

XT-551TB TOP AND BOTTOM BELTS

CASE SEALER

**OPERATION
MANUAL**



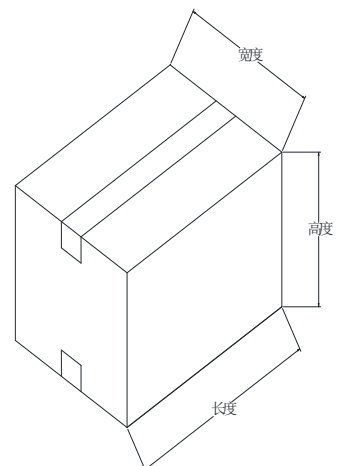
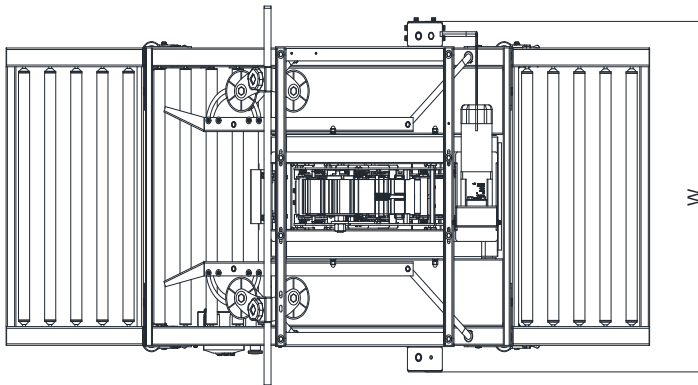
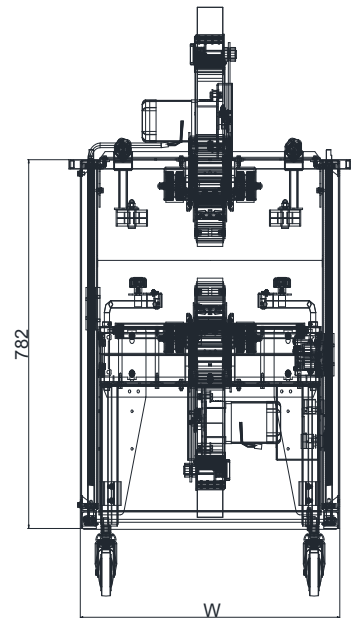
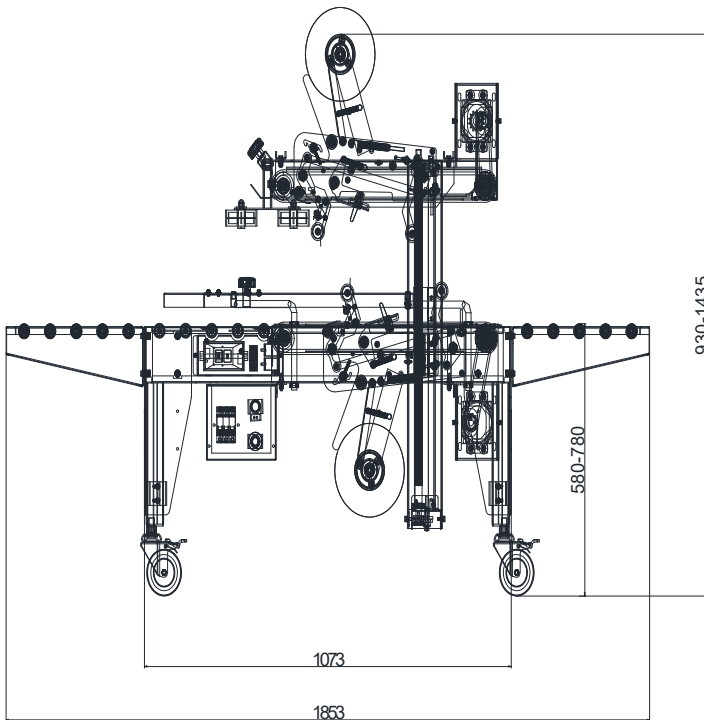
CATALOGUE

1. Specification and Technical Data.....	2
2. Installation.....	3
2.1. Assemble casters and adjust the table height.....	3
2.1.1.Assemble casters:	3
2.2.Move and fix the machine in a production line.....	3
2.3 Install infeed/outfeed conveyor.....	3
2.4.Spare parts description.....	4
2.5. Height and width adjustment(Refer to above figure).....	5
2.6. Tape head adjustment.....	5
3. Operation.....	9
4. Trouble shooting.....	10
5.Schematic.....	12
6.Spare parts list.....	13
7. Features.....	33
8. Usage instruction:.....	33
9. Maintenance:.....	33
10. Usage Notes: warning marks as below.....	33
11. Warranty policy as below.....	34

1. Specification and Technical Data

Model	SIZE(mm)				WIDTH(kg)	CARTON SIZE(mm)		
	length	width	height	Tape height		length	width	height
XT551TB5050	1073	755	930-1435	Adjustable	113	150-∞	160-500	110-500
XT551TB6060		855	930-1535	580-780	125		160-600	110-600
XT551TB7050		955	930-1435		120		160-700	110-500

The tape width: 2" (45mm) or 3" (78mm)



2. Installation

2.1. Assemble casters and adjust the table height

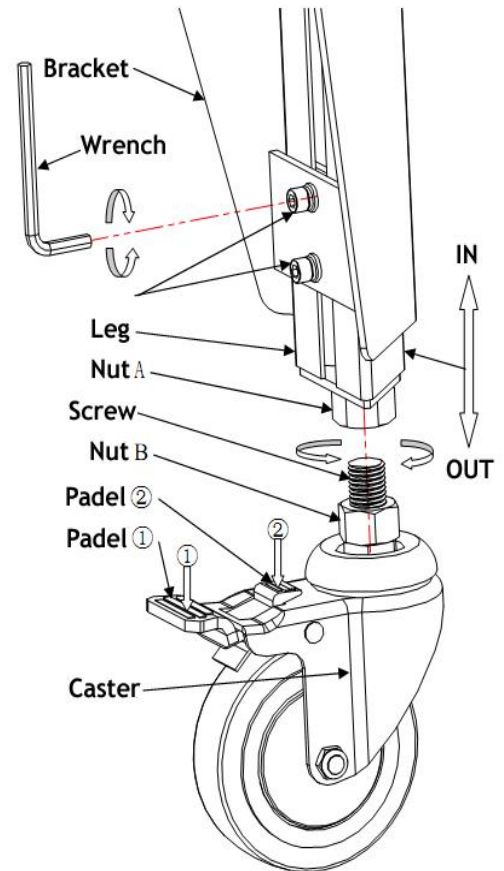
2.1.1. Assemble casters:

Screw into NUT A and fasten NUT B to fix the brake casters.

2.1.2. Adjust table height

The table height can be adjusted by stretching in or out four legs

Methods: 1. use the wrench to loosen the two screws 2. stretch in/out the legs to required height 3. use the wrench to tighten the two screws



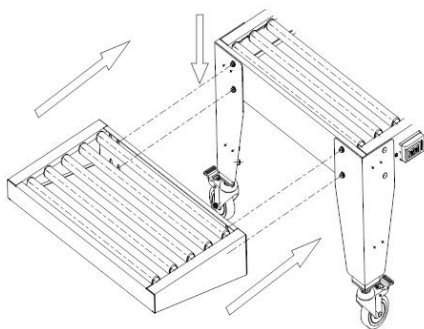
2.2. Move and fix the machine in a production line

Fix Method: Step down the four pedal① of the brake caster.

Move Method: Step down the four pedal② to move the machine.

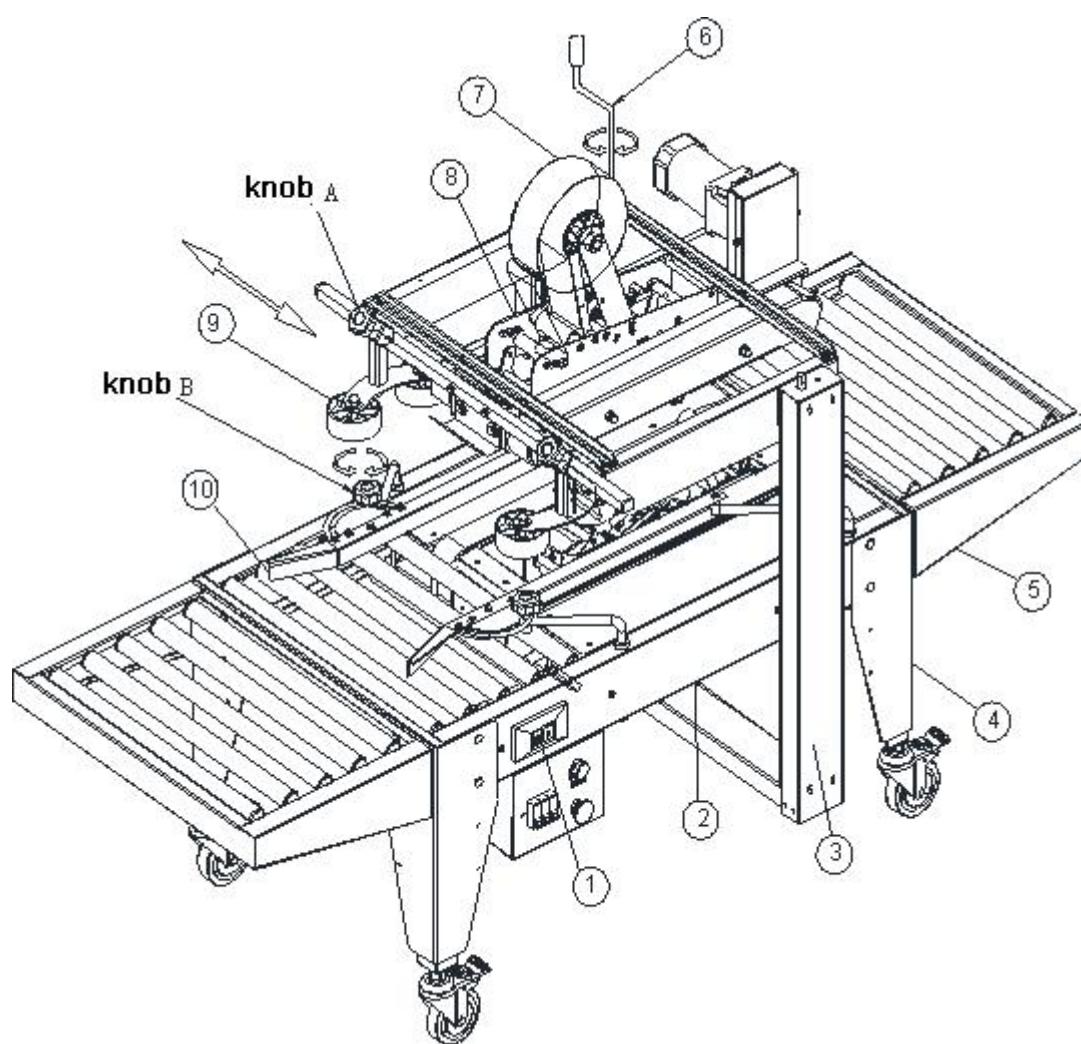
2.3 Install infeed/outfeed conveyor

Hang the infeed/outfeed conveyors onto the side of a machine body



2.4.Spare parts description

NO.	Description	NO.	Description
1	Switch	6	Height adjusting crank
2	Machine body	7	Tape
3	Side Post	8	Tape Head
4	Leg	9	Width adjusting compression roller
5	Infeed/Outfeed conveyor	10	Width adjusting guide rail



2.5. Height and width adjustment(Refer to above figure)

1) Incorrect position of width adjusting compression roller⑨ may cause tape out of centel position.

2) Adjustment method:

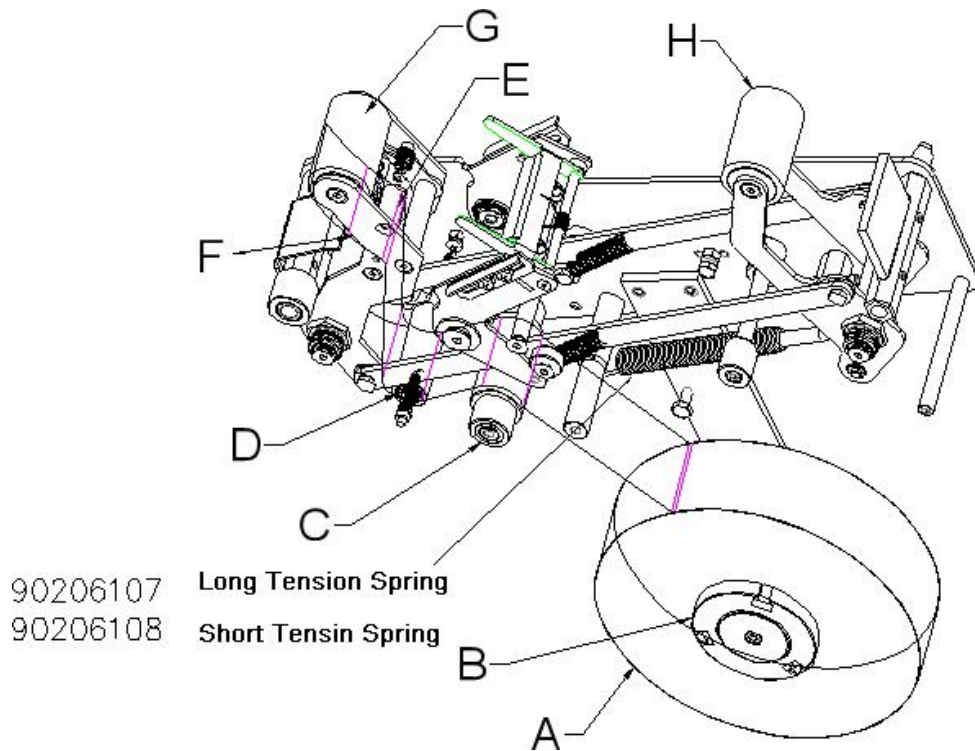
- a. Loose Knob A, move width adjusting compression rollers ⑨ at both sides to make the distance between 2 rollers wider the box .
- b. Loose Knob B, move width adjusting rail ⑩ at both sides to make the distance between 2 rails wider the box .
- c.
- d.
- e. Adjust width adjustment knob B, ③ and make the distance between 2 side belts bigger than box width.
- c. Adjust height adjustment crank⑦ and make the tape head higher a little than box height.
- d.Put the boxes on the table in the center position
- e. Adjust side width adjustment crank ③ to make the side belts touch the 2 sides of a box tightly.
- f. Adjust the height adjustment crank ⑦ anti-clockwisely to press the box.
- g. Put the right and left side compression roller ⑩ to touch the box and tightened the knobs A.

2.6. Tape head adjustment

2.6.1. Tape loading and winding

- a. Put tape A onto the tape head B
- b. pull out the tape, wind the tape around one-way roller C, then pass through roller D
- c. wind through front embossed roller E, through left and right fixed plate F then through rubber roller G (refer to below figure)

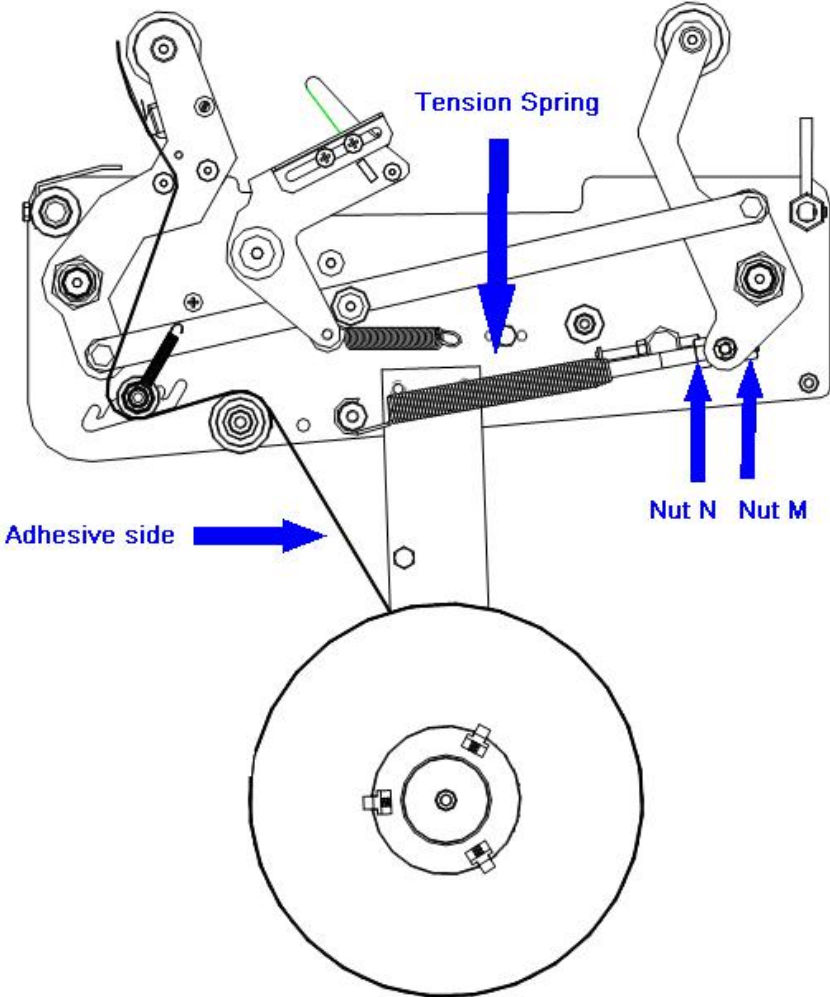
Remark: During the threading, the adhesive side is facing the operator.



2.6.2 Tension adjustment

- a. Purpose: Make sure the tape adhere on box firmly without wrinkles.
- b. principle: Keep the taping speed is proportional to the belts speed, to be adjusted according to the material and hardness of the carton box.
- c. Method: Loosen tension lock nut N, screw in (increase tension power of rubber roller G and H) or screw out (decrease tension power of rubber roller G and H) tension adjustment nut M until get required tension, then fasten tension nut N.

Tape winding diagram

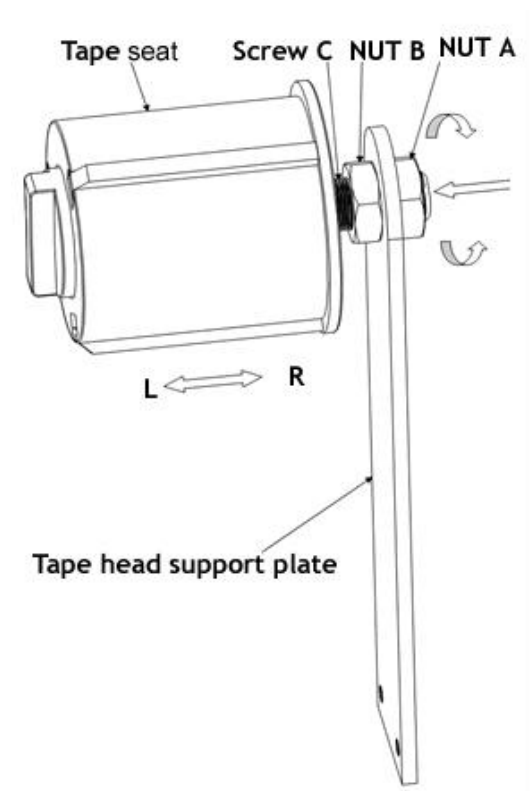


2.6.3. Regulate the tape in the center of a box.

- a. Recommend use of OPP adhesive tape
- b. If the tape is off the center of the box, clockwise or anti-clockwise adjust Nut A,B
- c. Method (refer to below figure)

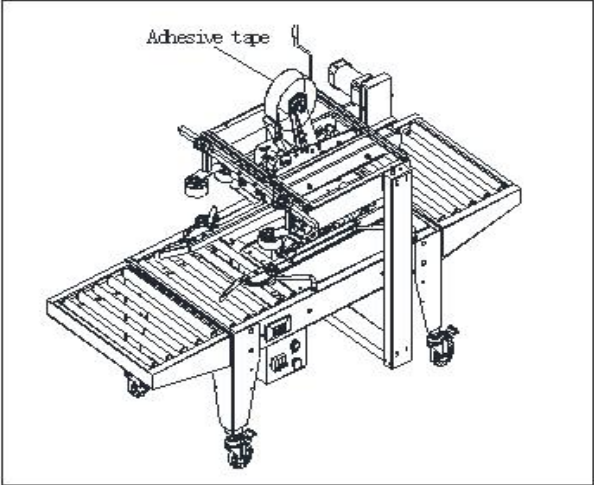
Move to left: Screw out Nut A, move the lock screw C left, fasten Nut B;

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

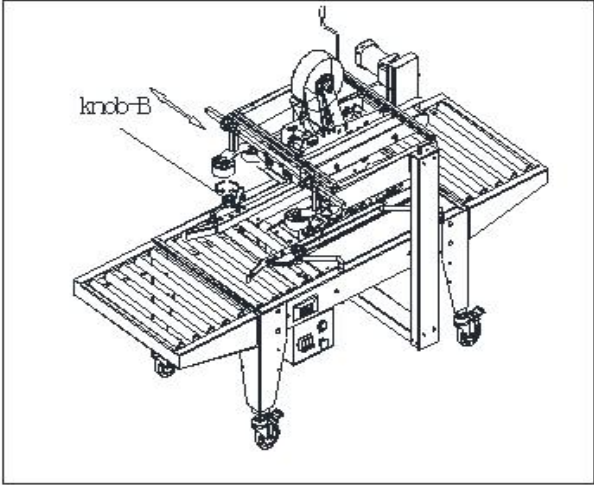


3. Operation

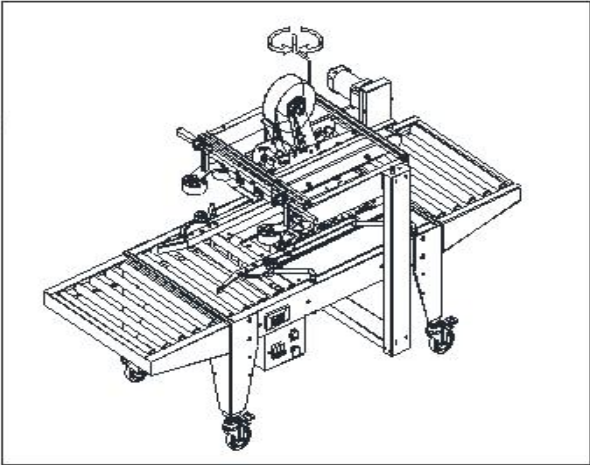
1)load tape onto tape head



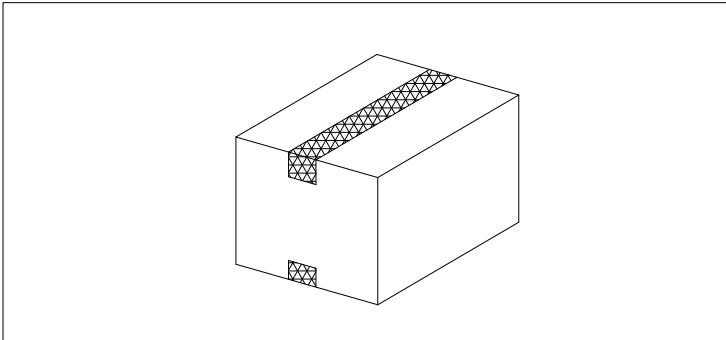
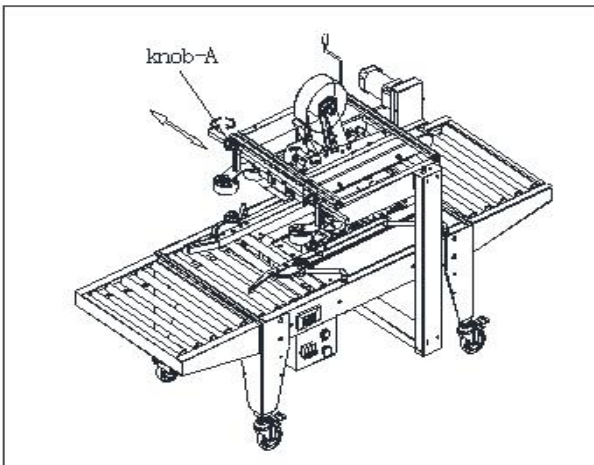
2) adjust width guider rail



3) adjust height



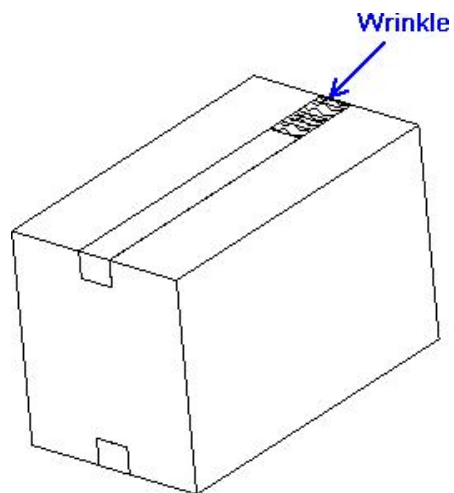
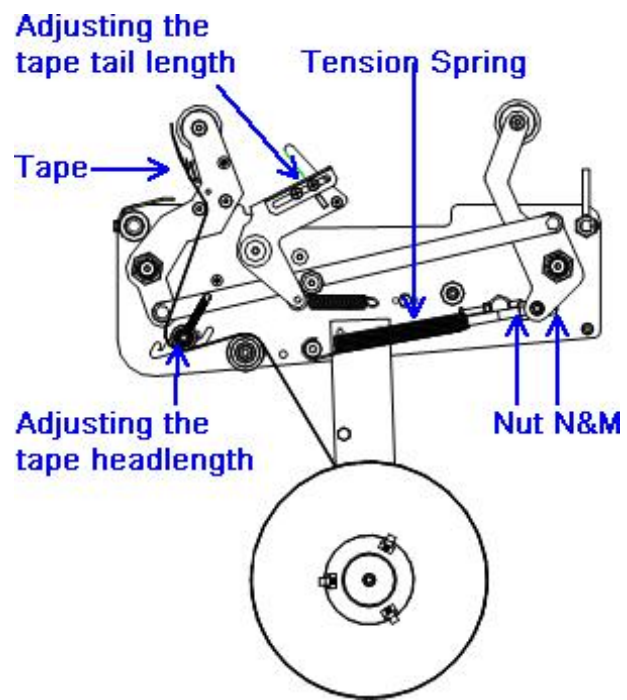
4) adjust side guide roller



4. Trouble shooting

NO	Fault	Reason	Trouble Shooting
1	Tape can not be cut off	*Knife is not sharp enough *Knife tip is jammed with adhesive	*Replace with a new knife * Clean the knife
2	A trailing of tape after cut off motion	*Knife is not sharp enough *Knife holder has trash *Tension spring is loose * Screw is loose	* Replace knife * Clean trash *Adjust spring tension *check tape head screws and fasten.
3	Tap is not fully adhering to the box	*Main spring is too loose *The roller shafts which the tape runs over are not effective due to accumulated tape adhesive	* Tighten the main spring * Clean adhesive * Lubricate roller shaft
4	Box blocked on the way	*tape roller adjustable nut is too tight *Improper box height adjustment * Main spring too tight	* loosen tape roller adjustable nut *Readjust the height *Loosen the main spring
5	Tape broken during sealing on box	*Knife protrudes too far	*readjust the knife position
6	Tape can not travel smoothly	*one- way roller is broken * wrong tape winding	* replace one-way roller * Correct tape winding
7	Tape is off center on the application	*both guide wheels have uneven pressure on the box	*re-adjust the distance between both guide wheels
8	Tape end wrinkling on the carton	* Tape roller assembly is too tight * Knife is not sharp enough or jammed with trash * One- way roller is not effective * Main spring is too tight	* Adjust tape roller assembly spring * clean trash *replace knife or one-way roller shaft
9	Carton box is protrudent before sealing, the tape edge wrinkling after sealing	* belts speed is not consistent * box side cover not aligned * the packaged have not been fulfilled in the box * Tape roller resistance is too much	*Keep the consistent speed for belts * Align box side cover to proper position * Adjust the tape roller resistance

Tape is wrinkling on the box. Please refer to below picture, turn the tension knob clockwise to compress tape seat, adjust Nut N, M to increase spring tension.

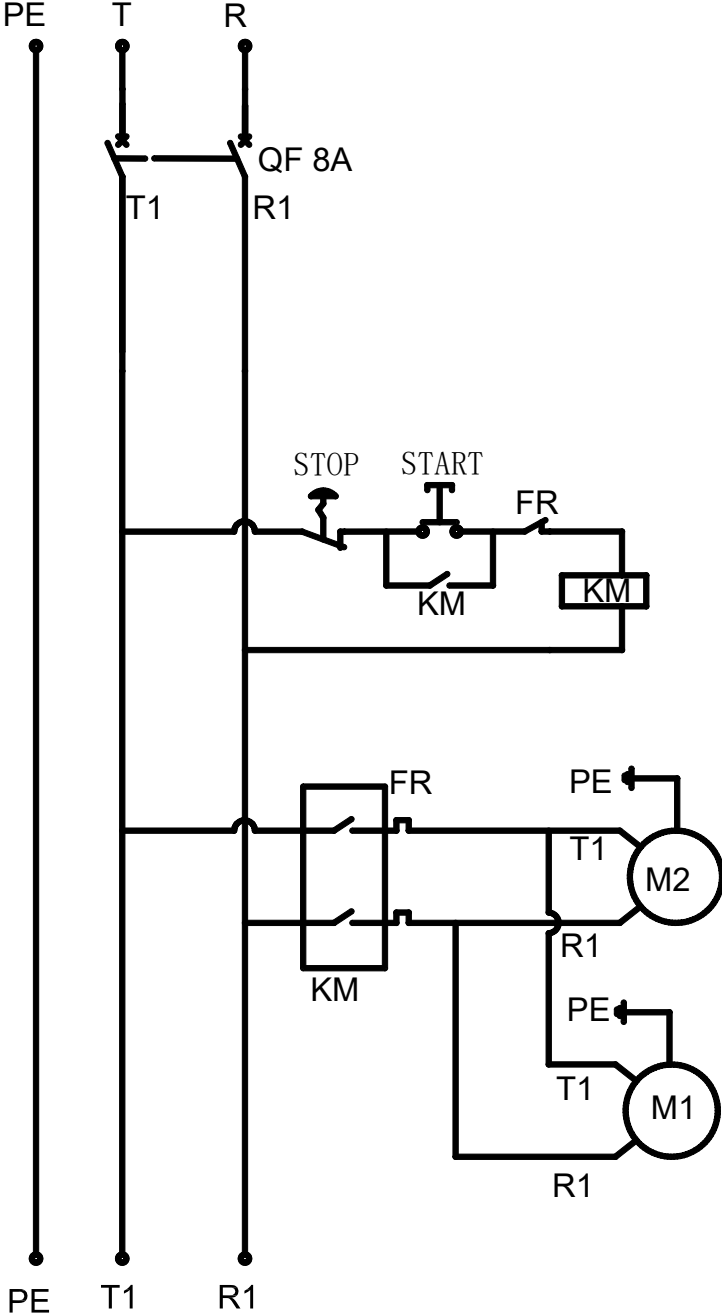


Remark:

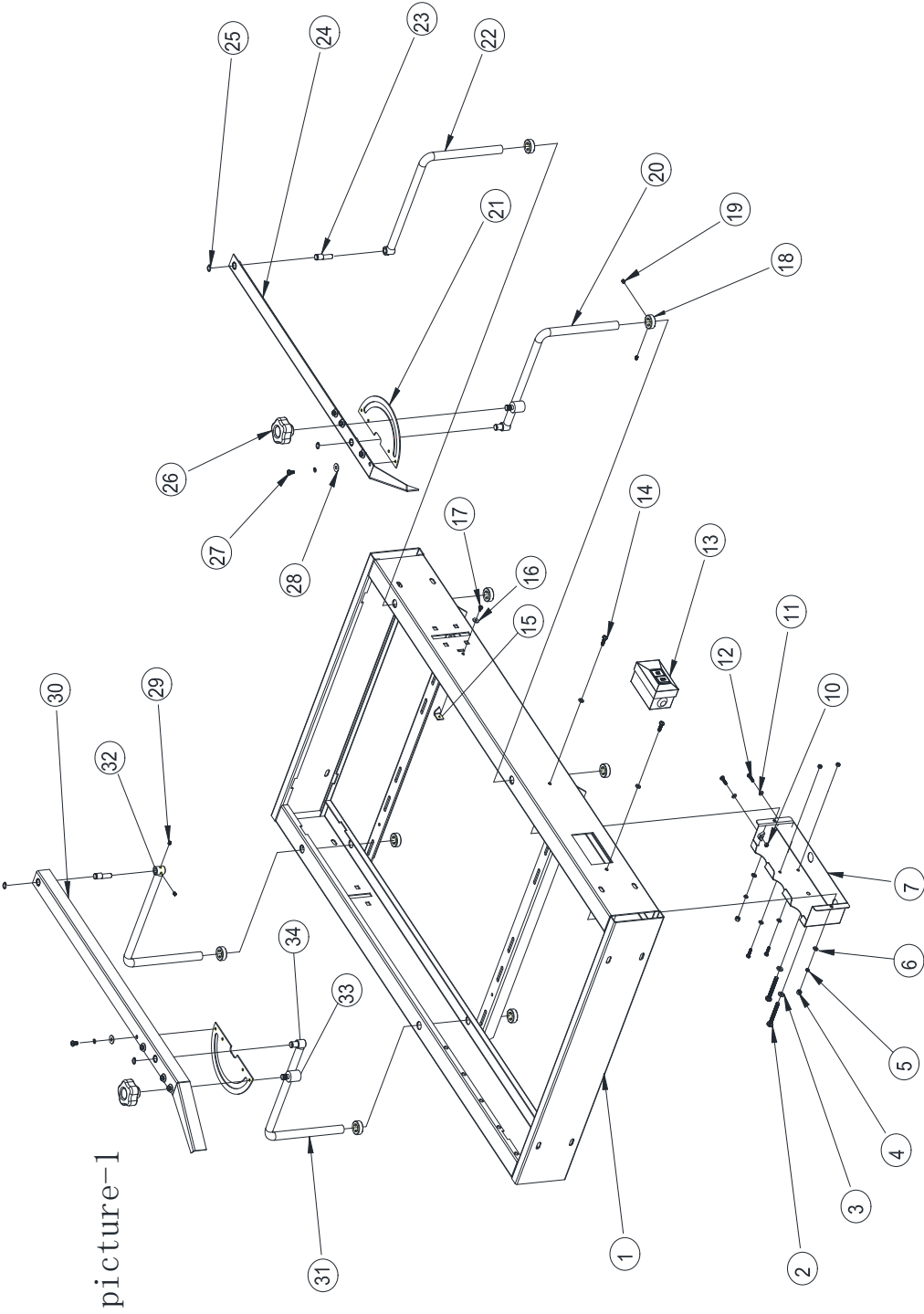
1. Switch off power before you repair or adjust
2. Blade must be clean up and lubricate before using
3. After using for a while, adjust belt a little bit tighter

5.Schematic

1∅ 220VAC 50HZ

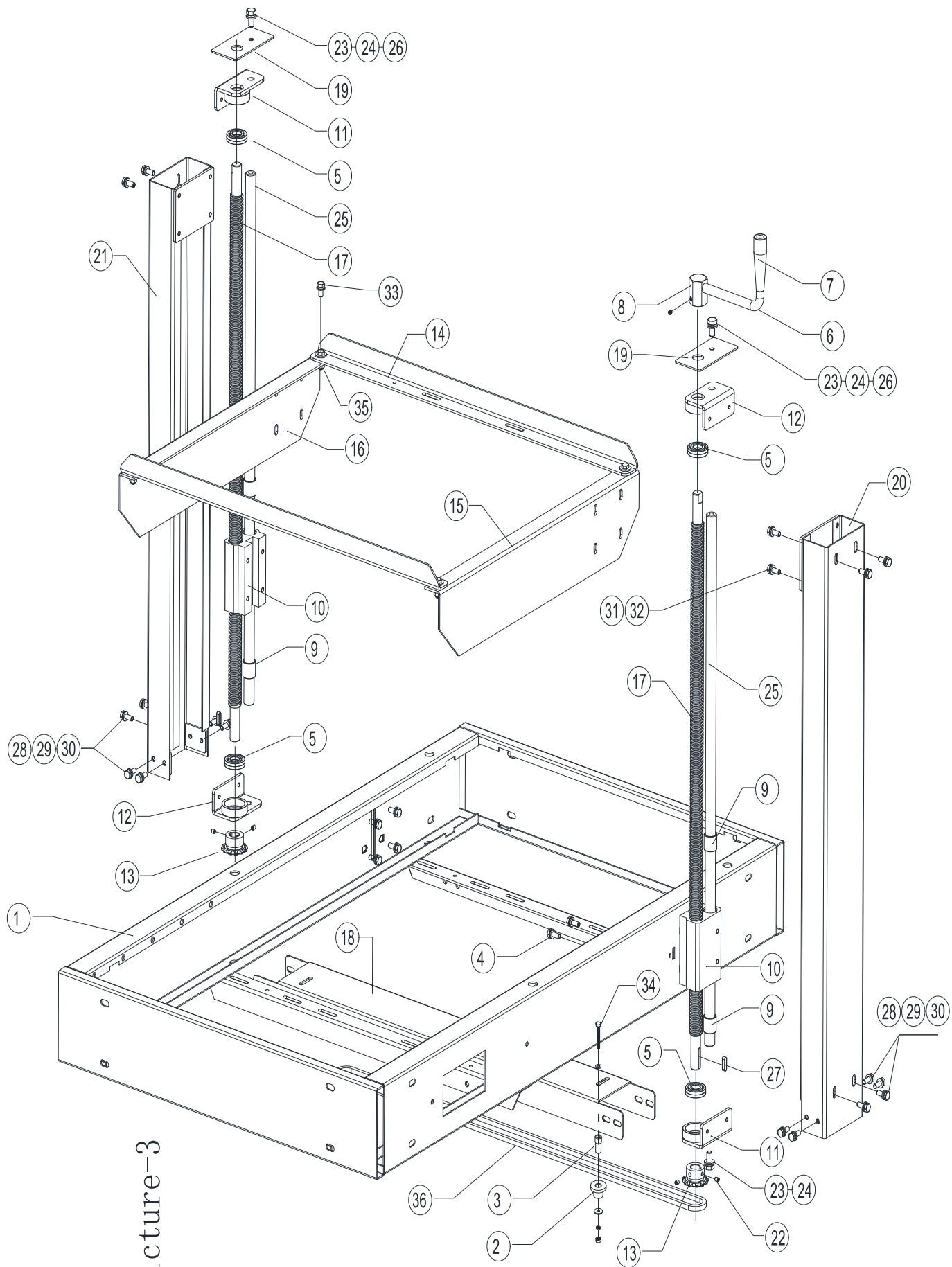


6.Spare parts list



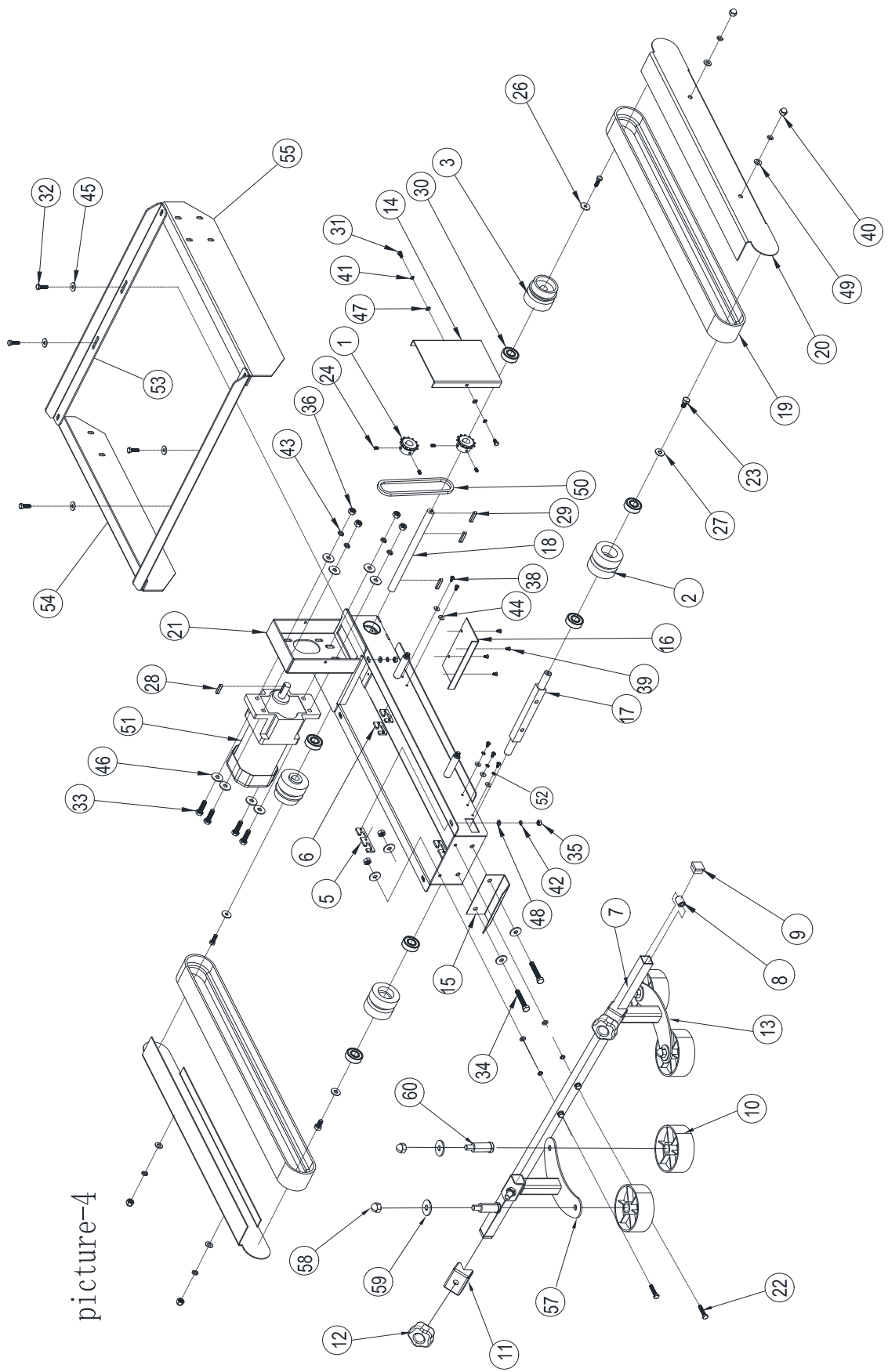
NO.	ERP NO	Description	QTY	PARTS NO.
1	90301001-1	Machine Frame welding parts	1	XT9037-HJT-102
2	90204002	screw	2	GBT818 -M6x50
3	60630015-1	Washers	2	GBT97.1-D6
4	60620005	Nut	2	GBT6170-M5
5	60630010	Washer	10	GBT93-D5
6	60630010	Washer	4	GBT97.1-D5
7	90205019-1	Control box	1	XT9037-10-122
10	60620001-1	Nut	4	GBT6170-M4
11	60630007	Washer	4	GBT97.1-D4
12	60616045-1	Nut	4	GBT818- M4x16
13	60210544	ON-OFF switch	1	KE215
14	60616066-1	screw	2	GBT818-M5x16
15	90205018-1	Indicator	1	XT9036-10-116
16	60630005	Washer	1	GBT96-D4
17	60616036-1	Screw	1	GBT818-M4x6
18	90304002-1	Limit Ring	8	XT9037-10-112
19	60613007	Screw	16	GBT79-M5x6
20	90301004-1	Front swing arm parts L	1	XT9037-HJT-104L-V2
21	90305009	Width adjusting board	2	XT9037-10-119
22	90301004-1	Rear swing arm parts	2	XT9037-HJT-103V1
23	90304010-1	Adjusting shaft	2	XT9037-10-118
24	90301005-1	Left guide plate parts	1	XT9037-HJT-105L-V1
25	GBT893.1D=10	Star Knob	4	GBT893.1D=10
26	60320019	Screw	2	XT9037-30-117
27	60616062-1	Washer	8	GBT818-M5x10
28	60630009-1	Screw	8	GBT96-D5
29	60613007	Right guide plate parts	4	GBT77-M5x5
30	90301006-1	Rear swing arm parts R	1	XT9037-HJT-105R
31	90301004-1	Adjusting rod fix sleeve	1	XT9037-HJT-104R-V2
32	90304004	Crank shaft	2	XT9037-10-115
33	90304006	Guide rail fixing shaft	2	XT9037-10-114
34	90304007	Star Knob	2	XT9037-10-117

NO	ERP NO	Description	QTY	Part No
1	90301001-1	Machine Frame	1	XT9037-HJT-102T
2	60410008	Brake caster	4	XT9036-10-100
3	90205005-1	Leg fixing plate	4	XT9036-10-104
4	90204003-1	Machine Frame spring	8	XT9036-10-118
5	90204004-1	Extension conveyor spring	8	XT9036-10-119
6	90301016-1	Front extension conveyor	2	XT9037-50-100HJ-V1
7	90301016-1	Rear extension conveyor	2	XT9037-50-100HJ-V1
8	90206011	Roller plug	34	XT9036-50-102
9	90206002	R type pin 100	1	XT9036-50-108-1
10	90206003	R type pin 170	1	XT9036-50-108-2
11	90201001-1	Leg	4	XT9036-HJT-100-V1
12	90201002	Leg	4	XT9036-HJT-101
13	90304001-1	Supporting Rod	8	XT9037-10-110
14	90305006-1	Machine frame cover	2	XT9037-10-111
15	90304024-1	Extension conveyor roller shaft	12	XT9037-50-101
16	90304022	Extension conveyor roller	12	XT9037-50-102
17	90304022	Machine frame long roller	10	XT9037-50-104-1
18	90304024-1	Machine frame long roller shaft	5	XT9037-50-105
19	60615085-1	Screw	8	GBT70.1--M8x25
20	60620009-1	Nut	16	GBT6170-M8
21	60630020-1	Plain Washer	16	GBT97.1-D8
22	60640004-1	Spring Washer	16	GBT93-D8
23	60611023-1	Bolt	32	GBT5783-M6X20
24	60616105-1	Screw	8	GBT819- M4X12
25	60640003-1	Spring Washer	40	GBT93-D6
26	60630018-1	Plain Washer	8	GBT96-D6
27	60630015-1	Plain Washer	40	GBT97.1-D6
28	60620019-1	Nut	4	GBT6170-M16
29	60660050	Bearing 6001 Option	30	6001
30	90206012	Roller plug cap option	30	TX9036-50-102-01
31	90206013	Roller plug cap option	30	TX9036-50-102-02



picture-3

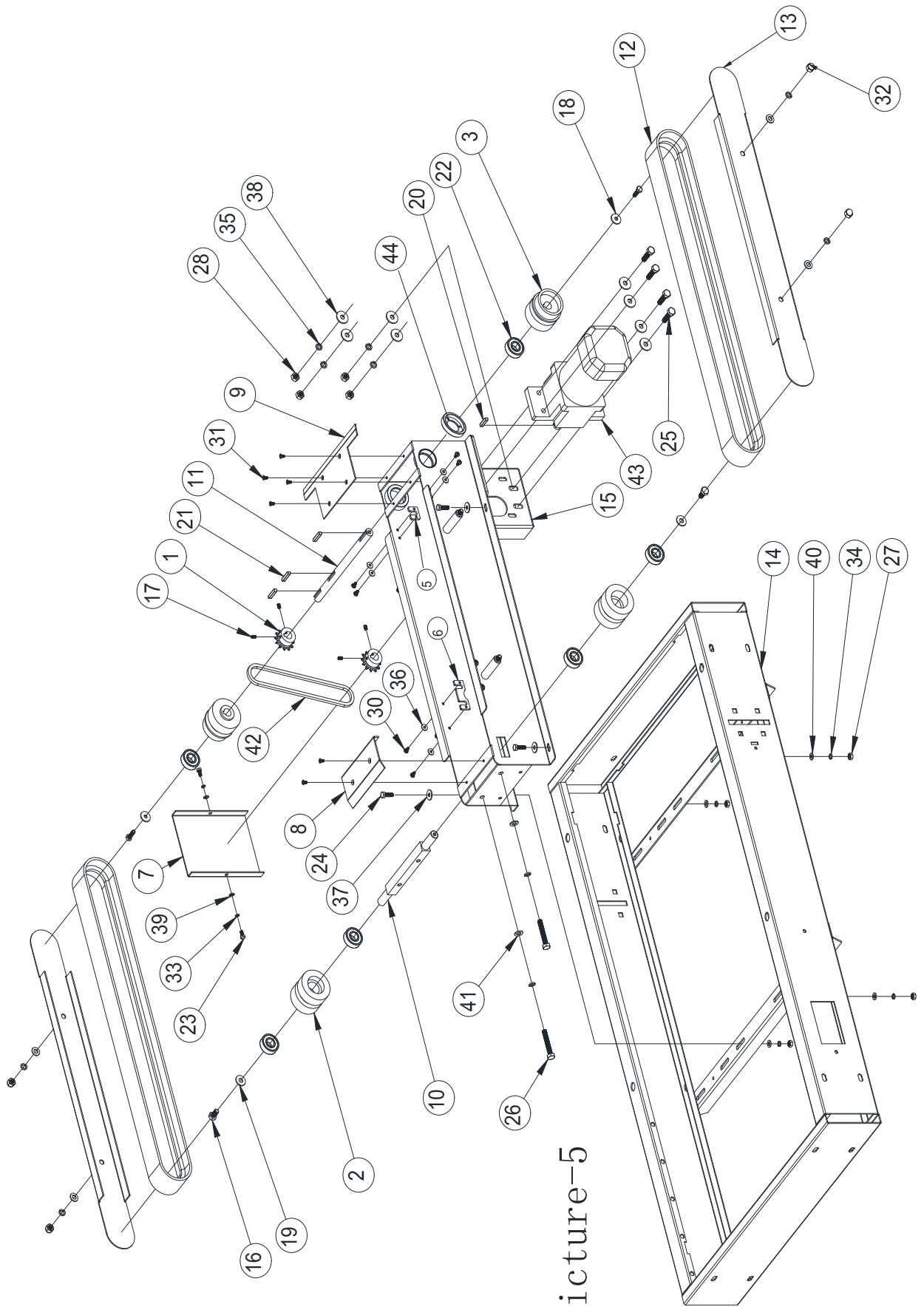
NO	ERP NO	Description	QTY	Part No
1	90301001-1	Machine Frame	1	XT9037-HJT-102
2	90204001	Reduction wheel	1	XT9036-10-114
3	90204002-1	Reduction wheel shaft	1	XT9036-10-115
4	90204003-1	Bolt M6*12	8	GB5783
5	60660054	Bearing 16002	4	GB276
6	90204007	Crank	2	XT9036-20-105-V1
7	90206001	Crank handle	2	XT9036-20-106-V1
8	90204008-1	Crank fixing sleeve	2	XT9036-20-107-V1
9	90304004	Shaft sleeve C16*20*20Y	4	GB12613
10	90204023-1	Nut seat	2	XT9036-30-102
11	90301014-1	Fixing seat	2	XT9037-40-202-V2R
12	90301013-1	Fixing seat	2	XT9037-40-202-V2L
13	90206004-1	Driving chain wheel	2	XT9036-20-104-V1
14	90305039-1	Top fame crossbar	2	XT9037-20-118-V1
15	90305040	Top frame fixing board	1	XT9037-20-119L
16	90305041	Top frame fixing board	1	XT9037-20-119R
17	90304018	Post crew	2	XT9037-40-204-V1
18	90305050-1	Chain protection cover	1	XT9037-40-110
19	90305051-1	Post top cover	2	XT9037-40-205-V2
20	90301015	Main post parts	1	XT9037-HJT-112L-V3
21	90301015-1	Main post parts	1	XT9037-HJT-112R-V3
22	60613011	Hexagonal flat head fixing screw M5*10	8	GB79-M5*10
23	60611041-1	Bolt M8x16	4	GBT5783-M8x16
24	60630018-1	Plain Washer	4	GBT96.1-D6
25	90304019-1	Post guiding rod	2	XT9037-40-203-V2
26	60640003-1	Spring Washer	4	GBT93-D6
27	60682042	Pin	2	GBT1069-J4x20
28	60620009-1	Nut	24	GB5783-M8
29	60630020-1	Plain Washer	24	GBT97.1-D8
30	60640004-1	Spring Washer	12	GBT93-D8
31	60611019-1	Hex bolt	8	GB5783- M6*12
32	60611020-1	Hex bolt	8	GB5783- M6*16
33	60611023-1	Hex bolt	4	GBT5783-M6X20
34	60611028	Hex bolt	1	GBT5783-M6X45
35	60620007-1	Nut	13	GBT6170-M6
36	60671005	Chain 06B-155 pieces	1	06B-155



picture-4

NO	ERP NO	Description	QTY	Part No
1	90206004-1	Chain wheel 06B Z=12	2	XT9036-20-104
2	90206005	Rear driving roller	2	XT9036-20-123-V1
3	90206006	Main driving roller	2	XT9036-20-124-V1
5	90205047-1	Top tape head fixing plate 1	2	XT9036-40-106-1
6	90205048-1	Top tape head fixing plate 2	2	XT9036-40-106-2
7	90205049	Side compressing wheel guide rod	1	XT9036-40-107
8	90204028-1	Side compressing wheel guide rod steel	2	XT9036-40-108
9	90206009	Side compressing wheel guide rod cover	2	XT9036-40-109
10	90206010	Side compressing wheel	2	XT9036-40-111
11	90205054-1	Side compressing wheel fixing plate	2	XT9036-40-113
12	60320019	Star knob:M10*20	4	GB/T7274.4
13	90301012-1	Compressing wheel holding bracket R	2	XT9037-HJT-110-1-v1
14	90305022	Motor cover	1	XT9037-20-108
15	90305037	Front guide plate	1	XT9037-20-115
16	90305038	Top cover	1	XT9037-20-116-V1
17	90304016-1	Driven roller shaft	1	XT9037-30-100
18	90304017-1	Driving roller shaft	1	XT9037-30-101
19	90306002	Belt	2	XT9037-30-107
20	90305045-1	Top belt cover R	1	XT9037-30-109R-V1
21	90301009	120W Top motor seat base	1	XT9037-HJT-108-V3
22	60611025-1	Bolt	2	GBT5783-M6x30
23	60611041-1	Bolt	2	GBT5783-M8x16
24	60613009	Screw	4	GBT77-M5x8
26	GBT96-D6	Washer	2	GBT96-D6
27	GBT96-D8	Washer	2	GBT96-D8
28	60682009	Flat key	1	GBT1096-J-5X25
29	60682010	Flat Key	3	GBT1096-J-5X28
30	60660081	Bearing	6	GBT276-6202ZE
31	60611009	Bolt	2	GBT5783-M5X10
32	60611023-1	Bolt	6	GBT5783-M6X20
33	60611050-1	Bolt	4	GBT5783-M8X30
34	60611054-1	Bolt	2	GBT5783-M8X50
35	60620007-1	Nut	4	GBT6170-M6
36	60620009-1	Nut	6	GBT6170-M8
38	60616039-1	screw	10	GBT818-M4X8
39	60616103-1	screw	4	GBT819-M4X8
40	60620049	Nut	4	GBT923-M8

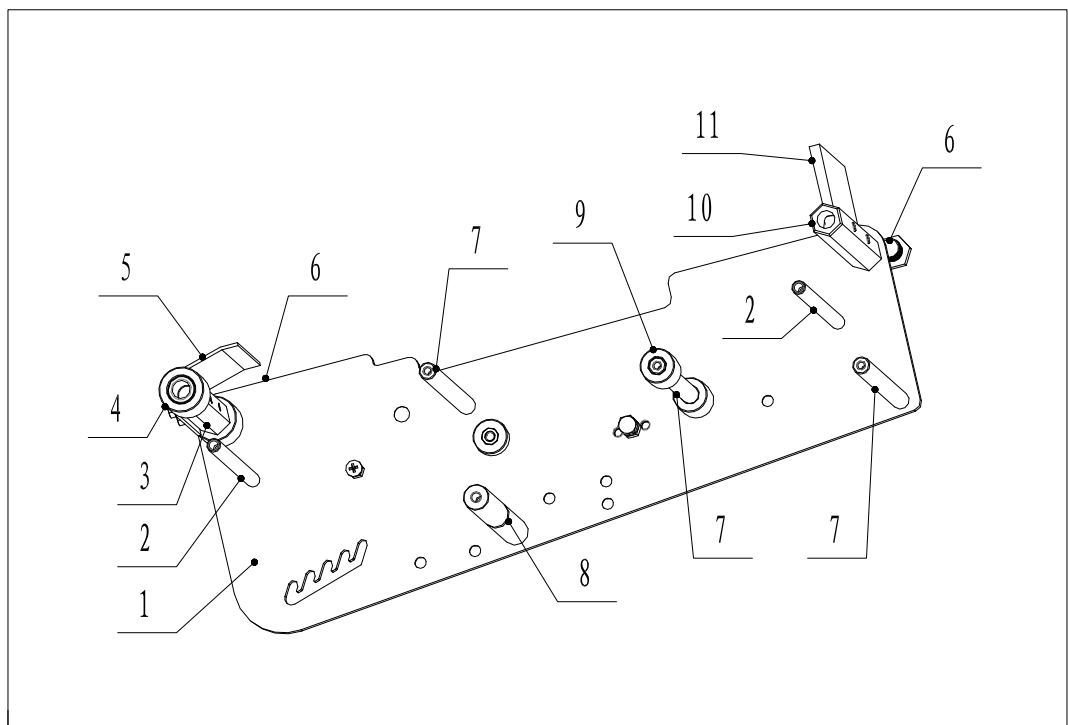
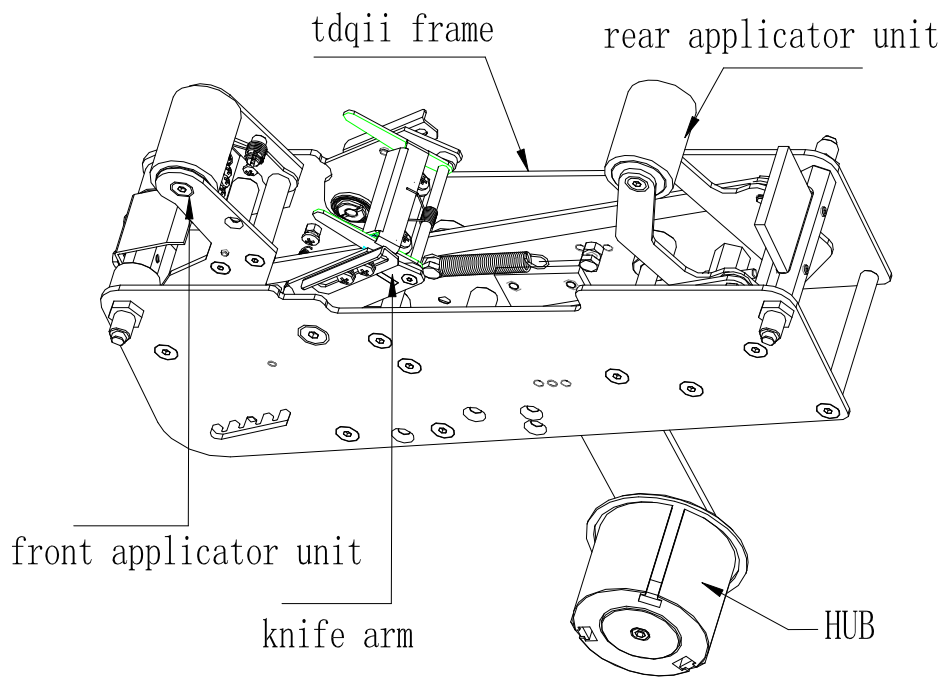
41	60640002-1	Spring Washer	2	GBT93-D5
42	60640003-1	Spring Washer	6	GBT93-D6
43	60640004-1	Spring Washer	8	GBT93-D8
44	60630005	Plain Washer	10	GBT96-D4
45	60630018-1	Plain Washer	4	GBT96-D6
46	60630027-1	Plain Washer	12	GBT96-D8
47	60630010-1	Plain Washer	2	GBT97.1-D5
48	60630015-1	Plain Washer	6	GBT97.1-D6
49	60630020-1	Plain Washer	4	GBT97.1-D8
50	60671013	Chain 06B-41	1	GB/T1243
51	60220021	Motor	1	5IK120-C-F;5GU1:15
52	60640001	Spring washer	10	GB/T93 D4
53	90305039-1	Top frame crossbar	2	TX9037-20-118-V1
54	90305040-1	Top frame fixing board L	2	TX9037-20-119L-V1
55	90305041-1	Top frame fixing board R	1	TX9037-20-119R-V1
56	90305044-1	Top belt cover L	1	XT9037-30-109L-V1
57	90301011-1	Side compressing rod L	1	XT9037-HJT-110-2-v1
58	60620050	M10 Nut	2	GB/T802
59	60630029-1	M10 Plain Washer	4	GB/T96.1
60	90204029-1	Side compress roller shaft	4	XT9036-40-111



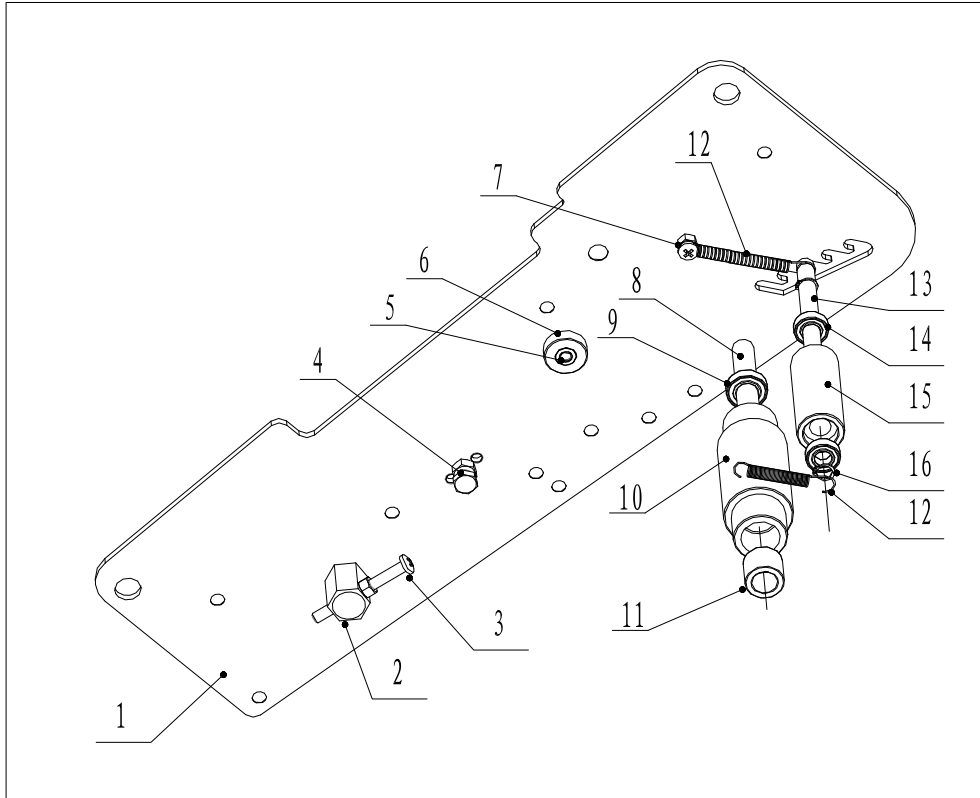
picture-5

NO	ERP NO	Description	QTY	Part No
1	90206004-1	Chain wheel 06B Z=12	2	XT9036-20-104-v1
2	90206005	Rear Driven roller	2	XT9036-20-123
3	90206006	Main driving roller	2	XT9036-20-124
5	90205047-1	Tape head fixing plate 1	2	XT9036-10-113-1
6	90205048-1	Tape head fixing plate 2	2	XT9036-10-113-2
7	90305022	Motor cover	1	XT9037-20-108-V1
8	90305023	Rear compressing plate	1	XT9037-20-110-V1
9	90305024	Front compressing plate	1	XT9037-20-111
10	90304016-1	Driven roller shaft	1	XT9037-30-100
11	90304017-1	Driving roller shaft	2	XT9037-30-101
12	90306002	Belt	2	XT9037-30-107
13	90305042	Bottom belt cover	1	XT9037-30-108L-V1
14	90301001-1	Machine frame	1	XT9037-HJT-102v2
15	90301007-1	120W bottom motor seat parts	1	XT9037-HJT-106-V3
16	60611041-1	Bolt	2	GBT5783-M8x16
17	60613009	Screw	4	GBT77-M5x8
18	60630018-1	Washer	2	GBT96-D6
19	60630027-1	Washer	2	GBT96-D8
20	60682009	Flat key	1	GBT1096-J-5X25
21	60682010	Flat key	3	GBT1096-J-5X28
22	60660081	Bearing	6	GBT276-6202ZE
23	60616062-1	Bolt	2	GBT818-M5X10
24	60611023-1	Bolt	6	GBT5783-M6X20
25	60611050-1	Bolt	4	GBT5783-M8X30
26	60611054-1	Bolt	2	GBT5783-M8X50
27	60620007-1	Nut	4	GBT6170-M6
28	60620009-1	Nut	4	GBT6170-M8
30	60616038-1	Screw	8	GBT818-M4X8
31	60616104-1	Screw	6	GBT819-M4X10
32	60620049	Nut	4	GBT923-M8
33	60640002-1	Spring Washer	2	GBT93-D5
34	60640003-1	Spring Washer	4	GBT93-D6
35	60640004-1	Spring Washer	10	GBT93-D8
36	60630005	Plain Washer	8	GBT96-D4
37	60630018-1	Plain Washer	4	GBT96-D6
38	60630027-1	Plain Washer	8	GBT96-D8

39	60630010-1	Plain Washer	2	GBT97.1-D5
40	60630015-1	Plain Washer	4	GBT97.1-D6
41	60630020-1	Plain Washer	6	GBT97.1-D8
42	60671014	Chain 06B-49	1	GB/T243
43	60220021	Motor	1	5IK120-C-F;5GU1:15
44	90304013-1	Bearing seat	4	TX9037-20-112
45	90305043-1	Bottom belt cover	1	XT9037-30-108R-V1

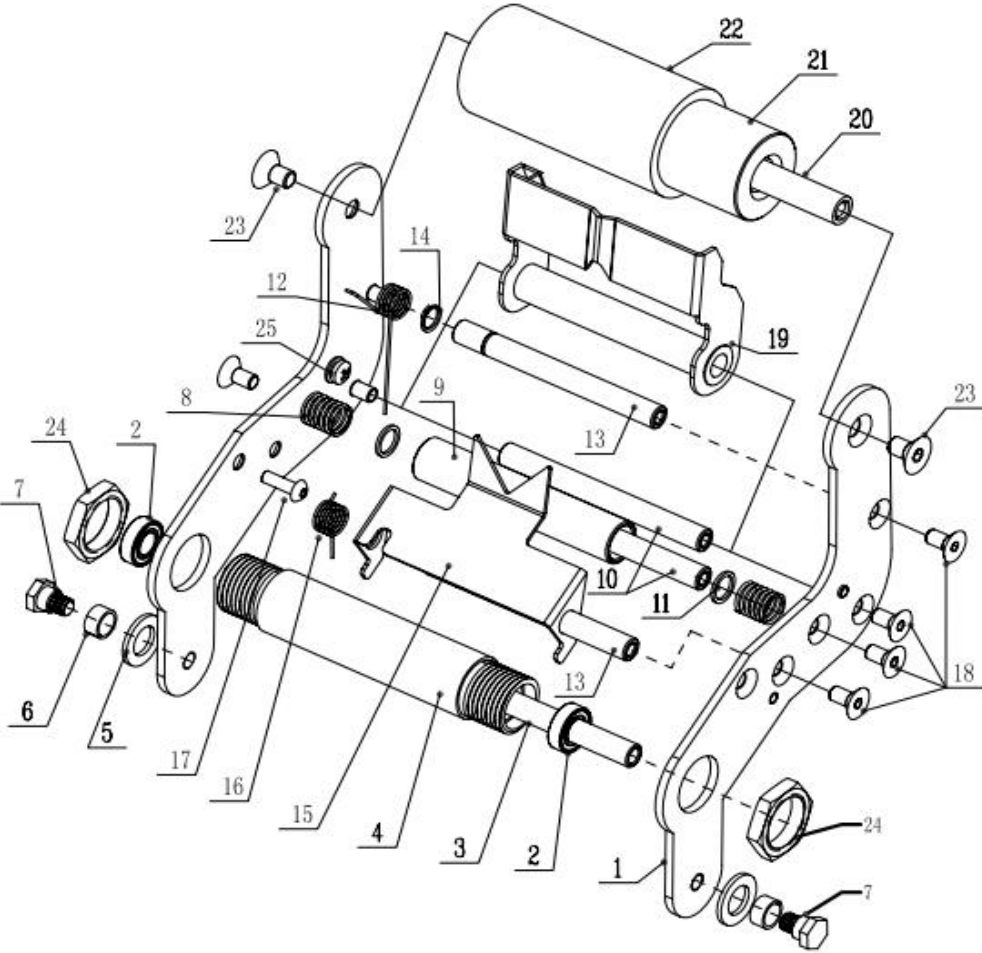


No.	ERP NO	Part name	Quantity	Part no.
1	90205101-1	Left board	1	TDQII3-101L-V1
2	90204121-1	Swing bar axis pin	2	TDQII-117-02
3	90204107-1	Fixing rod	1	TDQII-106
4	90204109	Swing bar noise elimination bush	2	TDQII-107
5	90205103	Guide plate	1	BT3.0S-138-V1
6	90204105-1	Brush support pillar tight screw	4	TDQII-105
7	90204101-1 90204102-1	Round support pillar	3 3	BT3.0S-106 BT2.0S-106
8	90204140	Tension spring support pillar	1	TDQII-133
9	90204151	Rear tape compress bracket roller	2	TDQII-156-V1
10	90204103-1 90204104-1	Brush support pillar	1 1	BT3.0S-103 BT2.0S-103
11	90206120 90206121	Brush	1 1	BT3.0S-104 BT2.0S-104



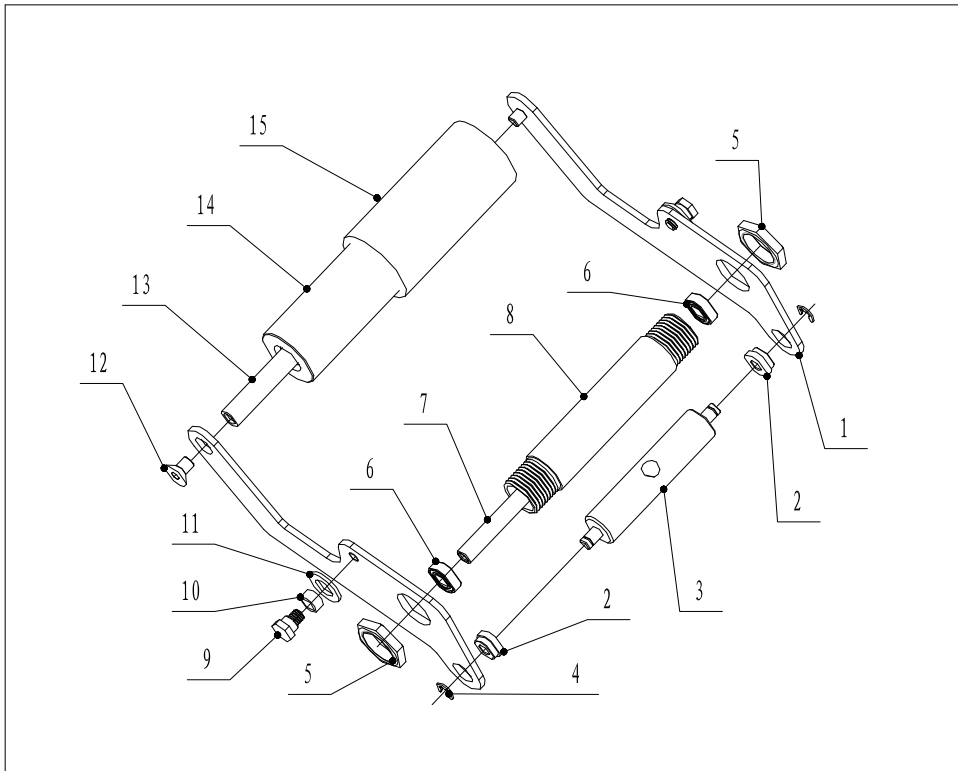
No.	ERP NO	Part name	Quantity	Part no.
1	90205102-1	Right board	1	TDQII3-101R-V1
4	60611019-1	Hex nut	1	M6*12(GB/T5783)
5	60612020-1	Hexagonal socket head screw	1	M6*10 (GB/T70.3)
6	90204148	Cutter bracket stop wheel	1	TDQII-145
7	60616062-1	Cross pan head screw	2	M5*10(GB/T 823)
8	90204112-1	One-way roller shaft	1	TDQII-110
9	60660066	Bearing	1	61800-Z
10	90204110-1	One-way roller	1	TDQII-109
11	60660000	One-way bearing	1	HF1216
12	90206101	Idler axis tension spring	2	TDQII-111
13	90204116-1	Idler axis	1	TDQII-113
14	60660100	Bearing	2	GB/T 276
15	90204114	Idler	1	TDQII-112
16	60651005	d0=8 shaft elastic closing ring	2	GB/T 894.2

Front tape head assembly picture (new)



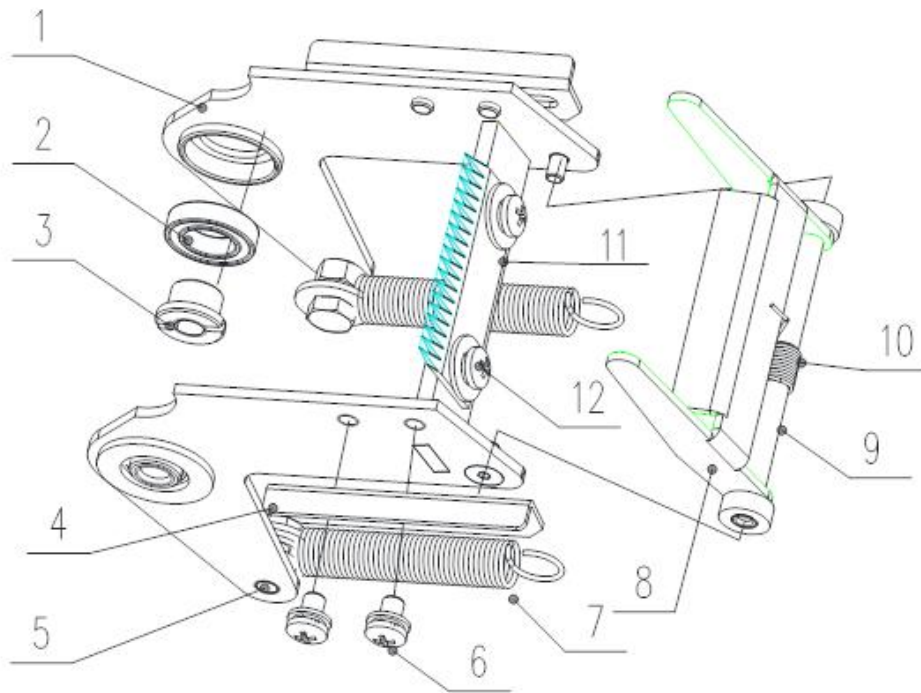
No.	ERP NO	Part name	Quantity	Part no.
1	90202104	Front swing bar	2	TDQII-114-V3
2	60660067	Bearing	2	61801-Z
3	90204121-1	Swing bar axis pin	1	TDQII-117-02
4	90204119-1	Swing bar fixed bush	1	TDQII-117
5	60630029-1	M10 small washer	2	GB/T 848
6	60660119	Shaft bush	2	P10*8*5(GB12613)
7	90204139-1	Connecting lever screw	2	TDQII-132
8	90206104	Spring	2	BT2.0S-130
9	90204130	Front embossed roller	1	TDQII-123
10	90204133-1	Front embossed roller shaft	2	TDQII-124
11	90204132	Spring washer	2	TDQII-123-02
12	90206105	Tape protection bracket spring	1	TDQII-128-01
13	90204137-1	Tape protection bracket twist spring shaft	1	TDQII-127-01
14	60651005	d0=8 shaft elastic closing ring	1	GB/T 894.2
15	90205112	Tape holding plate (2 or 3 inch)	1	TDQII-201
16	90206106	Tape holding plate twist spring	1	TDQII-202
17	60616045-1	Crossing pan head screw	1	M4*16:GB/T 70.2
18	60612011-1	Hexagonal socket head screw	8	M5X10:GB/T70.3
19	90201101-1	Tape holding bracket	1	TDQII-125-V2HJ
20	90204124-1	Rubber roller shaft	1	TDQII-118
21	90204125	Swing bar rubber roller	1	TDQII-119
22	90206102 90206103	Rubber roller sleeve	1 1	BT3.0S-126 BT2.0S-126
23	60612020-1	Hexagon socket screw	2	M6X10:GB/T70.3
24	60620026	Nut	2	M20*1.5
25	60616036-1	Crossing pan head Screw	2	M4X6:GB/T 823

Rear tape head assembly picture



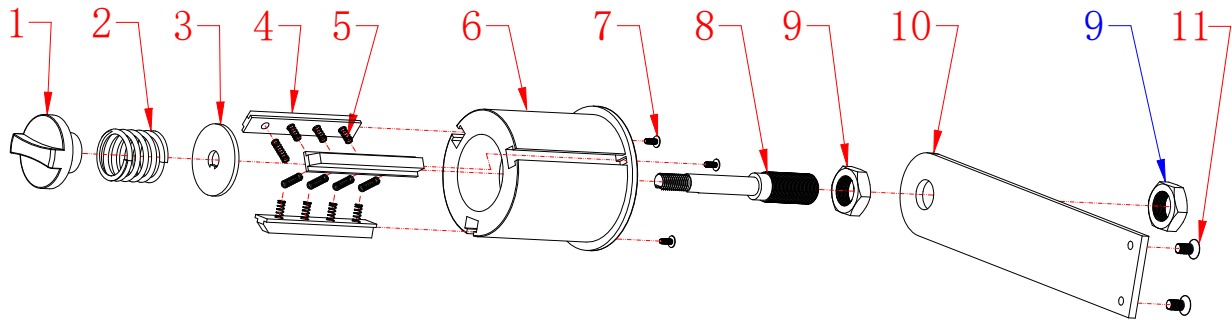
No.	ERP NO	Part name	Quantity	Part no.
1	90202106	Rear swing bar	2	TDQII-115
2	90204129	Shaft bush 6*12*6	2	TDQII-122-01
3	90204127-1	Swing bar tension spring adjusting rod	1	TDQII-122
4	60651029	Open Ring ETW5.0	2	ETW5.0
5	60620026	Nut	2	M20*1.5
6	60660100	Bearing	2	GB/T 276
7	90204121-1	Swing bar axis pin	1	TDQII-117-02
8	90204119-1	Swing bar fixed bush	1	TDQII-117
9	90204139-1	Connecting lever screw	2	TDQII-132
10	90204129	Shaft bush	2	P10*8*5(GB12613)
11	60630028	M10 small washer	2	GB/T 848
12	60612020-1	Hexagonal socket head screw	2	M6X10:GB/T 70.3
13	90204123-1	Rubber roller shaft	1	TDQII-118
14	90204125	Swing bar rubber roller	1	TDQII-119
15	90206102	Rubber roller sleeve	1	BT3.0S-126

Cutter bracket assembly picture



No.	ERP NO	Part name	Quantity	Part no.
1	90201103-1	Cutter bracket	1	TDQII-HJT-102
2	60660067	Bearing	2	61801-Z
3	90204145-1	Cutter bracket shaft	2	TDQII3-138-v1
4	90205121	Cutter bracket adjusting plate	1	TDQII3-137-v1
5	60611019-1	Hex bolt	1	M6*12(GB/T5783)
6	60616061-1	Cross pan head screw	2	M5X12(GB/T 818)
7	90206114	Cutter tension spring	2	BT2.0S-160-V2
8	90206111	Cutter cover	1	TDQII3-141G
9	90204146-1	Cutter cover shaft	1	TDQII3-142-v1
10	90206113	Cutter cover twist spring	1	TDQII3-144
11	90206109	Cutter	1	BT3.0S-155
12	60616061-1	Cross pan head screw	2	M5X12(GB/T 818)

Tape seat assembly picture



No.	ERP NO	Part name	Quantity	Part no.
1	90206116	Knob handle	1	BT2.0S-166
2	90206117	Lock spring	1	BT2.0S-169
3	90205123-1	Lock spring washer	1	BT2.0S-168A
4	90206119	Compressing plate	3	BT2.0S-171A
5	90206118	Compress plate spring	9	BT2.0S-170
6	90206115	Tape holder	1	BT2.0S-163
7	60616002	Screw	3	ST2.9*9.5
8	90204149-1	Tape holder fixing rod	1	BT2.0S-165A
9	60620023	Nut	2	M8X1.5
10	90205122-1	Tape holder supporting board	1	BT2.0S-164
11	60612022-1	Bolt	2	GB-T70.3-M6X1 2

7. Features

- 1> Easy operation, easy maintenance, no noise
- 2> Strong structure
- 3> Easy adjustment for width and height.
- 4> Accord with standard requirement, necessary spare parts are available
- 5> Roller table are easy to take apart.

8. Usage instruction:

- 1> Load tape on the tape seat, (Make sure the adhesive side of tape face upwards)
- 2> Adjust machine height and width according to carton box dimension
- 3> Start machine
- 4> The bottom flaps of carton must be folded by operator before carton sealing.
- 5> Put carton box at the entrance then can pack the box

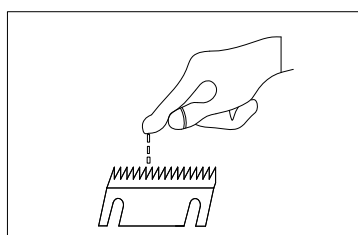
9. Maintenance:

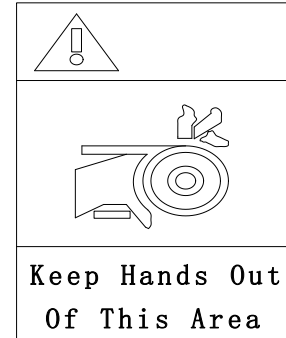
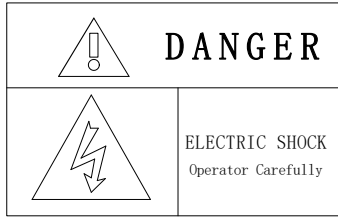
- 1> Lubrication :Lubrication all the moving parts on the tape head with light oil or grease every two months.
- 2> Check:Check all the moving bolts nuts and belts every two months,if found loosening tighten then right away.

10. Usage Notes: warning marks as below

1> Safety notes:

- a. Belts driving unit is moving parts, don't touch them while running to avoid injury.
- b. The knife of tape head is very sharp, pay attention to it while winding, cleaning and repair.
- c. Cut off power supply while exam and repair machine, otherwise will be dangerous.





2> Requirement for tape and carton box

- A. Deformed tape and stored too long time tape can't be used.
- B. Carton box must be kept dry, (wet box can't be packed on machine)

11. Warranty policy as below

Free of charge repair of machine within 1 year, provided that the machine is operated according to correct method; Free spare parts available. (except for incorrect operation and except for wearing parts)

Remarks: This manual is for the improved machine. The machine may updated or changed without notice.