



**8 NET, Inc.**

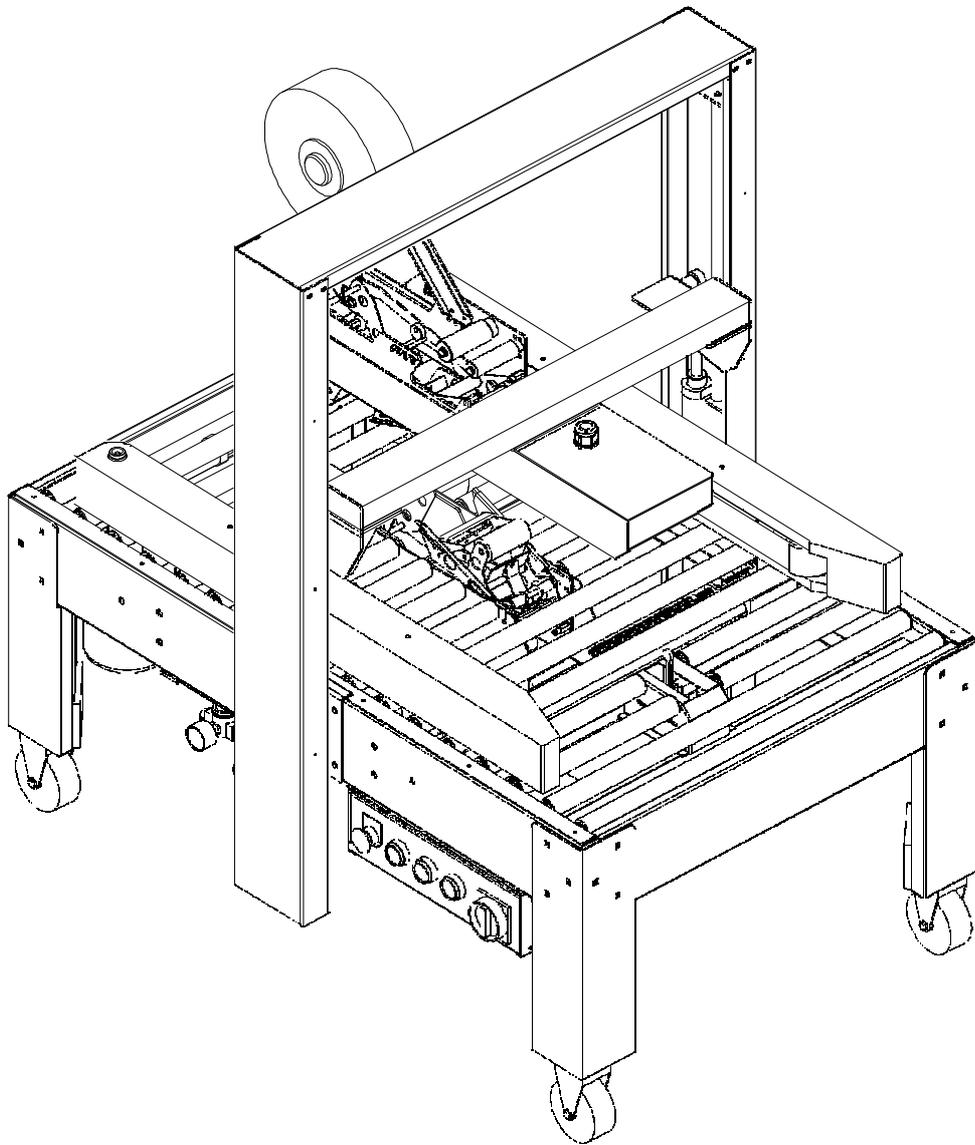
**Installation Guide / Operating Manual**

**CTM-FA217, Fully Automatic Tape  
Sealing Machine**

# JP-501A

## AUTO CARTON SEALER

### MANUAL



# JP-501A

## AUTO CARTON SEALER

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APPENDIX : Parts Assembly - Taping Head

APPENDIX : Parts Assembly - Machine

## I. SIGNS DESCRIPTION

In order to avoid damage, please read the safety signs carefully before operation.

1. “Electric Warns” Warning Sign Figure 1-1 on Electric Box and Wire Connection Box, etc. It is a warning sign for electric wares. Only the authorized operators and the repairmen are allowed to open them for the operation or repair.

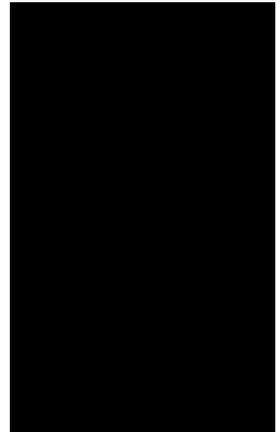


Figure 1-1

2. “Rotating Belt” Warning sign Figure 1-2 on machine belt. It is a warning sign for turning danger. Do not let your clothes or hands crushed by the moving part. Before repairing, verify that the machine is shut down.

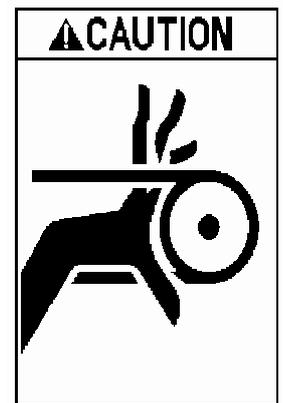


Figure 1-2

3. “Sharp Knife” Warning Sign Figure 1-3 on the knife blade. It is a warning sign to indicate that the knife is very sharp. Be careful when you feed the tape or process with repair. Don't let your hands be cut.



Figure 1-3

# . SPECIFICATIONS

## 1. Working Environment:

Do **NOT** put liquid containers near r on the electrical system,  
or use water to wash the machine in order to avoid damaging.

## 2. Power Supply = 110V!220V!380V!440V > 60Hz!50Hz > 1 or

110V!220V!380V!440V > 60Hz!50Hz > 3

(Other spec. on request).

## 3. Tape: Normal adhesive tape.

## 4. Tape width = From min. 36mm (1.5") to max. 50mm (2")

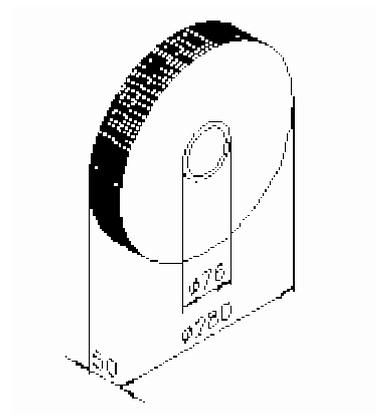
(Please advice if tape width: 2.5" or 3" is required.)

## 5. Standard Tape Roll Size = Inside

Diameter = 76mm (3") Outside

Diameter = 280mm (11") Tape

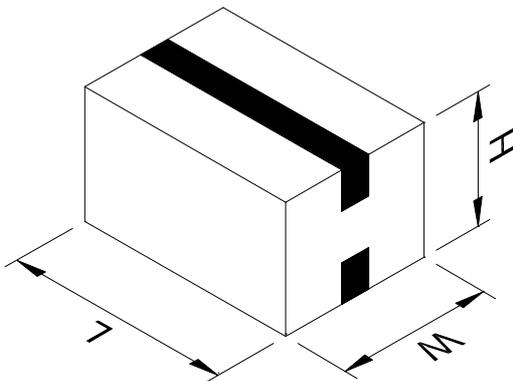
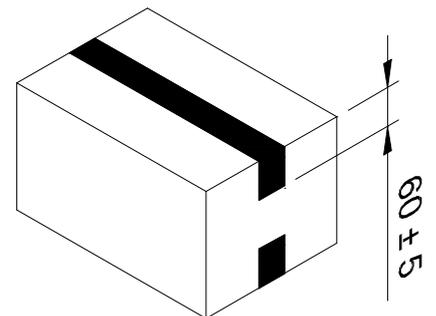
Width = 50mm (2")



## 6. Carton Sealing Length = Max. Length 60 mm±5mm

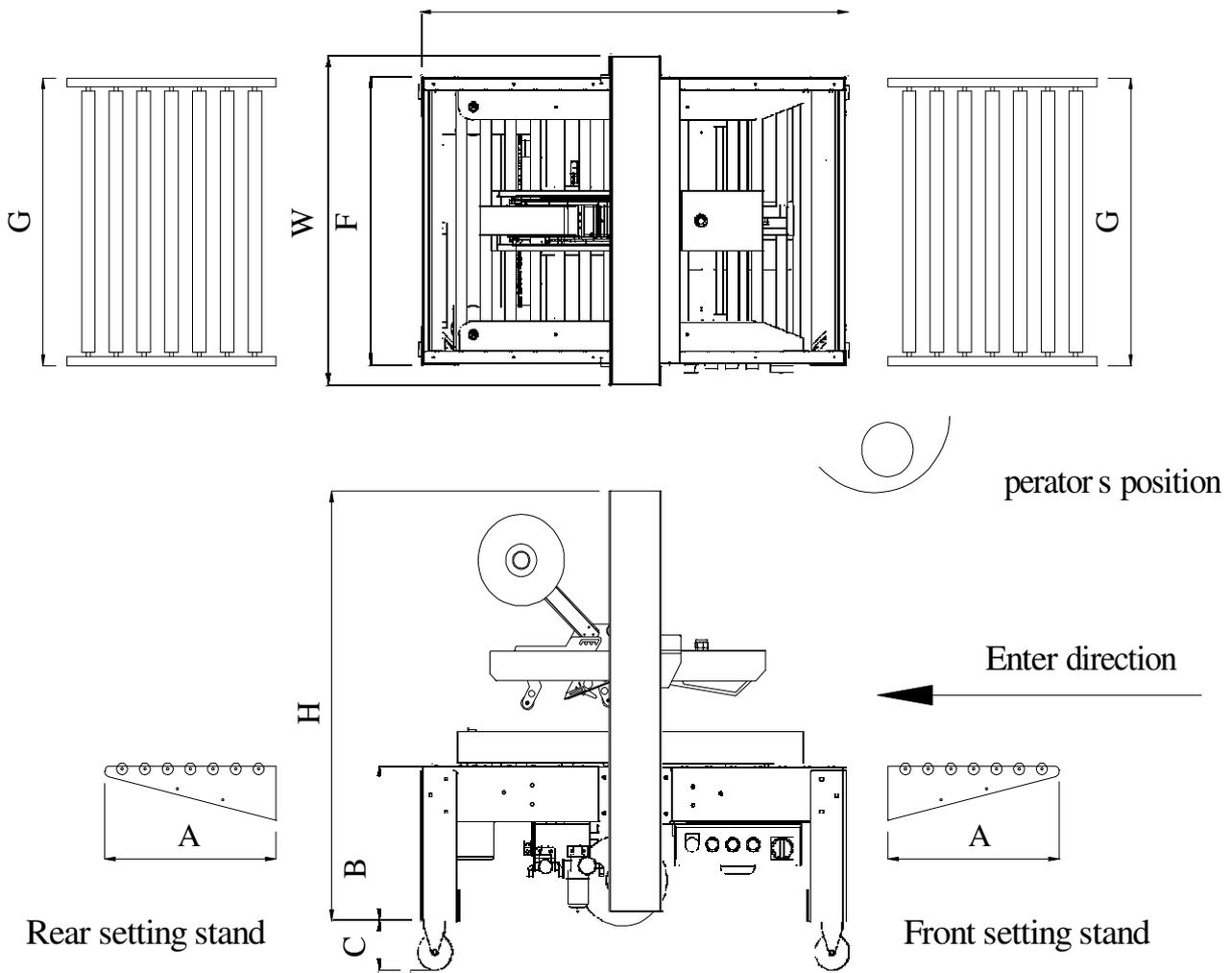
## 7. Standard Carton Dimension =

Standard Carton



	L	W	H
Min	150	110	150
Max	∞	500	500

7. Machine Size =



	W	L	H	A*	B	C	F	G
Min(mm)	-	-	1180	-	435	-	-	-
Max(mm)	910	1250	1330	500	635	135	805	655

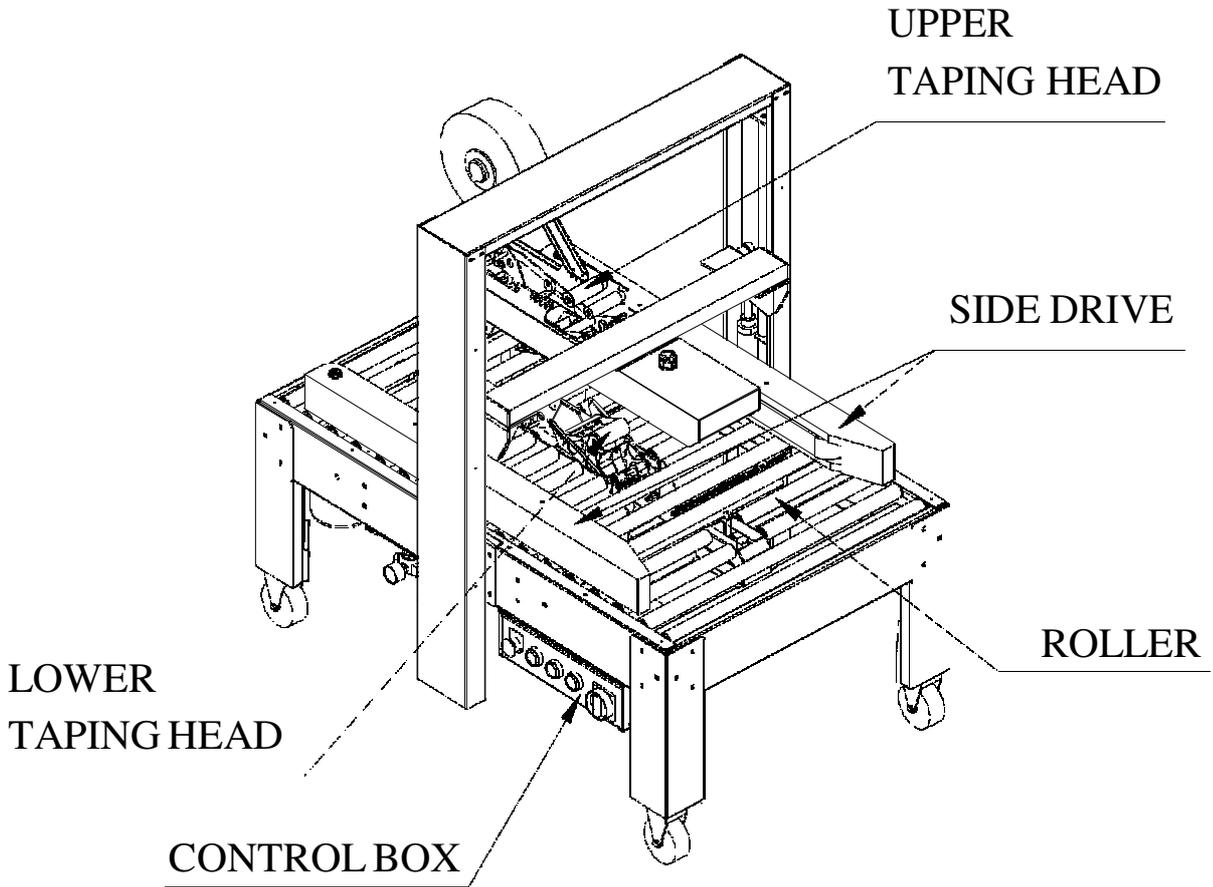
\*Option: Front and rear setting stand (according to customer appoint)

8. Sealing Speed = 20M!Min

9. There are "TWO" taping heads of this machine, upper and lower taping head for each.

# . ILLUSTRATION AND INSTALLATION

## ( A ) ILLUSTRATION OF MACHINE



## ( B ) ILLUSTRATION

Please install this machine according to the following procedure

1. Leg adjustment: This machine is equipped with the adjustable legs; the legs can be adjusted to obtain different height from min. 570mm to max. 770m, it is to be in accordance with the customer's conveyor height. Please refer to Figure3-1.
2. Check the power supply is in accordance with the voltage which the machine needs.
3. Install plastic pipe, Adjusting the pressure to 5~6kgf/cm<sup>2</sup>, Refer to Figure 3-2.
4. Thread the adhesive tape onto upper taping head and lower taping head.
5. Turn on the power, And put the carton into the entrance of the machine. When machine touches lower downward switch, the clips will move inward and upper driven moves downward, When fixed arm touches carton and approach switch reacts, The motor will star The belt will adjust to the suitable size for cartons. Refer to Figure 3-3.
6. The machine begins sealing. See Figure 3-4.

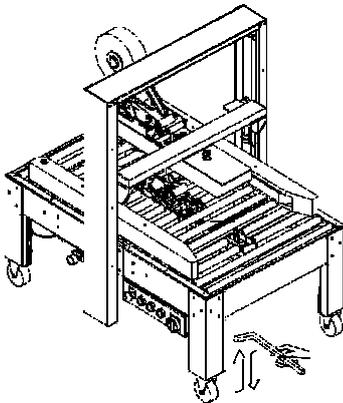


Figure 3-1

Must hang high the frame assembly is hanging and loosen leg holder screws, adjust needs the altitude.

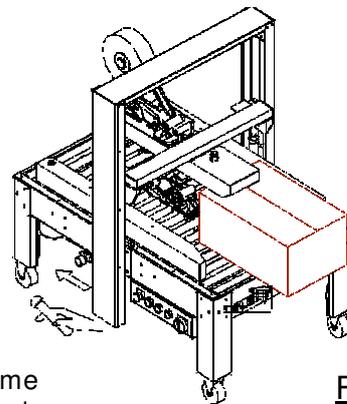


Figure 3-2

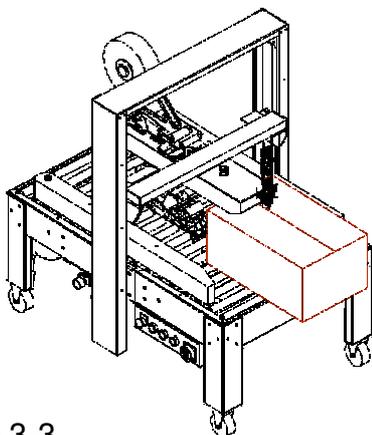


Figure 3-3

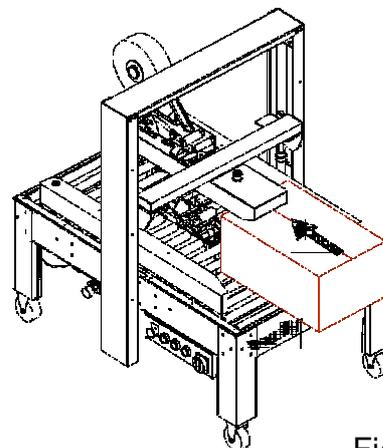
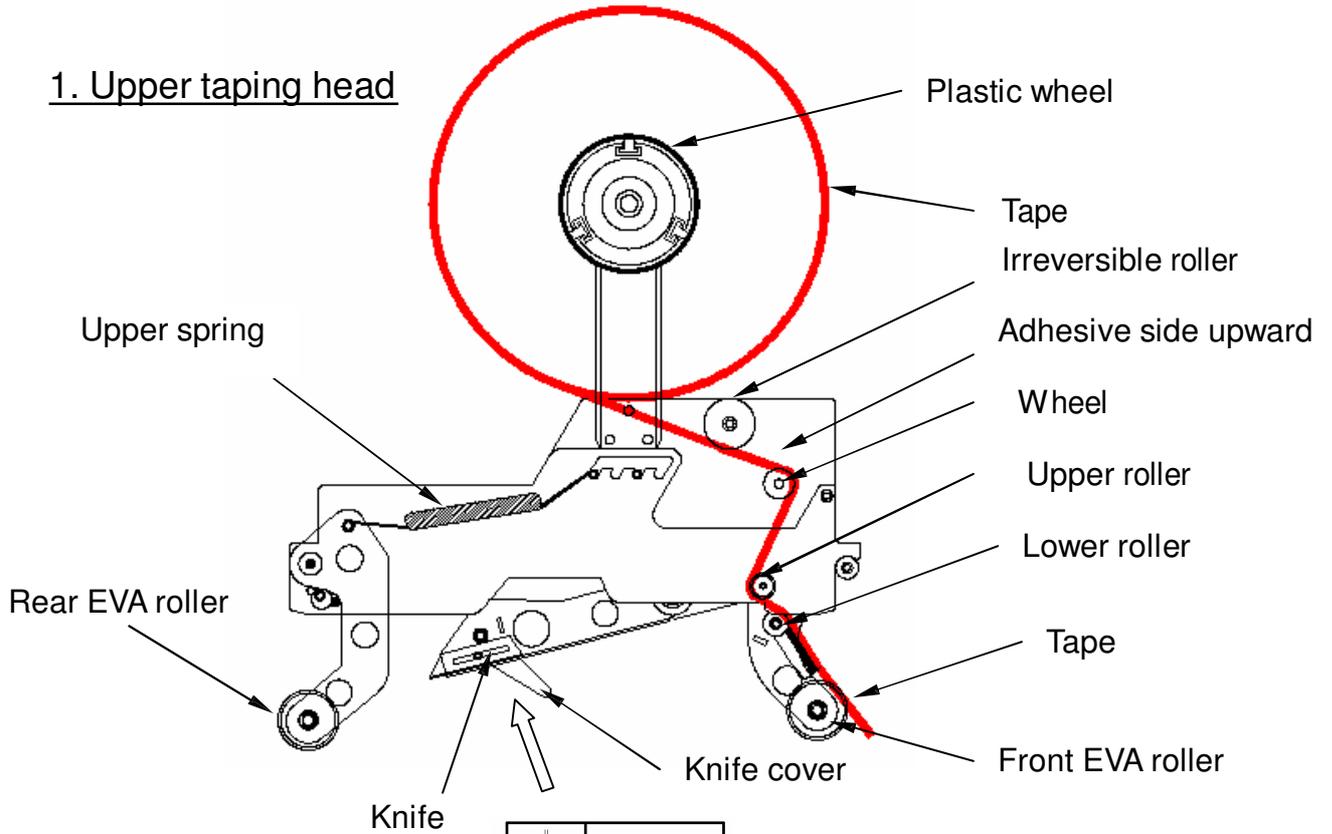


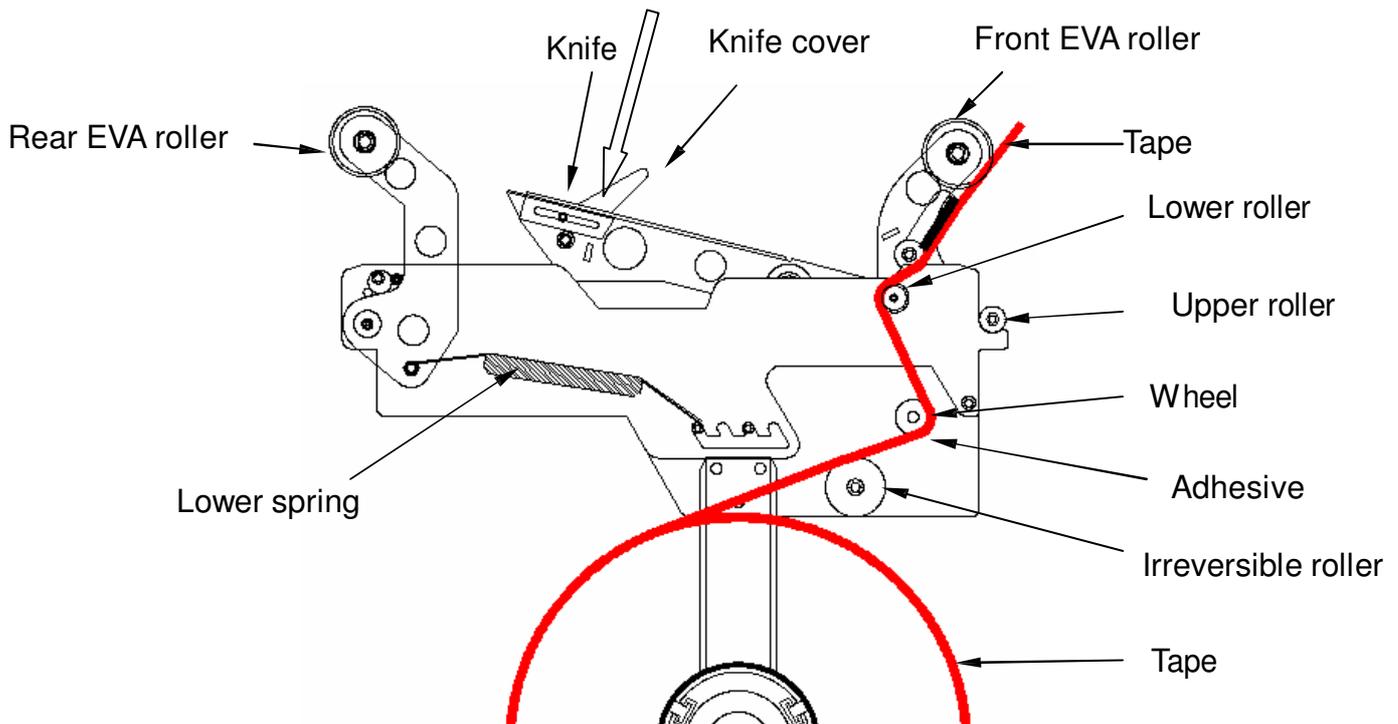
Figure 3-4

# ( C ) ILLUSTRATION OF TAPING HEAD

## 1. Upper taping head



## 2. Lower taping head



## ( D ) THREADING METHOD

- Threading method of upper taping head for  $60\pm 5\text{mm}$  carton sealing length:
  1. Fix the tape on the tape roll (adhesive side is up).
  2. Adhere the guide plate to the tape, as shown in Figure 4-1.
  3. Cut off the extra tape on the middle of rubber wheel, see Figure 4-2.
- Threading method of lower taping head for  $60\pm 5\text{mm}$  carton sealing length:
  1. Fix the tape on the tape roll (adhesive side is down).
  2. Adhere the guide plate to the tape, as shown in Figure 4-3.
  3. Cut off the extra tape on the middle of rubber wheel, see Figure 4-4.

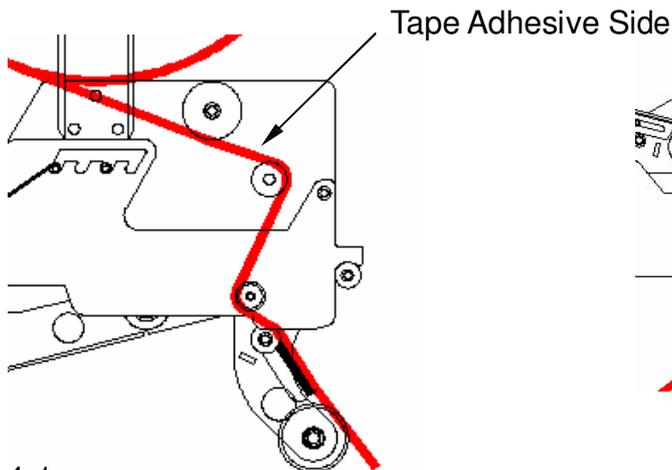


Figure 4-1

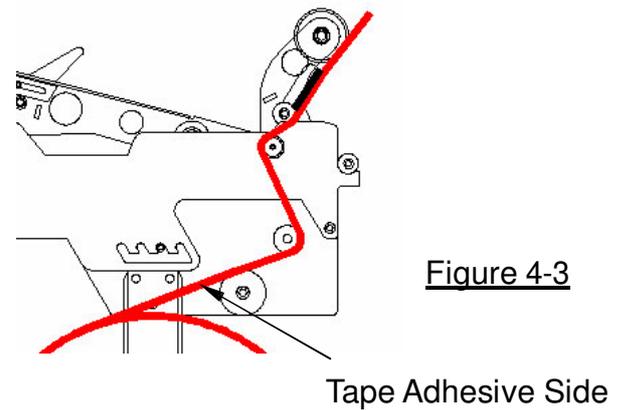


Figure 4-3

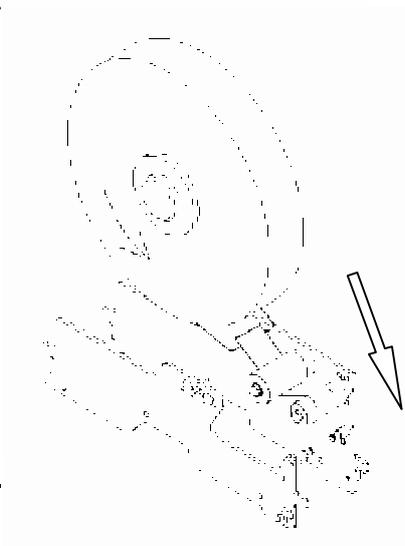


Figure 4-2



Figure 4-4

UPPER TAPING HEAD THREADING

LOWER TAPING HEAD THREADING

## . ADJUSTMENT

### ( A ) TAPE DRUM FRICTION BRAKE ADJUSTMENT

The tape will make the box too tight when the tape drum friction is too tight. When it is too loose, the tape drum friction will over travel and the tape will make the box too loose. Turn the knurled nut clockwise to increase the braking force, and counter- clockwise to decrease the braking force.

Adjust to minimum tension that prevents excessive tape roll over travel.

See Figure 5-1.

### ( B ) APPLYING MECHANISM SPRING ADJUSTMENT

When the spring is too loose, the tape can be cut off too early or the tape can not fully stay on the box. Also, when it is too tight, it can damage the box.

See Figure 5-2 for adjusting.

### ( C ) BOX DRIVEN BELT'S TENSION ADJUSTMENT

If the box driven belt's tension is too tight then the motor will overload and will breakdown easily. If too loosen, it will slip. When adjusting the box driven belt's tension, operator should move the cover away and adjust the screw. See Figure 5-3 Figure 5-3

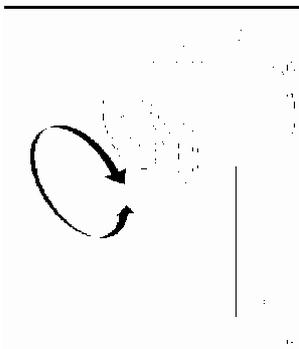


Figure 5-1

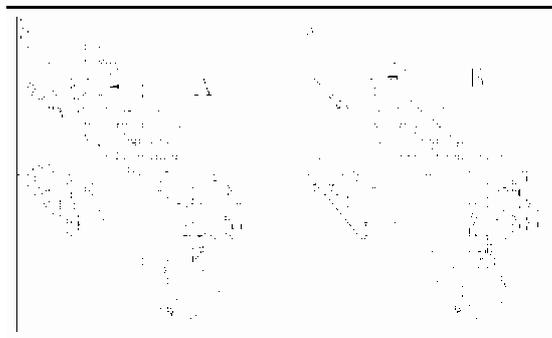


Figure 5-2

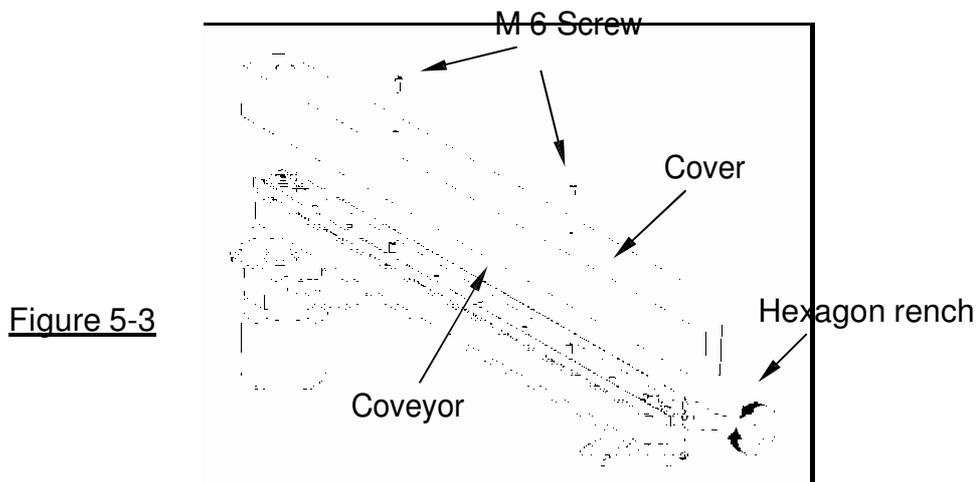


Figure 5-3

## V. MAINTENANCE

Before maintaining this machine, the maintenance person should read this manual carefully. In order to avoid dangerous, maintenance person must turn off the power before maintaining.

### ( A ) BLADE REPLACEMENT

As shown in Figure 6-1 ↗ loose the screw ( a ) .

Then, replace the new blade ( b ) with the beveled side away from the blade holder. Finally, tighten the screws ( a ) to secure the blade.

### ( B ) BOX DRIVEN BELTS REPLACEMENT

Refer to Figure 6-2. Loosen tension screws ( a ) counter-clockwise until all tension is removed , remove and retain center plate. Remove splicing pin ( b ) from old belt to remove and discard. Place new belt over pulleys with laced splice at top. Insert splicing pin. Pin must not extend beyond the edge of belt. Replace the side cover and center plate, secure with original fasteners.

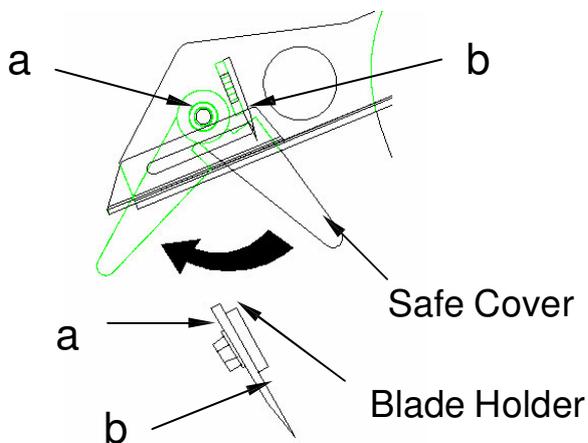


Figure 6-1

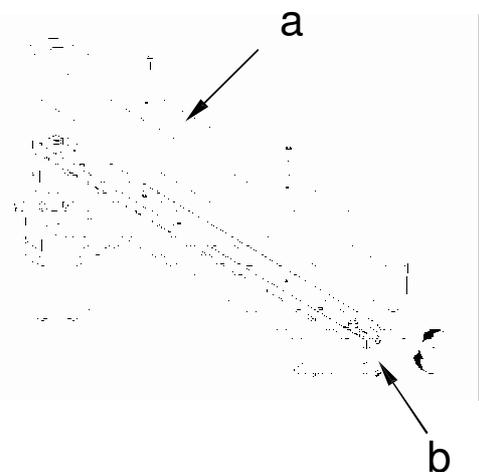


Figure 6-2

### ( C ) MACHINE CLEANNESS AND LUBRICATING

In order to make the machine operation normally, all parts that movable in the machine have to lubricate by 30# machine oil every week. And blade should be checked everyday if there is too much viscose on it.

## . SEALING BOX ADJUSTMENT

The standard of carton sealing size  $60\pm 5\text{mm}$ , it can be changed according to the customer's request. Before adjusting, please make sure that the power is turned off. If the power is not disconnected, sever injury to personnel would occur easily.

1. As shown in figure 7-1, rotate and adjust the shaft-spacer to be at the position which is 60mm below the taping head and rubber wheel, then the carton sealing length will be 60mm long.

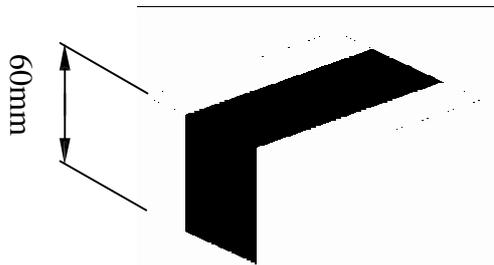


Figure 7-1

2. As shown in figure 7-2, re-thread the adhesive tape.

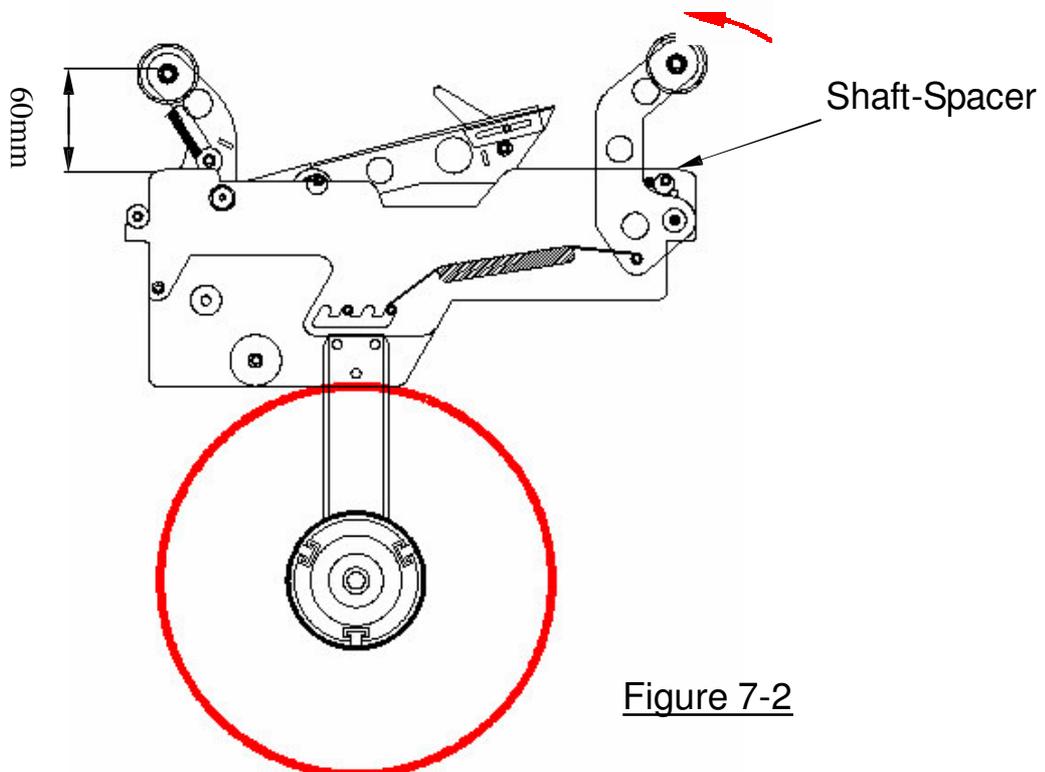
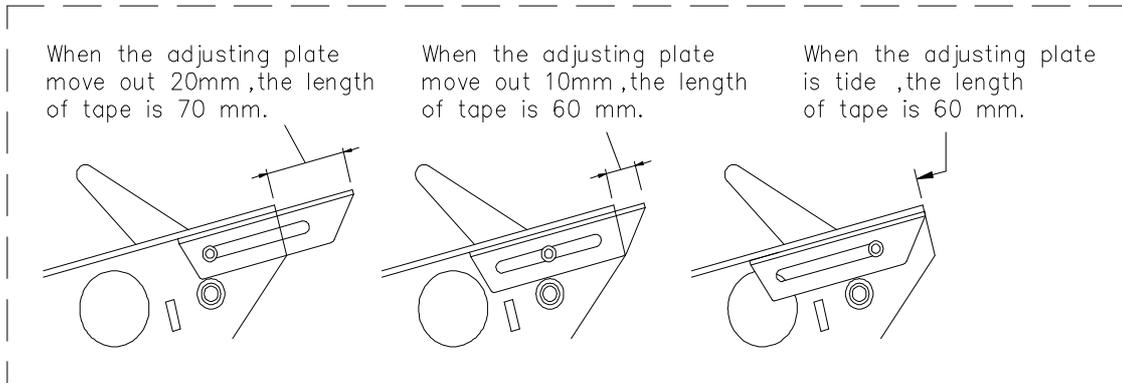


Figure 7-2

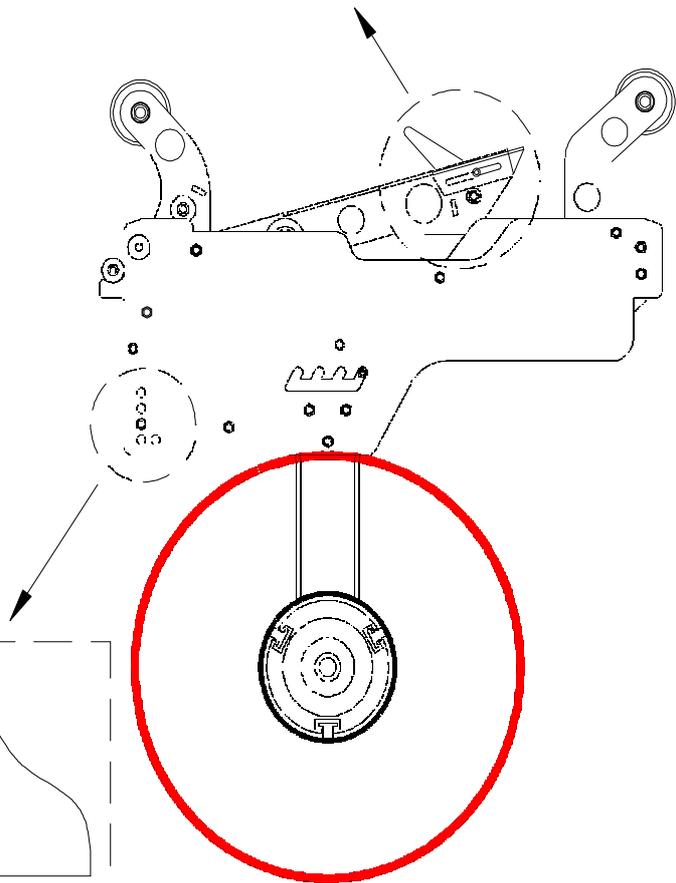
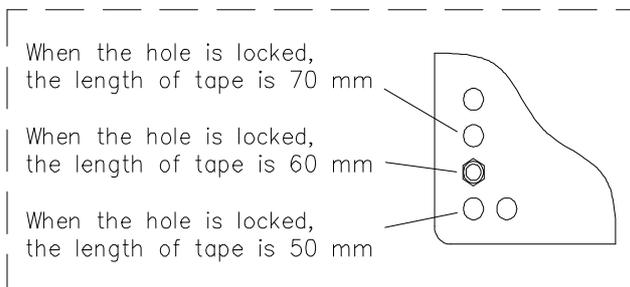
3. Turn on the power to check whether the length is desirable.

# PROCESS OF OVERLAP ADJUSTMENT

## Length adjustment of rear tape



## Length adjustment of front tape



## . TROUBLE SHOOTING

Problem	Possible Causes	Resolution
Driven Belts do not convey boxes.	Boxes are too narrow, size incorrect.	Check machine spec. Boxes are too narrow than recommended. They will cause slippage and belts worn.
	Driven Belts worn.	Replace a new driven belt.
	The pressure of upper tapping head is insufficient.	Adjust the height of upper tapping head.
	Rubber wheel tension of tape head is insufficient	Adjust the position of cam
	Tapping head applying spring set too high.	Reduce spring pressure
Conveyor belt can NOT move.	The belt tension is insufficient	Adjust the belt tension
	The power is off	Check the power is on
	The motor does not run	Check if the motor worn out or not. Replace it
The upper tapping head interfere with the lower tapping head	The position of upper tapping head is too low.	Refer to Sealing Box Adjustment. Adjust the length of carton sealing into 60mm.
The driven belts breaks	Belt worn out	Replace belt
	Excessive belt tension	Adjust belt tension
The light box tangle at exit.	The position of upper tapping head is too low.	Adjust the height of upper tapping head
Boxes tangle in tapping head.	The position of upper tapping head is too low.	Adjust the height of upper tapping head
The tape roll makes a reverse turn.	The one-direction roller worn out.	Replace for a new roller

Blade can NOT cut tape or tape's end is jagged or shredded	The blade blunt or breaks	Replace for a new blade
	The strength of tape tension is not enough	Put screws of tape drum assembly anti- clockwise to loosen
	The glue is on the blade	Clean blades
	The blade is not in place	Adjust the blade.
	The set screw of the blade is worn out or loose	Replace or tighten the screws.
Machine makes noises	The bearing of belt bearing bracket- worn out.	Replace bearing NO.6205ZZ
The length of overlap tape on the carton too short	Threading mistake	Refer to threading chapter
	Tape's tension too low	Adjust the tape drum assembly's tension
	Trap out feed holder too low	No gap between strap out feed holder and slice
The length of the overlap on the carton too short	Upper, lower out feed roller not smooth	Get rid of dirty and lubricate
	Blade's position too outside	Adjust the blade's position
	Threading mistake	Re-thread strap
	Tension of tape drum assembly too strong	Loosen the nut of tape drum assembly anti-clockwise
Tape not adhere to the center	Carton not toward the cantering guide	Adjust the carton's position
	Centering guides not centered	Adjust centering guide
Tape wrinkle NOT adhere well	Roller of tapping head not smooth	Discard the dirty & lubricate
	The position of upper tapping head is too height	Adjust the height of upper tapping head bracket
Tape's head of lower tapping head is upright down	Strap out feed holder too low	Adjust slice of strap out feed holder and strap out feed holder, no gap

## . SELF- PROVIDED PARTS SUGGESTION

There are” TWO” taping heads of this machine , upper and lower taping head for each.

Below the quantities are for “EACH” taping head.

No.	Part No.	Description	Q'ty
1	CHS6803-2002	Roller- Buffing	4
2	CHS6803-3005	Tight Spring of Upper Taping Head	1
3	CHS6803-3006	Tight Spring of Lower Taping Head	1
4	CHS6803-4007	Blade	2
5	CHS6803-4009	Spring- Cutter	4

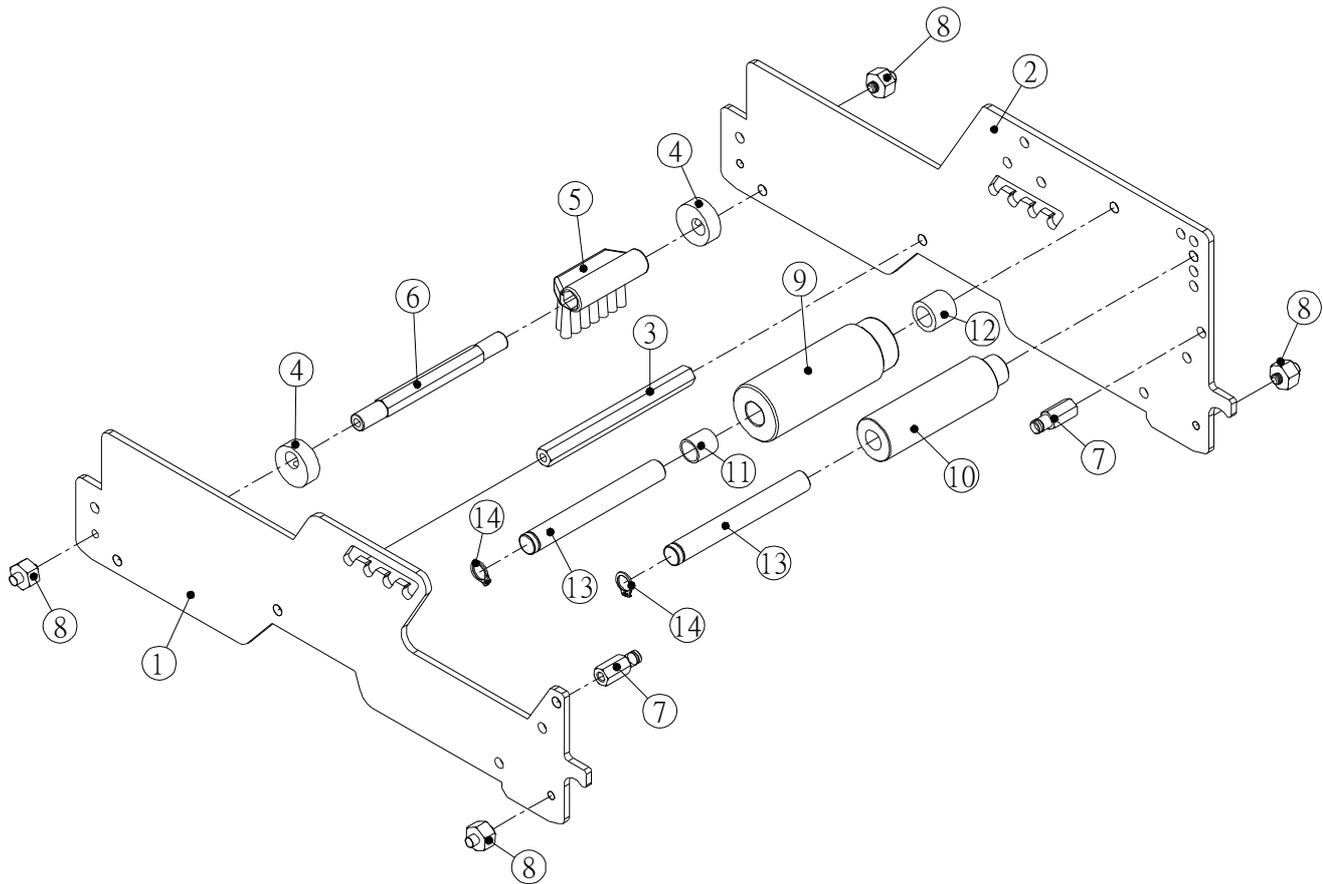
## 3” TAPING HEAD ASSEMBLY AND PART LIST

※ There are” TWO” taping heads of this machine, upper and lower taping head for each.

※ Below the quantities are for “ONE” taping head.

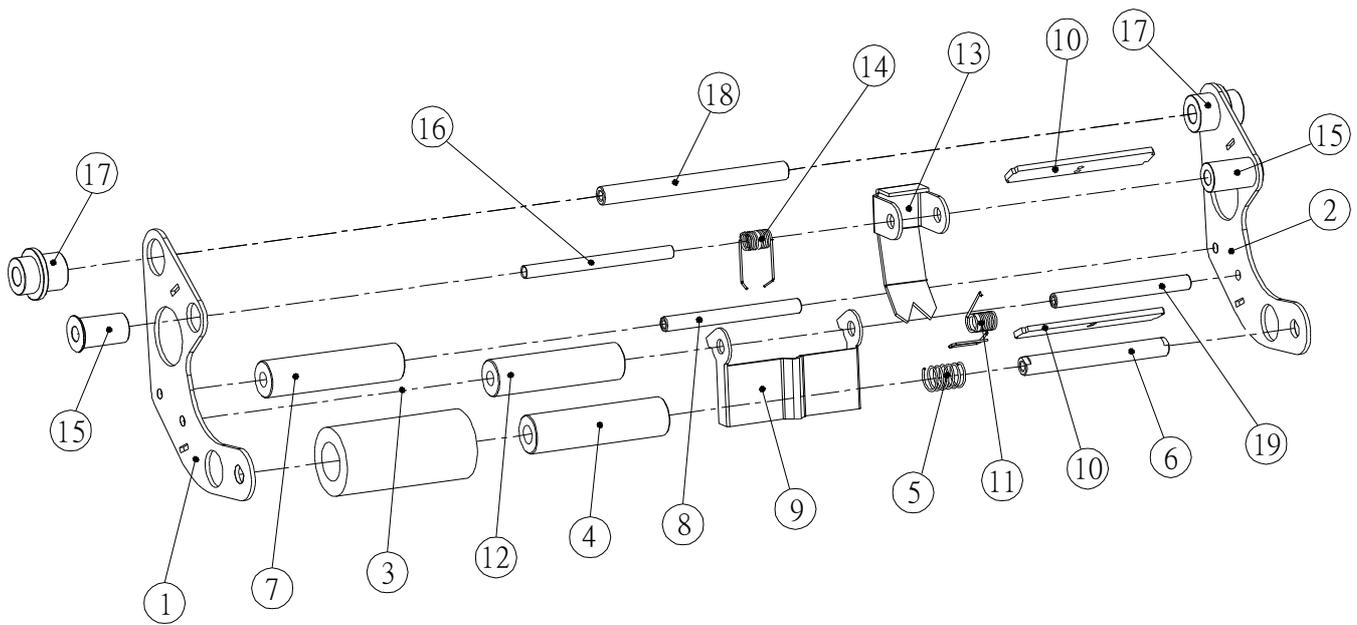
Fig.1	Frame Unit .....	1
Fig.2	Front Applying Arm .....	2
Fig.3	Rear Applying Arm .....	3
Fig.4	Blade Unit .....	4
Fig.5	Link Unit .....	5
Fig.6	Tape Assembly .....	6

**Fig 1. Frame Unit**



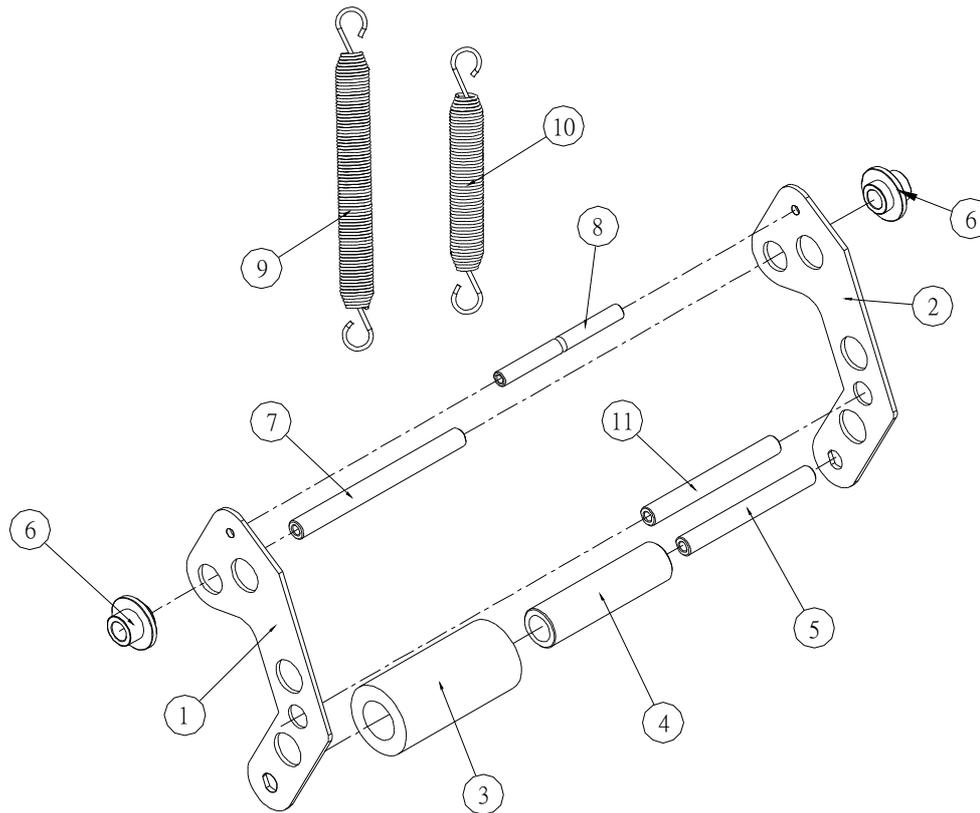
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-1001	Frame Upper Assembly -Left	1
2	CHS-6803-1002	Frame Upper Assembly -Right	1
3	CHS-6803-1003	Spacer-Upper	2
4	CHS-6803-1004	Ciller-Adjust Tension	2
5	CHS-6803-1006	Brush	1
6	CHS-6803-1007	Shaft-Spacer	1
7	CHS-6803-1008	Clamp-Spring	2
8	CHS-6803-1009	Screw	4
9	CHS-6803-1010	Pattern Roll	1
10	CHS-6803-1011	Roller	1
11	1215	Bearing	1
12	NSK TROO FC12 LOCK	Bearing	1
13	CHS-6803-1012	Shaft	2
14	087	C Type Check Ring	4

**Fig 2. Front Applying Arm**



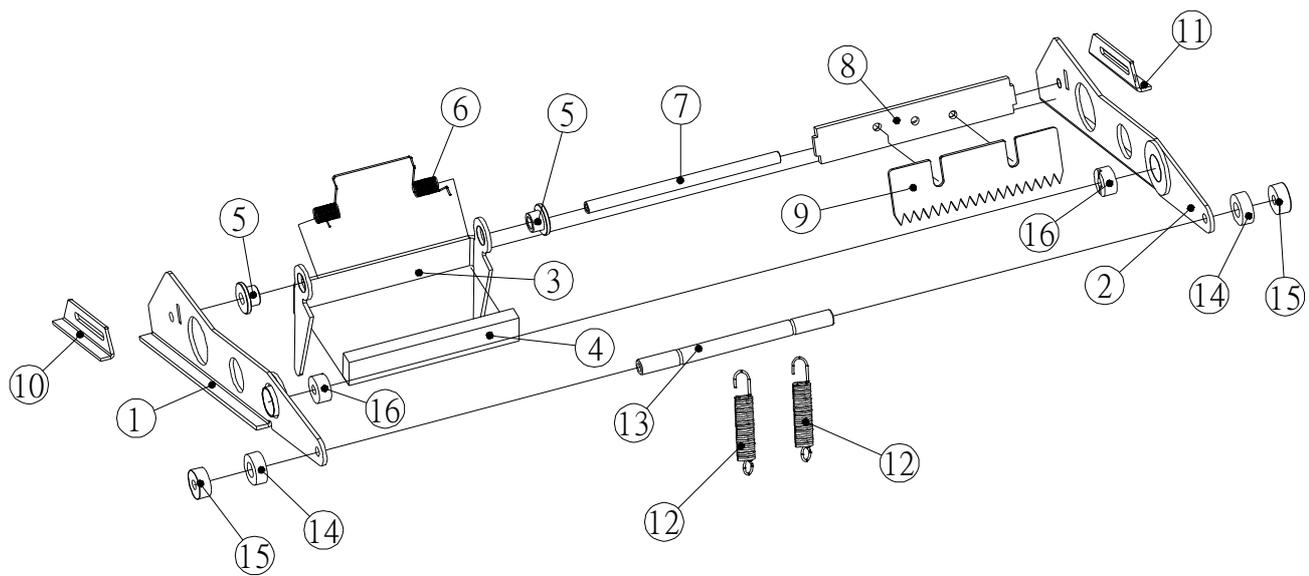
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-2001	Applying Arm -Left	1
2	CHS-6803-2001	Applying Arm -Right	1
3	CHS-6803-2002	Roller-Applying NM	1
4	CHS-6803-2003	Bushing-Applying Roller	1
5	CHS-6803-2004	Spring-compression	1
6	CHS-6803-2005	Shaft	1
7	CHS-6803-2006	Roller-Knurled Assembly	1
8	CHS-6803-2018	Shaft	1
9	CHS-6803-2008	Plate-Tape	1
10	CHS-6803-2009	Plate-Tape	2
11	CHS-6803-2010	Spring	1
12	CHS-6803-2011	Roller-Wrap	1
13	CHS-6803-2012	Plate-Tape	1
14	CHS-6803-2013	Spring	1
15	CHS-6803-2014	Spacer-Applying Arm	2
16	CHS-6803-2015	Shaft	1
17	CHS-6803-2016	Spacer-Applying Arm	2
18	CHS-6803-2017	Shaft	1
19	CHS-6803-2007	Shaft	1

**Fig 3. Rear Applying Arm**



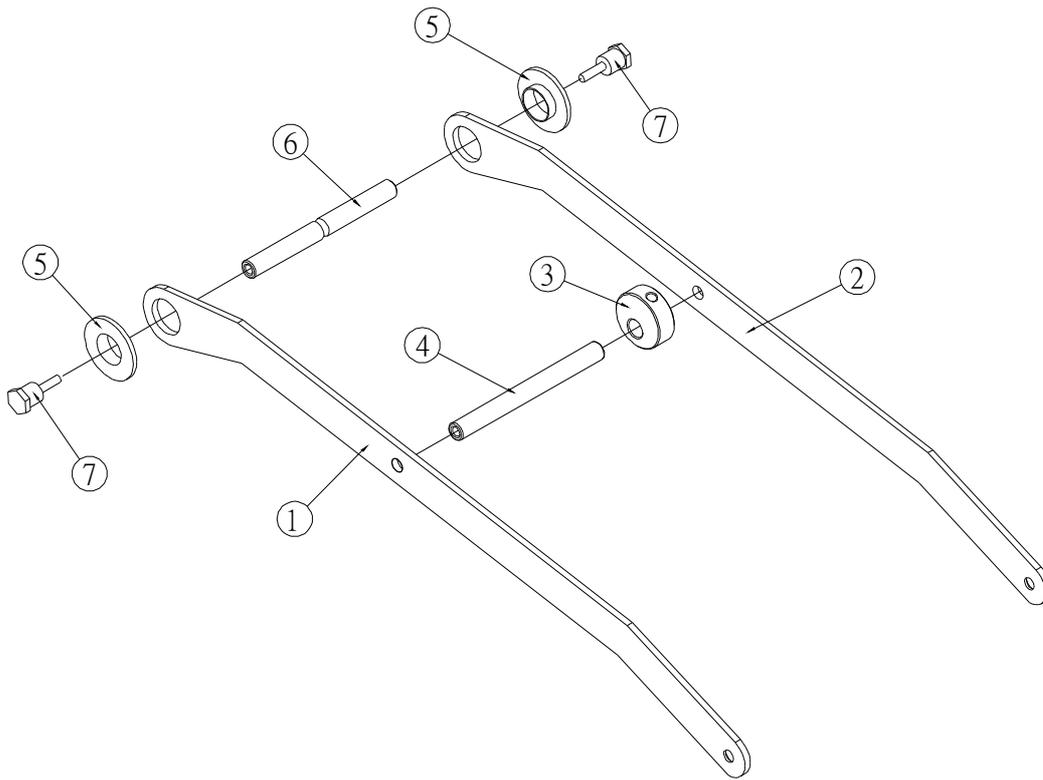
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-3001	Bushing Arm-Sub Assembly -Left	1
2	CHS-6803-3001	Bushing Arm-Sub Assembly -Right	1
3	CHS-6803-2002	Roller-Buffing MM	1
4	CHS-6803-3002	Bushing-Buffing Roller	1
5	CHS-6803-2005	Shaft-Buffing Roller	1
6	CHS-6803-3003	Shaft Bushing	2
7	CHS-6803-2017	Shaft	1
8	CHS-6803-3004	Ring Shaft	1
9	CHS-6803-3005	Tight Spring -Upper	1
10	CHS-6803-3006	Tight Spring -Lower	1
11	CHS-6803-2007	Shaft	1

**Fig 4. Blade Unit**



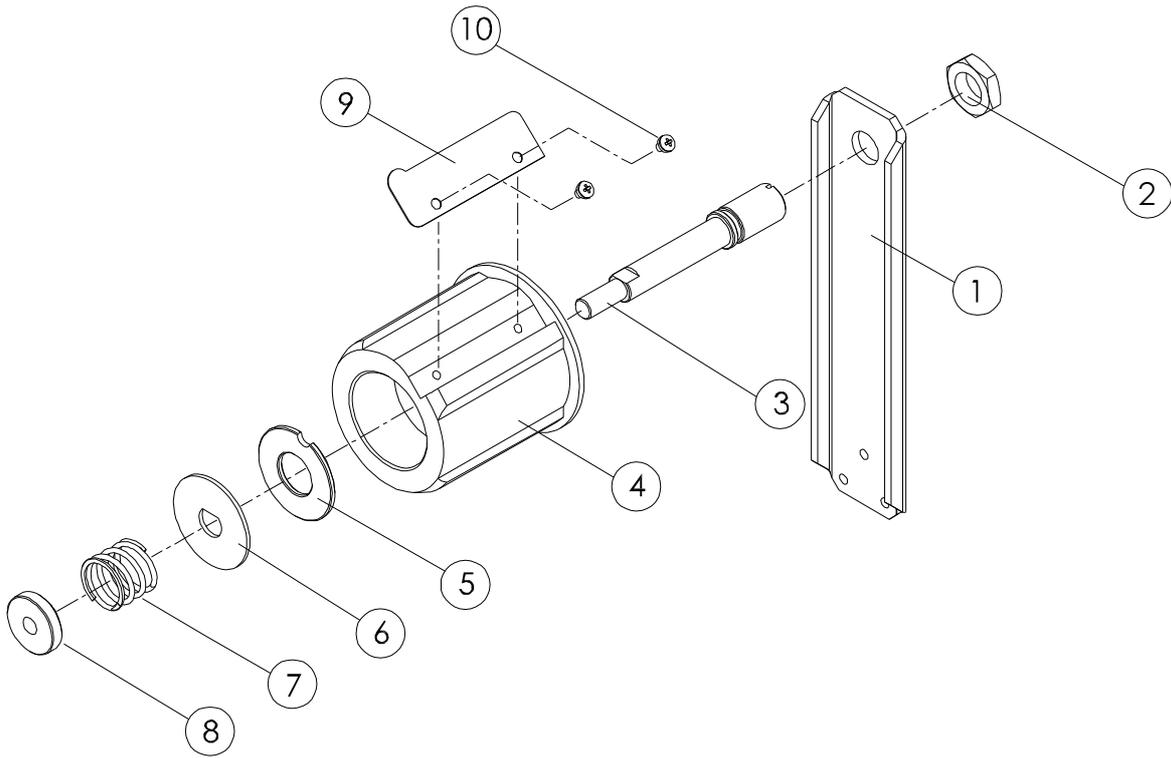
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-4001	Frame-Rear Cut-Off Weldment -Left	1
2	CHS-6803-4001	Frame-Rear Cut-Off Weldment -Right	1
3	CHS-6803-4002	Blade Guard	1
4	CHS-6803-4002	Cushioning Plate	1
5	CHS-6803-4003	Stop-Blade Assembly	2
6	CHS-6803-4004	Spring-Blade Guard	1
7	CHS-6803-4005	Shaft-Blade Guard	1
8	CHS-6803-4006	Plate-Blade	1
9	CHS-6803-4007	Blade	1
10	CHS-6803-4008	Adjustable Plate -Left	1
11	CHS-6803-4008	Adjustable Plate -Right	1
12	CHS-6803-4009	Spring Cutter	2
13	CHS-6803-4010	Shaft Spacer	1
14	CHS-6803-4011	Spacer	2
15	CHS-6803-4012	Spacer	2
16	CHS-6803-4013	Pivot-Cutter Lever	2

**Fig 5. Link Unit**



Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-5001	Left Link-Arm Bushing Assembly	1
2	CHS-6803-5001	Right Link-Arm Bushing Assembly	1
3	CHS-6803-5002	Cam- Tension	1
4	CHS-6803-2015	Shaft	1
5	CHS-6803-5003	Axle Bushing Bearing Shoulder	2
6	CHS-6803-5004	Shaft Pivot	1
7	CHS-6803-5005	Screw-Bearing Shoulder	2

**Fig 6. Tape Assembly**



Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-6001	Bracker Tape Drum	1
2	CHS-6803-6011	Nut	1
3	CHS-6803-6004	Shaft -Tape Drum	1
4	CHS-6803-6005	Tape Drum Assembly	1
5	CHS-6803-008	Washer -Friction	1
6	CHS-6803-6007	Washer -Friction	1
7	CHS-6803-6010	Thension Spring	1
8	CHS-6803-6009	Ring Nut -Adjustment	1
9	CHS-6803-6006	Taping Fixed Plat	1
10	FSTS 5/32" X 5/8"	Screw	2

# **AUTO CARTON SEALER**

## **Machine Frame Assembly and Part List**

**Applicative model No:**

***JP-501A***

Fig 1. Machine Body Device Assembly Figure.....	1
Machine Body Device Assembly Parts List .....	2~3
Fig 2. Lifting Device Assembly Figure.....	4
Lifting Device Assembly Parts List.....	5
Fig 3. Drive Device Assembly Figure.....	6
Drive Device Assembly Parts List .....	7
Fig 4. Upper Base Device Assembly Figure.....	8
Upper Base Device Assembly Parts List .....	9

Fig 1. Machine Body Device Assembly Figure

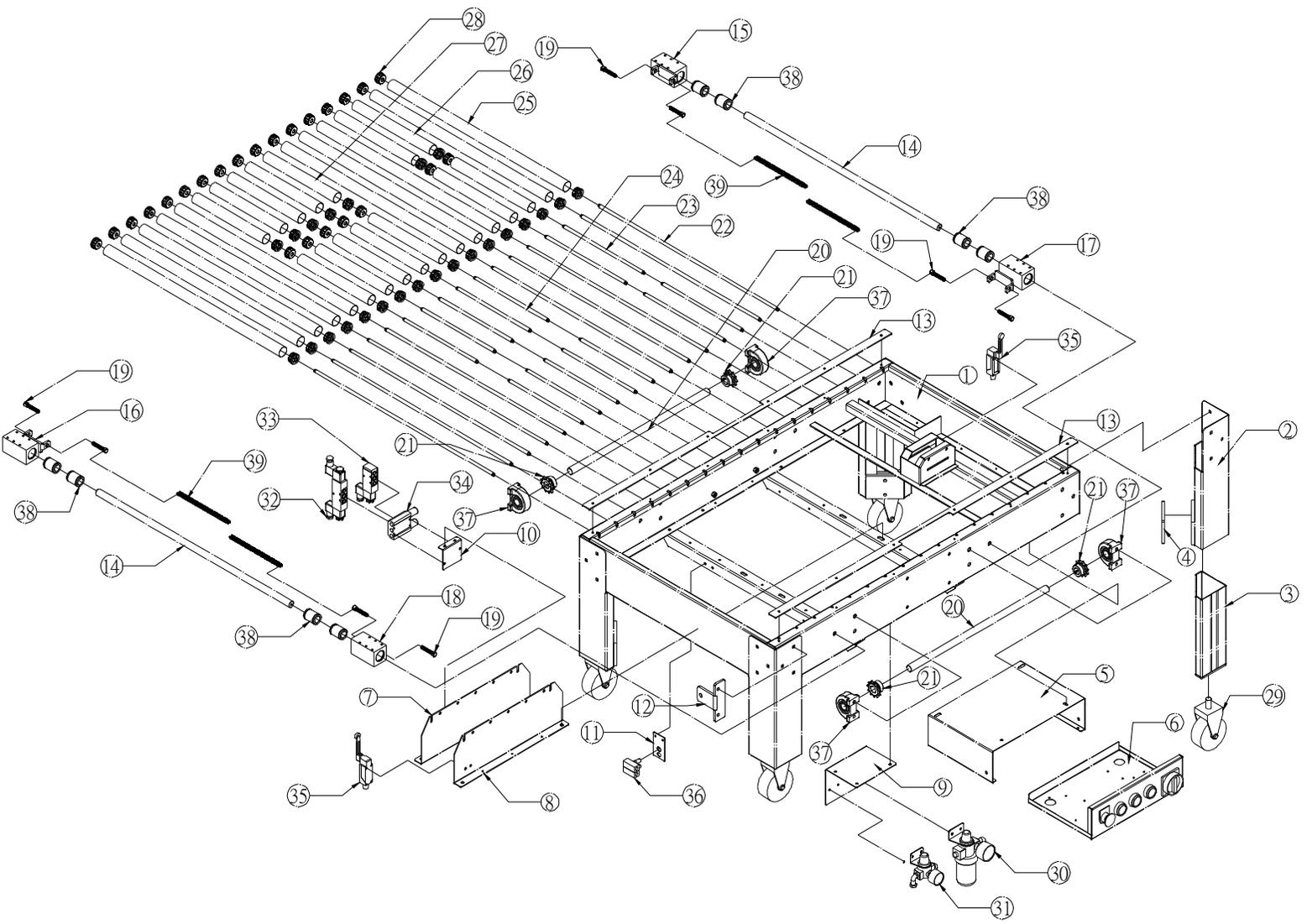


Table 1. Machine Body Device Assembly Parts List

Ref. No.	Part No.	Description	Q'ty
1	CHS6603A-1001	Machine Frame	1
2	CHS6603-1003	Outside Support Leg	4
3	CHS6603-1004	Inside Support Leg	4
4	CHS6603-1005	Clamp- Legs	4
5	CHS6603A-1004	Electrical Control Box Case	1
6	CHS6603A-1005	Electrical Control Box	1
7	CHS6603A-1002	Taping Head Applying Arm-R	1
8	CHS6603A-1003	Taping Head Applying Arm-L	1
9	CHS6603A-1006	Two Point Assembly Holder	1
10	CHS6603A-1007	Magnetic Valve Holder	1
11	CHS6603A-1008	Adjusted Valve Holder	1
12	CHS6603A-1009	Cylinder Base	1
13	CHS6603A-1011	Press Plate- Roller Shaft	2
14	CHS6603A-1015	Moving holder shaft	2
15	CHS6603A-1013	Moving Holder-F-L	1
16	CHS6603A-1013	Moving Holder -B-L	1
17	CHS6603A-1014	Moving Holder -F-R	1
18	CHS6603A-1014	Moving Holder -B-R	1
19	CHS6603A-1018	Adjusted Screw of Chain	8
20	CHS6603A-1016	Driven Shaft	2
21	CHS6603A-1017	Chain Wheel	4
22	CHS6603A-1019	Long Roller Shaft	10
23	CHS6603A-1020	Roller Shaft	4
24	CHS6603A-1021	Roller Shaft	10
25	CHS6603A-1022	Long Roller	10
26	CHS6603A-1023	Long Roller	4

Ref. No.	Part No.	Description	Q'ty
27	CHS6603A-1024	Long Roller	10
28	CHS6603-1020	Plastic Cap – Roller (closer)	48
29	5 / 8"	Caster	4
30	MAFR300-8A	Three Points Assembly	1
31	AR-2000	Adjusted Pressure Valve	1
32	MVSC-260-4E1	Magnetic Valve	1
33	MVSC-260-4E2C	Magnetic Valve	1
34	MVSC-260-5B2	Magnetic Valve Holder	1
35		Limit Switch	2
36	MSC200-8A	Adjusted Speed Valve	2
37	UCPA204	Needle Bearing	4
38	LM20UU	Linear Bearing	8
39	RS#40	Chain	4

Fig 2. Lifting Device Assembly Figure

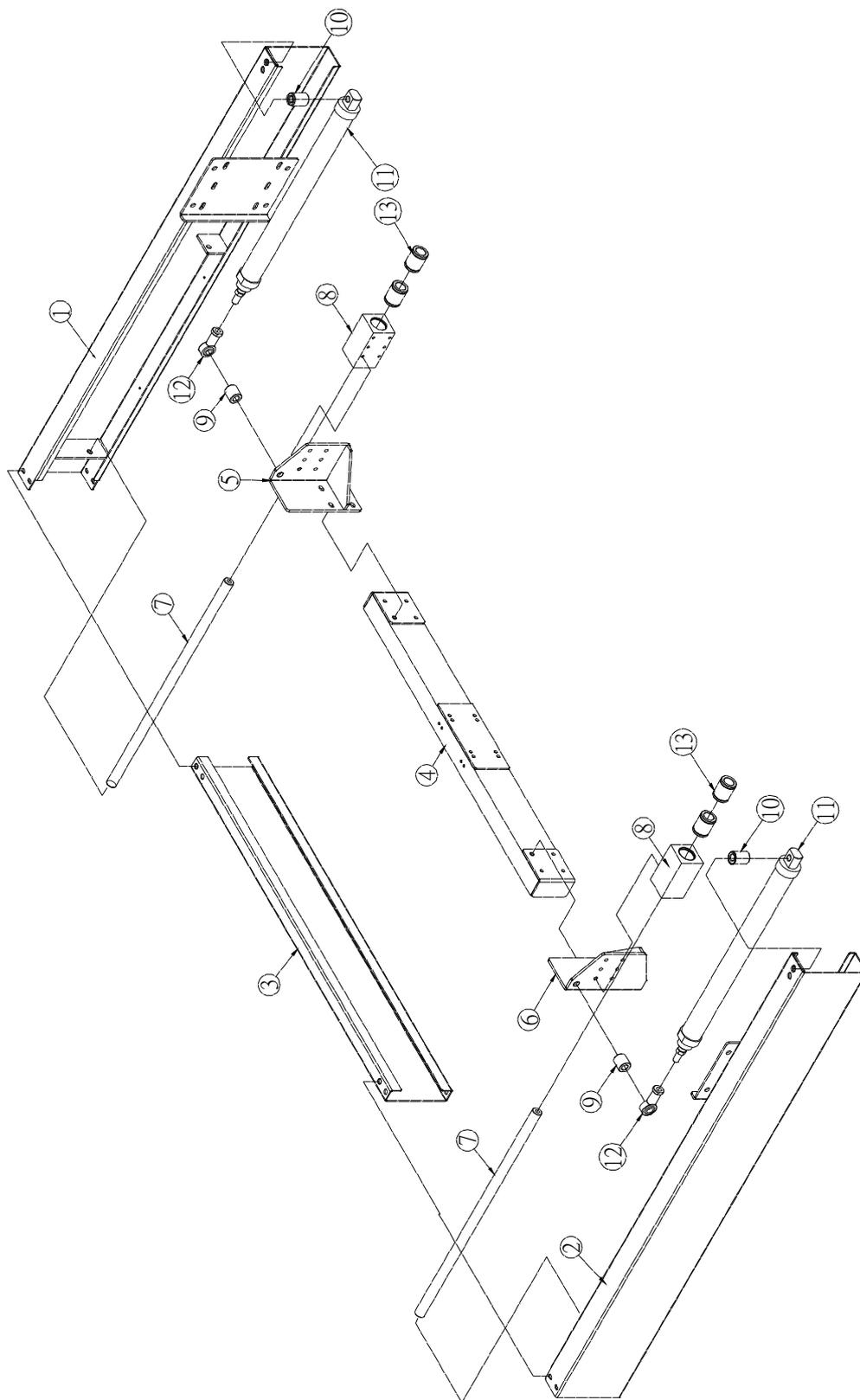


Table 2. Lifting Device Assembly Parts List

Ref. NO.	Part No.	Description	Q'ty
1	CHS6603A-2001	LH Column	1
2	CHS6603A-2001	RH Column	1
3	CHS6603A-2005	Upper Horizontal Column	1
4	CHS6603A-2003	Upper Pillar	1
5	CHS6603A-2004	LH Holder	1
6	CHS6603A-2004	RH Holder	1
7	CHS6603A-2002	Shaft	2
8	CHS6603A-1012	Moving Holder	2
9	CHS6603A-2006	Ring-Upper	2
10	CHS6603A-2007	Ring-Lower	2
11	MCMA-11-40-400A	Cylinder	2
12	PHS12	bearing	2
13	LM20UU	Linear Bering	4

Fig 3. Drive Device Assembly Figure

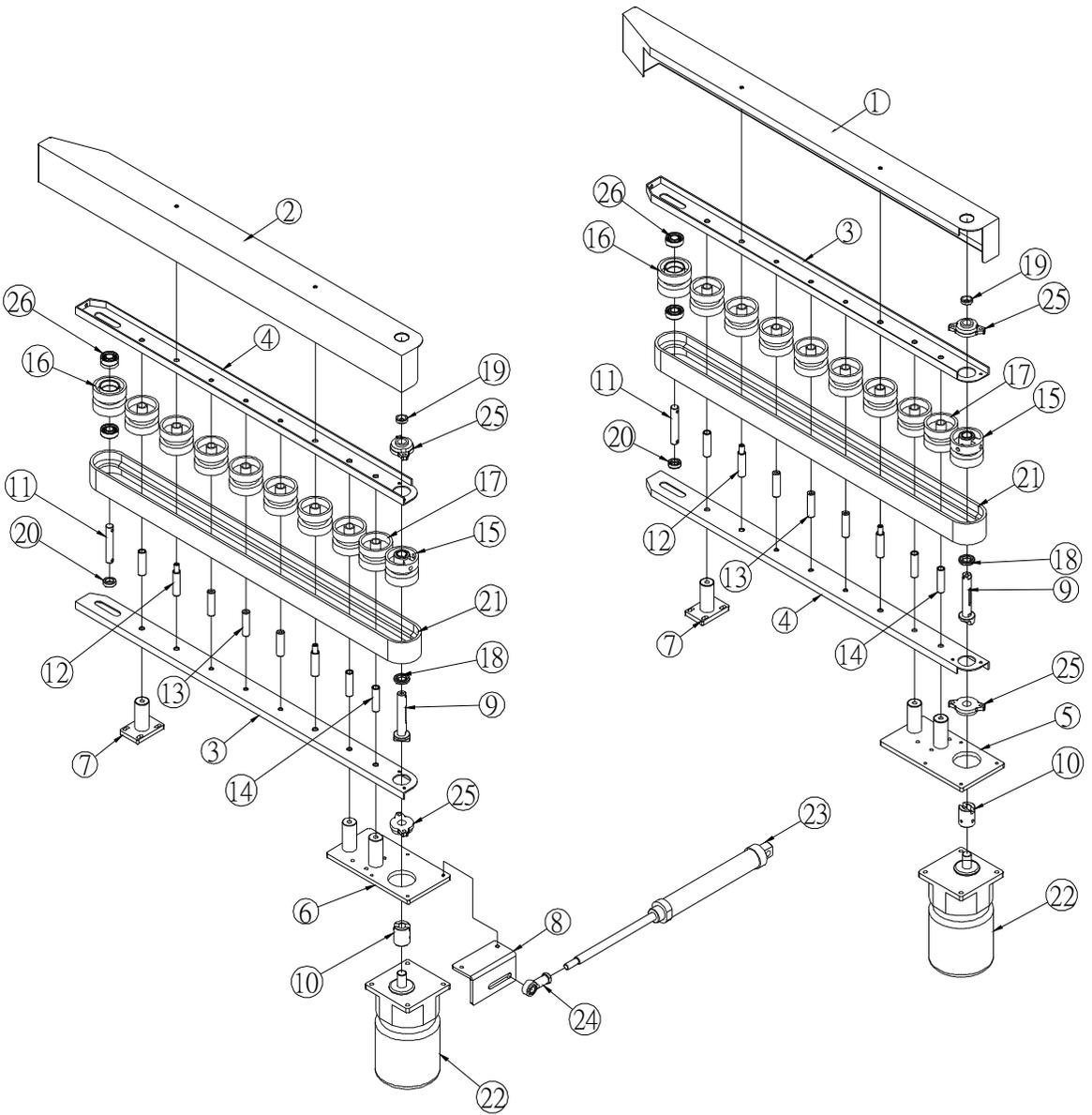


Table 3. Drive Device Assembly Parts List

Ref. No.	Part No.	Description	Q'ty
1	CHS6603-3001	Cover- Left	1
2	CHS6603-3001	Cover- Right	1
3	CHS6603-3002	Belt Bracket – R lower/L Upper	2
4	CHS6603-3002	Belt Bracket – L lower/R Upper	2
5	CHS6603-3003	Rear Driven Bracket-L	1
6	CHS6603-3003	Rear Driven Bracket-R	1
7	CHS6603-3004	Front Driven Bracket	2
8	CHS6603A-1010	Air pressure Push Board	1
9	CHS6603-3005	Main Driven Bracket	2
10	CHS6603-3006	Lower Driven Shaft	2
11	CHS6603-3007	Secondary Driven Bracket	2
12	CHS6603-3008	Belt Cover Shaft	4
13	CHS6603-3009	Long Idle Wheel Shaft	6
14	CHS6603-3010	Inner Bushing – Belt Wheel	6
15	CHS6603-3013	Main Belt Wheel	2
16	CHS6603-3014	Secondary Belt Wheel	2
17	CHS6603-3015	Idle Wheel	16
18	CHS6603-3011	Washer	2
19	CHS6603-3012	Main Driven Shaft Washer	2
20	CHS6603-3017	Washer	2
21	CHS6603-3016	Driven Belt	2
22	1/5HP	Gear Motor	2
23	Ø 40X200	Cylinder	1
24	PHS12	Connector	1
25	UFL003	Bearing	4
26	6202	Bearing	4

Fig 4. Upper Base Device Assembly Figure

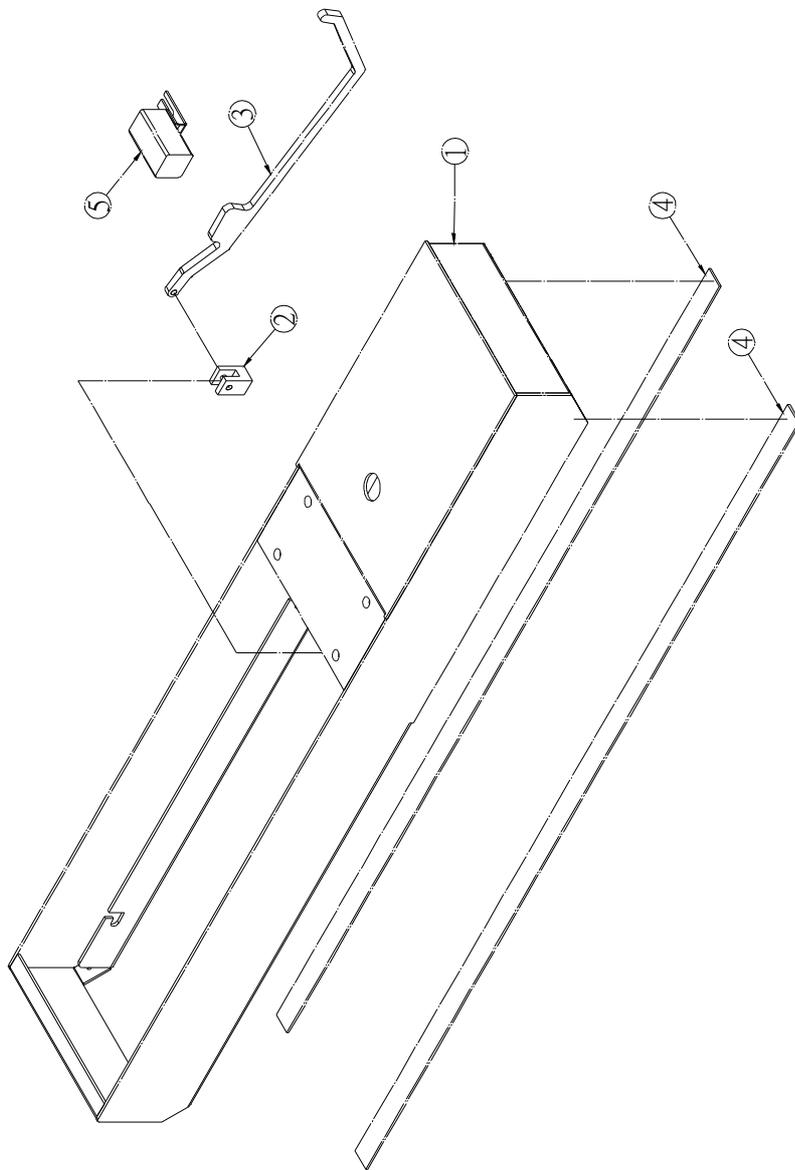
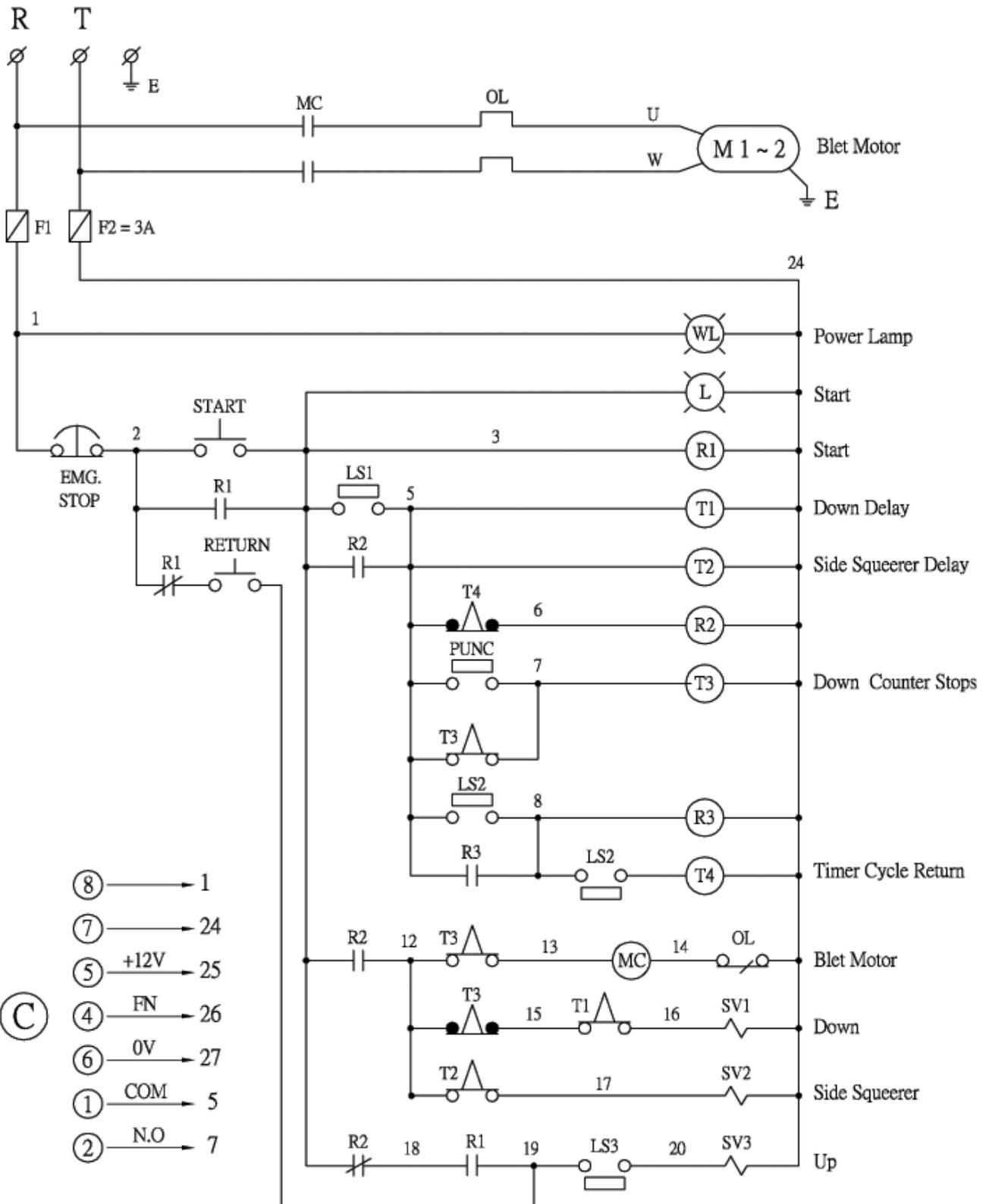


Table 4. Upper Base Device Assembly Parts List

Ref. No.	Part No.	Description	Q'ty
1	CHS6601A-4001	Upper Frame	1
2	CHS6603A-4002	Entrance Switch Sensor	1
3	CHS6603A-4003	Holder	1
4	CHS6601A-4002	Teflon	2
5	-	Entrance Switch	1

1∅ AC220V



- (C)
- ⑧ → 1
  - ⑦ → 24
  - ⑤ +12V → 25
  - ④ FN → 26
  - ⑥ 0V → 27
  - ① COM → 5
  - ② N.O → 7

T1 : Squeeerer  
 T2 : Down  
 T3 : Height  
 T4 : EXIT

# PNEUMATIC CIRCUIT DIAGRAM

