



8 NET, Inc.

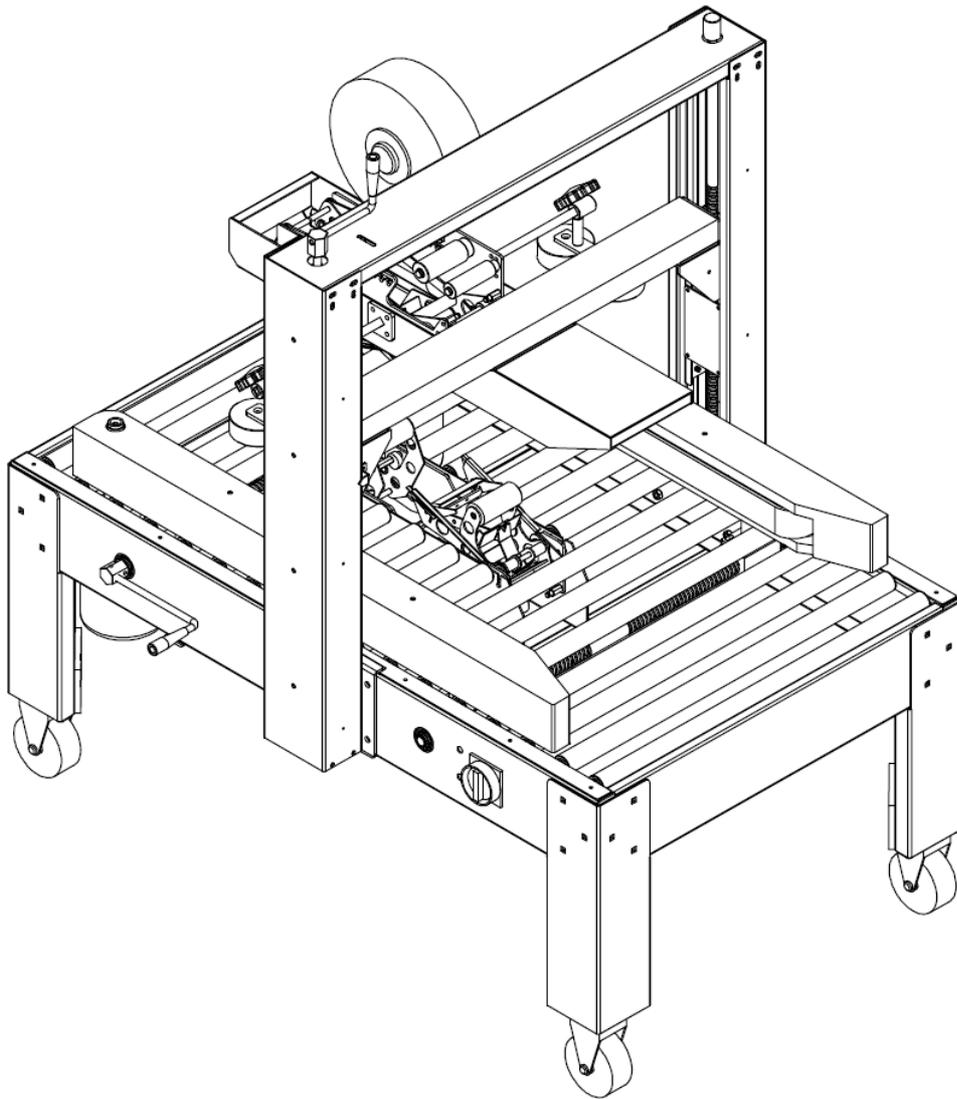
Installation Guide / Operating Manual

**CTM-SA236, Semi-Automatic Tape
Sealing Machine**

JP-501

CARTON SEALER

Manual



JP-501 CARTON SEALER

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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.

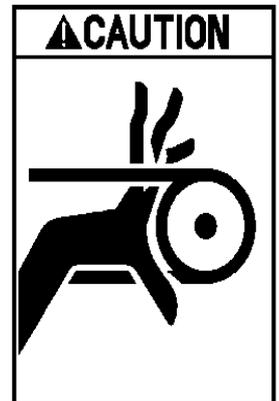


Figure 1-2

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

II. 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 : 1 ϕ , 110V/220V , 60Hz/50Hz

3 ϕ , 220V/380V/415V/440 , 60Hz/50Hz

(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 : 76 mm (3")

Outside Diameter : 280 mm (11")

Tape Width : 50 mm (2")

6. Carton Sealing Length :

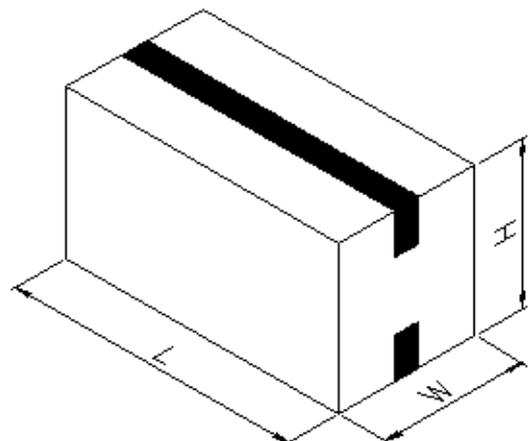
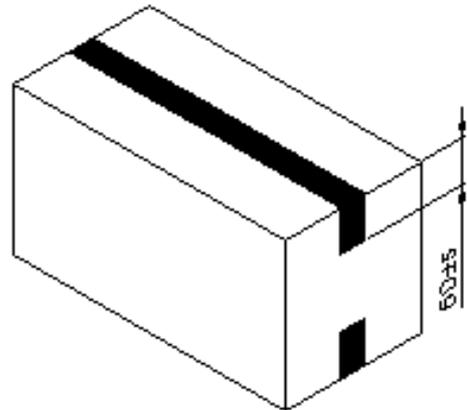
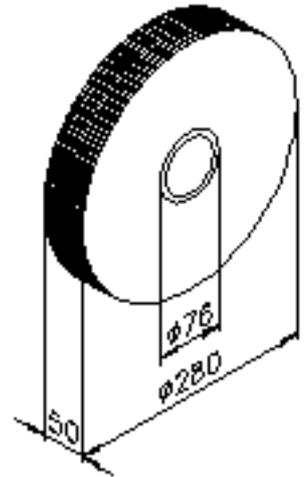
Max. Length 60 mm \pm 5 mm

7. Standard Carton Dimension :

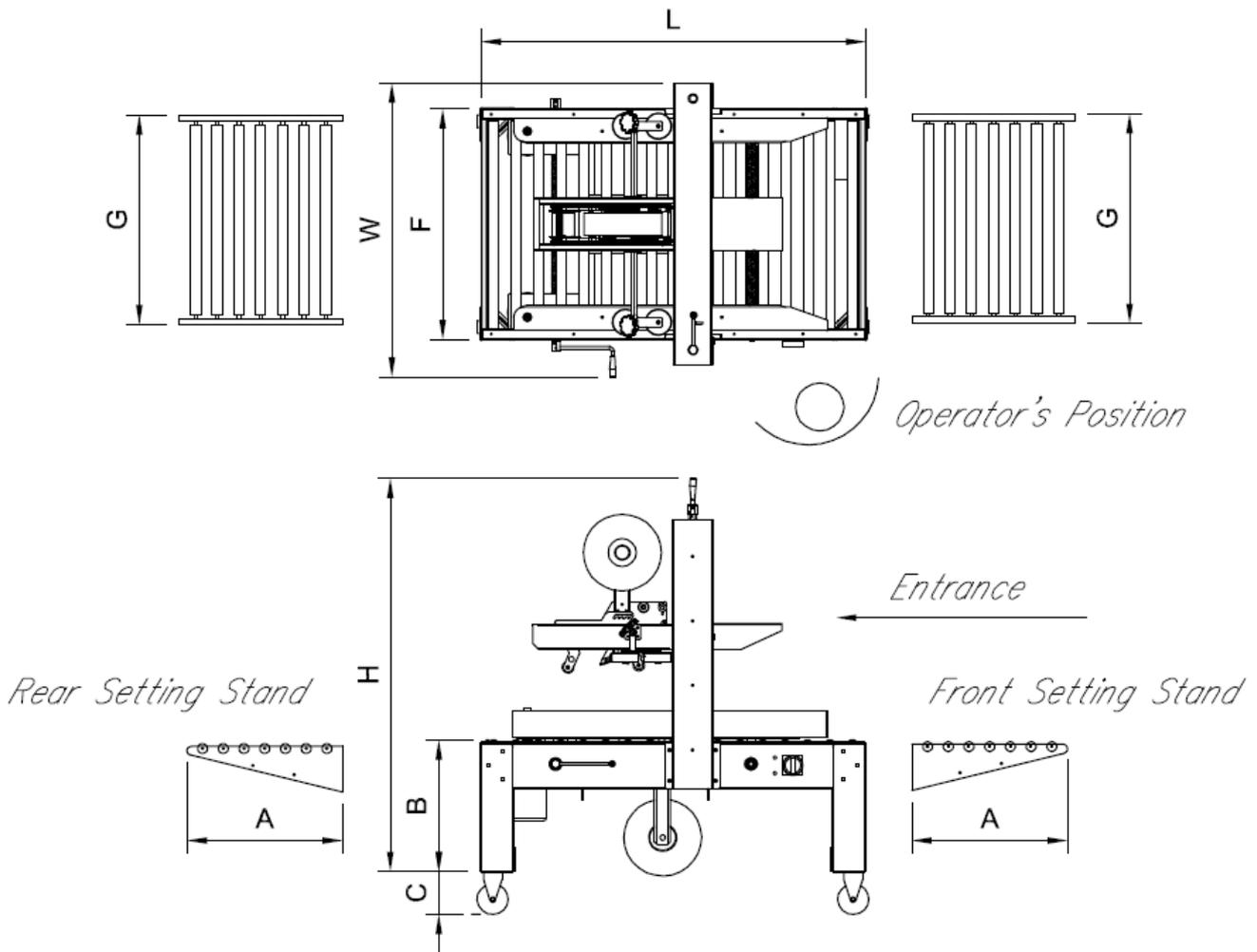
Standard Carton

	<i>L</i>	<i>W</i>	<i>H</i>
<i>Min</i>	<i>150</i>	<i>130</i>	<i>110</i>
<i>Max</i>	∞	<i>500</i>	<i>500</i>

Carton Weight : Max. Weight 30 kg



8. Machine Size :



	W	L	H	A*	B	C	F	G
MIN (mm)	-	-	1419	-	435	-	-	-
MAX (mm)	960	1250	1560	500	635	135	765	650

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

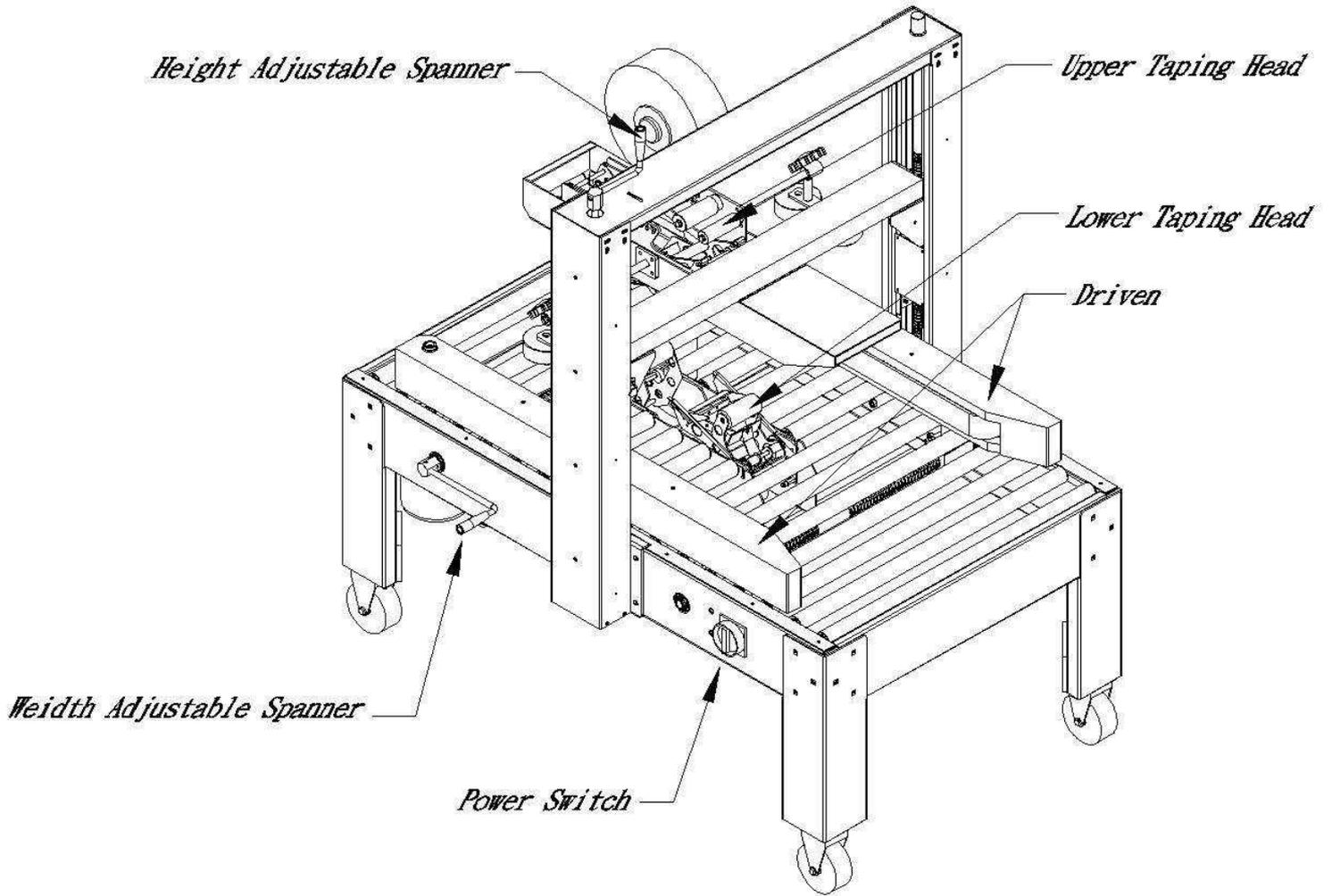
9. Machine Weight : N.W. 180kg , G.W. 250 kg.

10. Sealing Speed : Up to 40 Carton / Min.

11. There are two taping heads of the machine, upper and lower taping head for each..

III. Illustration and Installation

A) Illustration Of Machine



B) Illustration of Initial Setting

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 Figure2-1.
2. Put the carton toward the centering guide at the exit that turns the driven belt adjustable handle then adjusted to wheel. Please refer to Figure 2-2.
3. Adjust the upper taping head to meet the different cartons height. Please refer to Figure 2-3.
4. Thread the adhesive tape onto upper taping head and lower taping head..
5. Please check that the power supply is in accordance with the voltage which the machine needs.
6. The machine begins sealing. See Figure 2-4

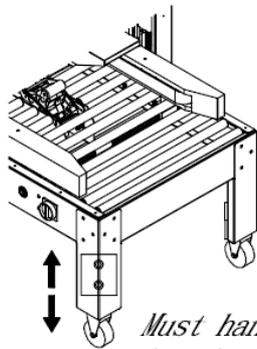


Figure 2-1

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

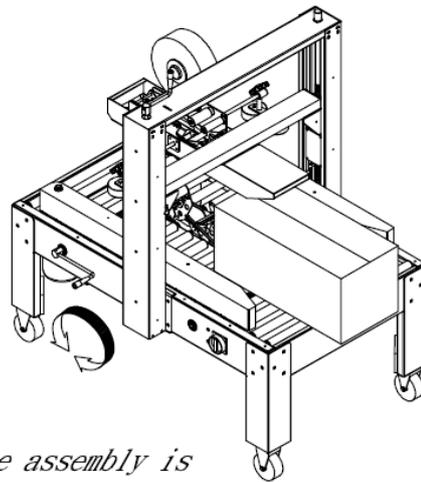


Figure 2-2

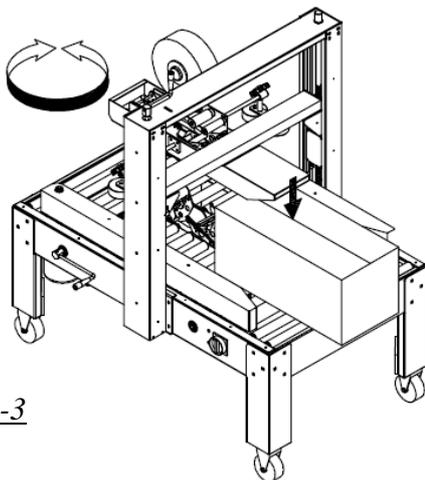


Figure 2-3

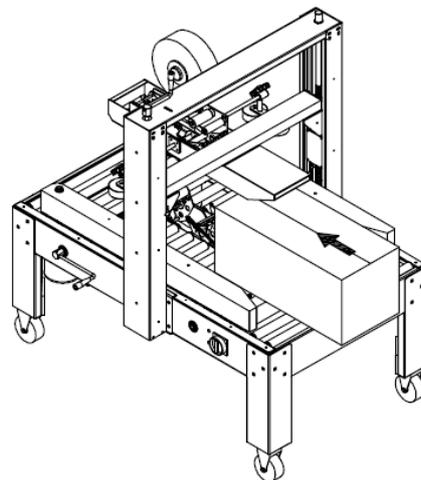
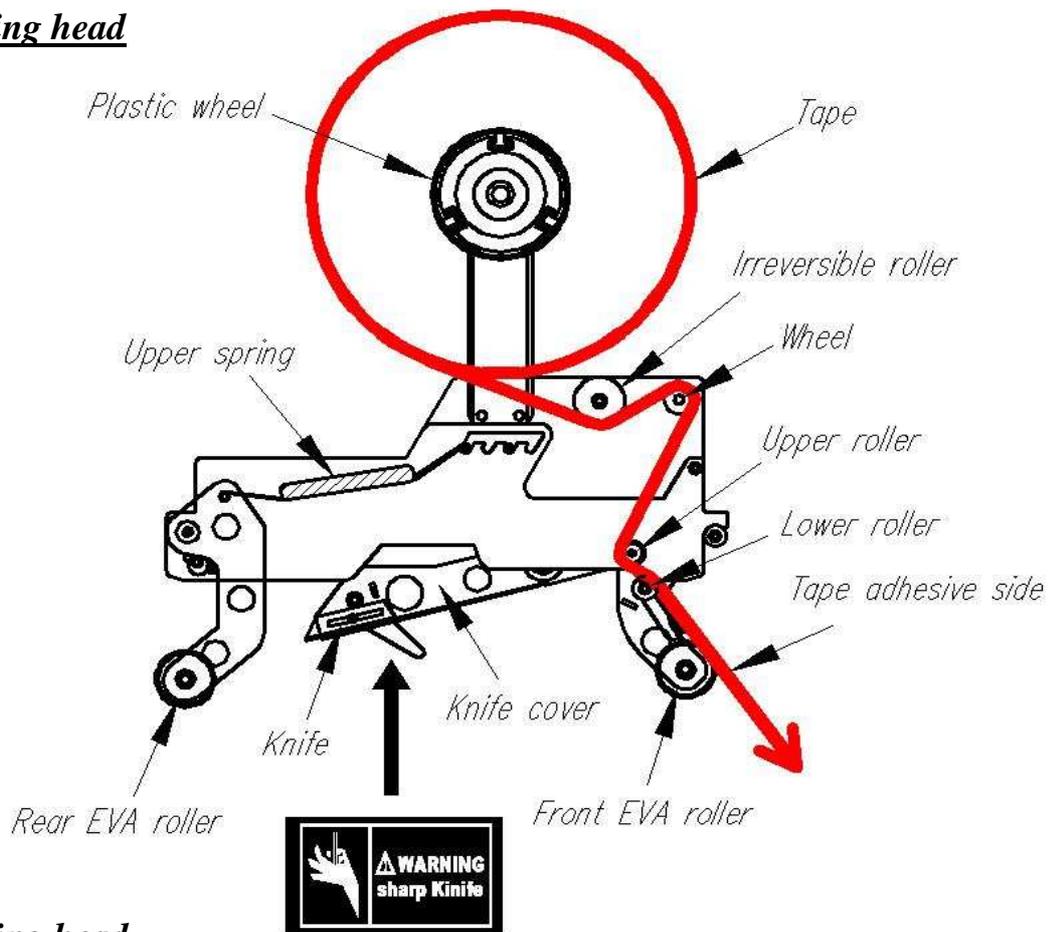


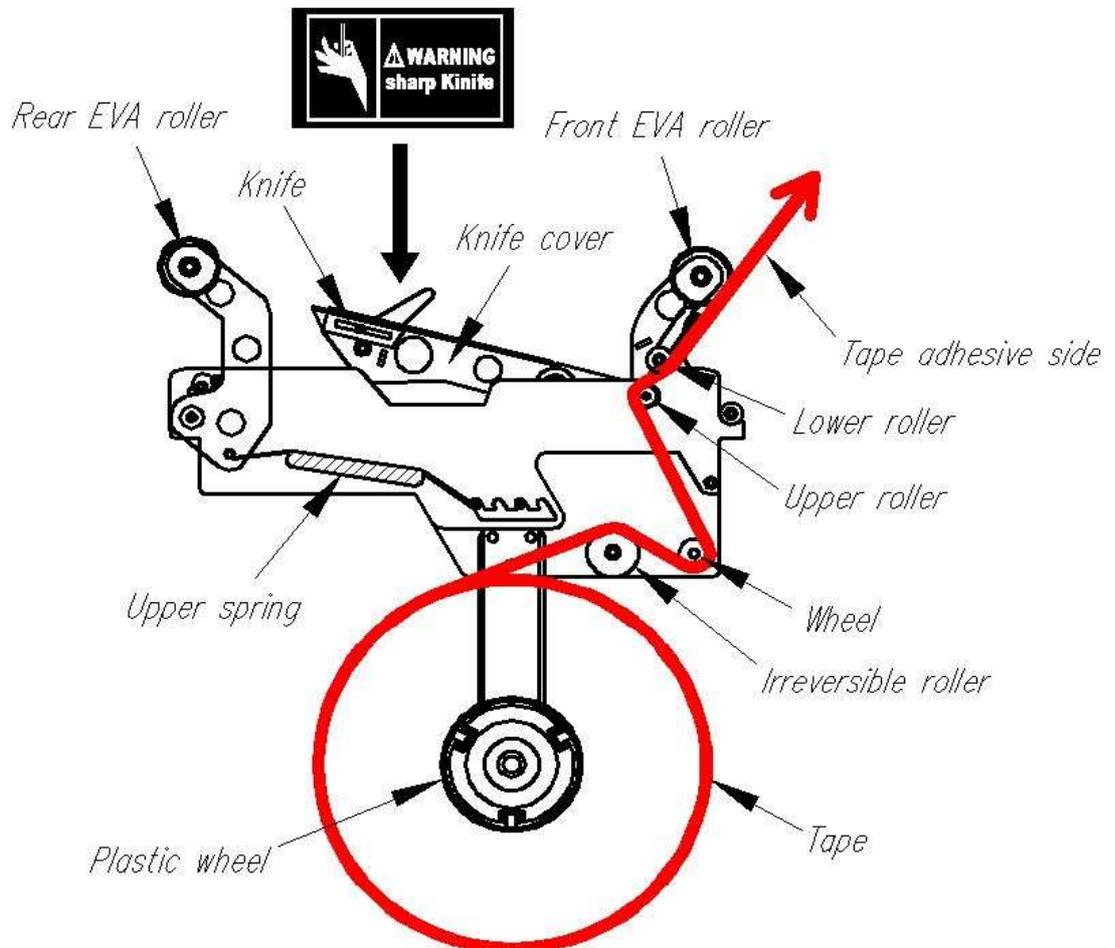
Figure 2-4

C) Illustration of Taping Head

1. Upper taping head



2. Lower taping head



D) Threading Method

◆ Threading method of upper taping head for 60 ± 5 mm carton sealing length:

- A. Fix the tape on the tape roll (adhesive side is up).
- B. Adhere the guide plate to the tape, as shown in Figure 3-1.
- C. Cut off the extra tape on the middle of rubber wheel, see Figure 3-2.

◆ Threading method of lower taping head for 60 ± 5 mm carton sealing length:

- A. Fix the tape on the tape roll (adhesive side is up).
- B. Adhere the guide plate to the tape, as shown in Figure 3-3.
- C. Cut off the extra tape on the middle of rubber wheel, see Figure 3-4.
- D.

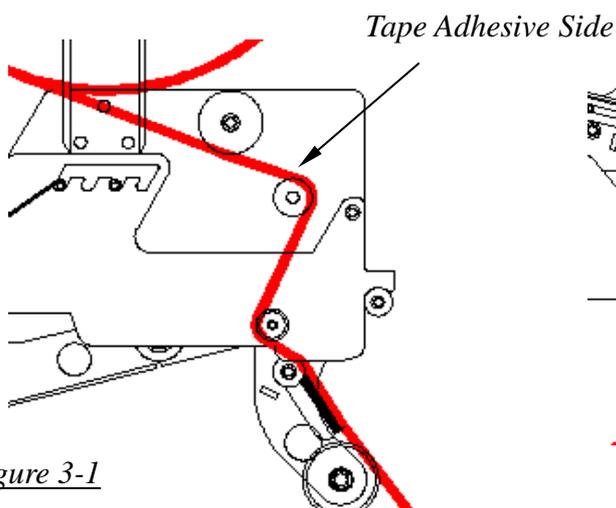


Figure 3-1

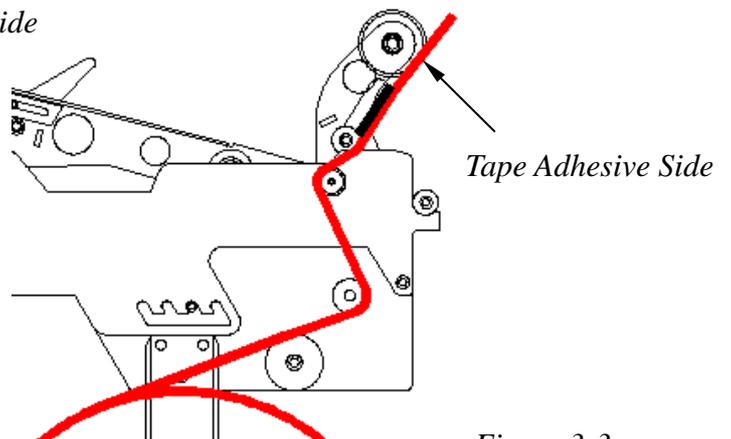


Figure 3-3

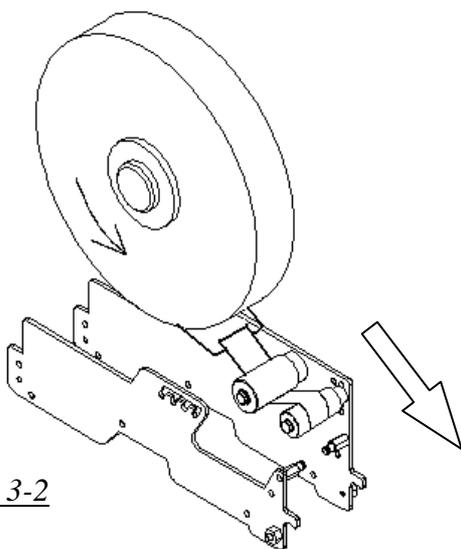


Figure 3-2

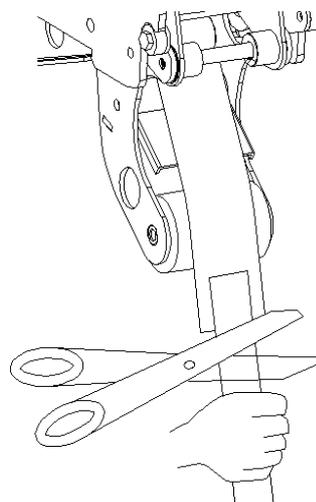


Figure 3-4

IV. Sealing Box Adjustment

The standard sealing size is 60 ± 5 mm, It can be changed according to the customer's request. Before adjusting , please make sure that the power is turned off.

Operation steps:

1. As shown in Figure 4-1-A, loosen the screws on upper taping head and take off the upper taping head upward.
2. As shown in Figure 4-1-B, take off the lower taping head upward.
3. As shown in Figure 4-2, adjust the cam between the rubber wheel and the bottom of tape head 60 mm, and then the length of tape is 60 mm ◦
4. As shown in Figure 4-2, re- threading.
5. Put the tape head back to the machine.
(The tension spring of upper taping head is looser).
6. Turn on the power and see if the sealing length meets your needs

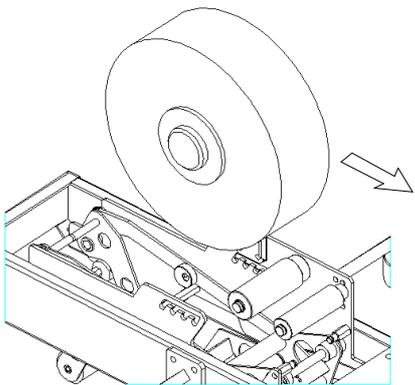


Figure 4-1-A

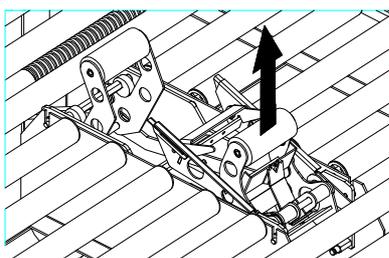


Figure 4-1-B

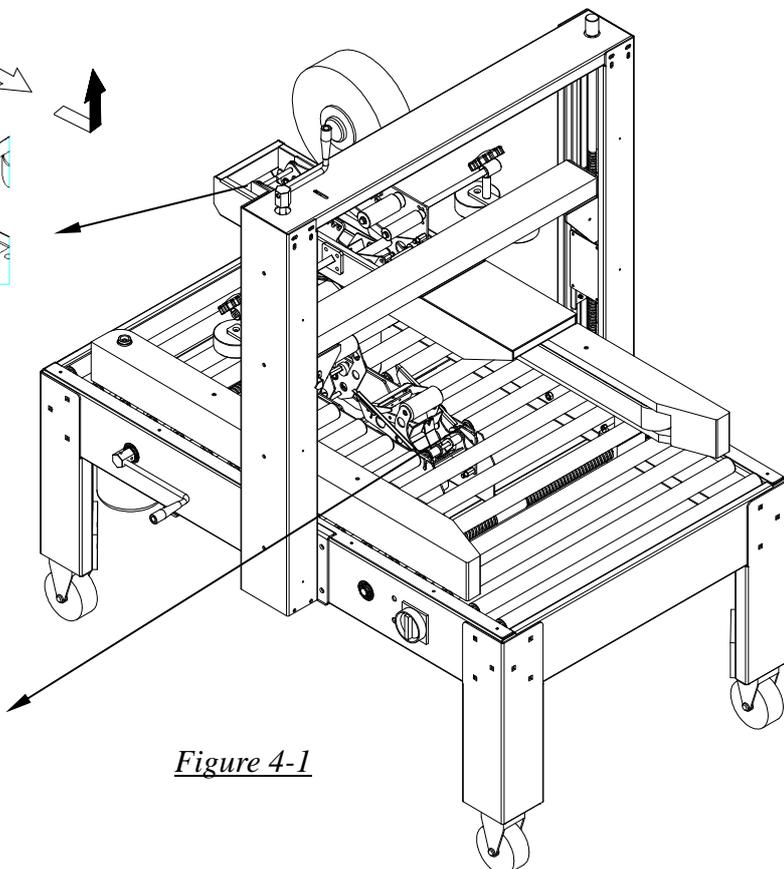
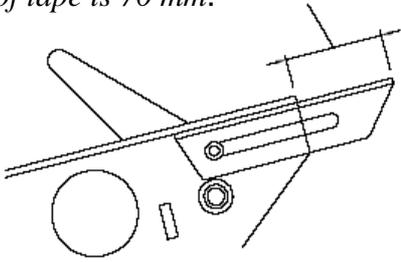


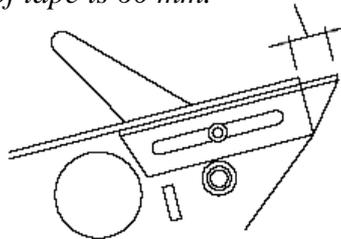
Figure 4-1

Process of rear overload adjustment

When the adjusting plate move out 20mm , the length of tape is 70 mm.



When the adjusting plate move out 10mm , the length of tape is 60 mm.



When the adjusting plate is tide , the length of tape is 50 mm.

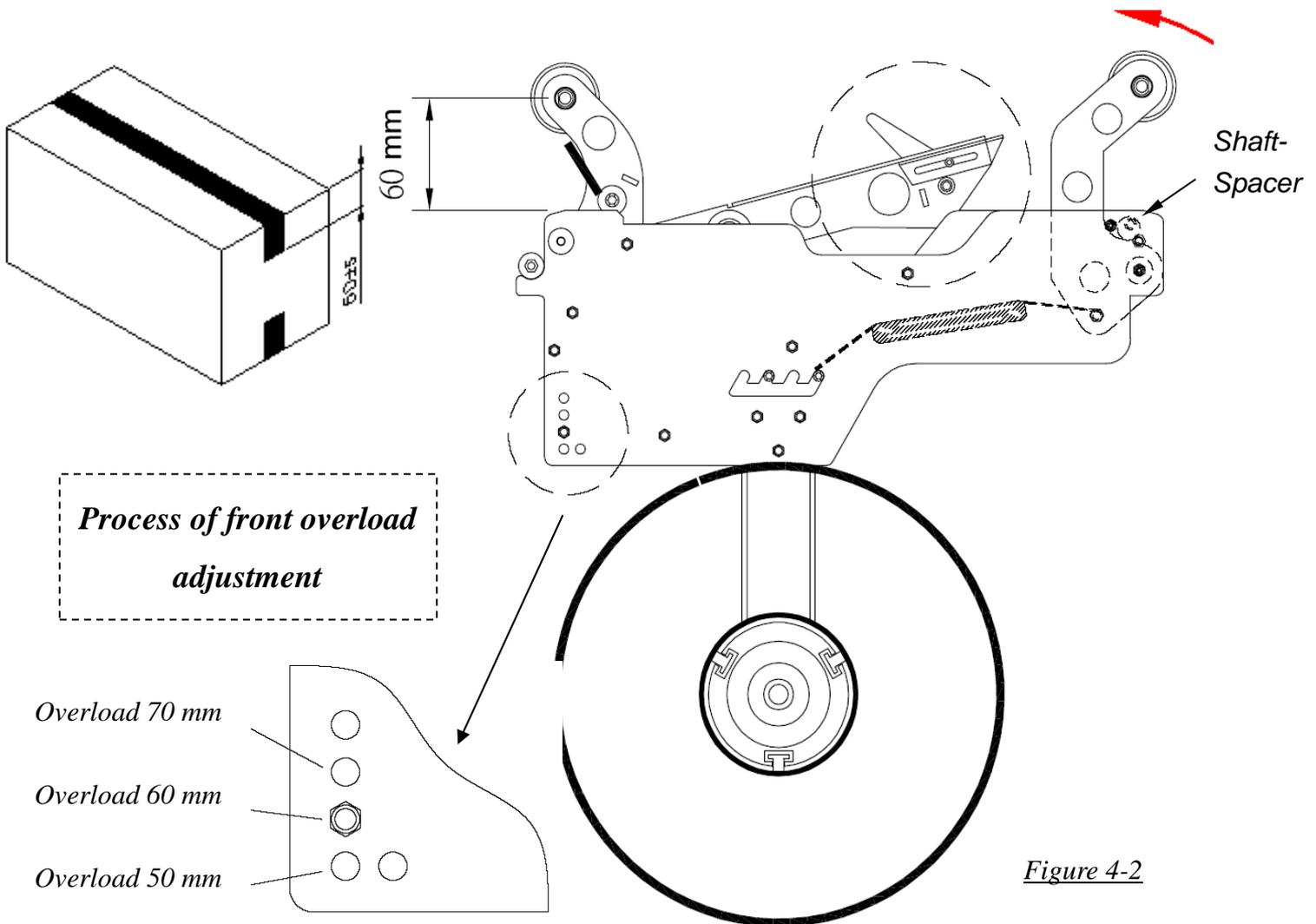
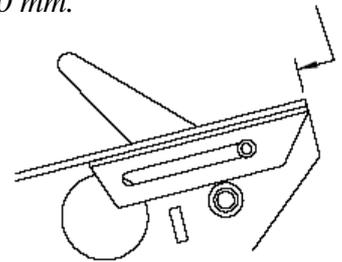


Figure 4-2

V. Adjustment

A) Tape Drum Friction Brake Adjustment

The tape will make the box too tight when the tape drum friction is too tight.

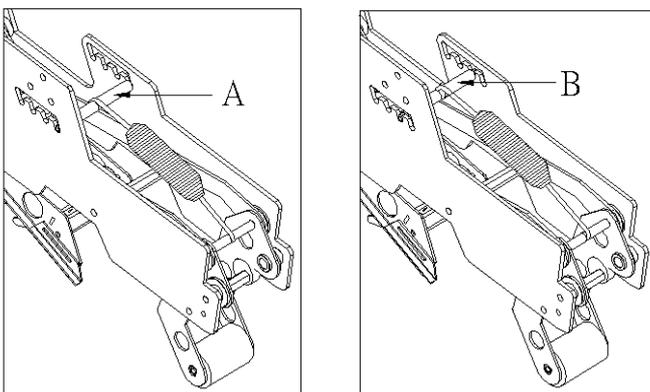
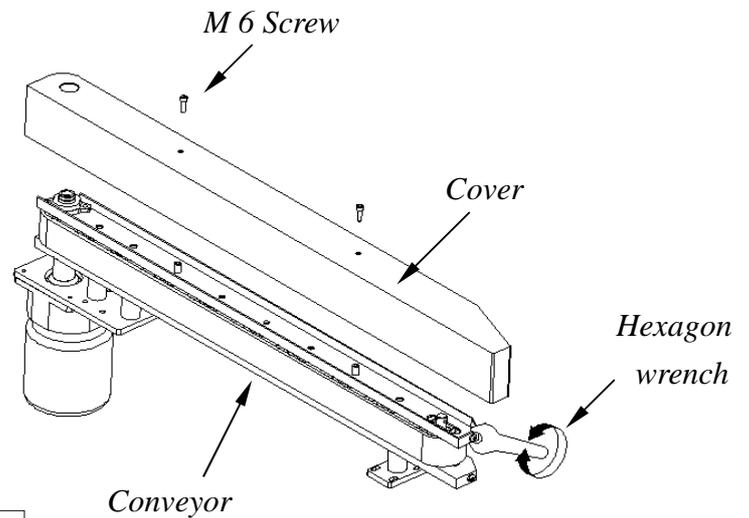
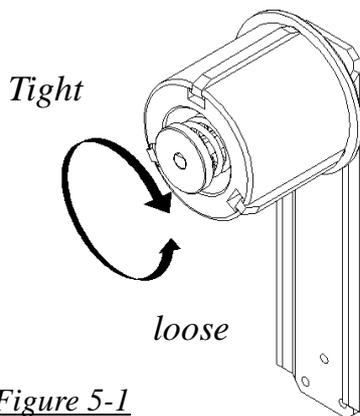
When it is too loose, the tape drum friction will over travel and the tape will make the box too loose. Turn the knurled nut clockwise to increase the braking force, and counter-clockwise to decrease the braking force. Adjust to minimum tension that prevents excessive tape roll over travel. See [Figure 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](#) °



VI · 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) 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) Driven Belts Replacement :

Refer to Figure 6-2. Remove and retain center plate(c) and four screws. Loosen tension screws(d) counter-clockwise until all tension is removed. Remove splicing pin 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.

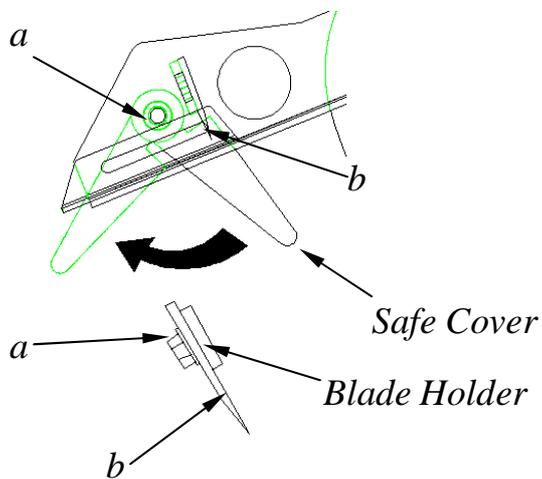


Figure 6-1

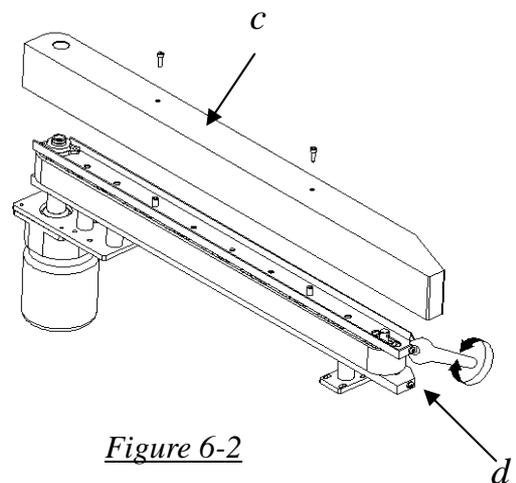


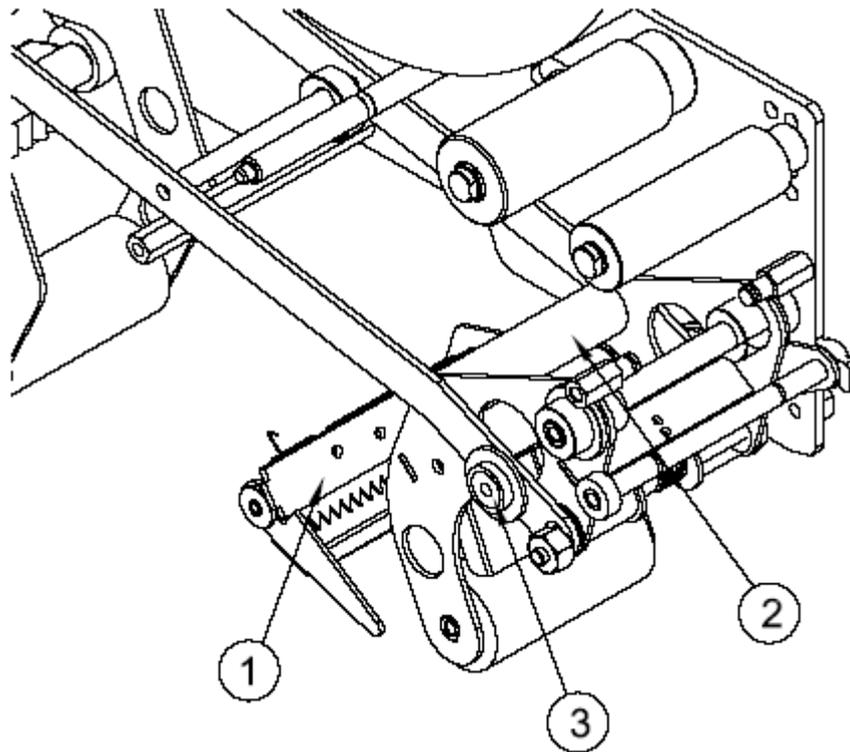
Figure 6-2

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.

(D) Maintenance Item And Period Cover



No.	Position	Maintenance	Maintenance Period cover No.			
			Day	Week	Month	Half a year
1	Blade	Tape Clean	◎	×	×	×
2	Pivot-cutter lever	30# Conditioner	×	◎	×	×
3	Roller-knurled assembly	30# Conditioner	×	◎	×	×

VII · Troubleshooting

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 60 mm.
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.
Problem	Possible Causes	Resolution
Machine makes noises	The bearing of belt bearing bracket- worn out.	Replace bearing NO.6202 zz
The length of overlap tape on the carton too long	Threading mistake	Refer to threading chapter
	Tape's tension too low	Adjust the tape drum assembly's tension
	Strap 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 centering 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 high	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

VIII 、 Self- Provided parts Suggestion

No.	Part No.	Description	Q'ty
1	CHS6802-2002	Roller- Buffing	4
2	CHS6802-3005	Tight Spring of Upper Taping Head	1
3	CHS6802-3006	Tight Spring of Lower Taping Head	1
4	CHS6802-4007	Blade	2
5	CHS6802-4009	Spring- Cutter	4
6	CHS6603-3016	Driven Belt	2

[TAPING HEAD ASSEMBLY AND PARTS LIST]

Fig.1 Frame Unit-Parts Photo & Parts List Page 1

Fig.2 Front Applying Arm-Parts Photo & Parts List Page 2

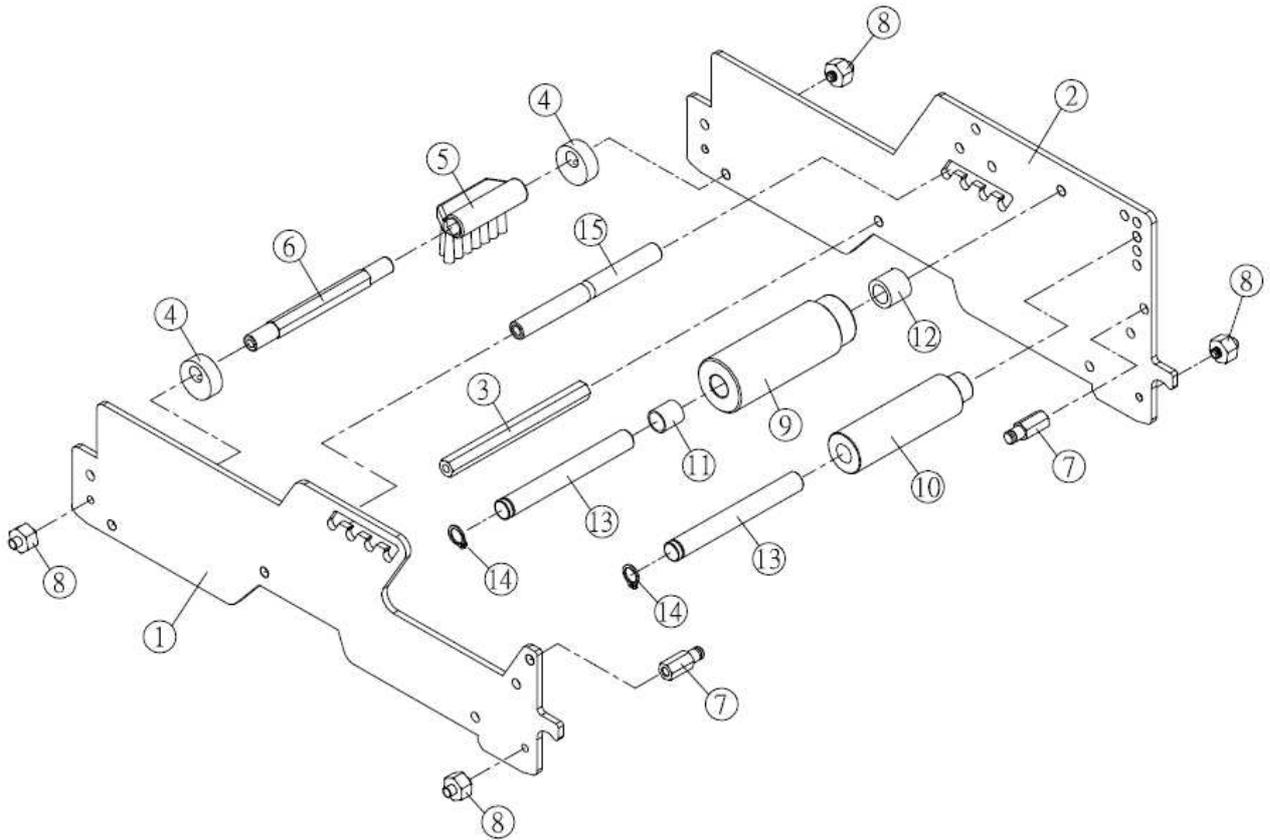
Fig.3 Rear Applying Arm-Parts Photo & Parts List Page 3

Fig.4 Blade Unit-Parts Photo & Parts List Page 4

Fig.5 Blade Unit-Parts Photo & Parts List Page 5

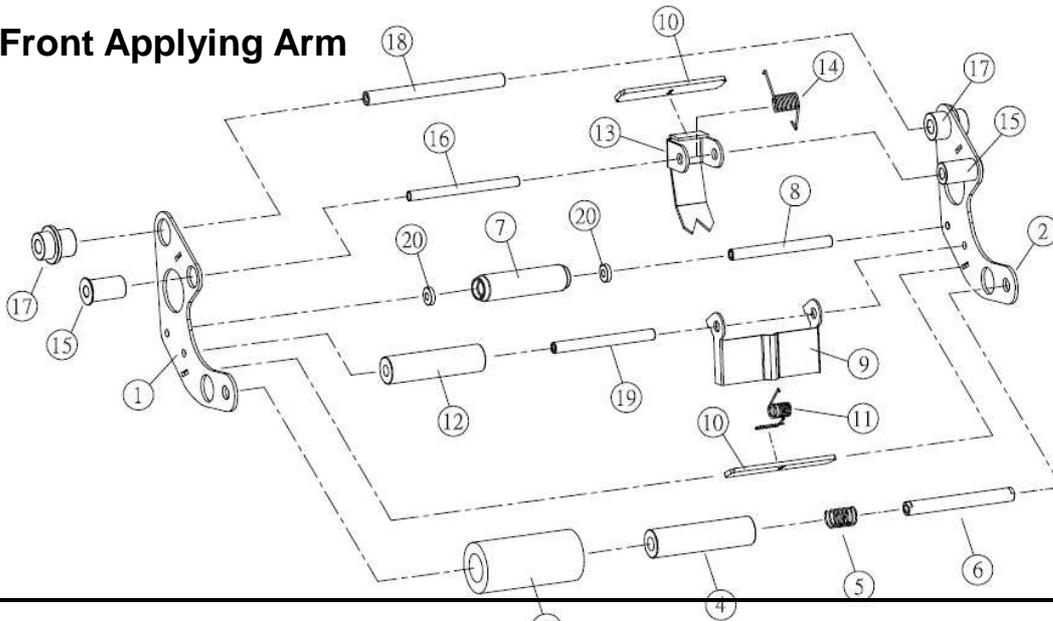
Fig.6 Tape Assembly-Parts Photo & Parts List Page 6

Fig 1. Frame Unit



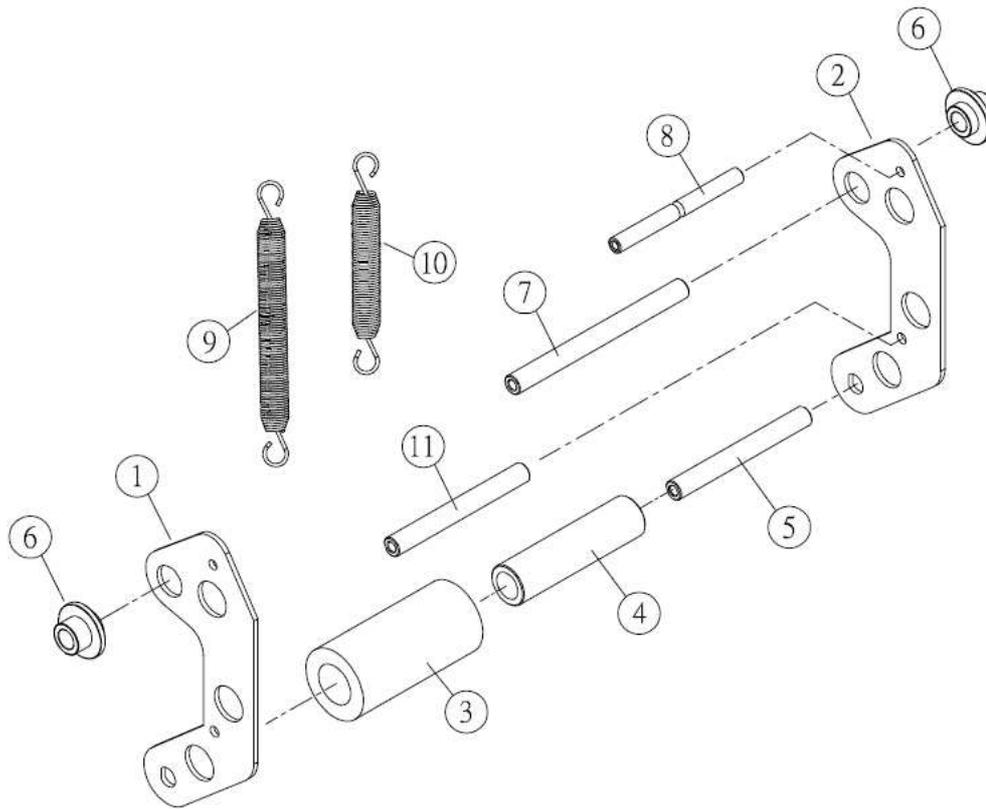
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-1001	Frame Upper Assembly -Left	1
2	CHS-6803-1002	Frame Upper Assembly -Right	1
3	CHS-68031003	Spacer-Upper	2
4	CHS-6803-1004	Ciller-Adjust Tension	2
5	CHS-6803-1006	Brush	1
6	CHS-6803-1007	Shaft-Spacer	1
7	CHS-6803-1008	Clamp-Spring	2
8	CHS-6803-1009	Screw	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-6802-1012	Shaft	2
14	087	C Type Check Ring	4
15	CHS-6803-3004	Ring Shaft	1

Fig 2. Front Applying Arm



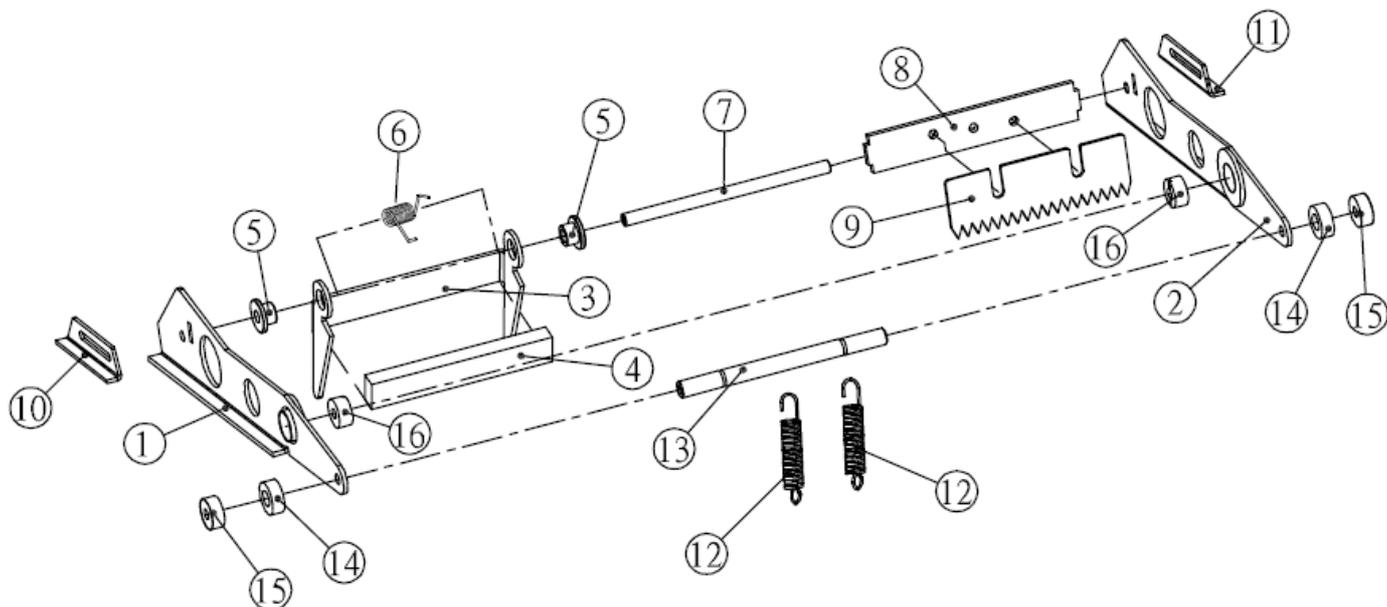
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-2001	Applying Arm -Left	1
2	CHS-6803-2001	Applying Arm -Right	1
3	CHS-6803-2002	Roller-Applying NM	1
4	CHS-6803-2003	Bushing-Applying Roller	1
5	CHS-6803-2004	Spring-compression	1
6	CHS-6803-2005	Shaft	1
7	CHS-6803-2006	Roller-Knurled Assembly	1
8	CHS-6803-2007	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
20	1480	Bearing	2

Fig 3. Rear Applying Arm



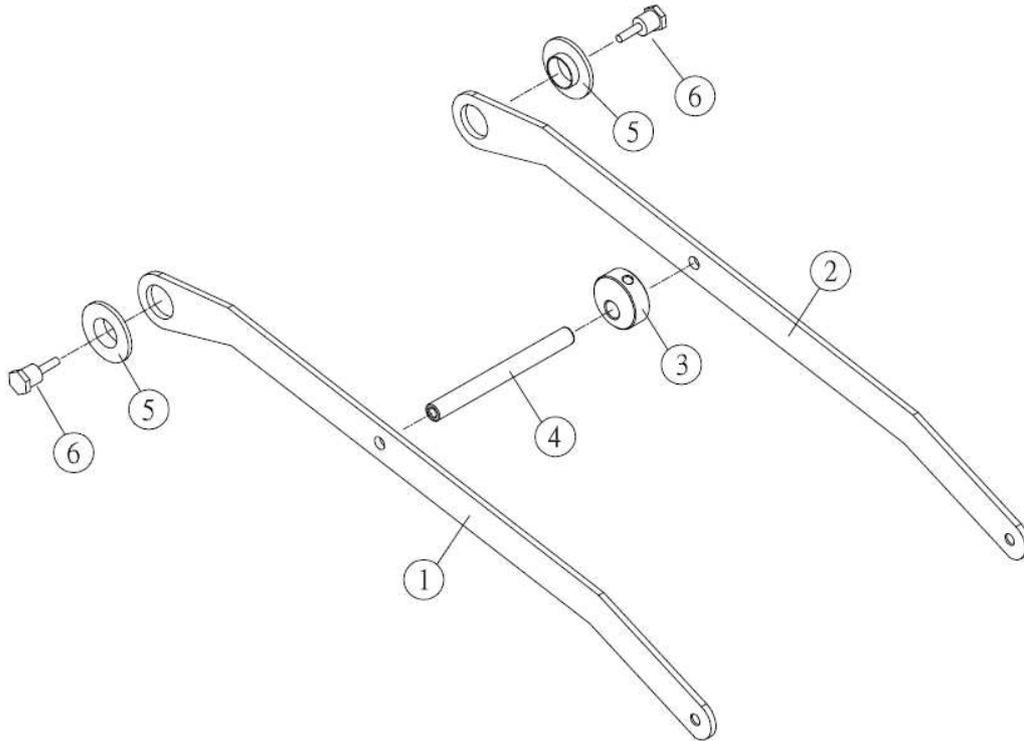
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-3001	Bushing Arm-Sub Assembly -Left	1
2	CHS-6803-3001	Bushing Arm-Sub Assembly -Right	1
3	CHS-6803-2002	Roller-Buffering MM	1
4	CHS-6803-3002	Bushing-Buffering Roller	1
5	CHS-6803-2005	Shaft-Buffering Roller	1
6	CHS-6803-3003	Shaft Bushing	2
7	CHS-6803-2017	Shaft	1
8	CHS-6803-5004	Shaft Pivot	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



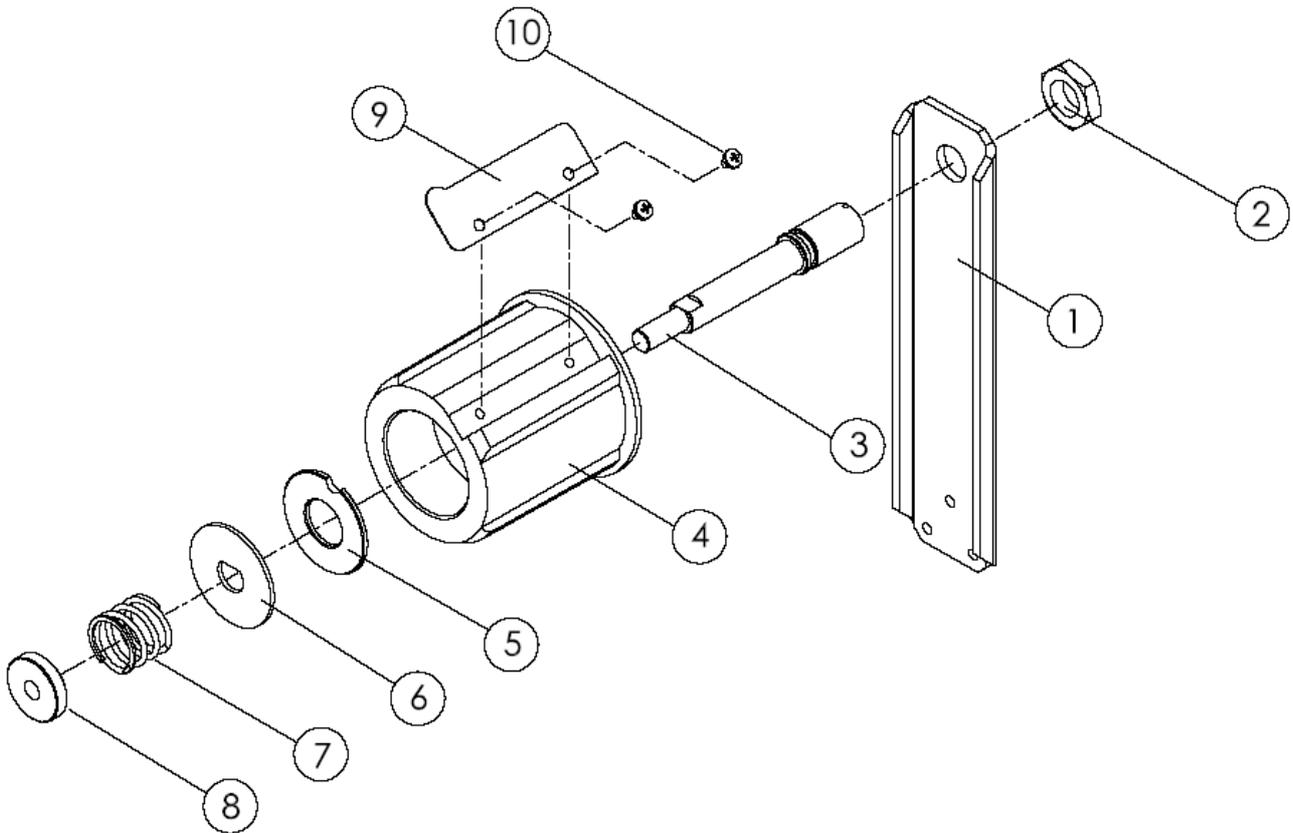
Ref. NO.	Part NO.	Description	Q'ty
1	CHS-6803-4001	Frame-Rear Cut-Off Weldment -Left	1
2	CHS-6803-4001	Frame-Rear Cut-Off Weldment -Right	1
3	CHS-6803-4002	Blade Guard	1
4	CHS-6803-4002	Cushioning Plate	1
5	CHS-6803-4003	Stop-Blade Assembly	2
6	CHS-6803-4004	Spring-Blade Guard	1
7	CHS-6803-4005	Shaft-Blade 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-6803-5005	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-6803-6008	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

CARTON SEALER
MACHINE FRAME ASSEMBLY AND PART LIST
APPLICATIVE MODEL No:
JP-501

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Fig 1. Machine Body Device Assembly Figure

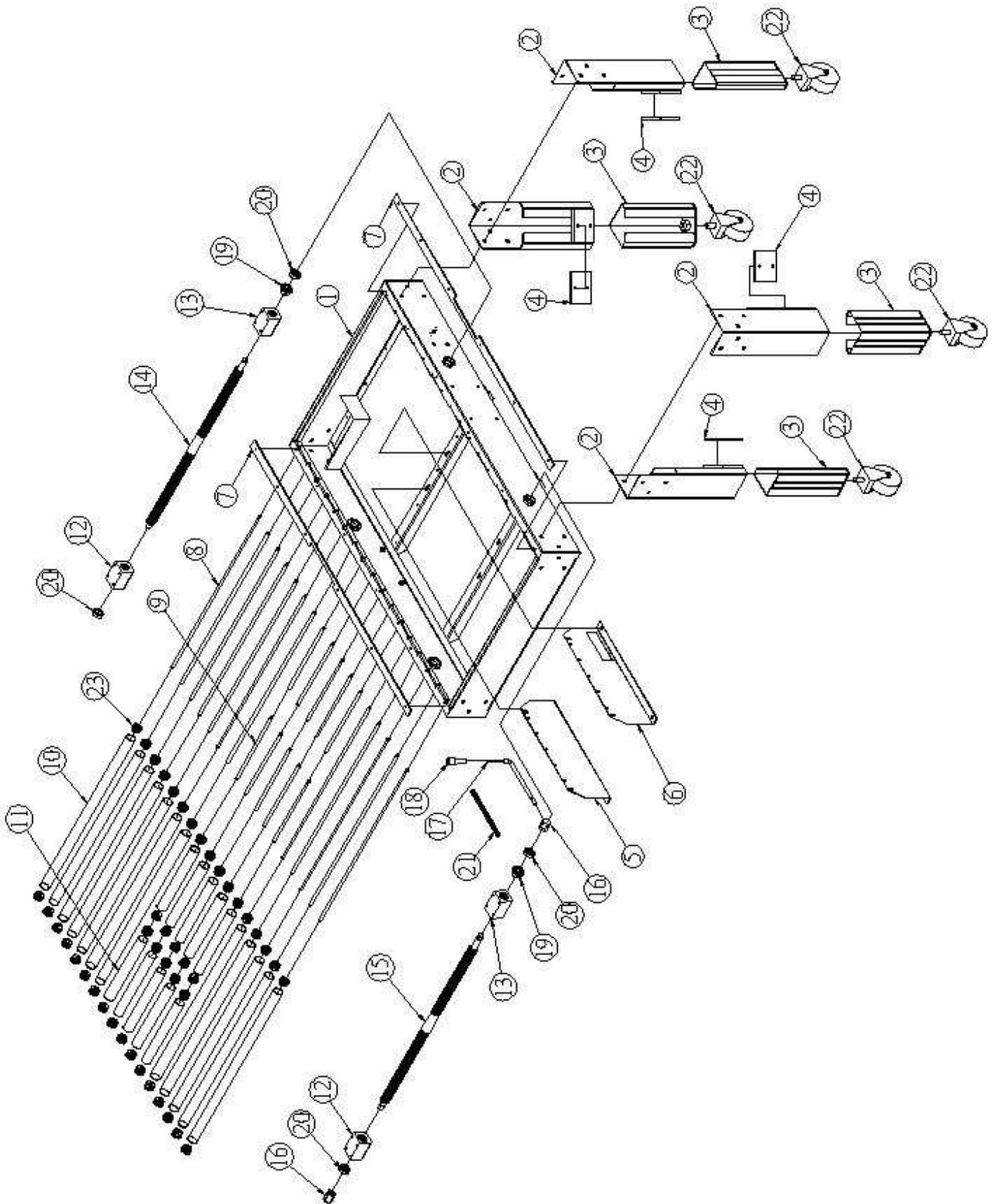


Table 1. Machine Body Device Assembly Parts List

Ref. No.	Part No.	Description	Q'ty
1	CHS6603-1001	Machine Frame	1
2	CHS6603-1003	Outside Support Leg	4
3	CHS6603-1004	Inside Support Leg	4
4	CHS6603-1005	Clamp-Legs	4
5	CHS6603-1006	Lower Taping Head Applying Arm-Right	1
6	CHS6603-1006	Lower Taping Head Applying Arm-Left	1
7	CHS6603-1007	Press Plate- Roller Shaft	2
8	CHS6603-1008	Long Roller Shaft	12
9	CHS6603-1009	Short Roller Shaft	10
10	CHS6603-1010	Long Roller	12
11	CHS6603-1011	Short Roller	10
12	CHS6603-1012	Left Side Nut	2
13	CHS6603-1012	Right Side Nut	2
14	CHS6603-1013	Front Screw	1
15	CHS6603-1014	Rear Screw	1
16	CHS6603-1015	Handle Bar Connection	2
17	CHS6603-1017	Handle Bar Lever	1
18	CHS6603-1019	Handle	1
19	CHS6603-4014	Lifter Chain Wheel	2
20	6003	Bearing	4
21	RS35#	Chain	1
22	5/8"	Wheel	4
23	CHS6603-1020	Plastic Cap Roller	44

Fig 2. Lifting Device Assembly Figure

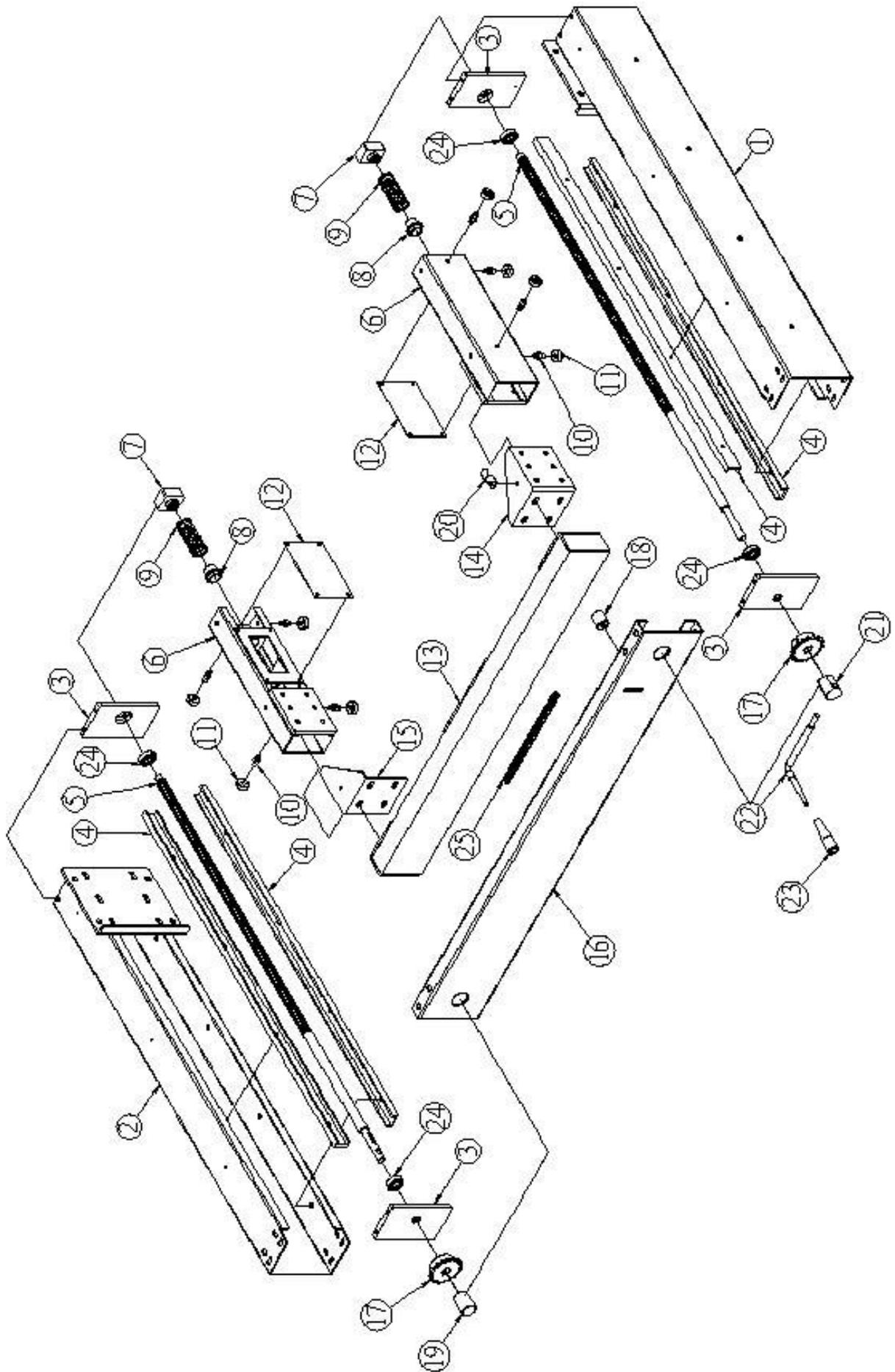


Table 2. Lifting Device Assembly Parts List

Ref. No.	Part No.	Description	Q'ty
1	CHS6603-2001	LH Column	1
2	CHS6603-2001	RH Column	1
3	CHS6603-2002-1	Piece	4
4	CHS6603-2003	Slide Way	4
5	CHS6603-2004	Lifter Screw	2
6	CHS6603-2005	Lifter Base	2
7	CHS6603-2006	Lifter Nut	2
8	CHS6603-2007	Spring Base	2
9	JP-501-2008	Spring	2
10	CHS6603-2009	Guide Pulley Fixed Axle	8
11	CHS6603-2010	Guide Pulley	8
12	CHS6603-2011	Lifter Cover Plank	2
13	CHS6603-2012	Upper Holder	1
14	CHS6603-2013	LH Holder	1
15	CHS6603-2013	RH Holder	1
16	CHS6603-2014	Upper Column	1
17	CHS6603-2015	Lifter Chain Wheel	2
18	CHS6603-2016	Chain Regulating Lever	1
19	CHS6603-2017	Screw Cover	1
20	CHS6603-2018	Height Indicating	1
21	CHS6603-1016	Lifting Handle Bar Connection	1
22	CHS6603-1018	Lifting Handle Bar Lever	1
23	CHS6603-1019	Handle Bar	1
24	6001	Bearing	4
25	RS35#	Chain	1

Fig.3 Drive Device Assembly Figure

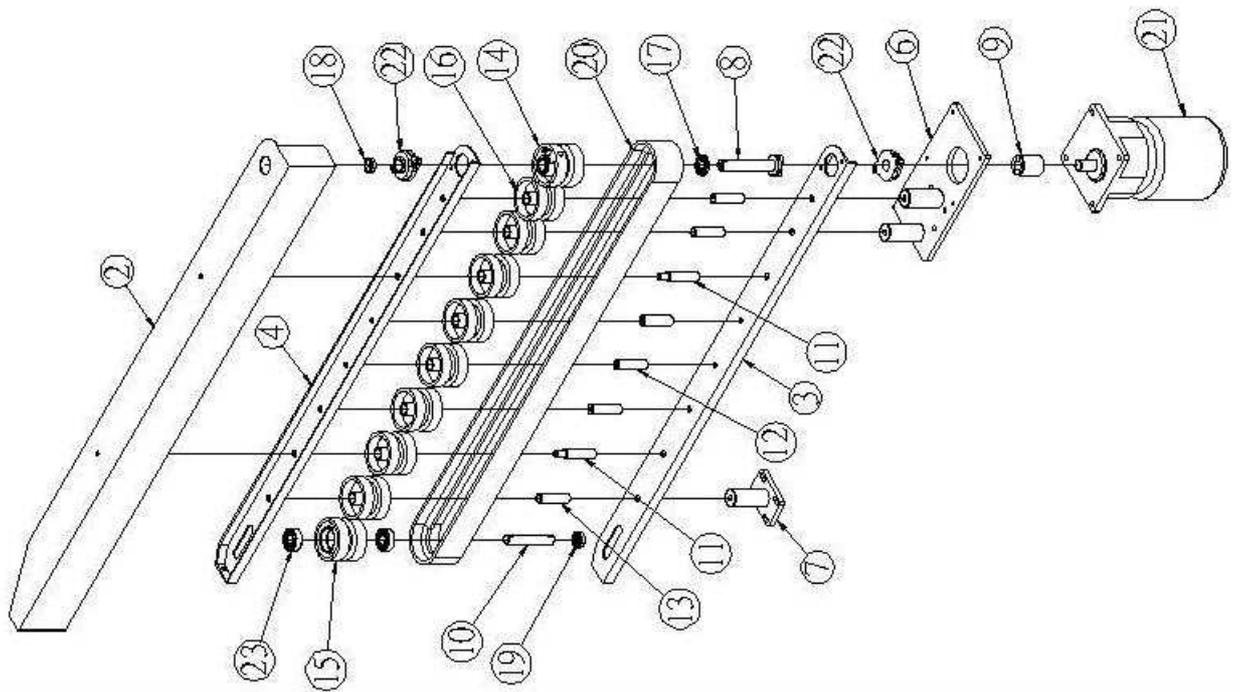
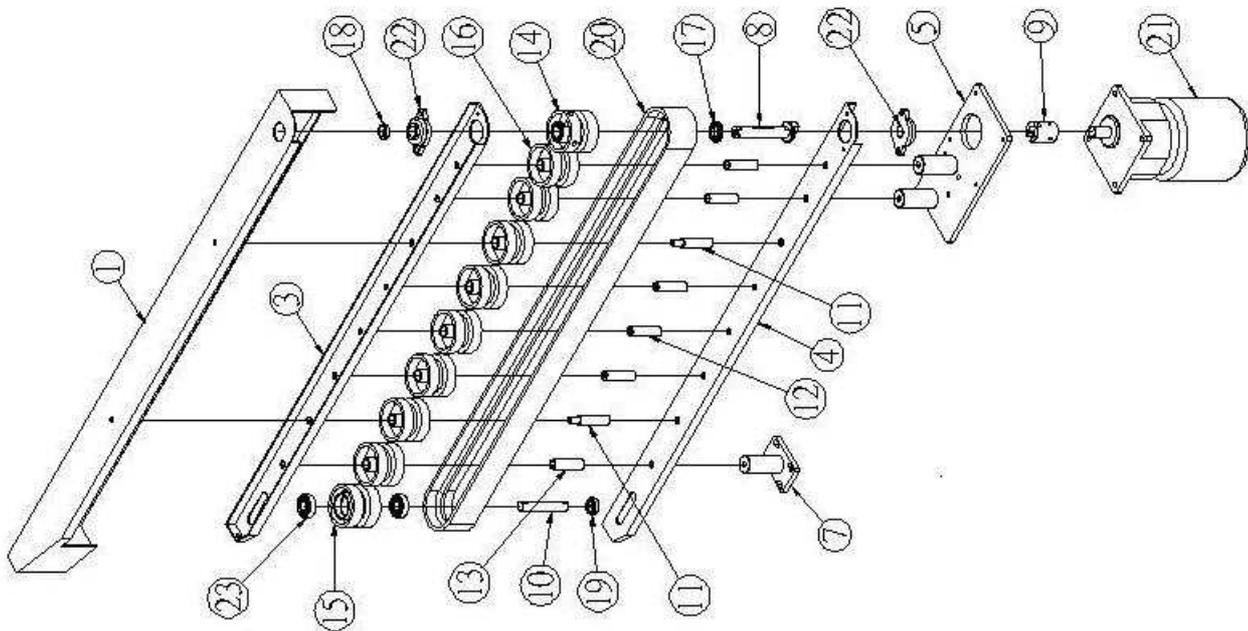


Fig.3 Drive Device Assembly Parts List

Ref. No.	Part No.	Description	Q'ty
1	CHS6603-3001	Driven Belt Cover-Left	1
2	CHS6603-3001	Driven Belt Cover-Right	1
3	CHS6603-3002	Belt Bracket-Left	2
4	CHS6603-3002	Belt Bracket-Right	2
5	CHS6603-3003	Left Driven Holder	1
6	CHS6603-3003	Right Driven Holder	1
7	CHS6603-3004	Driven Bracket	2
8	CHS6603-3005	Main Driven Bracket	2
9	CHS6603-3006	Low Driven Shaft	2
10	CHS6603-3007	Secondary Driven Bracket	2
11	CHS6603-3008	Belt Cover Shaft	4
12	CHS6603-3009	Long Idle Wheel Shaft	6
13	CHS6603-3010	Inner Bushing- Belt Wheel	6
14	CHS6603-3013	Main Belt Wheel	2
15	CHS6603-3014	Second Belt Wheel	2
16	CHS6603-3015	Idle Wheel	16
17	CHS6603-3011	Main Washer	2
18	CHS6603-3012	Main Driven Shaft Washer	2
19	CHS6603-3017	Second Washer	2
20	CHS6603-3016	Driven Belt	2
21	1/5HP	Gear Motor	2
22	UFL003	Bearing	4
23	6202	Bearing	4

Fig.4 Upper Base Device Assembly Figure

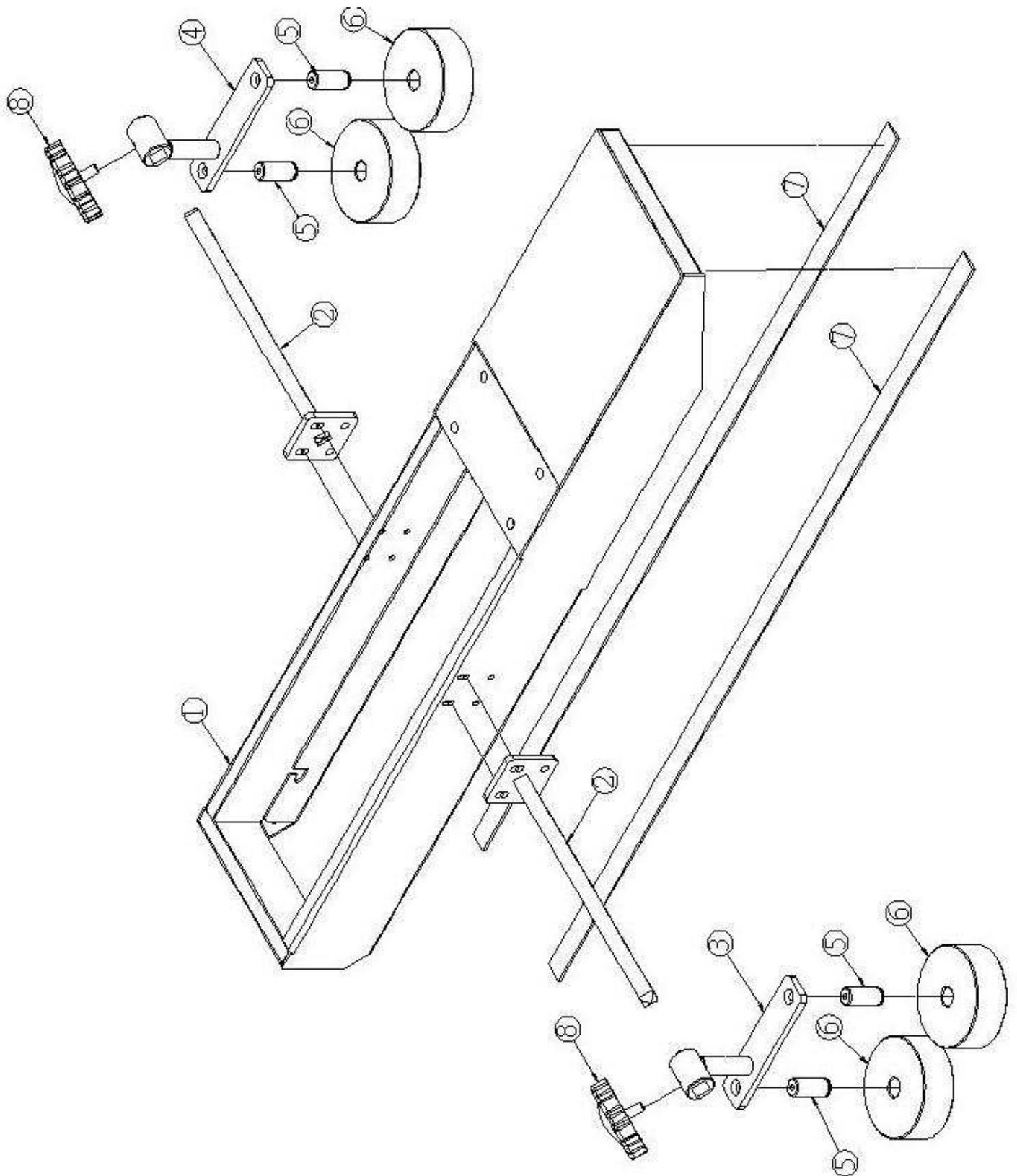
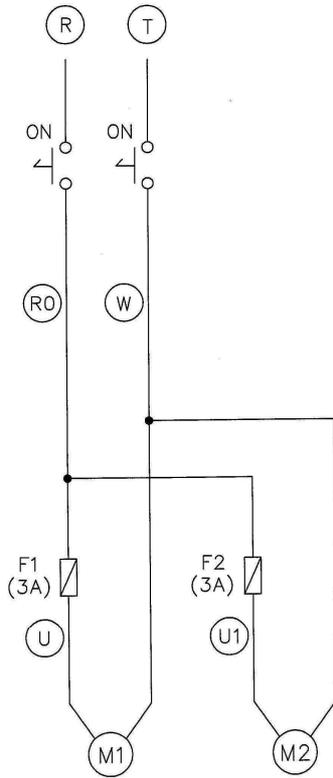


Fig.4 Upper Base Device Assembly Parts List

Ref. No.	Part No.	Description	Q'ty
1	JP-501-4001	Upper Frame	1
2	JP-501-4012	Auxiliary Guide Pulley Lever	2
3	CHS6603-4009	Auxiliary Guide Pulley Stand-Left	1
4	CHS6603-4009	Auxiliary Guide Pulley Stand-Right	1
5	CHS6603-4010	Auxiliary Guide Pulley Shaft	4
6	CHS6603-4011	Auxiliary Guide Pulley	4
7	JP-501A-4002	Teflon	2
8	M10X20L	Knob	2

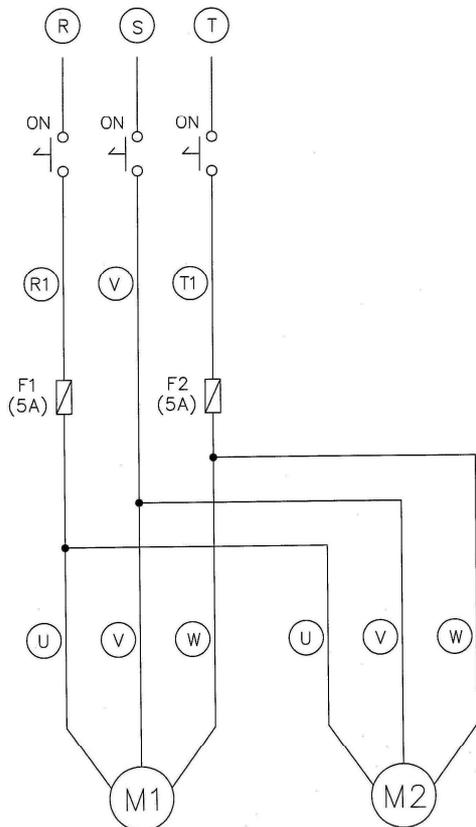
Circuits Diagram

(1) Single circuit diagram. See Figure 6-3



Left Driving Motor Right Driving Motor

(2) Three phase circuit diagram. See figure 6-4



Left Driving Motor

Right Driving Motor