

# SEMI-AUTOMATIC CARTON SEALER

Standard Model: FXJ6050M

FXJ6050A



Instruction manual and part list

## **INDEX**

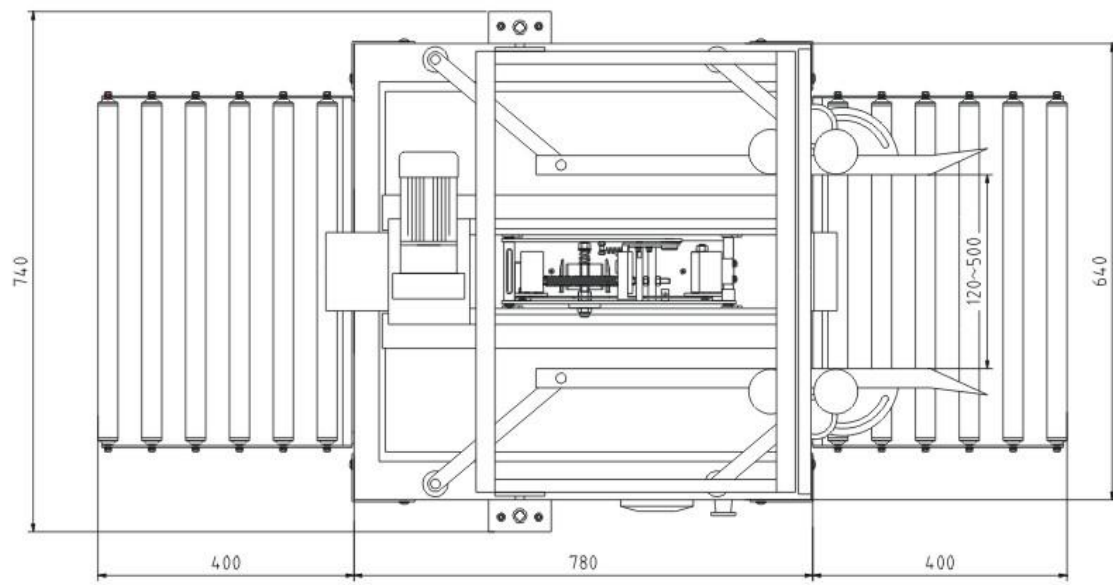
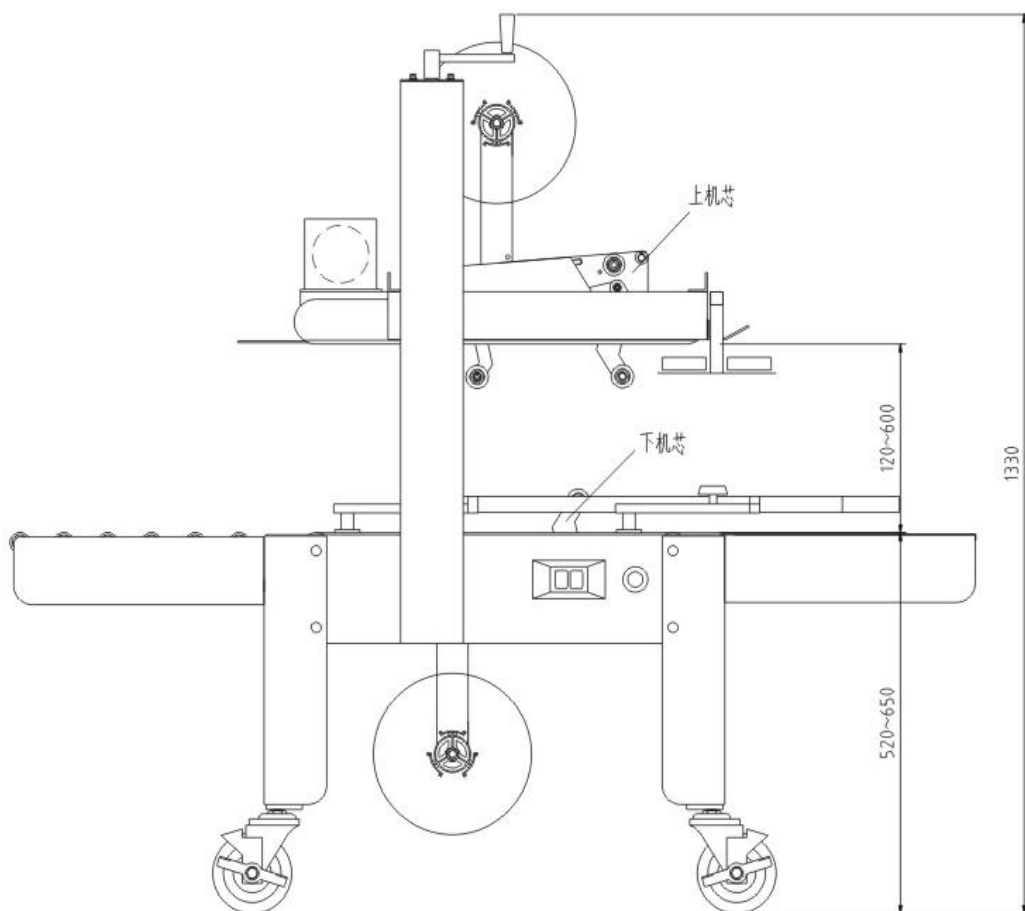
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## **GENERAL SAFETY RULES**

1. read and understand the entire instruction manual before operating the machine. Know it' s limitations, as well as the specific potential hazards peculiar to it.
2. Make certain the machine is properly grounded.
3. Before operating the machine, remove ties, rings, watches, other jewelry, and roll up sleeves above the elbows. Remove all loose clothing and confine long hair. Do not wear gloves.
4. Keep the floor around the machine clen.
5. Keep machine guards in place at all times when the machine is in use.
6. Do not overreach. Maintain a balanced stance at all times so that you do not fall lean against blades or other moving parts.
7. Make all machine adjustments or maintenance with the machine unpugged from the power source.
8. Replace warning labels If they become obscured or removed.
9. Make sure the power source switch is in the OFF position before connecting the machine to the power source.
10. Make a habit of checking to see that the keys and adjusting wrenches are removed before turning on the machine.
11. Keep belt guard and blade guards in place and in working order.
12. Failure to comply with all of these warnings could lead to serious injury.

# DIMENSIONAL DRAWING



## SPECIFICATIONS:

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<b>Rang of box dimensions</b>	<b>Length 100–unlimited mm</b> <b>Width 120–500 mm</b> <b>Height 120–600</b>
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<b>Tape width</b>	<b>2 " (50mm)</b> <b>2.5 " (60mm)</b>
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<b>Drivng belt speed</b>	<b>22m/min.(60Hz power source)</b> <b>18m/min.(50Hz power source)</b>
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<b>Box driving device</b>	<b>Top and bottom driving motor</b>
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<b>Height of roller conveyor table</b>	<b>440–680mm(adjustable)</b>
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<b>Motor</b>	<b>1/5HP (Lower belt)</b> <b>1/5HP (Upper belt)</b>
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<b>Machine dimensions</b>	<b>1580(L) × 640(W) × 1330(H)mm</b>
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<b>Power soure</b>	<b>Single or three phase</b>
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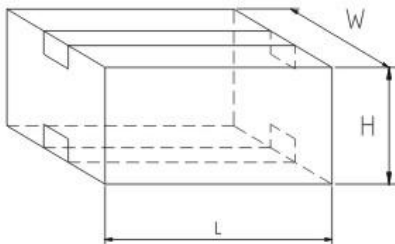
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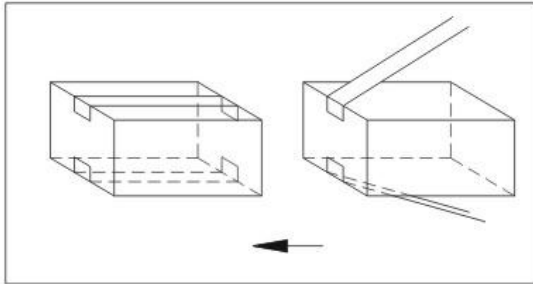
<b>Net weight</b>	<b>120kgs</b>
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<b>Gross weight</b>	<b>160kgs</b>
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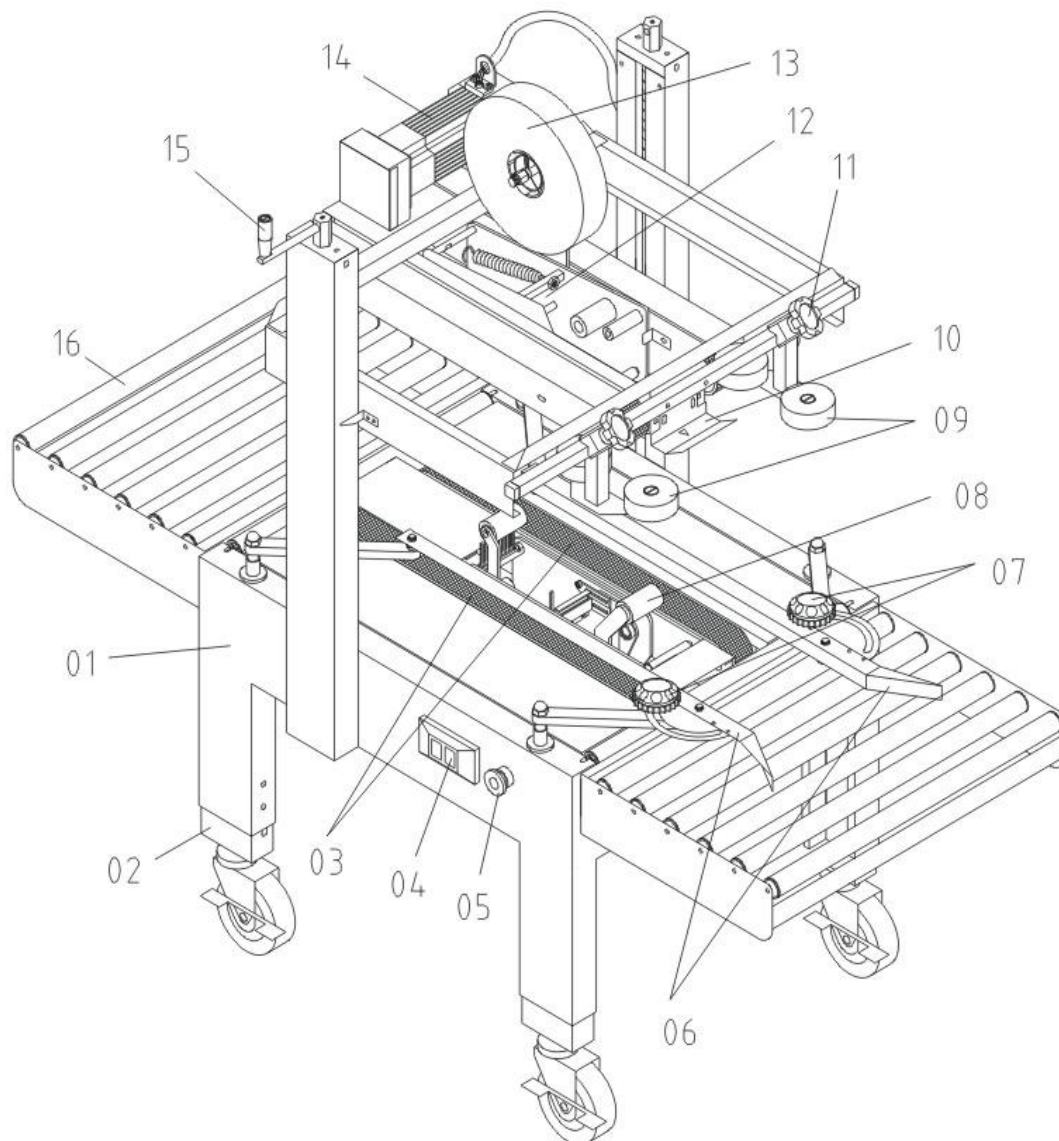
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## LEGEND OF THE MACHINE

- |                                 |                                     |
|---------------------------------|-------------------------------------|
| 01.Machine frame                | 09.Guide wheel                      |
| 02.Leveling adjuster            | 10.Top guide late                   |
| 03.Conveyor belt                | 11.Guide wheel adjustment knob      |
| 04.Power source switch(ON/OFF)  | 12.Upper tape head mechanism        |
| 05. Reset switch                | 13. Upper tape                      |
| 06.Carton guide rail            | 14.Upper tape head driving motor    |
| 07.Hand tighten lock wheel      | 15.Height adjustemntnt crank handle |
| 08.Lower tape head driving belt | 16.Conveyor roller                  |



## **POWER SOURCE WIRING**

1. Before connecting, make sure the voltage is the same for both the machine and the power source

All electrical information (such as voltage) has been wired before shipment, and is indicated on the electrical instruction label.

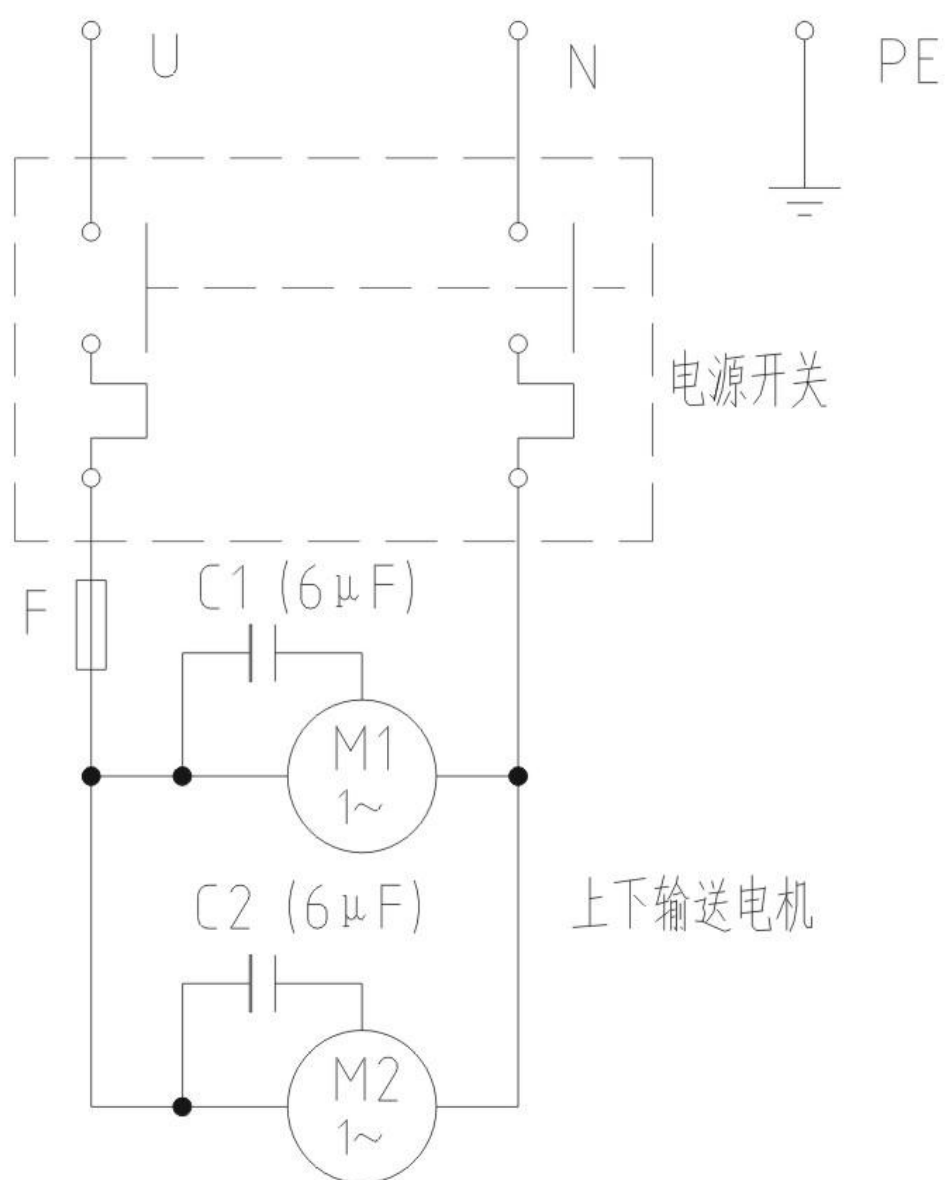
2. Connect the power source wires to the " R.S.T. " Connection points.

**The machine must be properly grounded to prevent possible damage from electric shocks. (3 phase only)**

3. After the power source wires have been connected, check to see if the wires are connected to the correct points by the running direction of the left and right driving belts. If the driving belts run in the correct direction, then the power source wires are connected to the correct points. If the driving belts run in the opposite direction, cut off the power source and change any two of the three power source wires to obtain the correct running direction. (3 phase only)

# ELECTRICAL WIRING DIAGRAM

1 $\phi$  AC220V 50/60Hz



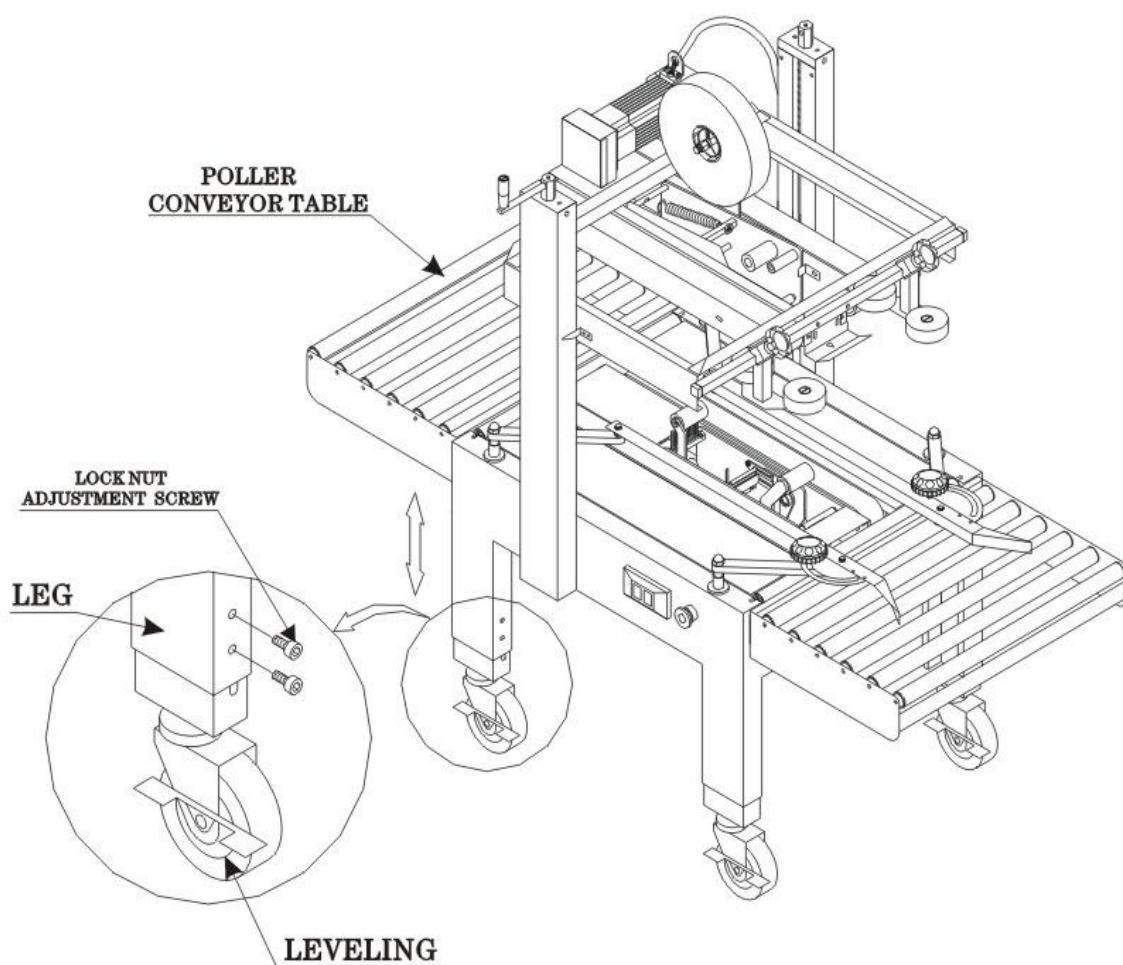


## LEVELING ADJUSTMENT FOR ROLLER CONVEYOR TABLE

Once the machine has been located at the work site, there needs to be a proper leveling adjustment for the roller conveyor table to suit your production line.

The leveling adjustment screws are located at the bottom of the 4 legs. Make the leveling adjustment by simply turning the leveling adjustment screws, Loosen the lock nut before you do it. Tighten-up the lock nut after the level has been properly adjusted.

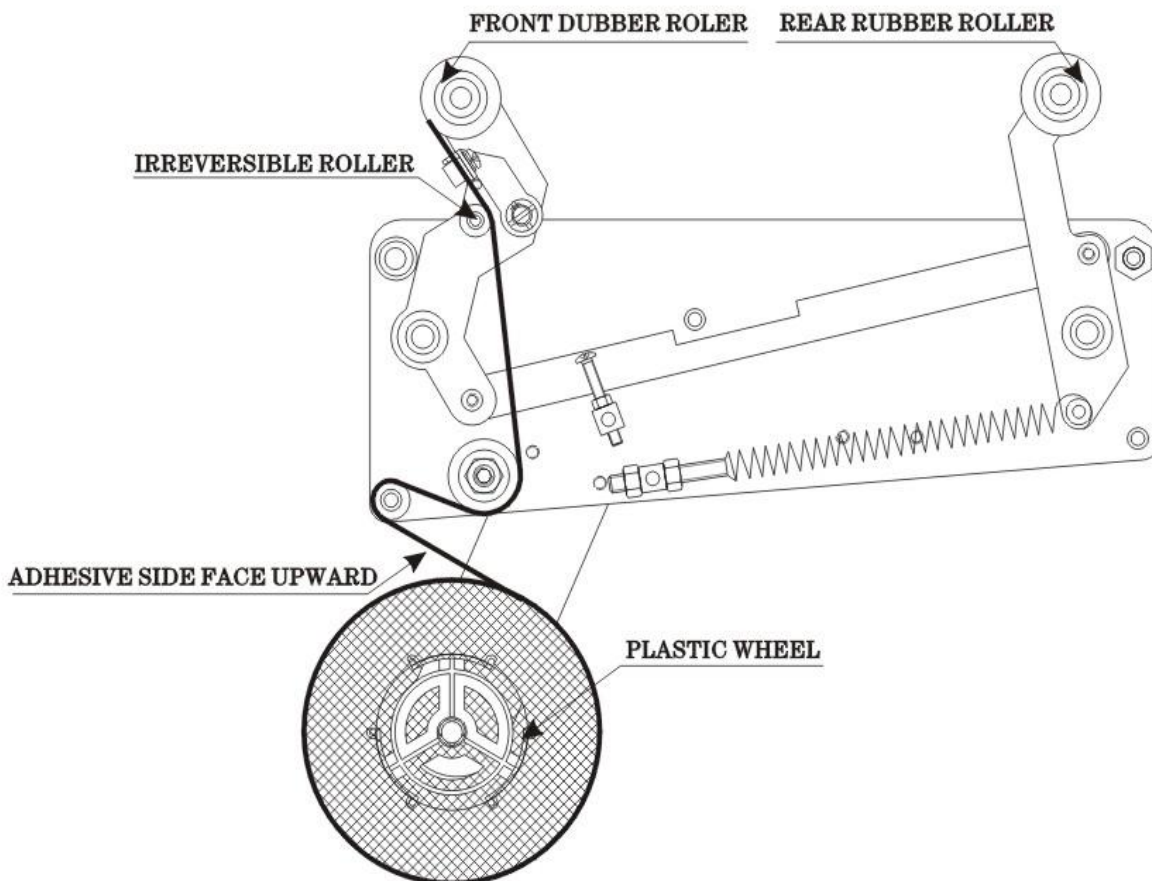
Fix the machine in place after leveling adjustment. Press the caster lock pedal for fixing the machine on work site.



## INSTALLING THE TAPE

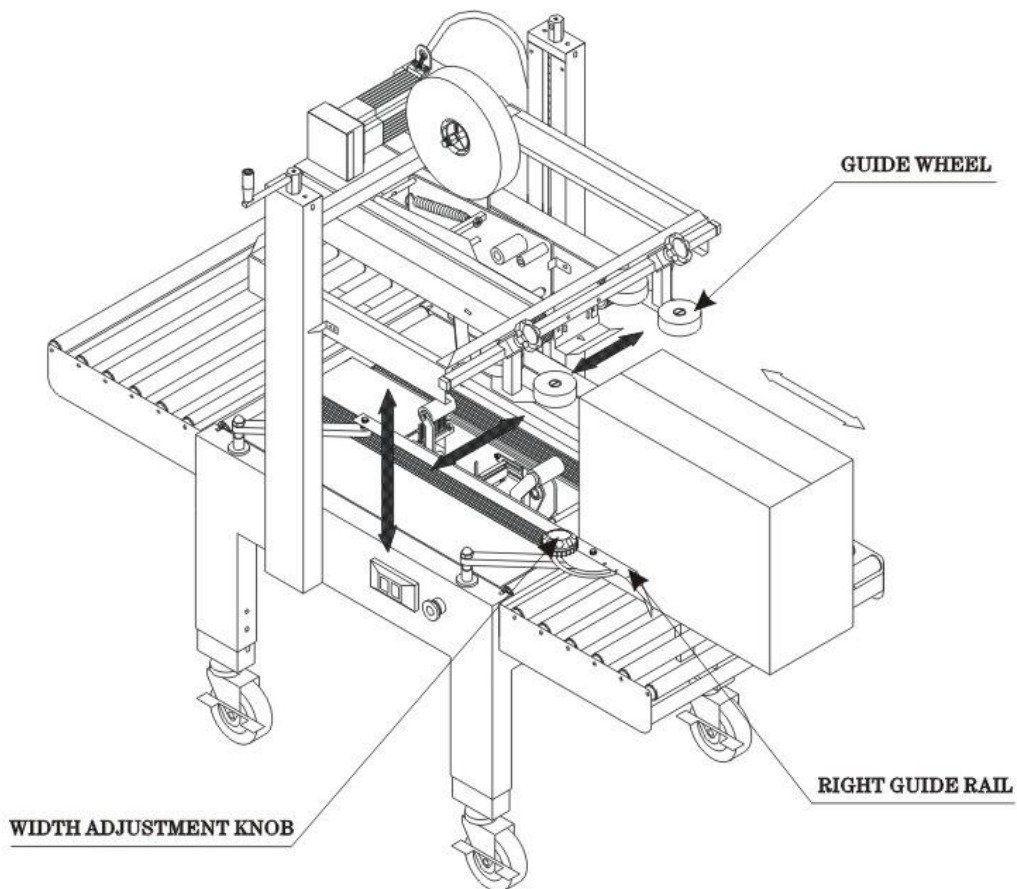
1. Fit the tape onto the tape loading wheel, and press it lightly to the extreme bottom (Make sure the adhesive side of tape faces upwards)
2. Pull out the tape.
3. Wind the tape around the plastic bush.
4. Wind the tape around the irreversible roller.
5. Pull out the tape through the space between the arch spring and front rubber roller.
6. Press the rear rubber roller inward to the extreme bottom. Pull the tape to the position of 20cm beyond the cutting knife.
7. Open the knife guard. Try to have the knife touch the tape for cutting off.

**CAUTION:** Pay special attention to avoid injury from the knife, with opening the knife guard and doing the cutting test.



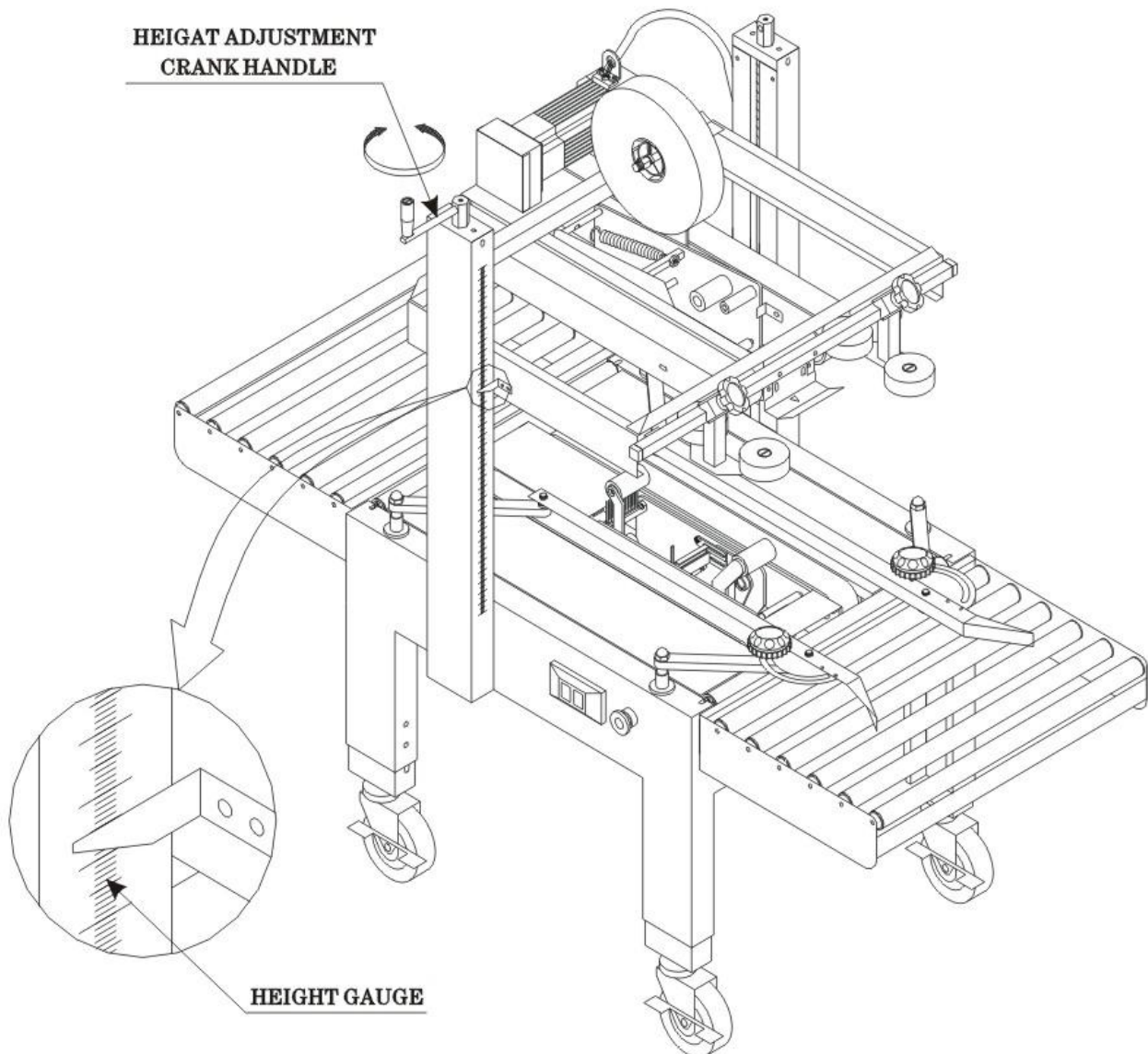
## **BOX WIDTH ADJUSTMENT**

1. Loosen the guide wheel fixing knob.
2. Move the guide wheel directly with your hands until the distance between guide wheels is about 30–50mm wider than the width of the box.
3. Loosen the width adjustment knob, move right/left clamping guide rail outward until the distance between the right and left rails is wider than the width of the box.
4. Place a box onto the roller conveyor table in proper position (see page 4) with the top and bottom covers folded. Move the right and left rails so that they properly press against both sides of the box. Tighten the width adjustment knob.
5. Adjust the box height.
6. Move the guide wheels so that they touch both top sides of the box.
7. Tighten the guide wheel fix knobs.



## **BOX HEIGHT ADJUSTMENT**

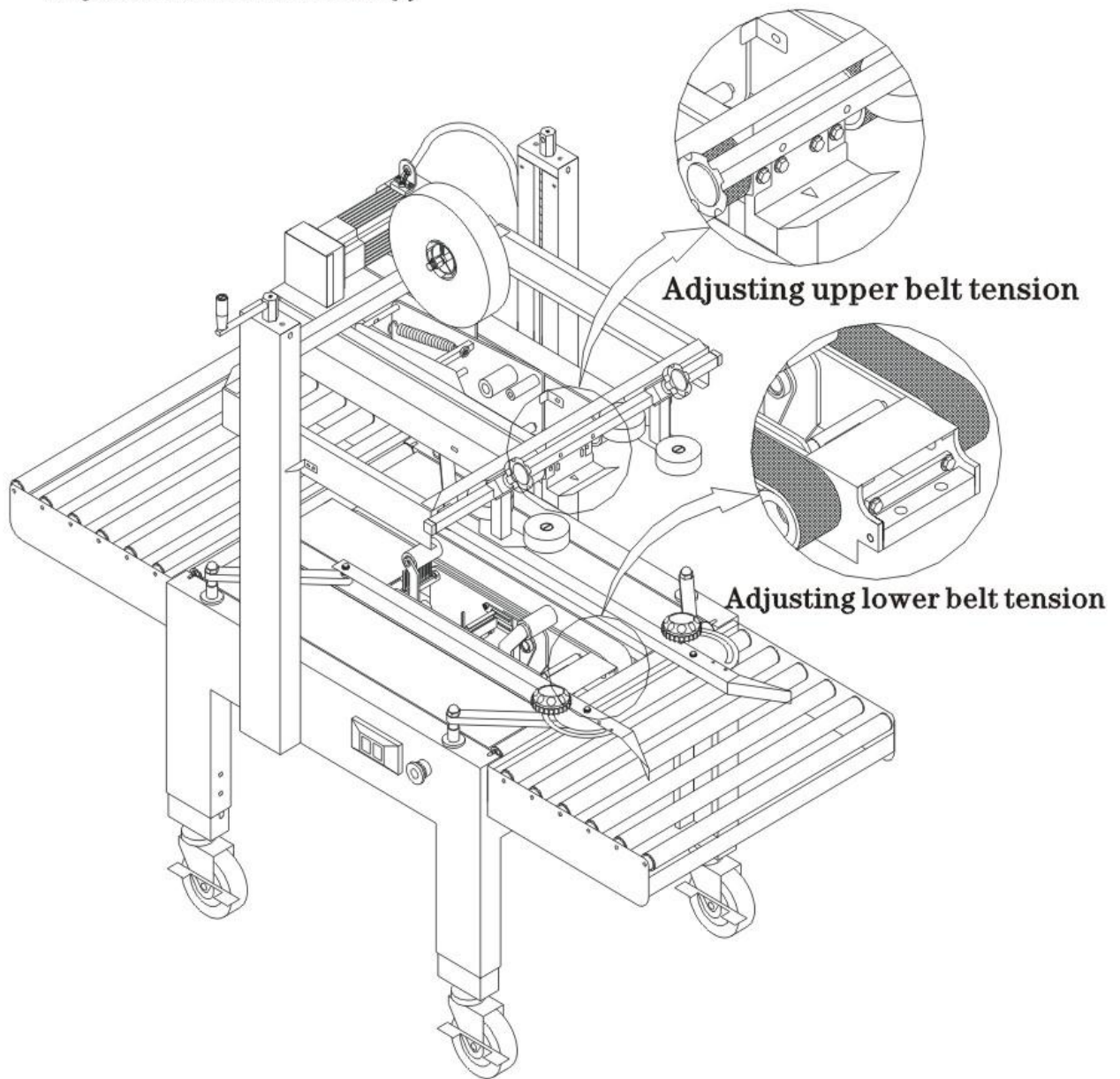
1. Make sure the box height.
2. Turn the height adjustment crank handle until the top driving belt holds down the box.
3. The box height can be read on the height gauge attached to the left frame of the machine.



## **ADJUSTING UPPER AND LOWER DRIVING BELT TENSION**

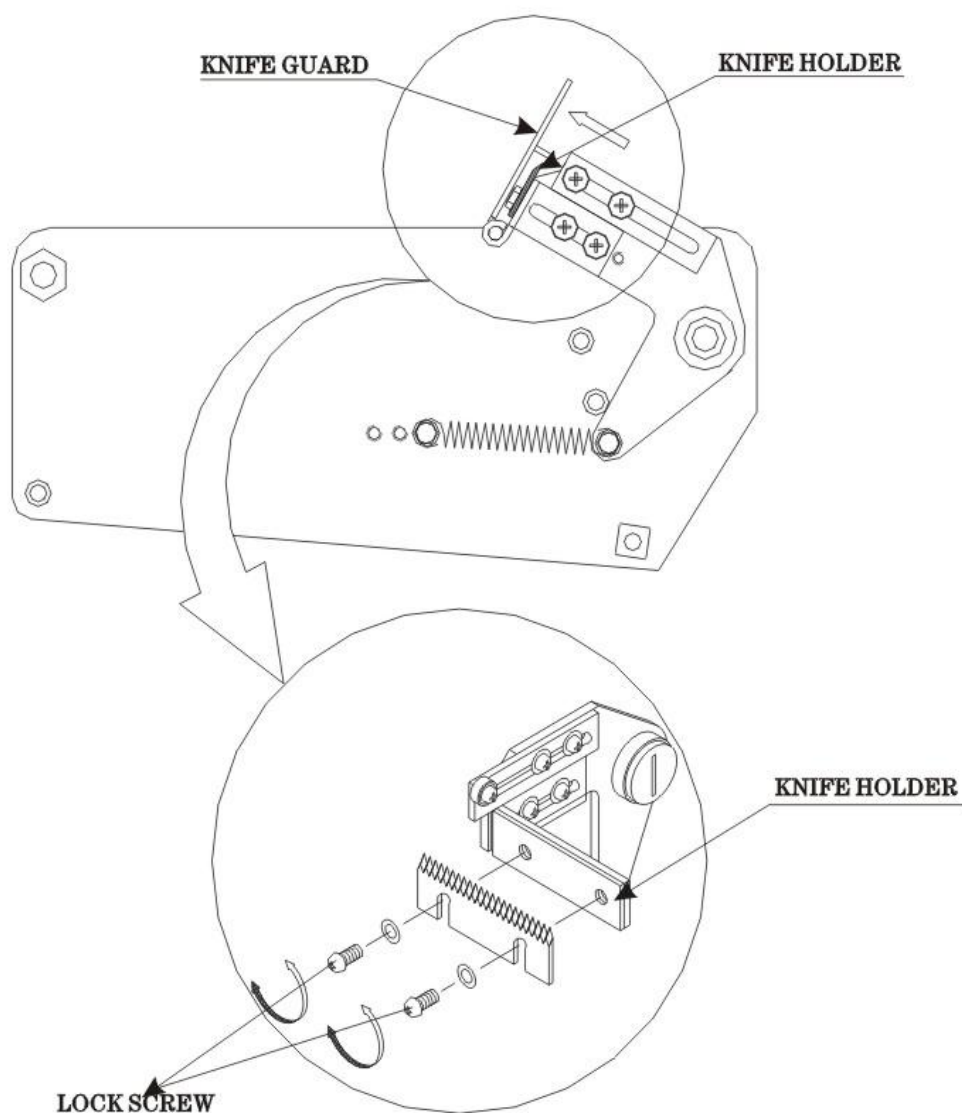
In case the driving belt is too loose to drive the carton, simply adjust the belt tension.

To do this, loosen the belt tension fix nut, and move the screw clockwise to tight the belt tension until proper tension is obtained, then tighten the belt tension fix nut. (Both sides of the screw should be adjusted simultaneously)



## **REPLACING THE KNIFE**

1. Make sure the power switch is in the OFF position.
2. Loosen the knife lock screw.
3. Open the knife guard. Carefully take out the old knife, and fit the new knife in place. Be careful not to fit the knife holder. (The proper distance between the knife and knife holder is 3mm)
4. Tighten the knife lock screw.



## **IDENTIFICATION BEFORE OPERATION**

1. Make sure the voltage level is correct.
2. Check to see if the driving belts run in the correct direction. (3 phase only)
3. Is width and height for box size xorrectly adjusted.
4. Keep all guards in place and in working order.
5. Make sure the tape has been properly installed.

## **OPERATION PROCEDURES**

1. Place the box be sealed onto the roller conveyoy table.
2. Adjust the width of the left/right guide rail.
3. Adjust the height of the top driving blet.
4. Adjust the width of the guide whell.
5. Start the driving belt to feed the box forward.
6. Check to see if the box feeds smoothly. Make proper adjustment according to procedures (2) (3) (4) if necessary
7. Then feed the box into the inlet end of the driving belt. The box will move automatically through the tape heads for sealing operations on the top and bottom of the box.

## TROUBLE SHOOTING

TROUBLE	PROBABLE CAUSES	REMEDY
Tape can't be cut-off	<ul style="list-style-type: none"> <li>※ Knife is not sharp enough</li> <li>※ Knife up is jammed with adhesive</li> </ul>	<ul style="list-style-type: none"> <li>※ Replace with a new knife</li> <li>※ Clean the knife with Volatile solvent</li> </ul>
A trailing of tape after cut off motion	<ul style="list-style-type: none"> <li>※ Unsmooth motion of knife holder due to choke</li> </ul>	<ul style="list-style-type: none"> <li>※ Knife holder extension spring fatigue</li> </ul>
Tape is not fully adhering to the box	<ul style="list-style-type: none"> <li>※ Main spring too loose</li> <li>※ The roller shafts which the tape runs over are not effective due to accumulated tape adhesive</li> <li>※ Tape wheel adjustment nut too tight</li> </ul>	<ul style="list-style-type: none"> <li>※ Tighten the main spring</li> <li>※ Lubricate roller shafts</li> <li>※ Loosen it</li> </ul>
Box choked on the way	<ul style="list-style-type: none"> <li>※ Improper Box Height Adjustment</li> <li>※ Main spring too tight</li> </ul>	<ul style="list-style-type: none"> <li>※ Re-adjust the height</li> <li>※ Loosen the knife position</li> </ul>
Tape broken during sealing on box	<ul style="list-style-type: none"> <li>※ Knife protrudes too far</li> </ul>	<ul style="list-style-type: none"> <li>※ Re-adjust the knife position</li> </ul>
Tape can't travel smoothly	<ul style="list-style-type: none"> <li>※ Tape adhesion is not even</li> <li>※ The roller shafts which the tape runs over are not effective due to accumulated tape adhesive</li> <li>※ Irreversible roller is not effective</li> <li>※ Tape loaded incorrectly</li> <li>※ Tape wheel adjustment nut too tight</li> </ul>	<ul style="list-style-type: none"> <li>※ Replace with a new tape roll</li> <li>※ Lubricate roller shafts</li> <li>※ Replacement</li> <li>※ Correct tape loading so that adhesive side faces upward</li> <li>※ Loosen it</li> </ul>
Tape mistracks frequently	<ul style="list-style-type: none"> <li>※ Irreversible roller is not effective</li> </ul>	<ul style="list-style-type: none"> <li>※ Replacement</li> </ul>
※ Tape is off center on application	<ul style="list-style-type: none"> <li>※ Both guide wheels have uneven pressure on the box</li> </ul>	<ul style="list-style-type: none"> <li>※ Re-adjust the distance between both guide wheels</li> </ul>

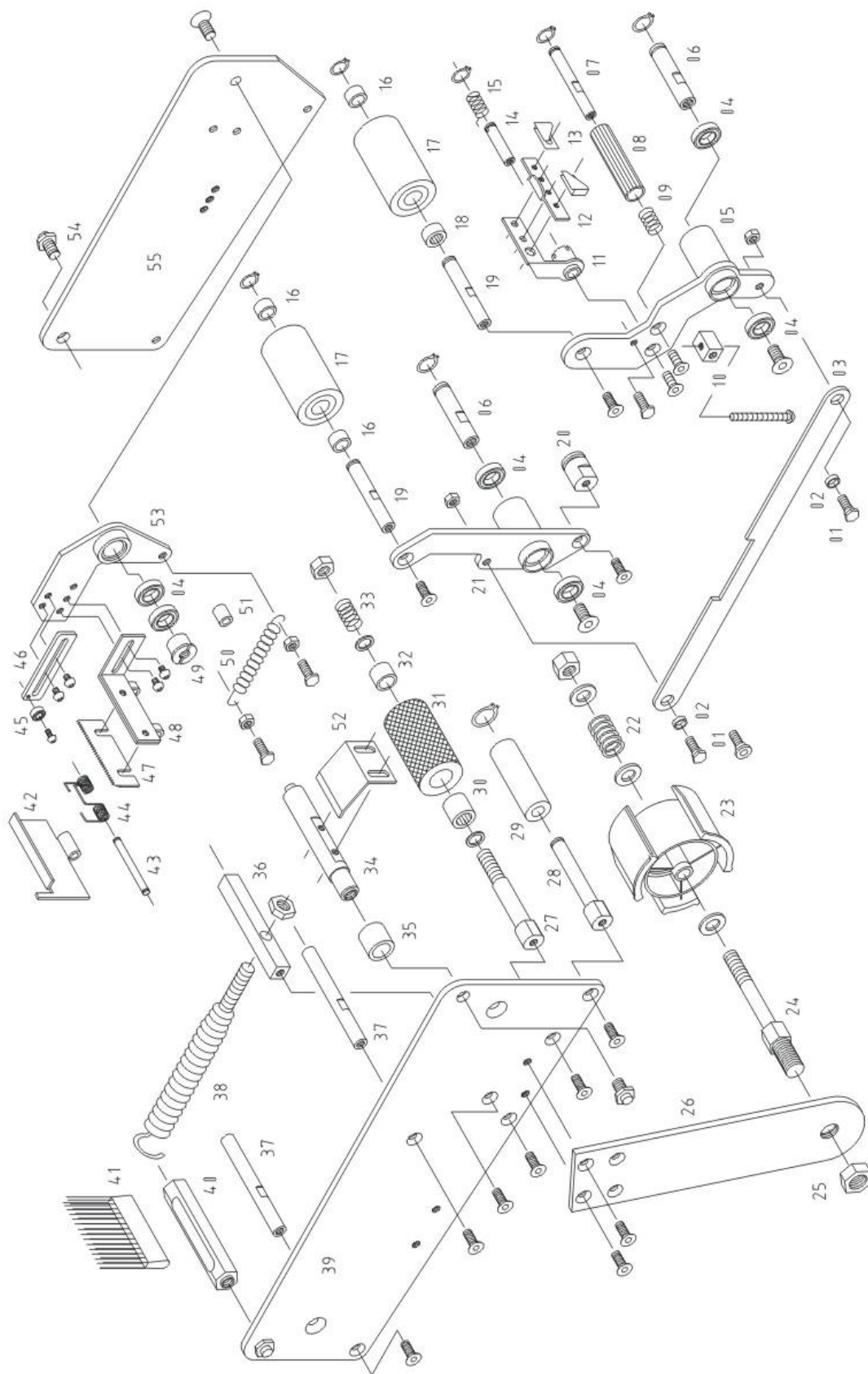


## TROUBLE SHOOTING

<b>PROBLEM</b>	<b>PROBABLE CAUSES</b>	<b>REMEDY</b>
<p><b>Tape end wrinkling on the carton</b></p>	<p><b>Tape wheel assembly(A) is too tight</b></p> <p><b>Inside tape wheel assembly with sharp edges &amp; dust</b></p> <p><b>Tape does not travel smoothly</b></p> <p><b>Knife is not sharp enough or is jammed with tape adhesive</b></p> <p><b>The knife holder is not functioning smoothly</b></p> <p><b>Bronze roller (irreversible roller) is not functioning</b></p>	<p><b>Loosen tape wheel assembly spring</b></p> <p><b>Remove tape wheel washer sharp edges and keep it clean. Grease the tape wheel</b></p> <p><b>Lubricate the roller shafts which the tape runs over</b></p> <p><b>Clean the knife with gasoline or alcohol (Volatile solvents)</b></p> <p><b>Check and lubricate to ensure that it functions smoothly. Adjust the knife holder's spring tension</b></p> <p><b>Replace it</b></p>
<p><b>NOTE: Clean the knife daily with a toothbrush and gasoline.</b></p>		

# MACHINE PARTS

## Machine Cartridge Diagram Details

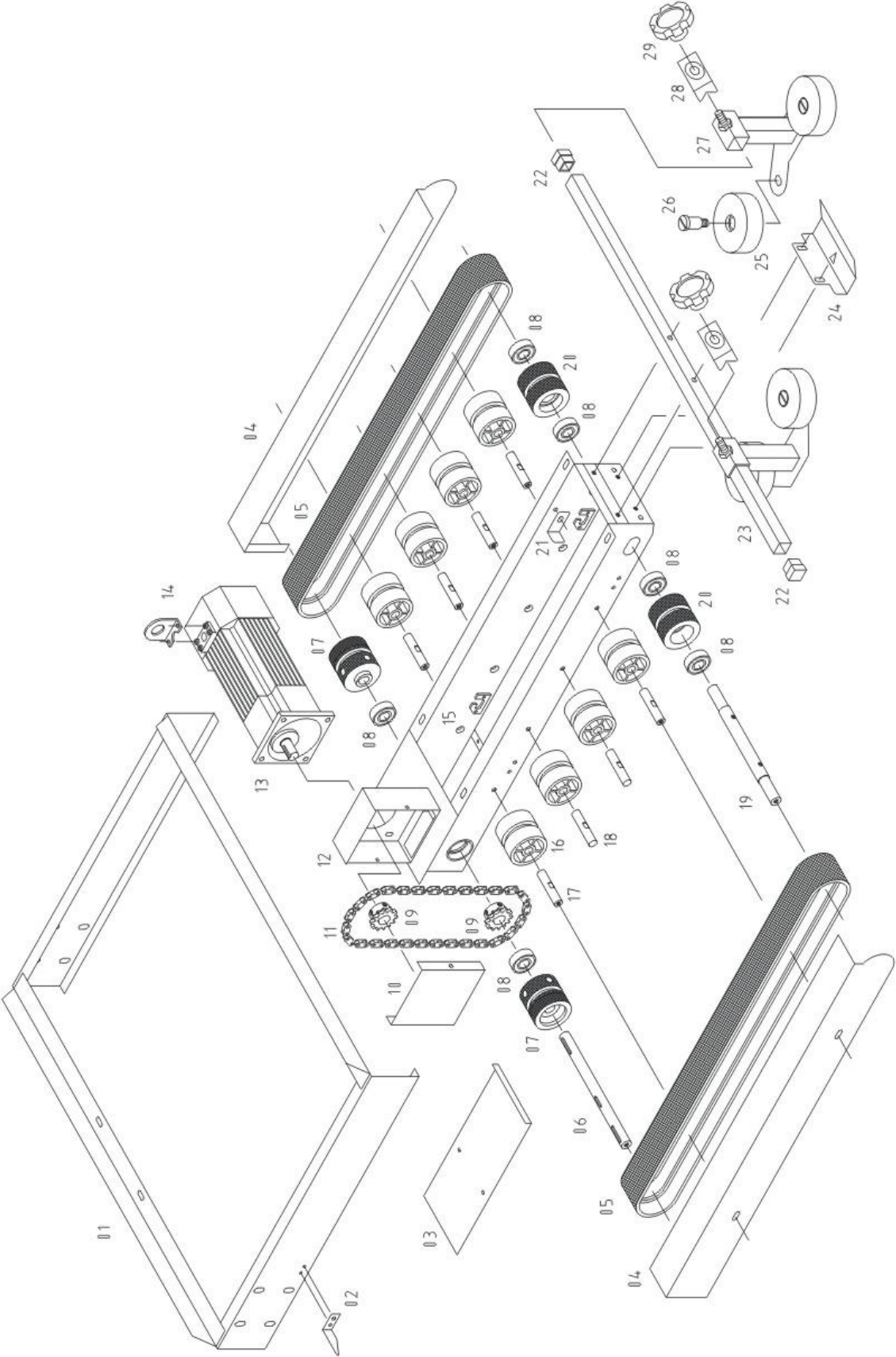


## SPARE PARTS LIST

S/N	Parts Name	Q'ty	Remarks	S/N	Parts Name	Q'ty	Remarks
1	Bolt	2	AS123-05-27	29	Idel wheel	1	AS123-05-08
2	Brasher	2	AS123-05-26	30	One way bearing	1	1216
3	Link	1	AS123-05-16	31	One way roller	1	AS123-05-05
4	Bearing	6	61801	32	One way roller washer	1	AS123-05-04
5	Cutter arm	1	AS123-05-15	33	Spring	1	AS123-05-07
6	Arm assembly shaft	2	AS123-05-10	34	Holding shaft	1	AS123-05-01
7	Brass roller	1	AS123-05-47	35	Arm assemble cushion	1	AS123-05-02
8	Brass roller shaft	1	AS123-05-48	36	Holder pillar	1	AS123-05-25
9	Spring	1	AS123-05-46	37	Pillar	2	AS123-05-18
10	Limit block	1	AS123-05-24	38	Main pull spring	1	AS123-05-23
11	Tape support	1	AS123-05-49	39	Side plate	1	AS123-05-19
12	Support plate holder	1	AS123-05-13	40	Pillar	1	AS123-05-17
13	Support plate	2	AS123-05-11	41	Brush	1	AS123-05-51
14	Shaft	1	AS123-05-50	42	Blade cover	1	AS123-05-35
15	Twist spring	1	AS123-05-14	43	Blade cover shaft	1	AS123-05-33
16	Rubber roller washer	3	AS123-05-28	44	Twist spring	1	AS123-05-34
17	Rubber roller	2	AS123-05-30	45	Bearing	1	623
18	Bearing (1014)	1	1014	46	Adjusing plate	1	AS123-05-38
19	Roller shaft	2	AS123-05-31	47	Blade	1	AS123-05-36
20	Pull sprign holder	1	AS123-05-20	48	Blade support	1	AS123-05-37
21	Rear roller arm	1	AS123-05-21	49	Blade arm bolt	1	AS123-05-29
22	Spring	1	AS123-05-43	50	Pull spring	1	AS123-05-41
23	Tape fixed support	1	AS123-05-42	51	Washer	1	AS123-05-40
24	Shaft	1	AS123-05-44	52	Feedin guide plate	1	AS123-05-12
25	Adjustable nut	1	AS123-05-45	53	Blade arm	1	AS123-05-39
26	Tape support plate	1	AS123-05-22	54	Holding screw	3	AS123-05-03
27	One way roller shaft	1	AS123-05-06	55	Side plate	1	AS123-05-32
28	Idel wheel shaft	1	AS123-05-09				

**MACHINE PARTS**

**Machine Cartridge Diagram Details II**



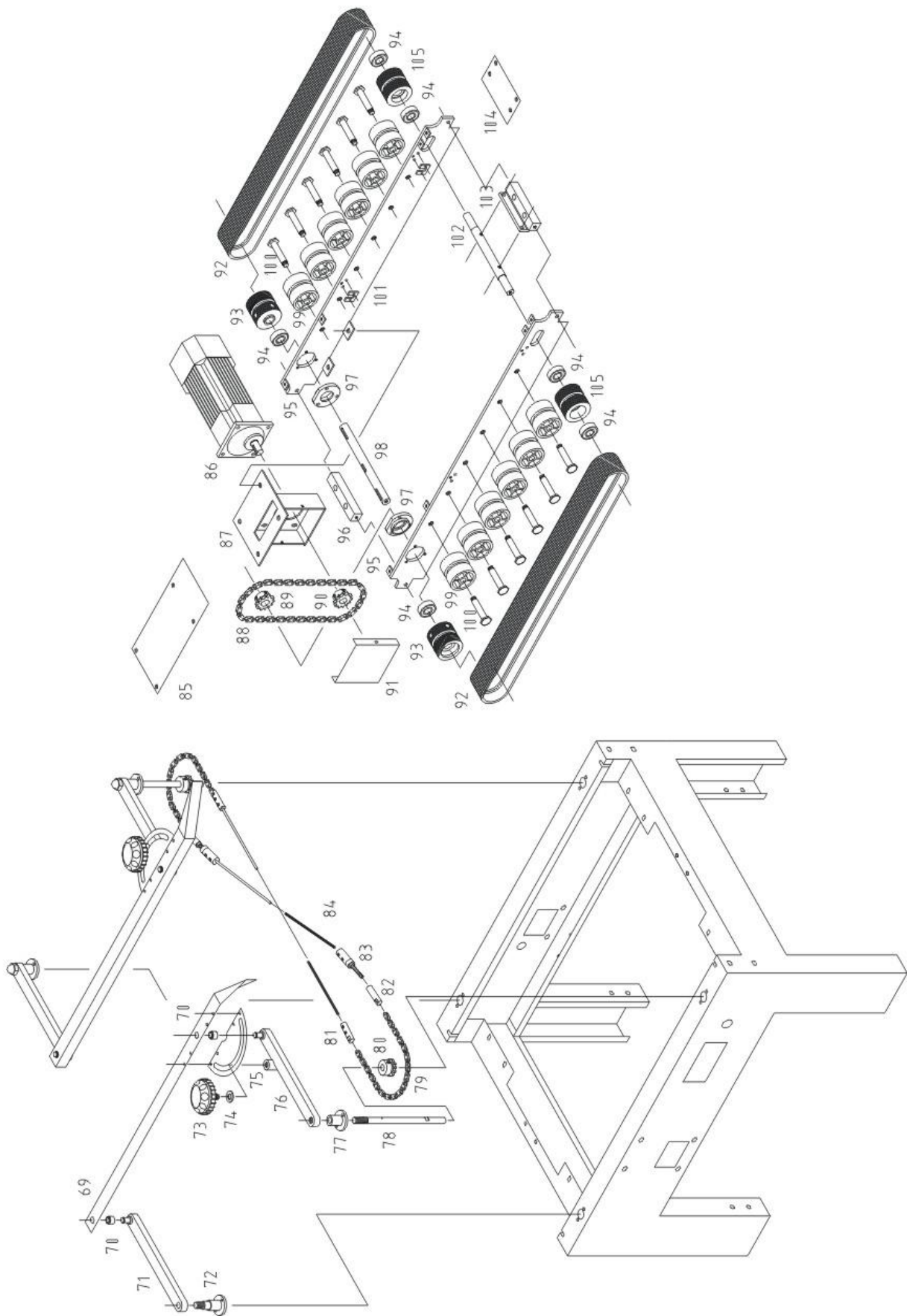


## SPARE PARTS LIST

S/N	Parts Name	Q'ty	Remarks	S/N	Parts Name	Q'ty	Remarks
1	Driving set holding frame	1	FXJ6050M-03-11	28	Locking bracket	2	AS223-04-13
2	Height indicator	1	AS123-03-03	29	Hand tighten lock wheel	2	AS223-04-12
3	Cover (Rear)	1	AS223-04-10	30	Machine frame	1	FXJ6050M-01-01
4	Belt cover	2	AS223-04-08	31	Hanging hook	8	AS123-01-10
5	Convey or belt	2	1335 × 50(5 × 8)	32	Machine leg	4	FXJ6050M-01-02
6	Driving shaft	1	AS223-04-05	33	Fixed plate	4	AS123-01-04
7	Pulley driver	2	AS123-04-16	34	Caster	4	5英寸
8	Bearing	6	6202	35	Frame	1	FXJ6050M-01-10
9	Sprocket wheel	2	AS223-04-04	36	Breaing cover	12	AS123-01-08-02
10	Cover(Motor)	1	AS223-04-03	37	Breaing	12	6000
11	Chain	1	L=28 × 9.525	38	Breaing seat	12	AS123-01-08-03
12	Upper taping set	1	AS223-04-02	39	Roller	6	FXJ6050M-01-07-02
13	Motor	1	GV-15-0090-18	40	Roller shaft	12	FXJ6050M-01-07-01
14	Motor wire frame	2	AS123-04-14	41	Roller	2	FXJ6050M-01-05-02
15	Taping head support	4	AS123-03-04-02	42	Plastic bushing	16	AS123-01-06-02
16	Pulley follower	14	AS223-04-11	43	Roller	4	FXJ6050M-01-05-01
17	Pulley shaft	4	AS223-04-06	44	Work support board	2	FXJ6050M-01-03
18	Pulley shaft	4	AS223-04-18	45	Roller frame	1	FXJ6050M-01-06
19	Adjustable shaft	1	AS223-04-07	46	Roller	6	FXJ6050M-01-07-02
20	Pulley follower	2	AS223-04-05	47	Bolt	1	AS123-02-12-03
21	T/H	1	AS223-04-17	48	Handle	1	AS123-02-12-04
22	Rubber plug	2	AS223-04-19	49	Rod	1	AS123-02-12-02
23	Compression roller support bar	1	AS223-04-11	50	Rod joint bracket	2	AS123-02-12-01
24	Top guide late	1	AS223-04-09	51	Cover	2	AS123-02-02
25	Guide wheel	4	AS223-04-15	52	Columm	2	AS123-02-01
26	Guide wheel shaft	4	AS223-04-16	53	Breaing seat	2	AS123-02-10
27	Guide wheel frame	2	AS223-04-14	54	Breaing	2	6003

# MACHINE PARTS

## Machine Cartridge Diagram Details IV



## SPARE PARTS LIST

S/N	Parts Name	Q'ty	Remarks	S/N	Parts Name	Q'ty	Remarks
55	Height adjustable spindle	2	AS123-02-03	82	Whorl tie-in	2	AS223-02-14
56	Column cover	4	AS123-02-11	83	Adjustable tie-in	2	AS223-02-12
57	Threaded tube	2	AS123-02-04	84	Tightwire	2	φ3
58	Breaing seat	2	AS123-02-05	85	Outside support board	1	FXJ6050M-03-10
59	Breaing	2	8103	86	Motor	1	GV-15-0090-18
60	Sprocket wheel	2	AS123-02-06	87	Motor fixed board	1	FXJ6050M-03-02
61	Chain	1	L=156×9.525	88	Chain	1	L=28×9.525
62	Chain cover	1	FXJ6050M-01-04	89	Sprocket wheel	1	FXJ6050M-03-06
63	Adjusting wheel	1	AS123-02-08	90	Sprocket wheel	2	AS223-04-04
64	Rubber roller washer	2	AS123-05-28	91	Cover (Motor )	1	AS223-04-03
65	Sprocker wheel	1	AS123-02-07	92	Convey or bell	2	1364×50 (5×8)
66	On/off switch	1	PS-111	93	Pulley driver	2	AS123-04-16
67	Emergency stop switch	1	AR22ER	94	Breaing	6	6202
68	Wire joint	1	M16	95	Work table main frame plate	1	FXJ6050M-03-01
69	Guide rail	2	FXJ6050M-02-01	96	Cross beam	1	FXJ6050M-03-03-01
70	Guide rail shaft washer	4	AS223-02-03	97	Breaing cover	2	FXJ6050M-03-04
71	Connect rail	2	FXJ6050M-02-03	98	Main drive axle	1	FXJ6050M-03-05
72	Fixation chain seat	2	AS223-02-04	99	Tdle wheel	12	AS123-04-11
73	Hand tighten lock wheel	2	AS223-02-07	100	Tdle wheel axle	12	FXJ6050M-03-08
74	Washer	2	AS223-02-08	101	T/H	4	AS223-03-02
75	Width guide	2	AS223-02-02	102	Adjustable shaft	1	AS223-04-07
76	Connect rail	2	FXJ6050M-02-02	103	Cross beam	1	FXJ6050M-03-03
77	Connect chain seat	2	AS223-02-05	104	Middle feed-in support board	1	FXJ6050M-03-09
78	Connect shaft	2	AS223-02-06	105	Pulley follower	2	AS123-04-05
79	Chain	2	L=9×9.525	106			
80	Sprocket wheel	2	AS223-02-11	107			
81	Fixed tie-in	2	AS223-02-13	108			