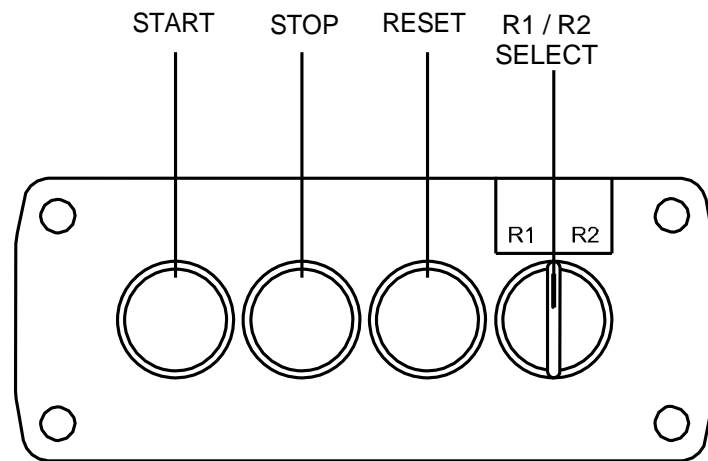
## Power

Plug the power supply cord into a properly wired and grounded outlet.

See the following for operation of Main Power switch and Control Panel buttons and switch.

**CAUTION!** When the power is turned on be aware of moving parts and belts

## Control Panel



## POWER

When the main power switch is in the “ON” position the power lamp should be illuminated.

**R1**

This mode functions as memory for the height of the carriage position. If the operator has equal height or similar height of packages, this mode memorizes and stays at the position of last taping job. This function enables operators to speed up their packaging time, the top carriage moves up slightly after each taping. It reduces the taping time for the following cartons with equal height.

**R2**

This mode allows the top carriage to stay at top position. It is suitable for operations that have various sizes of taping cartons.

The top carriage will always stay at the top position when in this mode. It enables changes of wider range cardboard boxes.

**START**

Press the button to get automatic or manual program running.

**STOP**

Press this button to stop all operation. If operator needs to change modes the operator is required to press the STOP button and then press START button for operation.

**RESET**

All taper settings will return to the home position when RESET button is pressed.

**EMERGENCY STOP**

Press the button to get emergency stop.

**MAIN POWER**

Use to turn the main power on or off.



# Adjustments

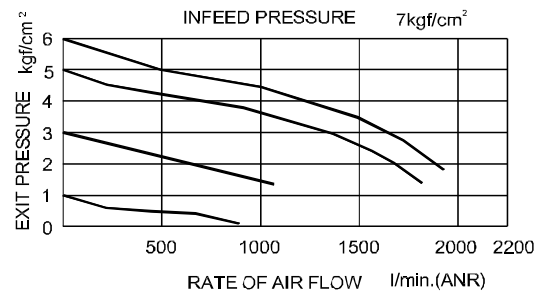
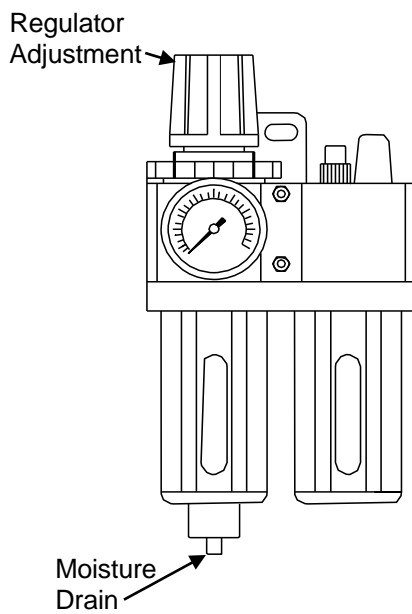
## Air Pressure unit

Adjustments on the 3-function elements (see diagram).

Air capacity: 2500cm<sup>3</sup>/ min

Pressure setting: 6kg/cm<sup>2</sup>

Please inspect periodically to see if the drain system is functional and if lubrication oil is needed.





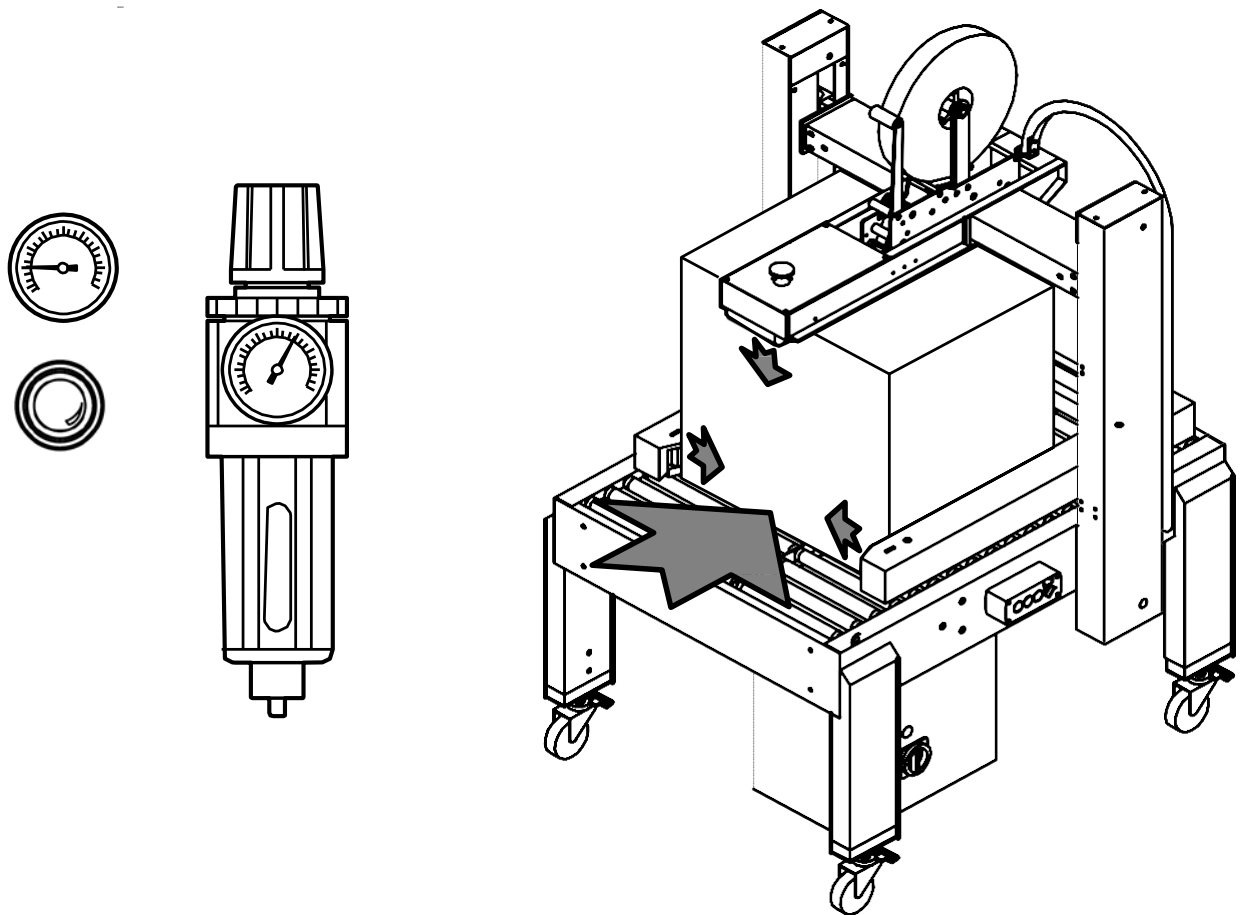


## Force Adjustment

The SB-EX Ran Case Taper has two pressure regulators on the system. Both pressure regulators are located on the left side of the machine.

- The main Filter/Regulator controls the primary system pressure and the lifting force of the upper frame assembly. This should be set to 80-90 PSI.
- The smaller regulator next to the primary Filter/Regulator controls the belt squeezing pressure. This should be set to 30-40 PSI for most case types.

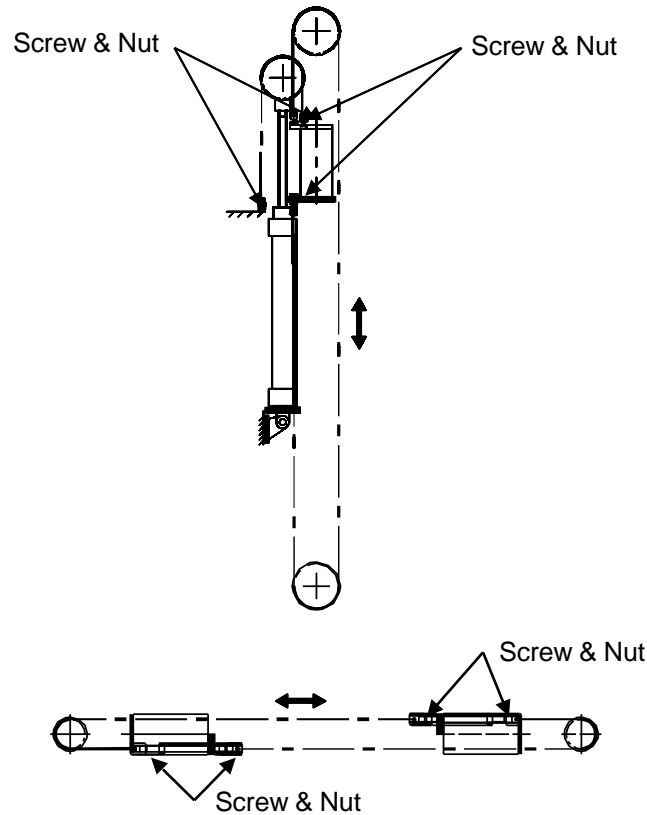
Too little belt squeezing pressure and the cases to stall and slip on the belts, causing premature wear.





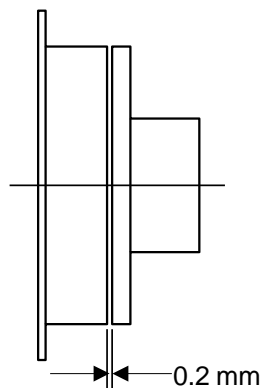
## Height and Width Adjustment

If there is a gap between width and height chains it may result in poor taping. Use the chain adjusting screw and lock nut to correctly adjust the height and width.



## Brake Adjustment

The most ideal distance between the carriage brake and brake plate is 0.2mm.





# Maintenance

The SB-Ex Ran Industrial Case Taping System will provide many hours of maintenance free operation. There are a few items that may require attention from time to time.

## Rollers

Make sure rollers stay clean and grease free. If you should have to clean the rollers simply wipe them down with a clean lint free cloth. If a more thorough cleaning is necessary wipe the rollers down with a mild detergent and water and let dry. **Never use harsh or abrasive cleaners or chemical agents when cleaning the rollers.**

## Cutting Knives

Occasionally inspect the cutting knives to ensure they are clean and free of adhesive residue. Make sure the cutting knife is sharp by inspecting cuts in the tape. Cuts should be straight and neat. If the quality of cuts is eroding, the knife blade is dull and should be replaced.

## Changing Knife Blades — Refer to Tape Head User Guide

Turn off and unplug the taper. It is not necessary to remove either tape head to change the blade. Refer to the Tape Head User Guide provided with the tape head for instructions for changing the knife blades.

**CAUTION!** Always be aware of the cutting edges while replacing the knife blades. Handle the knife blades carefully.



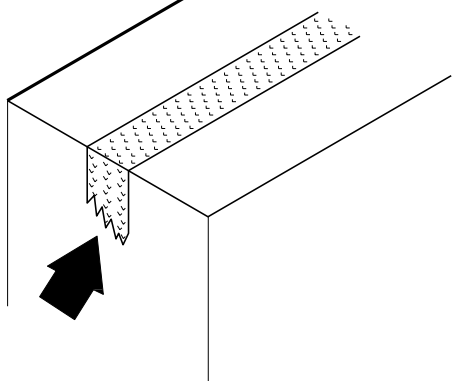
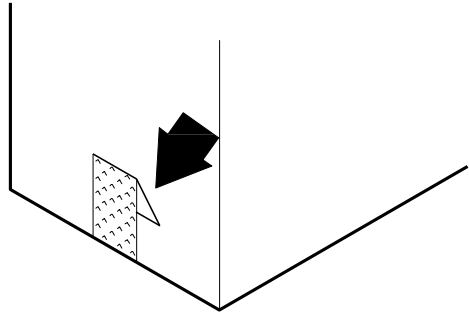
# Troubleshooting

PROBLEM	POSSIBLE CAUSE	SOLUTION
If machine is not functioning.	a) The air force may be not sufficient b) The 2 knobs for height & width are not released. c) Defective infeed & exit photo eye sensor.	a) Adjust the air Pressure b) Unscrew the 2 knobs. c) Adjust or replace the photo eye sensor.
If the carriage air cylinder does not work.	a) Bended hoses & wirings. b) Chain is not in position properly.	a) Re-position hoses & wirings. b) Accommodate the chain and check if they are tightly
If positioning of the top carriage is not accurate.	Check if the gap between the brake and brake plate is well- adjusted.	The gap should be in 0.2mm.
If the side adjustor air cylinder does not run appropriately.	Bended hoses & wirings.	Re-position hoses & wirings.
If machine cannot accomplish the operation of taping on cartons.	Forces from the side belts are insufficiently transferred to the box.	Increase the forces by adjusting air.
If top carriage does not stay at middle position.	The wirings of sensor of the air cylinder may be loosen or defective.	Adjust or replace a new sensor.

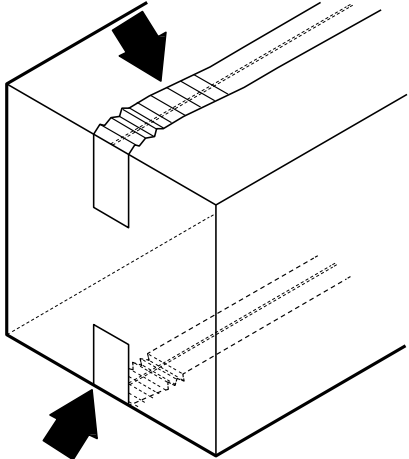
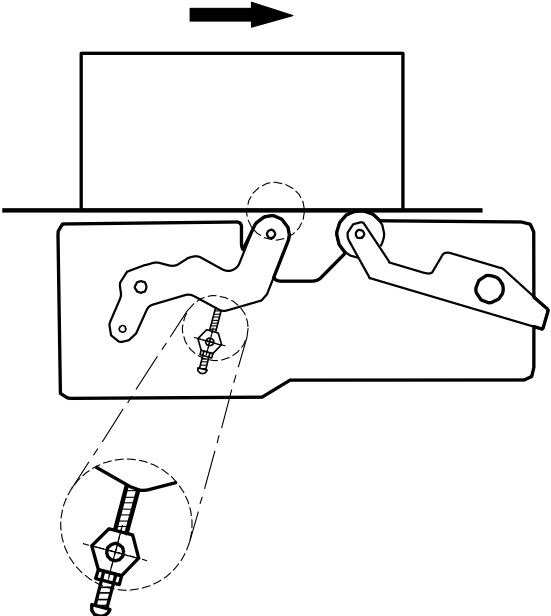
Press the START button.	Diagnostic Indicator	Indicator Meaning
	START button flashes 1 time	Machine is set at R1 mode
	START button flashes 2 times	Machine is set at R2 mode.
	START button flashes 3 times	Machine is set at U mode.
	START button flashes 4 times	Machine is set at RESET.
	START button flashes 5 times	Motor overloaded. Check through all possible problems and press overloaded RESET button.
	START button flashes 6 times	STOP button is on. Or the wirings may be disconnected.



Press the START button.	Diagnostic Indicator	Indicator Meaning
	START button does not flash at all	a) Turn on the power, power indication light will be on. b) Release the E-STOP button.

Problem	Solution
Uneven Tape Leg on Front	<ul style="list-style-type: none"> <li>• Tape tension is too low. Tighten the one-way clutch roller and/or the tape core.</li> <li>• Adjust the one-way clutch roller in the slot so it is slightly beyond the front wipe roller.</li> <li>• Adjust the tape leg length. See Tape Leg Adjustment section.</li> </ul>
Uneven Tape Leg Rear	<ul style="list-style-type: none"> <li>• Too much tape tension. Adjust the one-way clutch and or tape core.</li> <li>• Clean and ensure all rollers move freely. Lubricate all roller slots.</li> <li>• Tighten main spring.</li> </ul>
Uneven or Torn Tape 	<ul style="list-style-type: none"> <li>• Blade is dull. Replace blade.</li> <li>• Tape tension is incorrect. Increase tension.</li> <li>• Clean and adjust blade.</li> <li>• Blade mounted incorrectly or backwards.</li> <li>• Knife arm spring is worn. Replace knife arm spring.</li> <li>• Adjust cartridge height.</li> </ul>
Tape Folding 	<ul style="list-style-type: none"> <li>• Check that all rollers turn freely.</li> <li>• Check to be sure tape is threaded properly on front roller (page <b>Error! Bookmark not defined.</b>).</li> <li>• Check wipe down brush.</li> </ul>

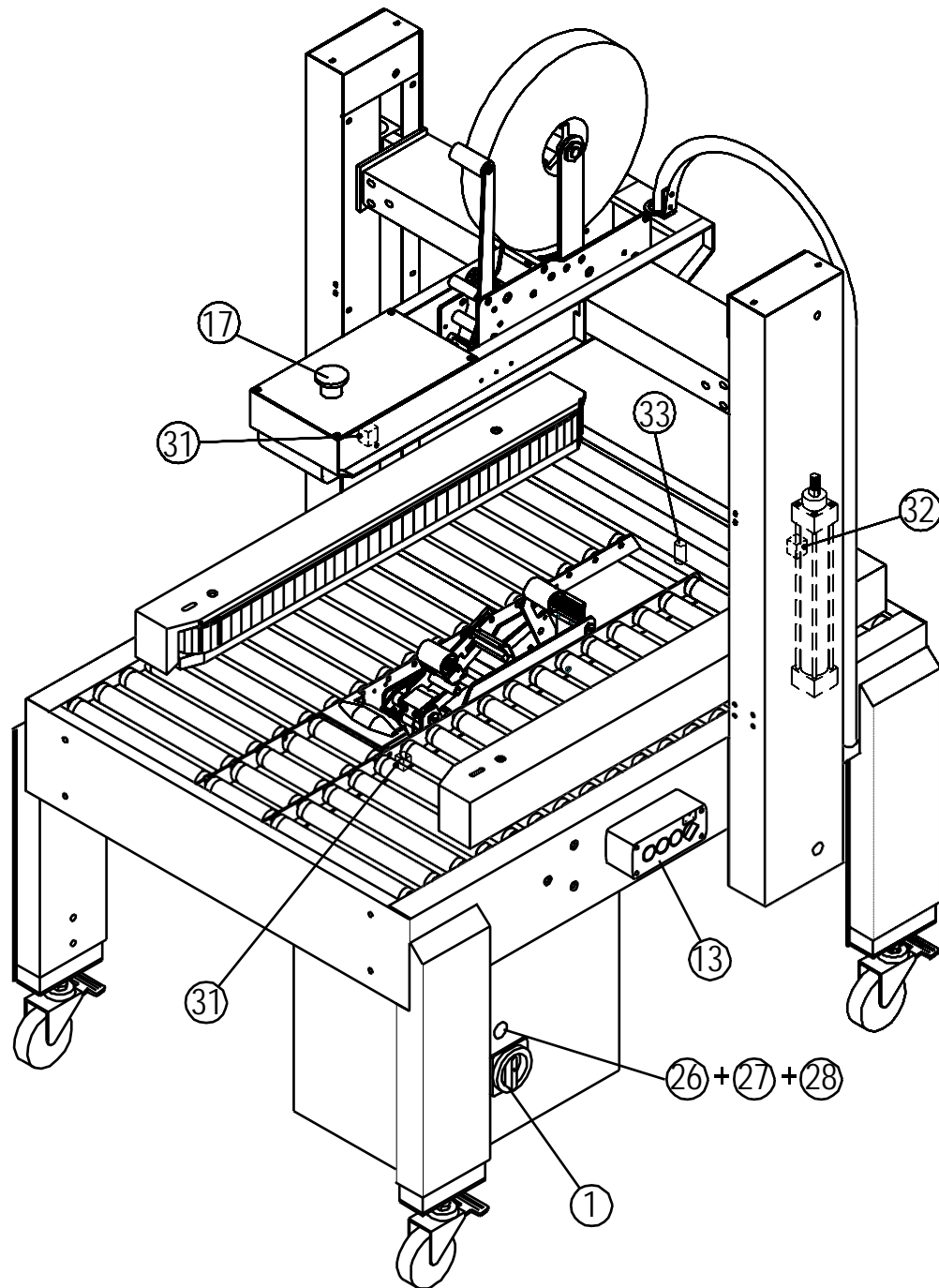


Problem	Solution
<p data-bbox="207 239 709 310">Tape Curling and Bunching Up — Easteys EX Tape Head Only</p> 	<ul style="list-style-type: none"><li data-bbox="751 239 1425 310">• Adjust the tape cartridge height (approximately .06 inches from box)</li></ul>  <ul style="list-style-type: none"><li data-bbox="751 947 1425 1018">• Check tape tension set by the spring tension at the tape core.</li></ul>



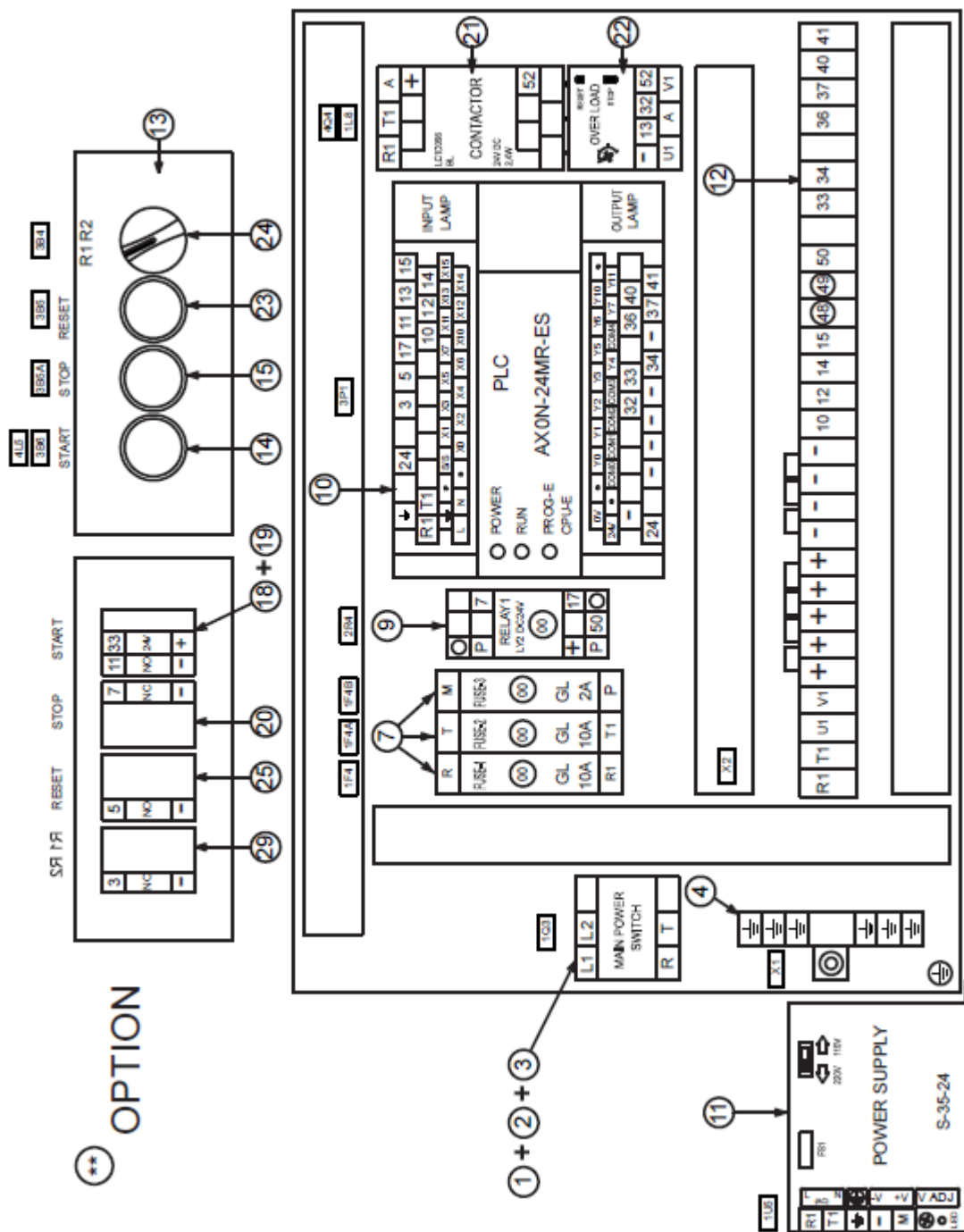
# Parts List

## Electrical





## Panel Layout

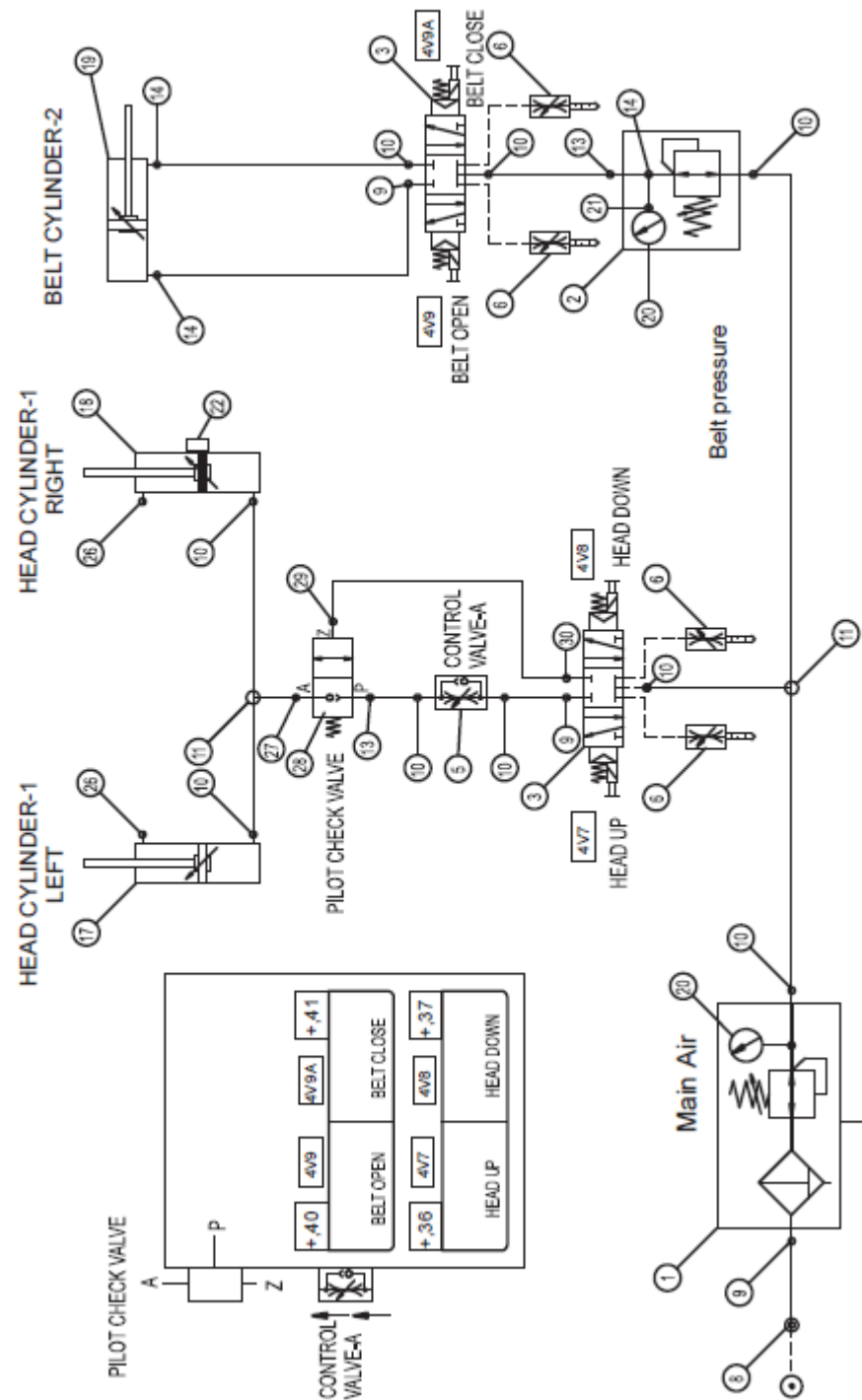






ITEM NO.	PART NO.	DESCRIPTION	Q'TY
1	71710001-01	POWER SWITCH → ON/OFF	1
2	71710001-02	→LINE SHANK	3
3	71710001-03	→LINE SHANK UNITS	3
4	70560601	TERMINAL BLOCKS TB6P	1
5	72551001	FUSE 10A GL	2
6	72550201	FUSE 2A GL	1
7	7250DF01	FUSE SEAT	3
8	7270R301	RELAY LY2 DC24V	1
9	7270B301	RELAY SEAT LY2	1
10	73002401	PLC AXON-24MR-ES	1
11	72810002	POWER SUPPLY S-35-24	1
12	7055TC10	TERMINAL POST 10P	1
13	71840002	ON/OFF SWITCH BOX	1
14	7150AW01	AUTO RUN GREEN LAMP→COVER	1
15	7155AA02	BUTTON RED	1
17	7155BC01	EMG.SWITCH	1
18	7150AW02	AUTO RUN GREEN LAMP→SEAT	1
19	7150CE24	AUTO RUN GREEN LAMP→LAMP	1
20	7158AZ02	BOTTOM SEAT CONTACTOR NOx1	1
21	72600001	CONTACTOR	1
22	71570002-02	THERMAL OVERLOAD RELAY	1
23	7155AA01	BUTTON WHITE	1
24	7160AD02	SELECTOR SWITCHES	1
25	7158AZ01	BOTTOM SEAT CONTACTOR NCx1	
26	7150AV01	AUTO RUN WHITE LAMP→COVER	1
27	7150AV02	AUTO RUN WHITE LAMP→SEAT	1
28	7150CE24	AUTO RUN WHITE LAMP→LAMP	1
29	7158AZ01	BOTTOM SEAT CONTACTOR NOx1	1
31	7355N102	PROXIMITY SWITCH PS-05N	2
32	81020001	MAGNETISM SWITCH	1
33	7360CD01	PHOTO SENSOR CD01	1

## Pneumatic

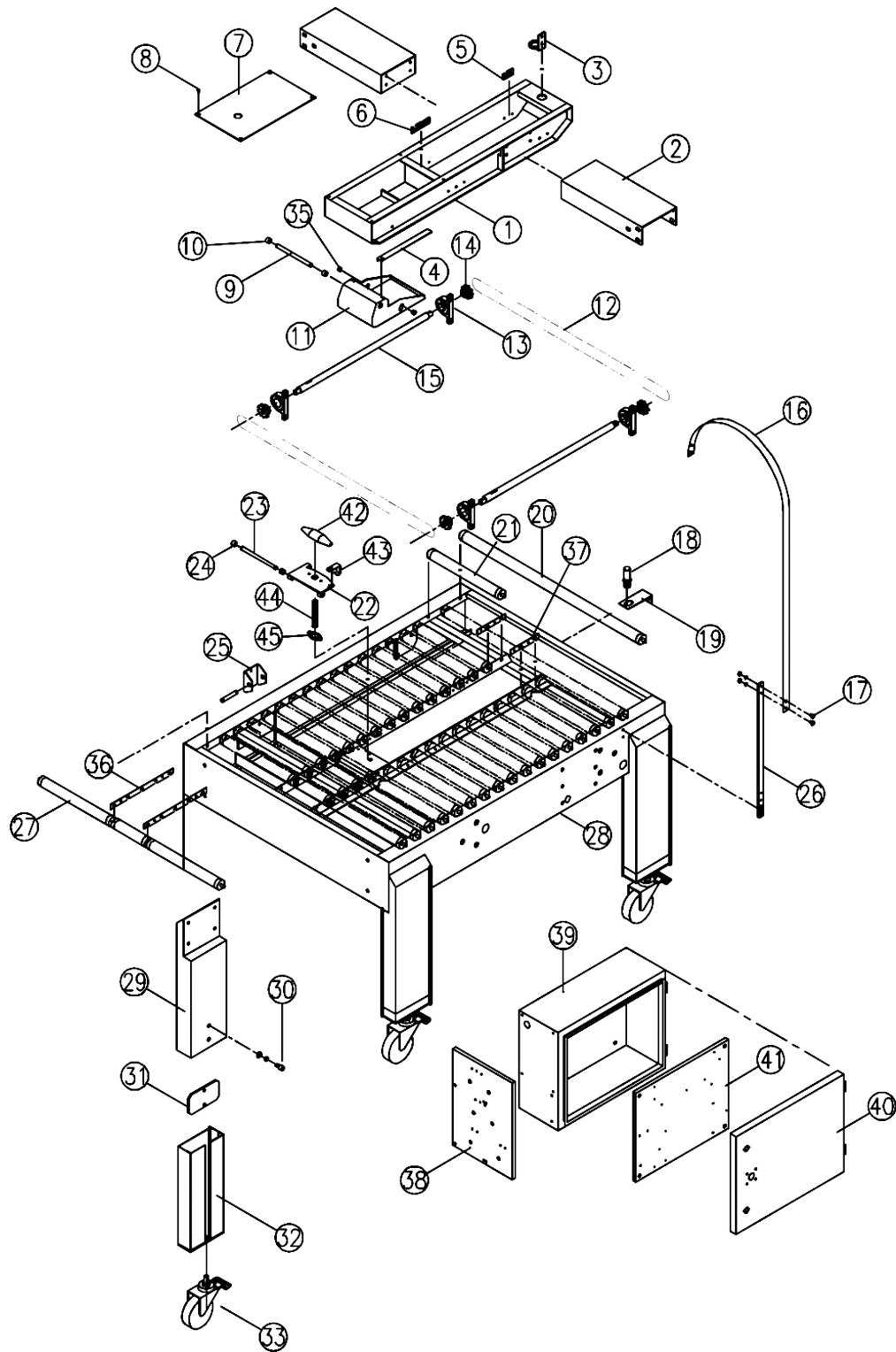




ITEM NO.	PART NO.	DESCRIPTION	Q'TY
1	81110001	AIR F.R.L UNITS	1
2	81040001	PRESSURE REDUCING VALVE	1
3	81090002	SOLENOID VALVE	2
5	81120001	CONTROL VALVE	1
6	81100001	REGULATE SILENCER	4
8	81060101	SPEEDINESSCCNNECTOR	1
9	81060201	CUPRUMCCNNECTOR	1
10	81140003	CONNECTOR L-802	9
11	81140001	CONNECTOR	2
12	81140101	ALUMINUMCONNECTOR	2
13	81140002	CONNECTOR C-802	2
14	81140004	CONNECTOR L-801	3
17	81010003	ISO CYLINDER (AL40*250)	1
18	81010004	ISO CYLINDER (ALR40*250)	1
19	81010005	ISO CYLINDER (AL32*250)	1
20	81040001-1	PRESSURE GAUGE	1
21	81050001	FEMALE CONNECTOR	1
25	81100104	BRASS SILENCER	2
26	81060117	CONNECTOR PCF-802	1
27	81096001	PILOT CHECK VALVE	1
28	81060109	CONNECTOR PL6-M5	1
29	81140007	CONNECTOR L-602	1



## Upper Taping Seat





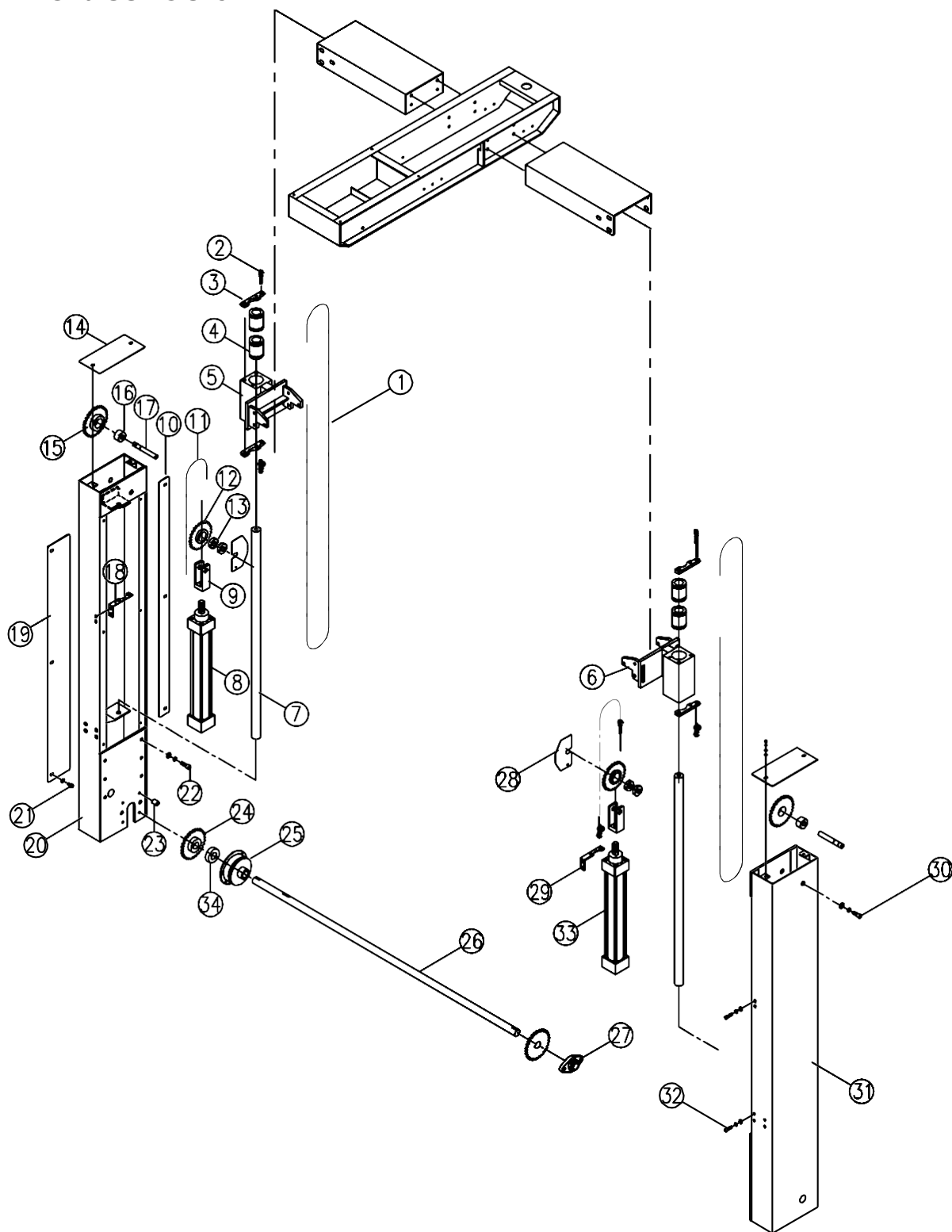
ITEM NO.	PART NO.	DESCRIPTION	Q'TY
1	CC100100	TAPING SET SUPPORT	1
2	CC101200	SUPPORT SET	2
3	CC100300	FIXED SEAT	1
4	CC101500	LIMIT SEAT	1
5	CA100200	A-PLATE	2
6	CA100300	B-PLATE	2
7	CC100200	COVR PLATE	1
8	10140406	SCREW M4*6L	4
9	CC301900	SHAFT	1
10	31001012	BUSH ALFB-1010	2
11	CC100600	<b>PUSH SET</b>	1
12	3240S408	CHAIN #40*75CM	4
13	30382043	BEARING SP004	4
14	CC301500	CHAIN WHEEL #40*9T	4
15	CC301700	SYNCHROSTEP SHAFT	2
16	CC100500	CABLE CLAMP	1
17	10100612	SCREW M6*12L & S.W & NUT	2
18	7360CD01	PHOTO SENSOR CD01	1
19	CC302600	SENSOR SEAT	1
20	CC302000	ROLLER (LONG)	2
21	CC302200	ROLLER (SHORT)	20
22	CC30180A	PUSH PLATE	1
23	CC301900	SHAFT	1
24	31001012	BUSH ALFB-1010	2
25	CC301200	CYLINDER SEAT	1
26	CC100400	FIXED SEAT	1
27	CC302100	ROLLER	7
28	CC300100	MACHINE FRAME	1
29	CC300200	MACHINE LEG	4
30	10101016	SCREW M10*16L & S.W & W	8
31	CC300400	CLAMP	4
32	CC30030A	ADJUSTABLE LEG	4
33	9202H501	CASTER	4
35	CC100800	PU RING	2



ITEM NO.	PART NO.	DESCRIPTION	Q'TY
36	CC303300	FOREPLATE	2
37	CC303400	POSTPLATE	2
38	CC302700	RADIOTUBE PLATE	1
39	CC400200	CONTROL BOX	1
40	CC400300	CONTROL BOX DOOR	1
41	CC400500	WIRING PLATE	1
42	CC330400	PUSH PLATE	1
43	CC303500	PUSH PLATE HAMULUS	1
44	CC303700	PUSH PLATE SPRING	1
45	CC303600	SPRING SEAT	1



## Vertical Column



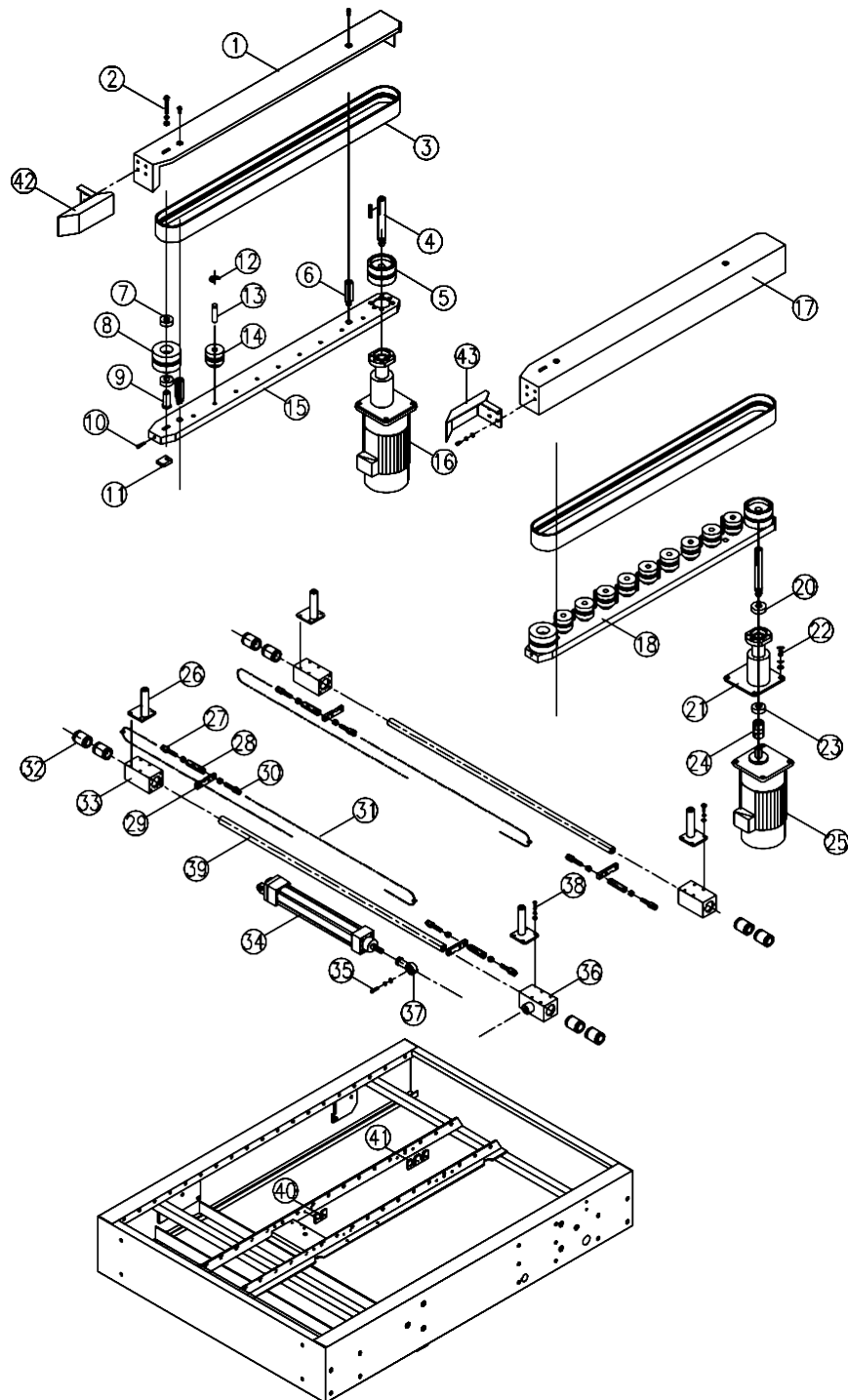


ITEM NO.	PART NO.	DESCRIPTION	Q'TY
1	3240S35A	CHAIN #35*214CM	2
2	CA332400	CHAIN ADJUSTMENT SCREW	8
3	CC201500	CHAIN ADJUSTMEN PLATE	4
4	3110LM25	LINEAR MOTION BEARING LM-25U	4
5	CC2002L0	SPINDLE SUPPORT	1
6	CC2002R0	SPINDLE SUPPORT	1
7	CC201100	SPINDLE SHAFT	2
8	81010003	ISO CYLINDER MCQV-11-40-250M	1
9	CC200800	CHAIN SUPPORT	2
10	CC201700	CHAIN COVER	2
11	3240S35B	<b>CHAIN #35*52CM</b>	2
12	CC200700	CHAIN WHELL	2
13	30300010	BEARING 6001ZZ	4
14	CC200400	COVER	4
15	CC200500	CHAIN WHELL	2
16	30300010	BEARING 6001ZZ	2
17	CC201400	CHAIN WHELL SHAFT	2
18	CC2020L0	FIXED PLATE	1
19	CC200300	CHAIN COVER	2
20	CC2001L0	COLUMN	1
21	10100510	SCREW M5*10L & S.W & W	12
22	10100816	SCREW M8*16L & S.W & W	12
23	CC202100	TRIG RING	4
24	CC200600	CHAIN WHELL	2
25	91022501	ELECTROMAGNETIC BRAKES EFB-2-015	1
26	CC201200	SYNCHROSTEP SHAFT	1
27	30382044	BERAING SFL004	2
28	CC201800	CHAIN WHELL COVER	2
29	CC2020R0	FIXED PLATE	1
30	10100816	SCREW M8*16L & S.W & W	2
31	CC2001R0	COLUMN	1
32	10100816	SCREW M8*16L & S.W & W	4
33	81010004	ISO CYLINDER MCQV-11-40-250M	1
34	30300040	BEARING 6004ZZ	1





## Side Belt Assembly





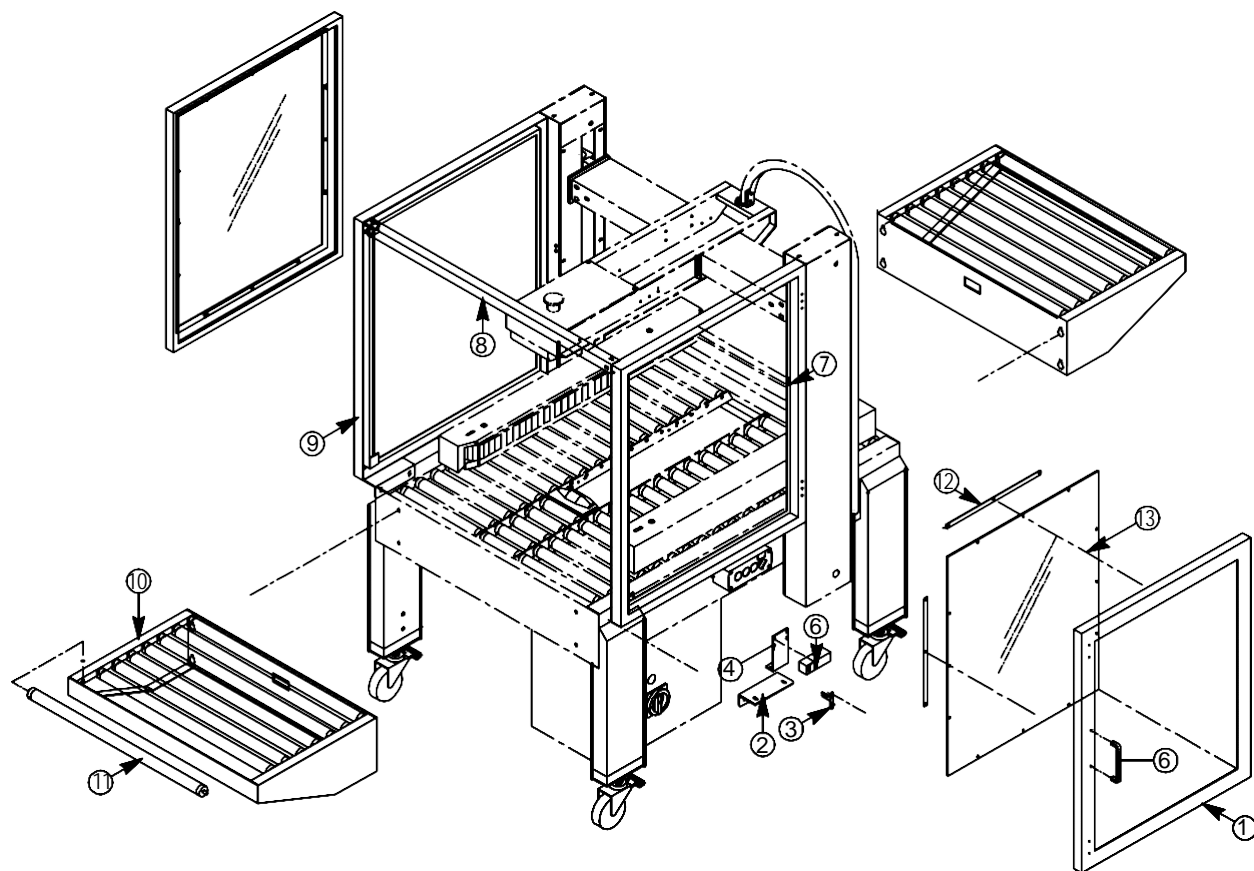
ITEM NO.	PART NO.	DESCRIPTION	Q'TY
1	CC3008LA	SIDE BELT COVER	1
2	10100870	SCREW M8*70L & S.W & W	2
3	CC300600	BELT	2
4	CA30250A	MOTOR SHAFT	2
5	CA301900	PULLEY DRIVER	2
6	CE300800	SPEDIAL SCREW	4
7	30300030	BEARING 6003ZZ	4
8	CA301100	PULLEY FOLLOWER	2
9	CA301200	PULLEY SHAFT	2
10	10130545	SCREW M5*45L	2
11	CA301800	ADJUSTMLNT BLOCK	2
12	11301200	RING STW-12	18
13	CA301400	PULLEY SHAFT	18
14	CA301300	PLASTIC PULLEY	18
15	CC3005L0	SUPPORT COLUMN	1
16	745111L1	MOTOR 110V/60HZ,T18:1	1
	745122L1	MOTOR 220V/60HZ,T18:1	1
	745122L2	MOTOR 220V/50HZ,T15:1	1
	745124L2	MOTOR 240V/50HZ,T15:1	1
	745138L1	MOTOR 380V/50HZ,T15:1	1
	745140L1	MOTOR 400V/50HZ,T15:1	1
17	CC3008RA	SIDE BELT COVER	1
18	CC3005R0	SUPPORT COLUMN	1
19			
20	30302031	BEARING 6203ZZ	2
21	CA302900	MOTOR SEAT	2
22	10100825	SCREW M8*25L & S.W & W	8
23	30300030	BEARING 6003ZZ	2
24	CA303000	UNIVERSAL JOINT	2
25	745111R1	MOTOR 110V/60HZ,T18:1	1
	745122R1	MOTOR 220V/60HZ,T18:1	1
	745122R2	MOTOR 220V/50HZ,T15:1	1
	745124R2	MOTOR 240V/50HZ,T15:1	1
	745138R1	MOTOR 380V/50HZ,T15:1	1
	745140R1	MOTOR 400V/50HZ,T15:1	1
26	CC300900	SUPPORT SHAFT	4
27	CC302300	CHAIN ADJUSTMENT SCREW	4



ITEM NO.	PART NO.	DESCRIPTION	Q'TY
28	CC302800	CHAIN ADJUSTMENT BAR	4
29	CC301300	CHAIN ADJUSTMENT SEAT	4
30	CC302500	CHAIN ADJUSTMENT SCREW	4
31	3240S408	CHAIN #40*75CM	4
32	3110LM20	LINEAR MOTION BEARING LM-20UU	8
33	CC301100	LINEAR MOTION BEARIN SEAT B	3
34	81010005	ISO CYLINDER MCQV-11-32-250M	1
35	10100825	SCREW M8*25L & S.W & W	1
36	CC301000	LINEAR MOTION BEARIN SEAT A	1
37	81060001	ROD END M10	1
38	10100612	SCREW M6*12L & S.W & W	16
39	CC301600	RIGHT-LEFT SHAFT	2
40	CA33060A	A-PLATE	2
41	CA33070A	B-PLATE	2
42	CA3010L0	GUIDE PLATE	1
43	CA3010R0	GUIDE PLATE	1



## Options



ITEM NO.	PART NO.	DESCRIPTION	Q'TY
1	KA1103750	SAFETY DOOR	2
2	CC400600	SUPPORT PLATE	2
3	PB400400	CIRCUIT BEAKER KEY	2
4	PG400600	SECURITY SWITCH SEAT	2
5	7365P002	CIRCUIT BEAKER SWITCH	2
6	CE400700	DOOR KNOB	2
7	CC4009R0	SAFETY DOOR SUPPORT	1
8	CC400700	SUPPORT	1
9	CC4009L0	SAFETY DOOR SUPPORT	1
10	CC400100	ROLLER SAET	2
11	CC401000	<b>ROLLER</b>	16
12	KA1103770	PLATE	8
13	KA3000480	ACRYLIC PLATE	2



## Tape Cartridge — Refer to Tape Head User Guide

Refer to the User Guide provided with the Tape Head for the Illustrated Parts List and part numbers for Tape Head parts.



# Appendix A: Electrical Schematic

