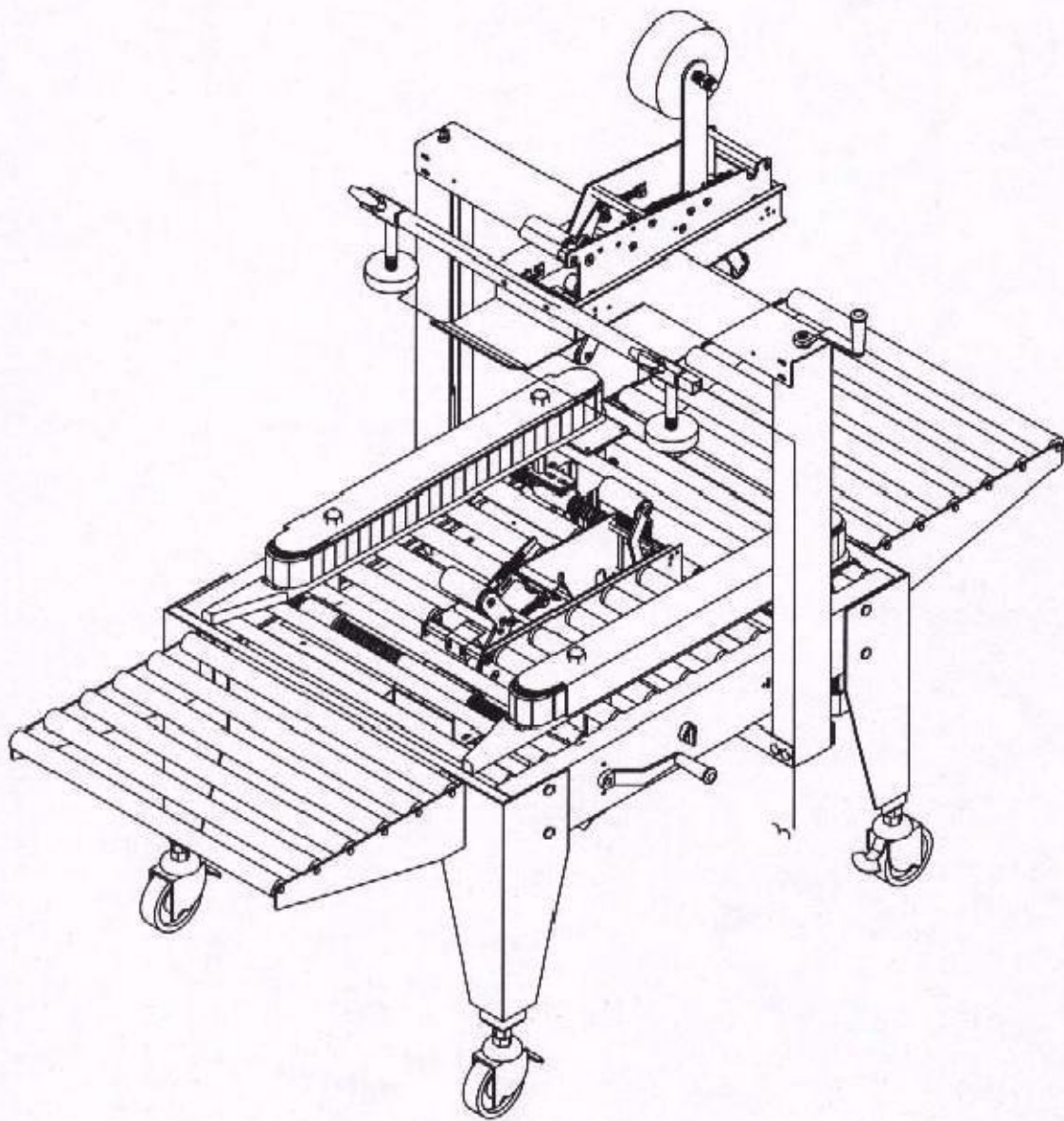


RPA-05

SEMI AUTOMATIC SIDE BELTS
DRIVEN CARTON SEALER

INSTRUCTION MANUAL



MACHINE SIZE

LENGTH: 865MM、 WIDTH: 830MM、 HEIGHT: 1040~1380MM

TABLE HEIGHT

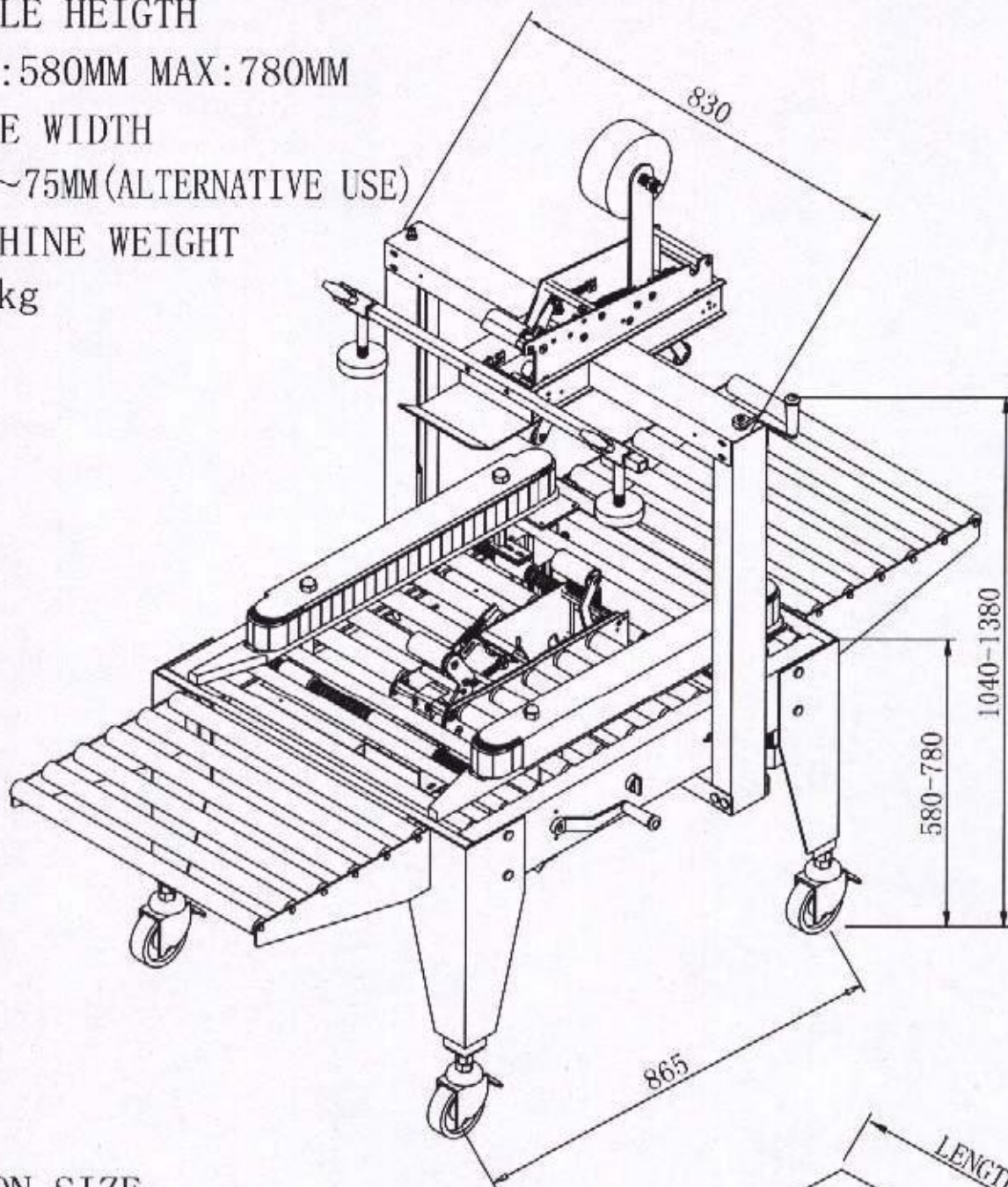
MIN: 580MM MAX: 780MM

TAPE WIDTH

48M~75MM (ALTERNATIVE USE)

MACHINE WEIGHT

113kg



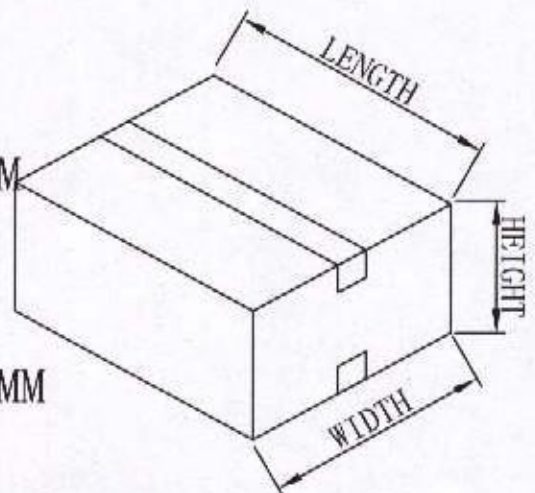
CARTON SIZE

LENGTH: 150~∞ MM WIDTH: 100~500MM

HEIGHT: 100~500MM TAPE2"

LENGTH: 150~∞ MM WIDTH: 120~500MM

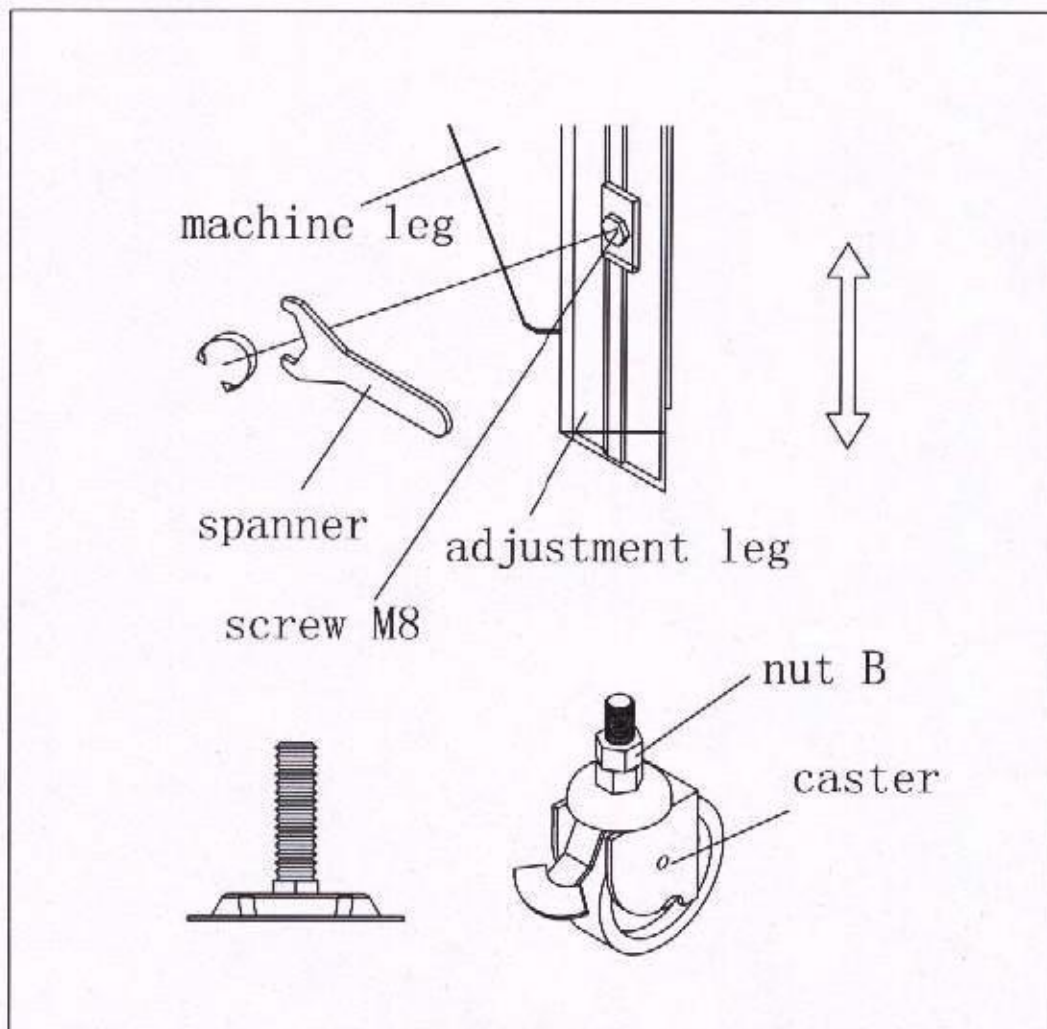
HEIGHT: 130~500MM TAPE3"



SET-UP AND ADJUSTMENT OF CASTER

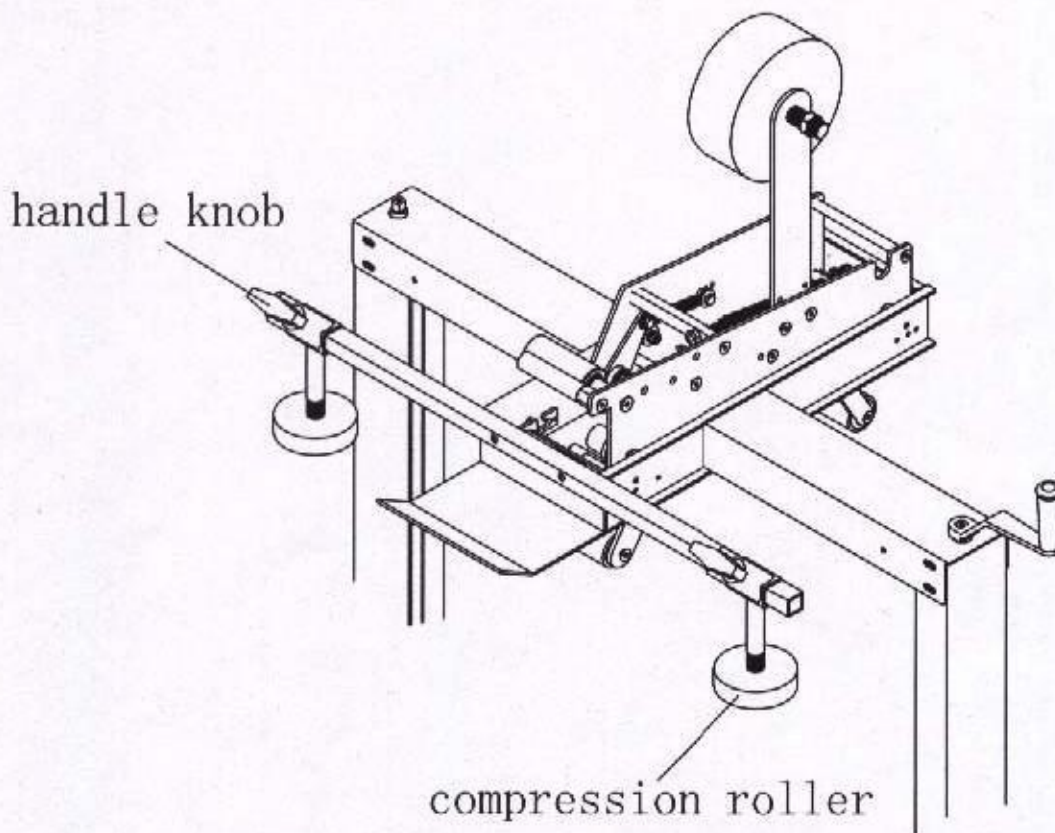
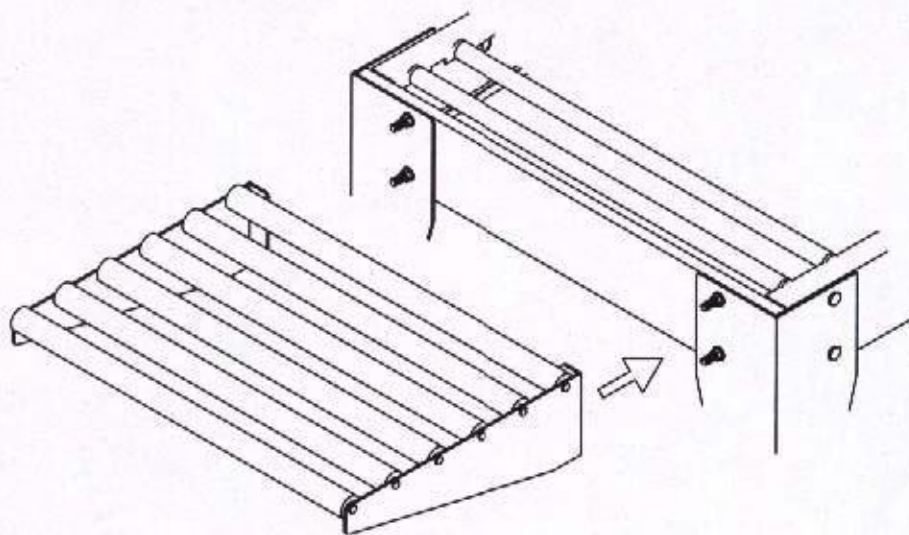
1. The machine conveyor height can be adjusted by stretching or shortening the four adjustable legs individually as shown in the figure below.

2. Turning the caster clockwise to the adjustable leg. To tighten the nut B to fix the caster with adjustable leg. When the machine is in production line, release the set of screws and adjust the leg to the suitable height. Then retighten the screws.

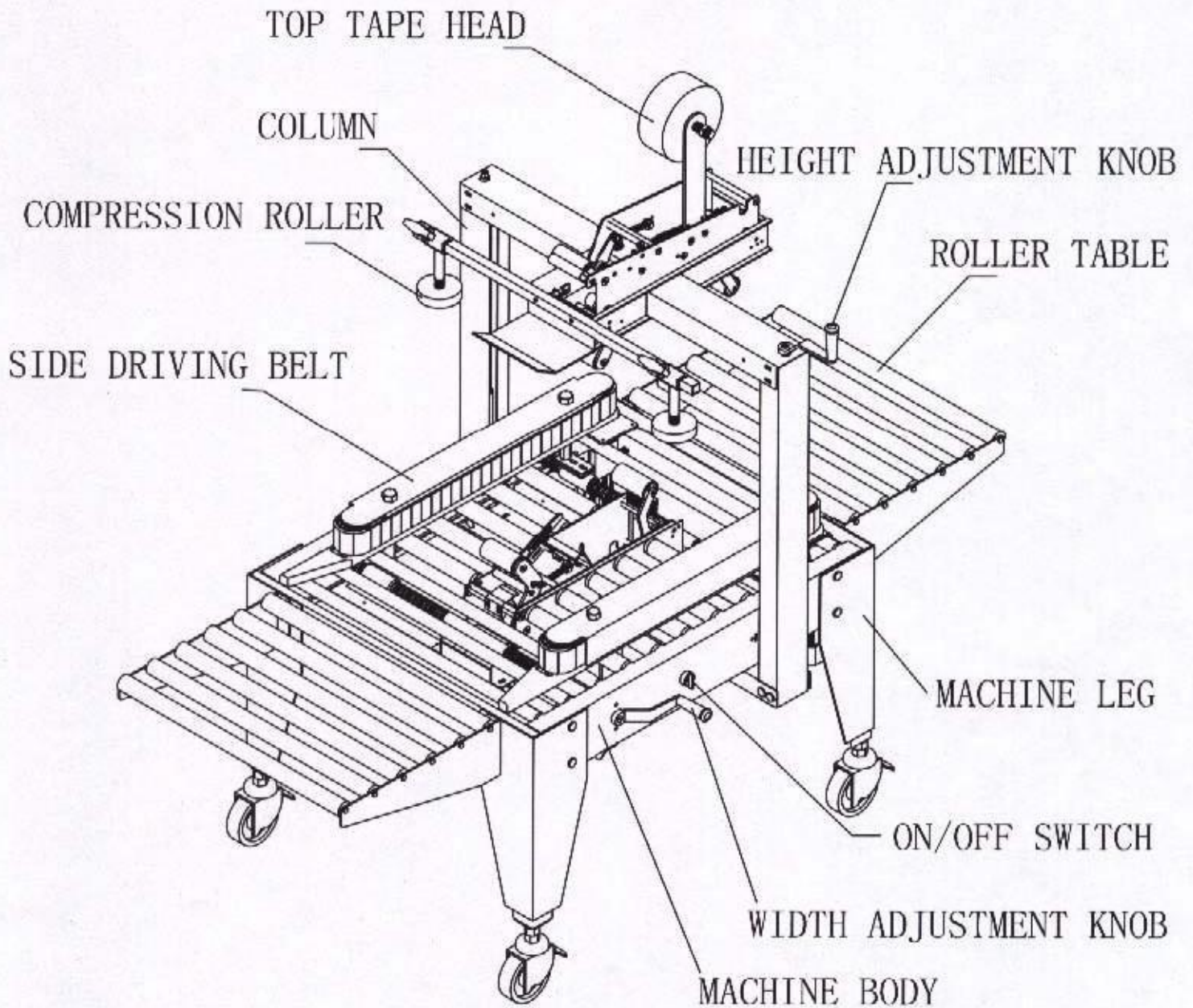


INFEED AND OUTFEED ROLLER TABLE INSTALLMENT

As shown in figure below:close the roller table to the machine body.

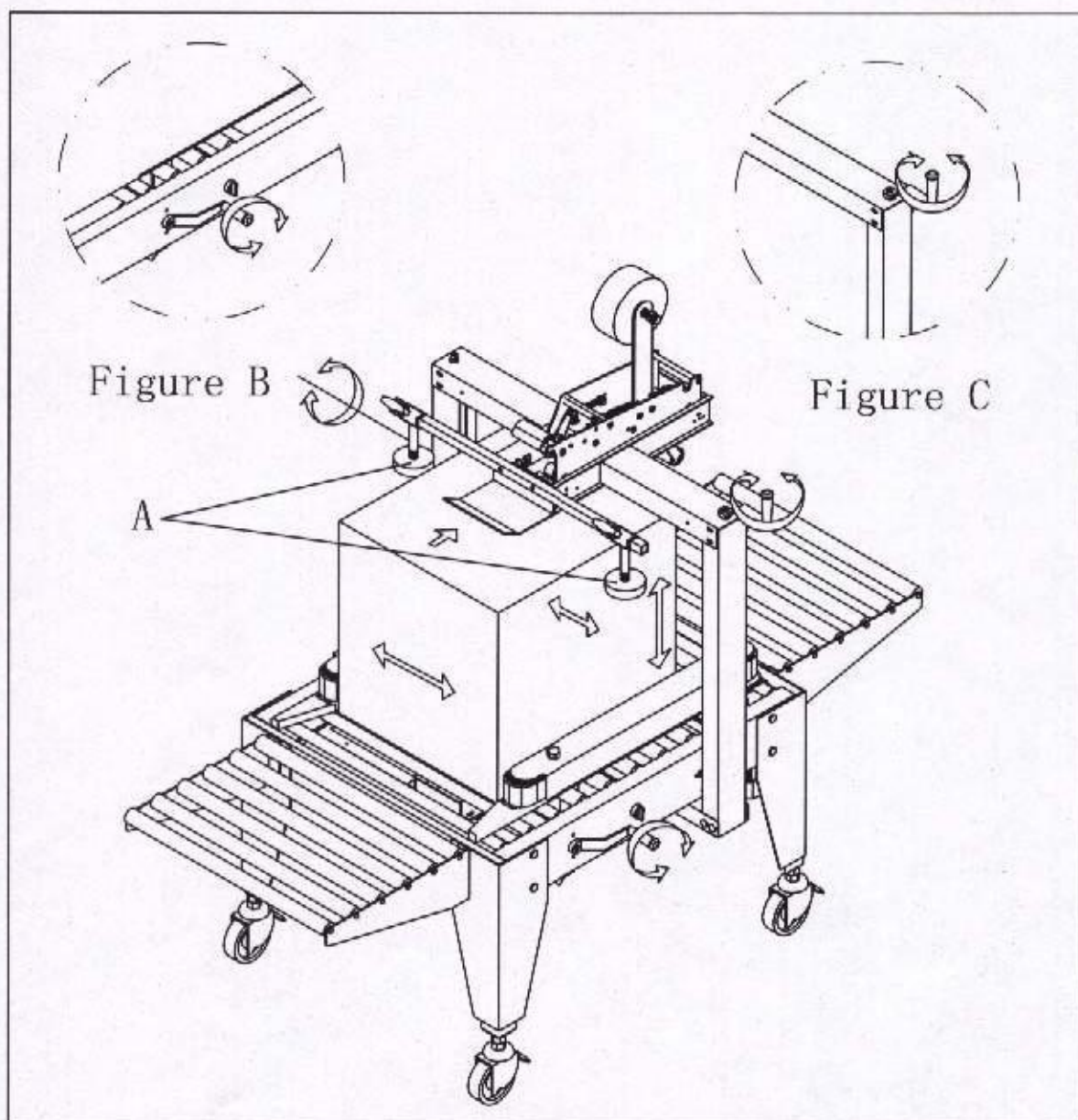


COMPONENTS



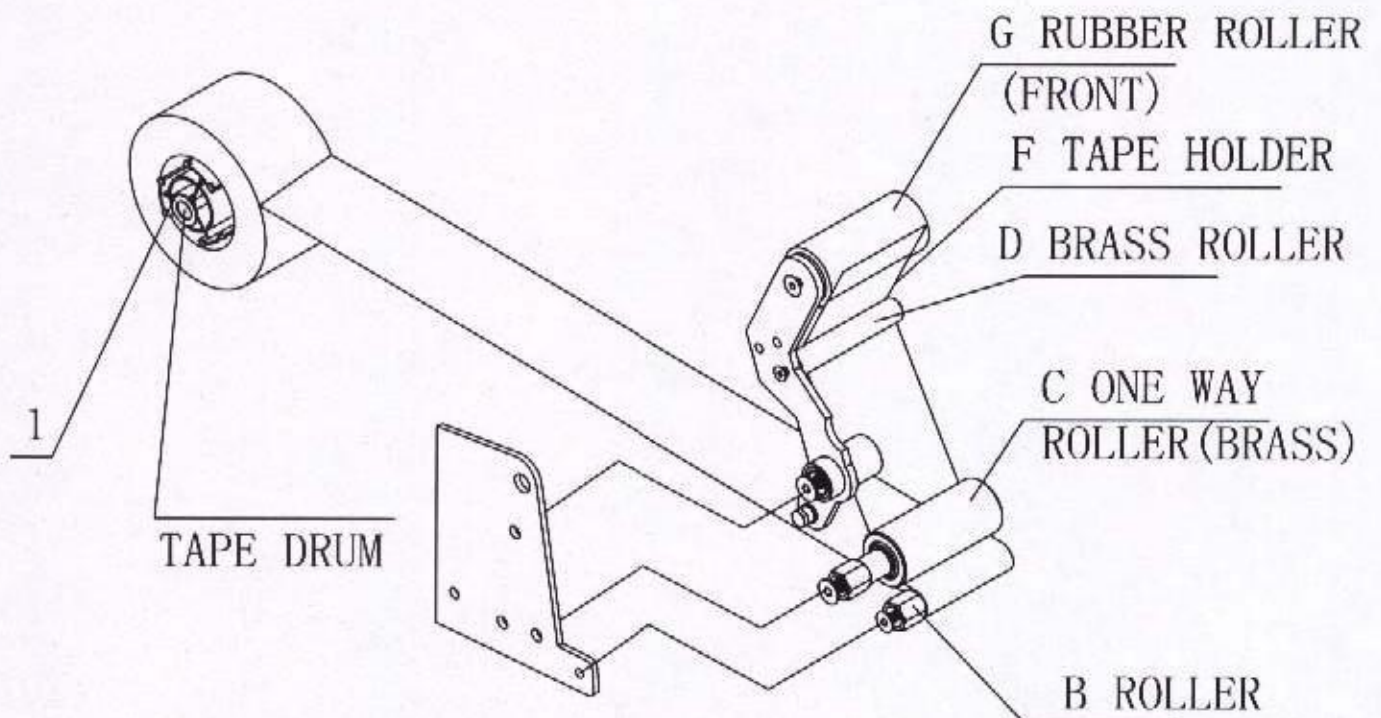
HEIGHT AND WIDTH ADJUSTMENT

1. Adjust compression roller (A) inward when carton top flap do not close enough.
2. The incorrect position of compression roller (A) may cause tape adhering misalignment.
3. Figure B is width adjustment handle knob. Adjustment based on belts contact carton surface and succeed in convey carton.
4. Figure C is height adjustment handle knob. Adjustment based on the bottom surface of upper taping set gently press carton upper surface.

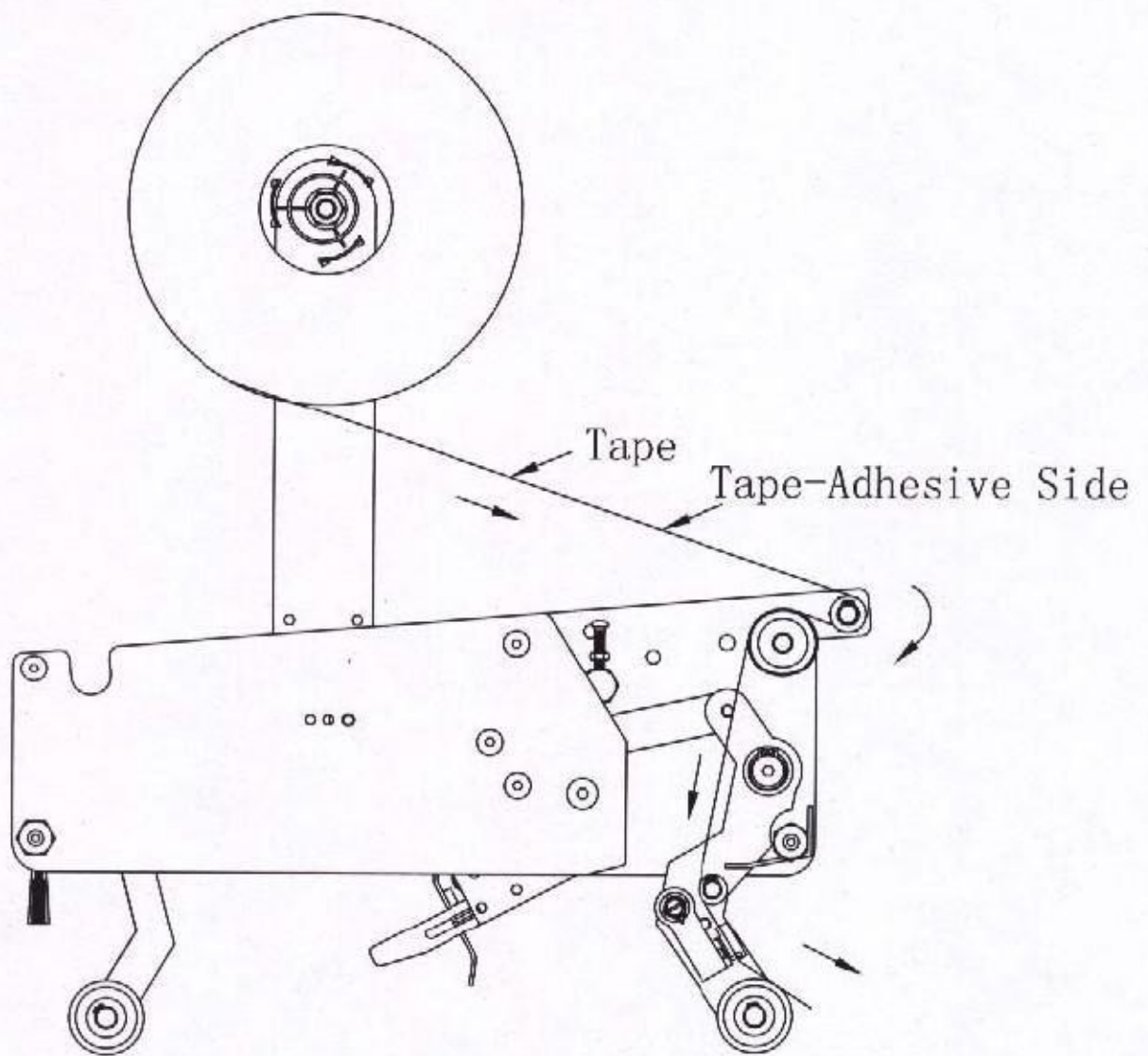


OPERATION AND ADJUSTMENT OF TAPE HEAD

First, the tape roll is fixed on the tape drum as shown in the figure below. Then pull the tape and pass it through roller B, follow by the one way roller C, and next pass by the brass roller D. At last the tape will pass through the tape holder F and come out in the front rubber roller G as shown in the figure. Make sure when going through the process. The adhesive of the tape is facing outward.



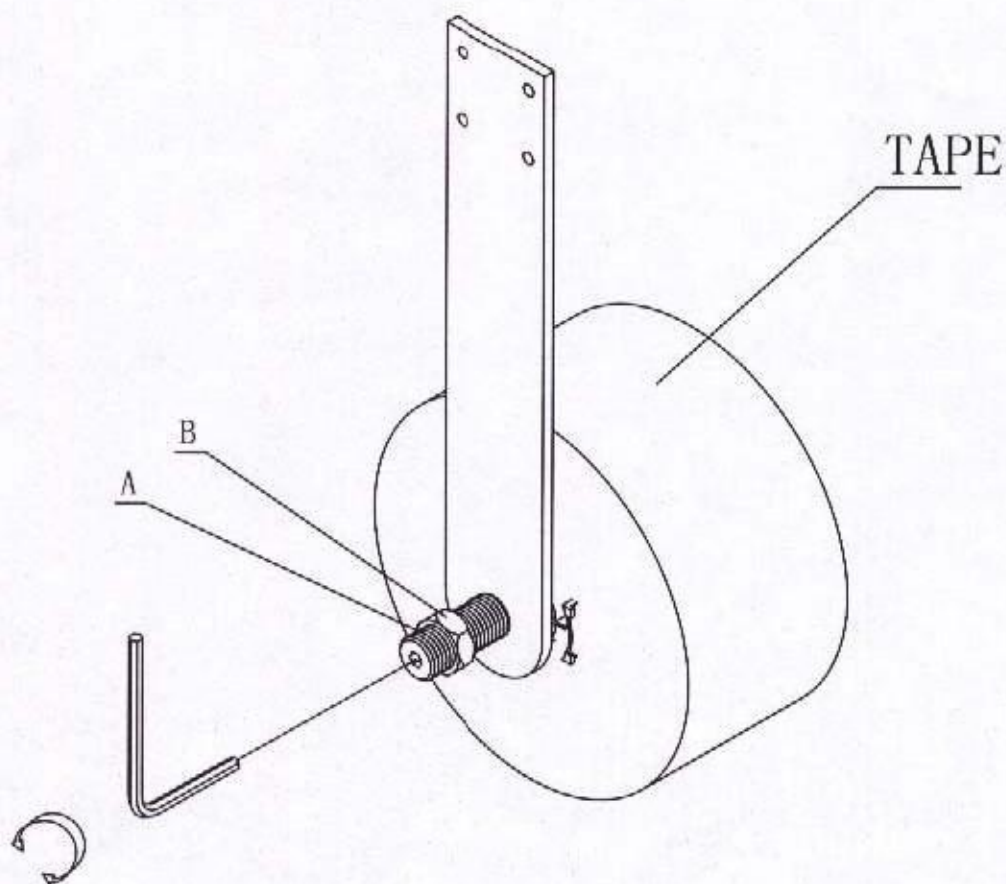
TAPE THREADING DIAGRAM



ADJUSTMENT OF TAPE HEAD

(FOR OPP TAPE)

If the tape not at the center line of carton, refer to figure. Release the special nut B, then by using screw A driver to turn the screw clock-wise or counter clock-wise until the tape is at the center line. Then retighten the nut B.

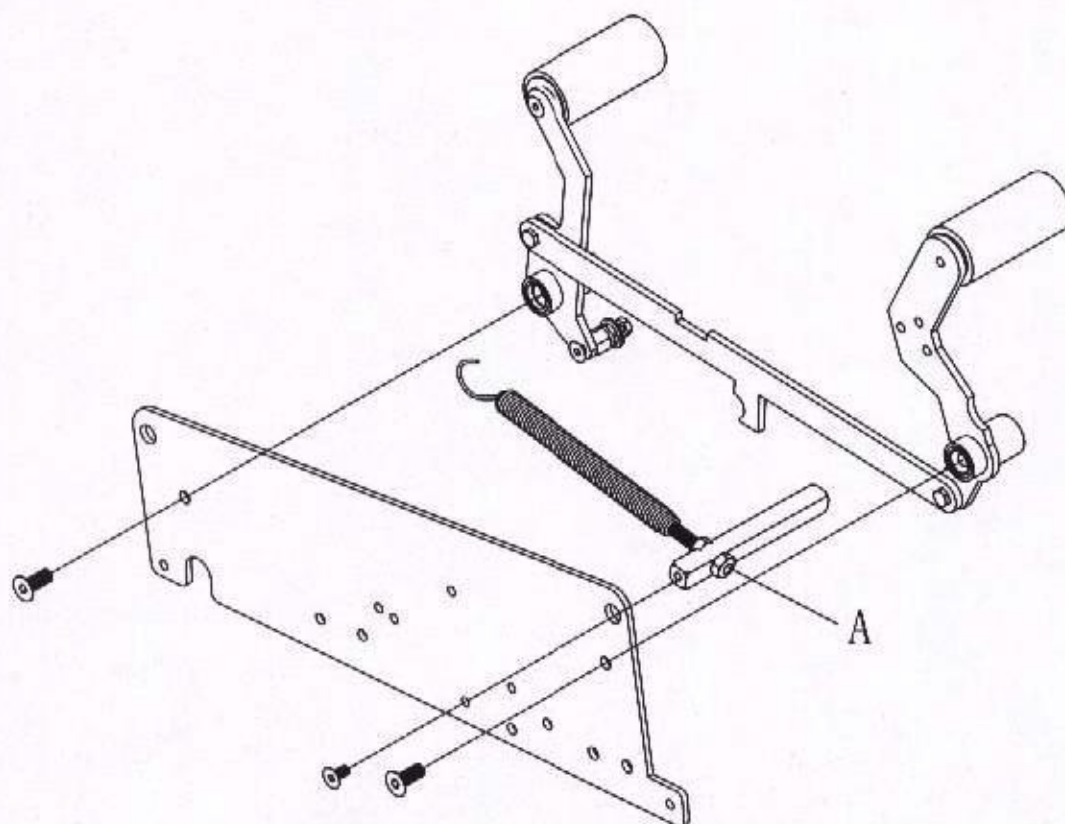


ADJUSTMENT OF TENSION APPLY TO RUBBER ROLLERS

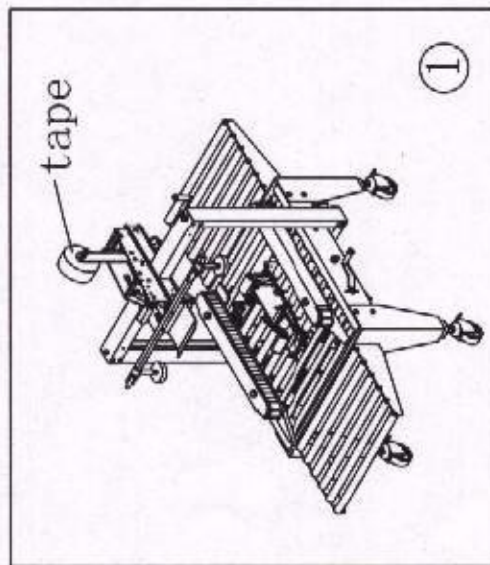
As shown in figure, when tighten the nut A on the spring, the tension apply to both rubber rollers will also increase.

The purpose of making this adjustment is to make sure that the tape adhere on carton firmly with no wrinke.

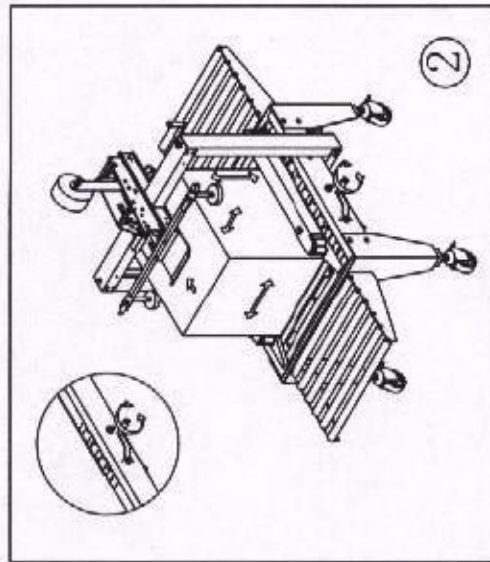
Nut A is to adjust the speed (to make carton with the belt speed is proportional, you can make appropriate adjustments according to the material and hardness of the carton)



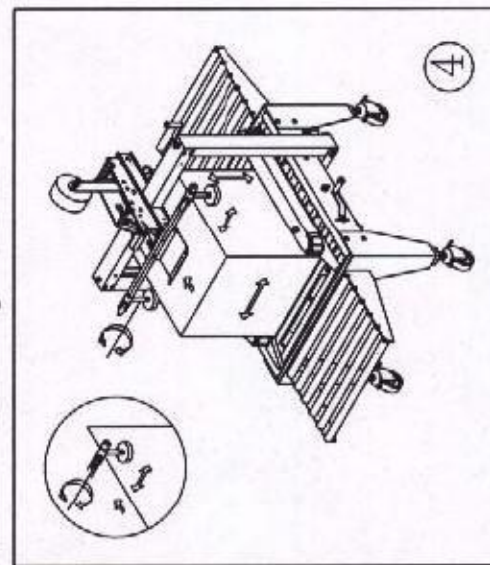
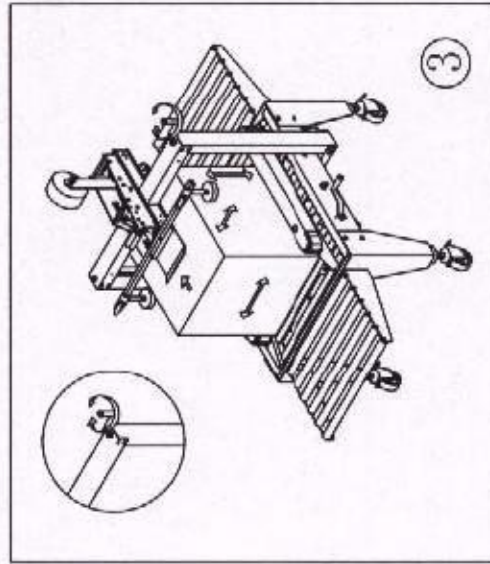
OPERATION PROCEDURE



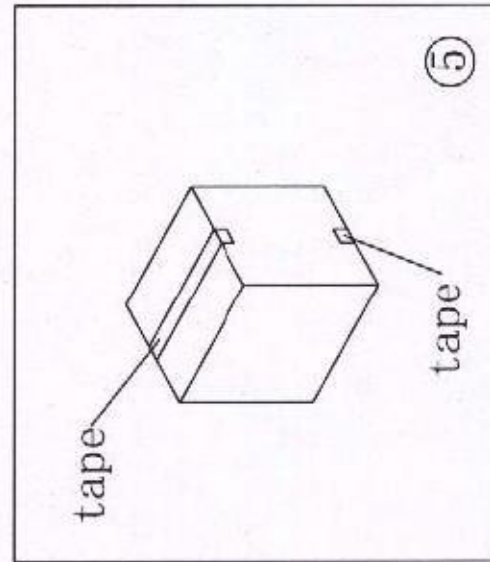
Install the tape to both top and bottom tape drum.



Adjustment width by handle knob. Adjustment height by handle knob.



Make compression rollers around carton, then fix its position.

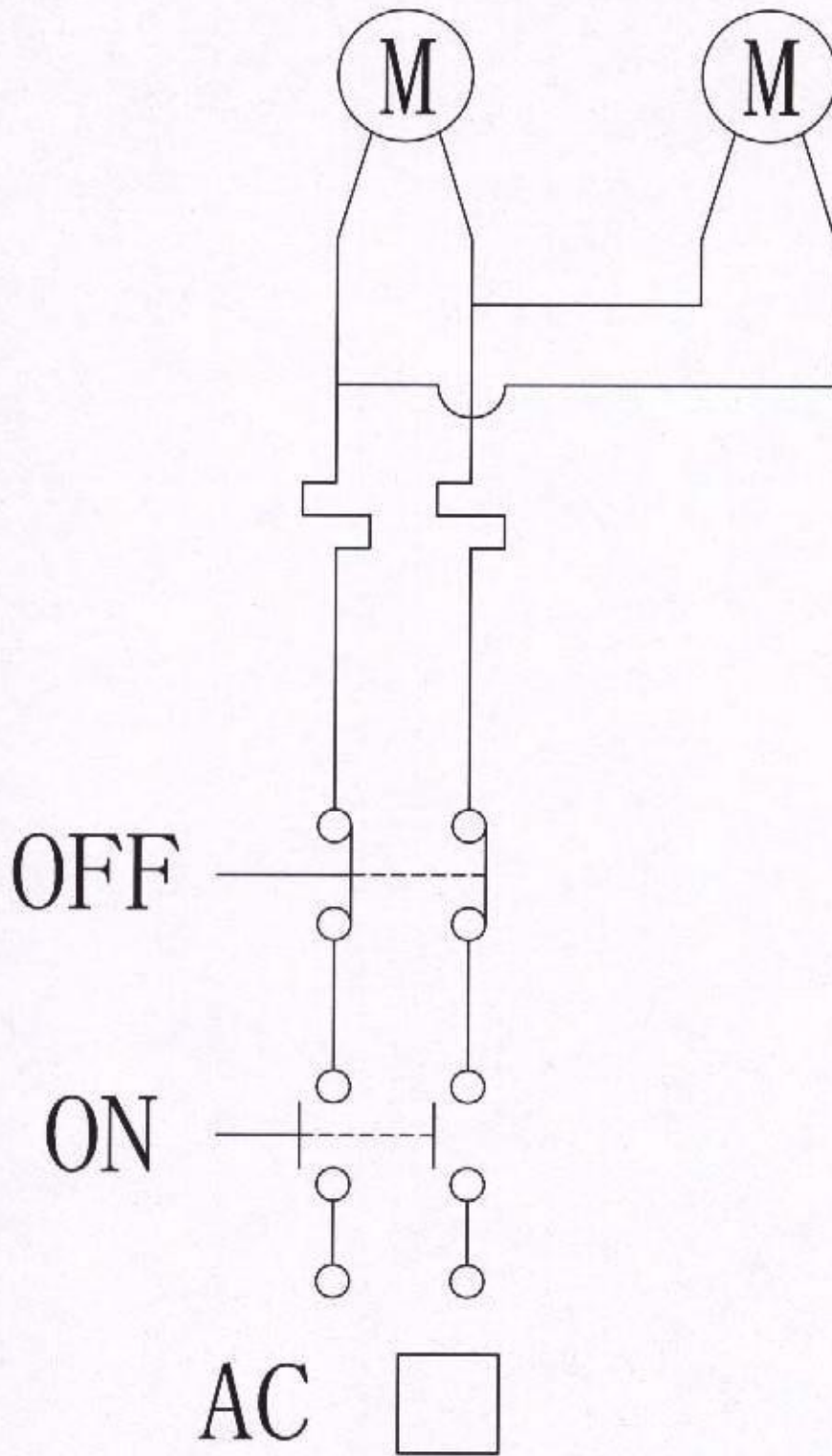


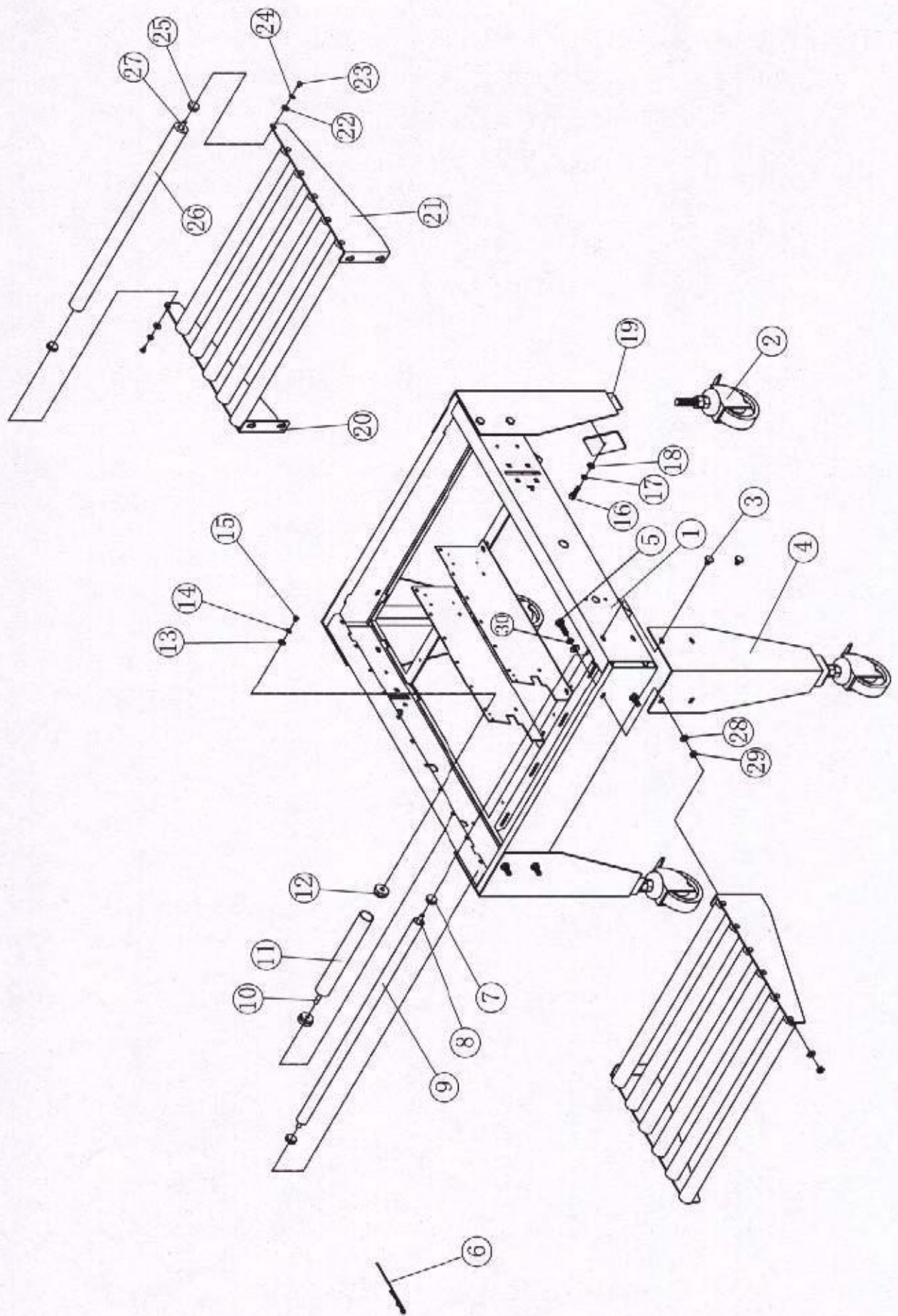
TROUBLE SHOOTING OF THE CARTON SEALER

	TROUBLES	PROBABLE CAUSES	REMEDY
1	The tape can't be cut off.	Knife blade is not sharp enough. Knife blade tip is jammed with adhesive.	Replace with a new knife blade. Clean the knife blade and lubricate.
2	A trailing of taping after cut off motion.	Unsmooth motion of knife. Blade holder due to chock.	Check if the knife blade holder screws are loose. Replace a new spring.
3	Tape is not fully adhering to the box.	Main spring too loose. The roller shafts with tape running over are not affected due to accumulate tape adhesive.	Tighten the main spring.
4	Carton chocked on the way.	The main spring is too tight. The front wheel stunk in middle. Both side belt had not tight strong.	Loosen the main spring appropriately. Re-adjusting the tape.
5	Tape falls off frequently.	One way roller loss of affection.	Renew one way roller.


























- REMARK: 1. Switch off before repair or adjust;
 2. Blade must be clean up and lubricate before using;
 3. After using for while, adjustable belt a little bit tighter.

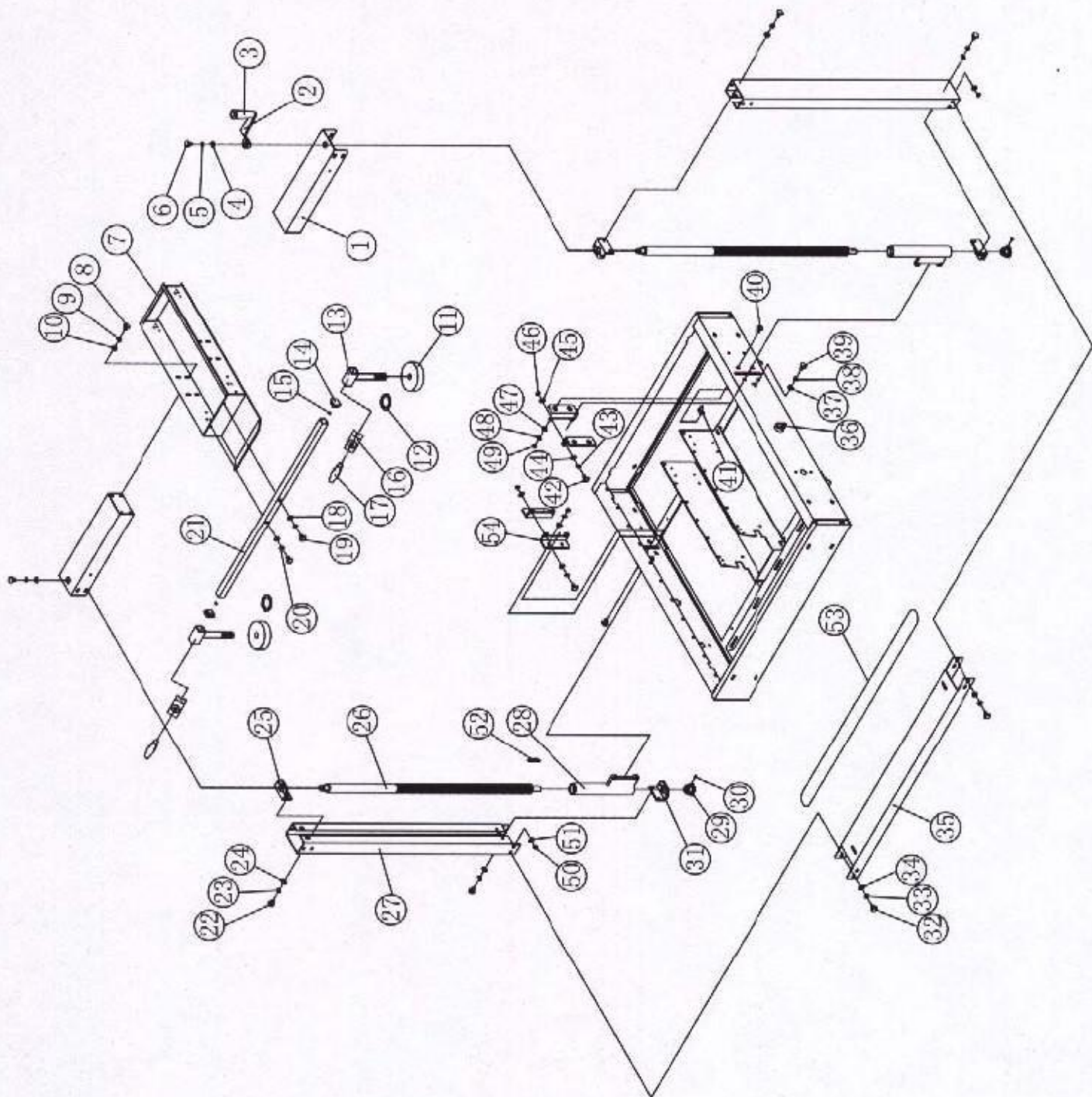
ELECTRICAL SCHEMATIC































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



























NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION	NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION
01		A1501A	MACHINE FRAME	1		16		SD616F	SCREW	8	M6X16
02		PA001H	CASTER	4	M16X4"	17		HB006S	SPRING WASHER	8	Ø 6
03		SJ816F	SCREW	8	M8X16	18		HA006S	WASHER	8	Ø 6
04		A1502A	MACHINE LEG	4		19		A1503A	ADJUSTABLE LEG	4	
05		SE830F	SCREW	8	M8X30	20		A1506B	ROLLER FRAME (L)	2	
06		FD001A	R-PIN	2		21		A1507B	ROLLER FRAME (R)	2	
07		A1509A	PLASTIC BUSHING	12		22		HA006S	WASHER	24	Ø 6
08		A1513A	ROLLER SHAFT	5	Ø 8X660	23		SE612F	SCREW	24	M6X12
09		A1514A	ROLLER	5	Ø 32X620	24		HB006S	SPRING WASHER	24	Ø 6
10		A1512A	ROLLER	12	Ø 32X235	25		A1509A	PLASTIC BUSHING	24	
11		A1511A	ROLLER SHAFT	12	Ø 8X260	26		A1510A	ROLLER	12	Ø 32X548
12		A1509A	PLASTIC BUSHING	20		27		A1508A	ROLLER SHAFT	12	Ø 8X554
13		HA006S	WASHER	12	Ø 6	28		HA008S	WASHER	24	Ø 8
14		HB006S	SPRING WASHER	12	Ø 6	29		NA008M	NUT	16	M8
15		SE612F	SCREW	12	M6X12	30		HB008S	SPRING WASHER	8	Ø 8

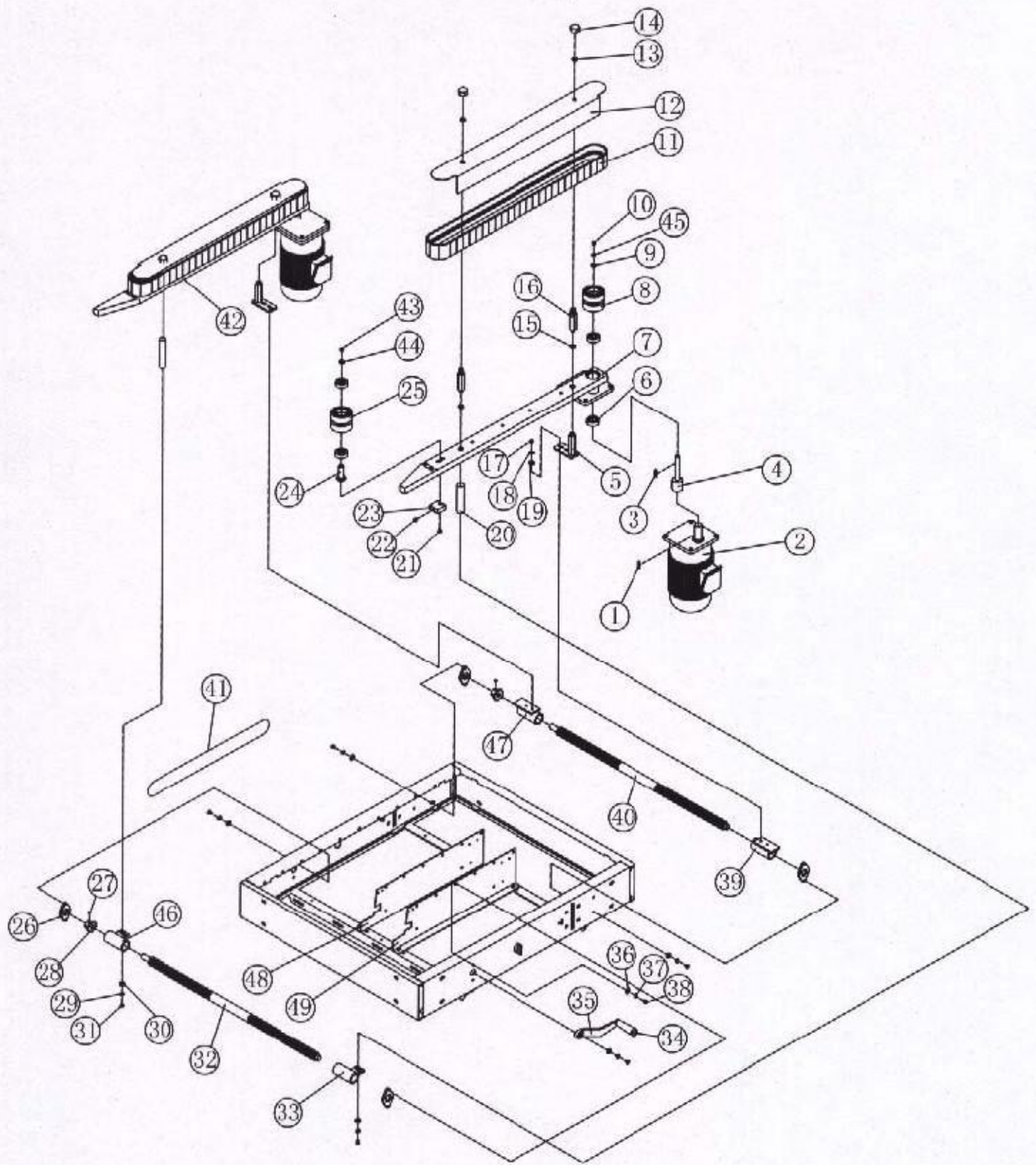




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NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION	NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION
01		A2101A	SUPPORT SET	2		14		A2511A	RUBBER PLUG	2	
02		A1516A-1	HANDLE CRANK ARM	1		15		A2516A	SUPPORT BAR BUSH	2	
03		A1517A	HANDLE KNOB	1		16		A2513A	LOCKING BRACKET	2	
04		HA006B	WASHER	2	Ø6	17		A2512A	HANDLE KNOB	2	
05		HB006B	SPRING WASHER	2	Ø6	18		HA006B	WASHER	2	Ø6
06		SE616F	SCREW	2	M6X16	19		SE635F	SCREW	2	M6X35
07		A2507B	DRIVING SET HOLDING FRAME	1		20		HB006B	SPRING WASHER	2	
08		SE612F	SCREW	8	M6X12	21		A2510A	COMPRESSION ROLLER BAR	1	
09		HB006B	SPRING WASHER	8	Ø6	22		SE612F	SCREW	8	M6X12
10		HA006B	WASHER	8	Ø6	23		HB006B	SPRING WASHER	8	Ø6
11		A2515A	COMPRESSION ROLLER	2		24		HA006B	WASHER	8	Ø6
12		DB017B	S-RING	4	Ø17	25		A2503A	BRACKET	2	
13		A2514A	COMPRESSION ROLLER SHAFT	2		26		A2503B-1A	HEIGHT ADJUSTMENT SPINDLE	2	






















RPA-05

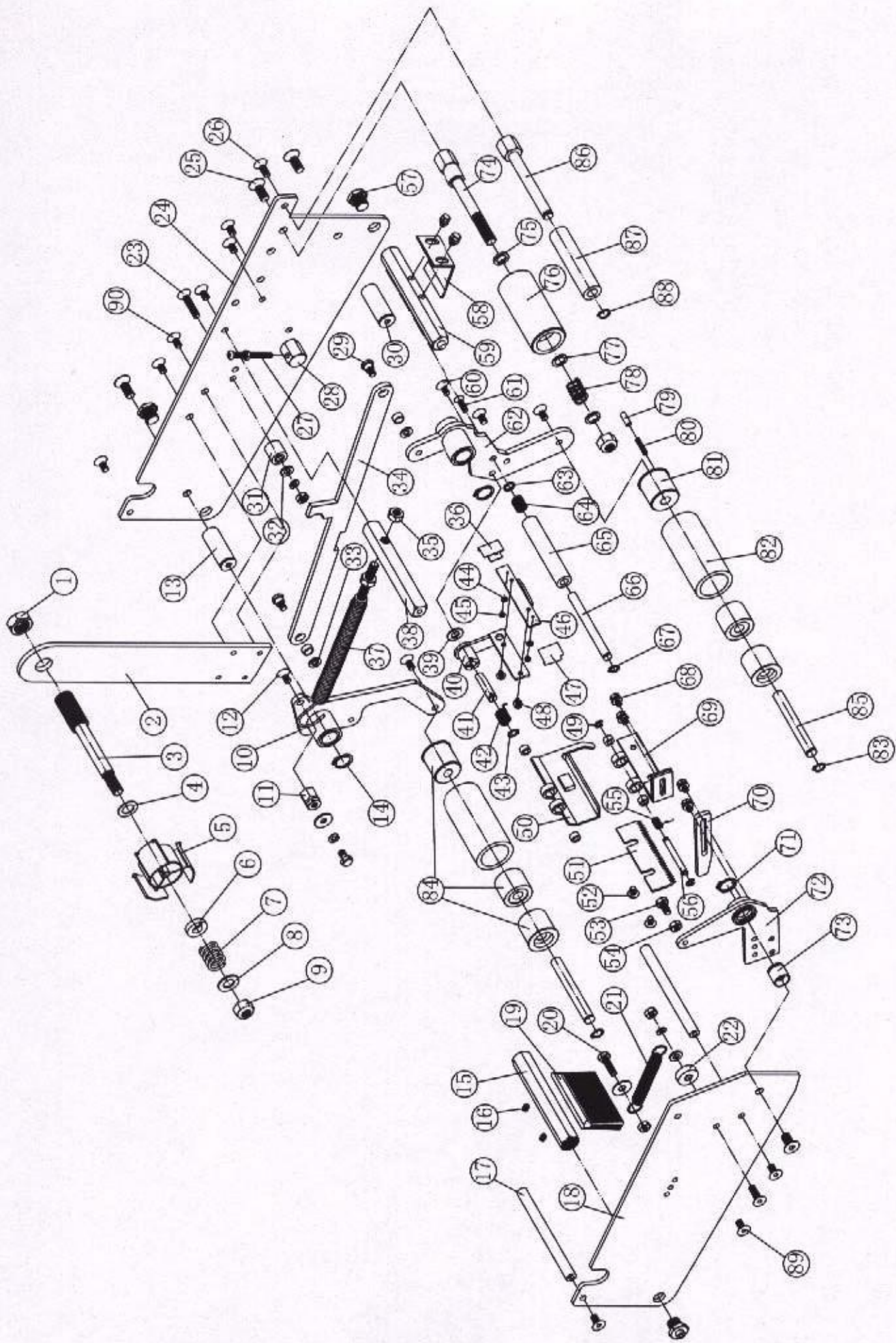
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28		A2505A	FRAME SUPPORT	2		42		SE825F	SCREW	4	M8X25
29		RS-001	CHAIN WHEEL	2	RS35X10 ø 12	43		HB008B	SPRING WASHER	4	ø 8
30		SI606F	SET SCREW	2	M6X6	44		HA008B	WASHER	4	ø 8
31		A2503C	SPINDLE BRACKET (BOTTOM)	2		45		HIA008B	WASHER	4	ø 8
32		SE612F	SCREW	8	M6X6	46		NA008M	NUT	4	M8
33		HB006B	SPRING WASHER	8	ø 6	47		HIA008B	WASHER	8	ø 8
34		HA006B	WASHER	8	ø 6	48		HIB008B	SPRING WASHER	8	ø 8
35		A2506A	CHAIN COVER	1		49		NA008M	NUT	8	M8
36		EF001	ON/OFF SWITCH	1		50		HA006B	WASHER	8	ø 6
37		HA004B	WASHER	1	ø 4	51		NA006M	NUT	8	M6
38		HB004B	SPRING WASHER	1	ø 4	52		LA004E	KEY	2	4mm
39		SA410F	SCREW	1	M4X10	53		RB003G	CHAIN	1	RS30X1630L
40		SJ814F	SCREW	8	M8X14	54		A1517A	BRACKET	4	

































NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION	NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION
01		TA005E	KEY	2	5mm	15		HA012B	WASHER	4	Ø 12
02		MA301B	MOTOR	2	1/8HP 220V 50Hz	16		A3507A-1	SPECIAL SCREW	4	
03		TA005E	KEY	2	5mm	17		SD616F	SCREW	4	M6X12
04		A3510A	DRIVER SHAFT	2		18		HB006S	SPRING WASHER	4	Ø 6
05		A3511A	SUPPORT SHAFT	2		19		HA006S	WASHER	4	Ø 6
06		BA003A	BEARING	8	6202Z	20		A3527A	SUPPORT PILLAR	2	
07		A3509A	SUPPORT COLUMN (R)	1		21		SD830F	SCREW	2	M8X30
08		A3504A	PULLEY DRIVER	2	N1-60X50W	22		SE660F	SCREW	2	M6X60
09		HA006B	WASHER	2	Ø 6	23		A3518A	ADJUSTMENT SCREW	2	
10		SE612F	SCREW	2	M6X12	24		A3517A	PULLEY-FOLLOWER SHAFT	2	
11		RA004H	BELT	2	48X1370	25		A3516A	PULLEY-FOLLOWER	2	
12		A3501A	BELT COVER (R)	2		26		A3514A	GUIDE PLATE SET	4	
13		HA008B	WASHER	4	Ø 8	27		SI606F	SET SCREW	2	M6X6
14		NC008M	NUT	4	M8	28		RS-002	SPROCKET	2	RS35XT10 Ø 15

RPA-05































NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION	NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION
29		HB008S	SPRING WASHER	2	Ø 8	41		RB003H	CHAIN	1	RS35X1040L
30		HA008B	WASHER	2	Ø 8	42		A3524A	BELT SUPPORT (L)	1	
31		SE820F	SCREW	2	M8X20	43		SE812F	SCREW	2	M8X12
32		A3515A	WIDTH ADJUSTMENT SPINDLE	1	720L	44		HA008B	WASHER	2	Ø 8
33		A3513B	FRAME SUPPORT (L)	1		45		HB006S	SPRING WASHER	2	Ø 6
34		A1517A	HANDLE KNOB	1		46		A3522B	FRAME SUPPORT (R)	1	
35		A1516A-1	HANDLE CRANK ARM	1		47		A3526A	FRAME SUPPORT (R)	1	
36		HA006S	WASHER	9	Ø 6	48		A1515A	BOTTOM TAPING SET SIDE PLATE (L)	1	
37		HB006S	SPRING WASHER	9	Ø 6	49		A1516A	BOTTOM TAPING SET SIDE PLATE (R)	1	
38		SE612F	SCREW	9	M6X12	50					
39		A3525A	FRAME SUPPORT (L)	1		51					
40		A3515A	WIDTH ADJUSTMENT SPINDLE (REAR)	1	704L	52					















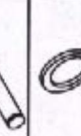





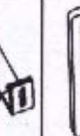











TAPE HEAD

NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION	NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION
01		NA018M	NUT	1		16		S1506F	SET SCREW	2	M5X6
02		TH401A	TAPE DRUM PLATE	1		17		TH412A-2" TH412B-3"	PILLAR	2	Ø 10X115
03		TH403A-2" TH403B-3"	TAPE DRUM SHAFT	1		18		TH411A-2" TH411B-3"	TAPE HEAD PLATE(L)	1	
04		HA010B	WASHER	1		19		TH420A-2" TH420B-3"	BRUSH	1	
05		TH402A-2" TH402B-3"	TAPE DRUM	1		20		SE618F	SCREW	1	M6X18
06		HA010B	WASHER	1		21		FB003A	BLADE ARM SPRING	1	
07		FA001A	SPRING	1		22		TH410A	BLADE ARM CUSHION	1	
08		HA010B	WASHER	1		23		SF625F	SCREW	1	M6X25
09		NF010A	NUT	2	M10	24		TH422A-2" TH422B-3"	TAPE HEAD PLATE(R)	1	
10		TH432A-2" TH432B-3"	REAR ROLLER ARM ASSEMBLY	1		25		SF820F	SCREW	3	M8X20
11		TH443A	SPRING HOLDER	1		26		SF616F	SCREW	1	M6X16
12		SF612F	SCREW	N	M6X12	27		SA535F	SCREW	1	M5X35
13		TH439A	REAR ROLLER ARM ASSEMBLY SHAFT	1		28		TH426A	HOLDING SUPPORT	1	
14		DB016E	S-RING	1	16	29		SJ010F	SPECIAL SCREW	2	
15		TH419A-2" TH419B-3"	PILLAR	1		30		TH439A	ROLLER ARM ASSEMBLY SHAFT	1	

TAPE HEAD

NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION	NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION
31		TH413A	SIMULTANEOUS BAR CUSHION	1		46		TH434A-2" TH434B-3"	TAPE HOLDER SUPPORT	1	
32		HA006S	WASHER	2	Ø 6	47		TH435A-2" TH435B-3"	TAPE HOLDER	1	LEFT
33		HA006S	WASHER	2	Ø 6	48		SA408F	SCREW	2	M4X8
34		TH440A-2" TH440B-3"	SIMULTANEOUS BAR	1		49		DA005E	E-RING	2	Ø 5
35		NA008M	NUT	2	M8	50		TH417A-2" TH417B-3"	BLADE COVER	1	
36		TH441A-2" TH441B-3"	TAPE HOLDER	1	RIGHT	51		TH416A-2" TH416B-3"	BLADE	1	
37		FB006C	MAIN SPRING	1	105L	52		SA508F	SCREW	2	M5X6
38		TH442A-2" TH442B-3"	HOLDING BAR	1		53		SE612F	SCREW	1	M6X12
39		HA005B	WASHER	1	Ø 5	54		NA006M	NUT	1	M6
40		TH436A-2" TH436B-3"	TAPE HOLDER ASSEMBLY	1		55		FD002A	SPRING	1	
41		TH437A	SHAFT	1		56		TH418A-2" TH418B-3"	BLADE SHAFT	1	Ø 5
42		ED005A	SPRING	1		57		TH421A	HOLDING SCREW	3	
43		DB008E	S-RING	N	Ø 8	58		TH408A	GUIDE PLATE	1	
44		HA003S	WASHER	2	Ø 3	59		TH424A-2" TH424B-3"	HOLDING SHAFT	1	
45		SA303F	SCREW	2	M3	60		SF512F	SCREW	1	

TAPE HEAD

NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION	NO.	DRAW	PART NO.	DESCRIPTION	QTY	SPECIFICATION
61		SF512F	SCREW	1	MSX12	76		TH407A-2" TH407B-3"	ONE WAY ROLLER (BRASS)	1	
62		TH427A-2" TH427B-3"	FRONT ROLLER ARM ASSEMBLY	1		77		HC010S	WASHER	2	Ø 10X1t
63		HC008S	WASHER	1	Ø 8	78		FA010A	SPRING	1	
64		FA003A	SPRING	1		79		TH430	BRASS SHAFT	1	
65		TH429A-2" TH429B-3"	PLASTIC PULLEY	3		80		FA004A	SPRING	1	
66		TH428A-2" TH428B-3"	BRASS ROLLER SHAFT	1		81		TH452A-2" TH452B-3"	PE-ROLLER	1	
67		DB008E	S-RING	1	Ø 8	82		TH431A-2" TH431B-3"	RUBBER ROLLER	2	
68		SE510F	SCREW	1	MSX10	83		DB010E	S-RING	1	Ø 10
69		TH423A-2" TH423B-3"	BLADE HOLDER	1		84		TH432A-2" TH432B-3"	PE-ROLLER (REAR)	1	
70		TH415A-2" TH415B-3"	ADJUSTABLE SLICE	1		85		TH433A-2" TH433B-3"	PE-ROLLER SHAFT	1	
71		DB016E	S-RING	1		86		TH404A-2" TH404B-3"	PULLEY SHAFT	1	
72		TH414A	BLADE ARM	1		87		TH405A-2" TH405B-3"	PLASTIC PULLEY	1	
73		TH413A	BLADE ARM SHAFT	1		88		DB010E	S-RING	1	Ø 10
74		TH406A-2" TH406B-3"	ONE WAY ROLLER SHAFT	1		89		SF612F	SCREW	8	M6X12
75		HC010S	WASHER	1	Ø 10X2t	90		SF608F	SCREW	2	M6X8