

CS50-SB Side belt driven Case Sealer



Operating
Manual

PREFACE

Thank you for purchasing the auto carton sealer.

This manual will show you the basic structure, using method and points for attention to use this machine safely and correctly. Please read this manual carefully before operating the machine. Be sure that the manual is hand to the final users. This manual content change, without prior notice. GPA carton sealer series use OPP tape to seal different kinds of cartons. The machine is operated and maintained easily with simple structure and high quality, for which it is widely used in various industries.

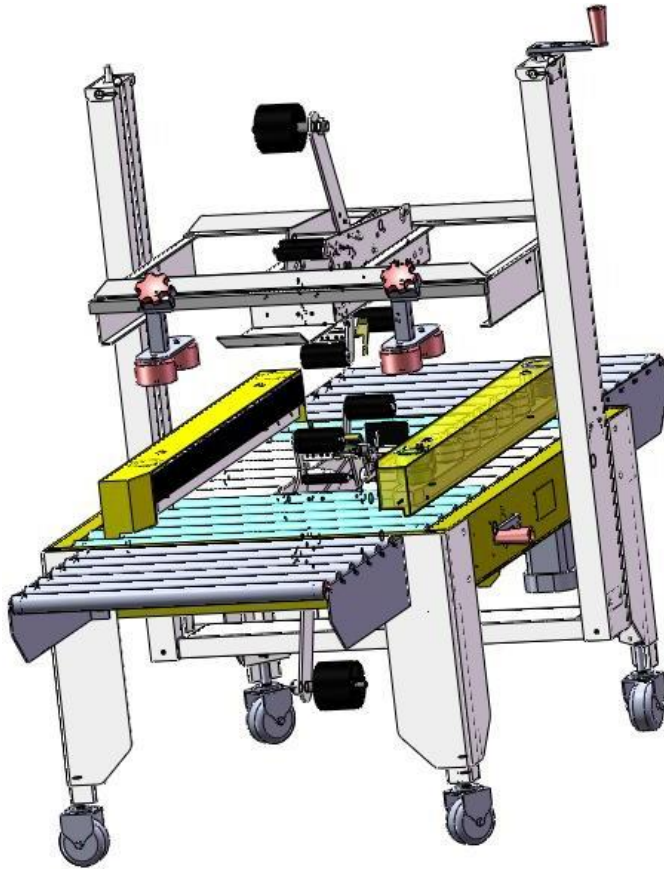
SAFETY INFORMATION

1. The operator should read the operating manual carefully before operating this machine.
2. The operator can not touch any driving parts before running this machine.
3. The maintenance personnel should read the operating manual carefully before maintaining this machine.
4. The power and gas must be closed when installing the tape and doing the daily maintenance.
5. Only the trained personnel can operate the machine.

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1. Specification



The main parameters are listed as follows:

Sealing width: 15cm~50cm

Sealing height: 12cm~50cm

Sealing length: 15cm~ $+\infty$ mm

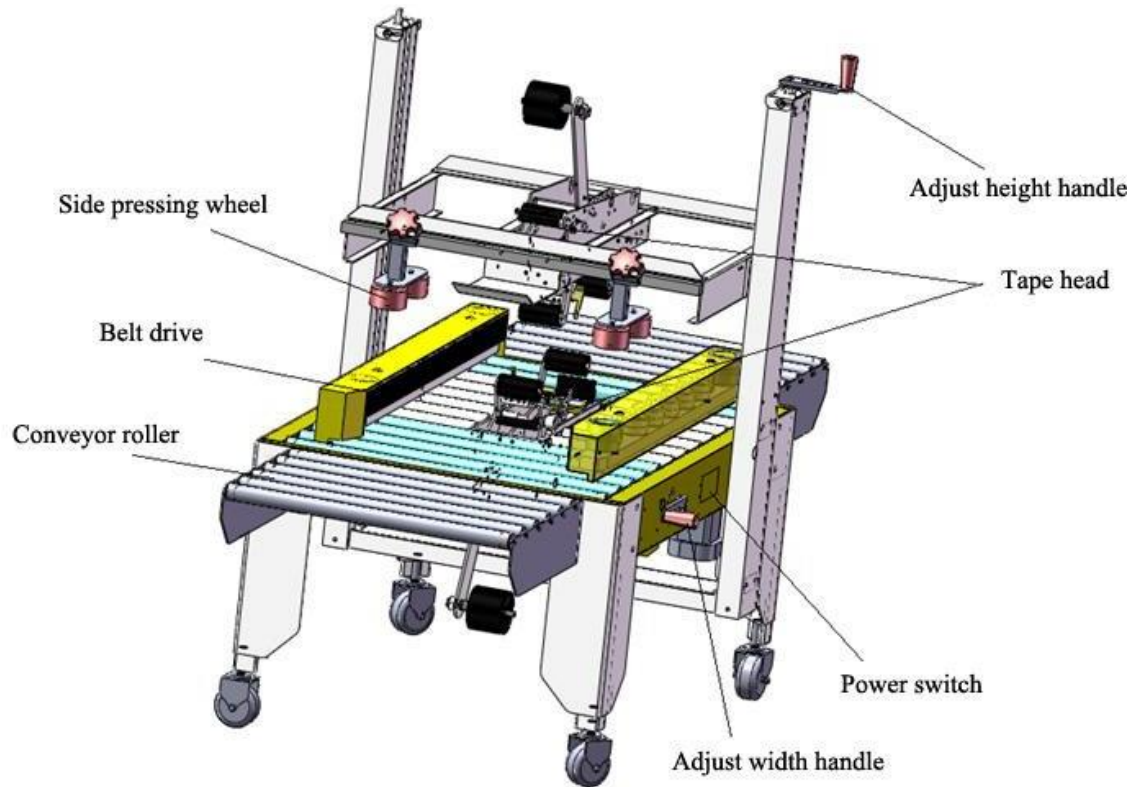
Table height: 55cm~72cm

Machine size: L 102cm \times W 85cm \times H 135cm

(without in-feed & out-feed conveyor)

Sealing speed: 20m/min

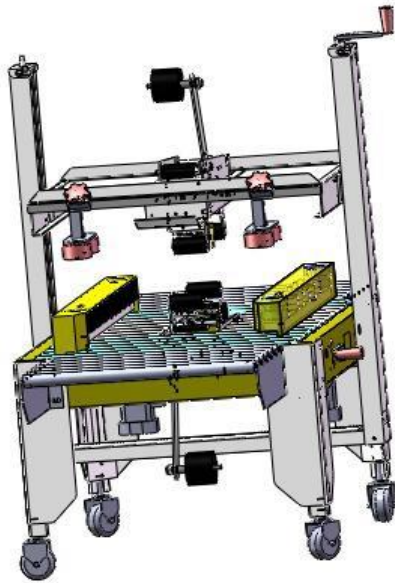
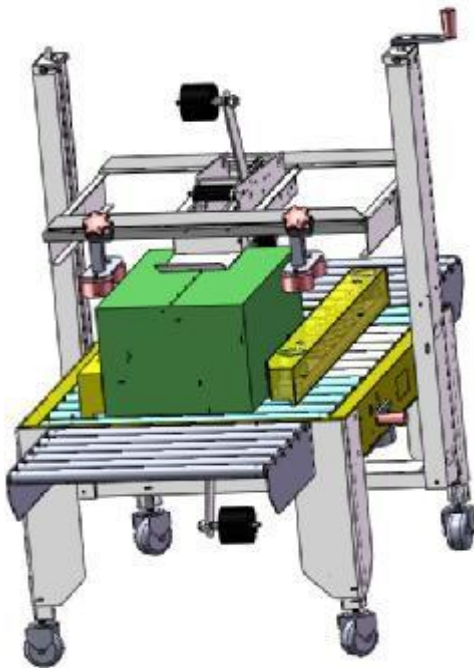
2. Machine structure and adjustment instruction(P.1):



P.1

3. Operation flow

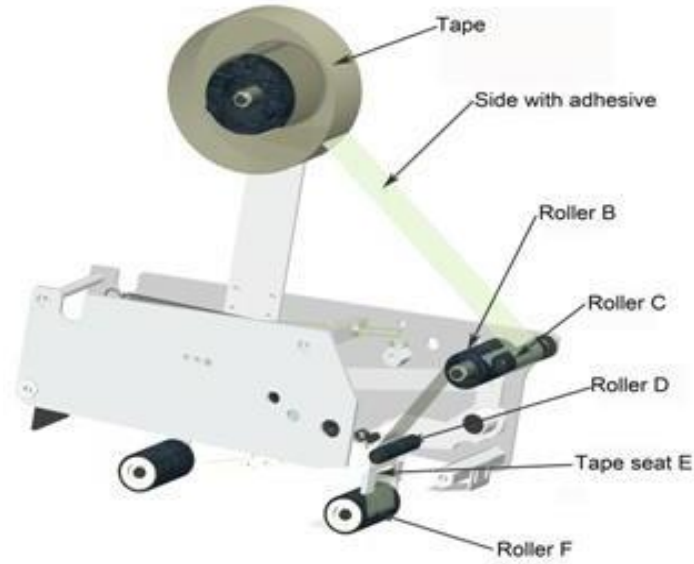
- 3.1 Folding the filled carton covers manually and then push it into the sealing system, adjust the width and height of the sealing system
- 3.2 Start the machine, push the fold carton into the sealing system, the carton is conveyed by the driven belt, then sealed up and bottom. P 3

**P.2****P.3**

4. Adhesive tape installation and adjustment P.4:

4.1 At first, install the roll of OPP adhesive tape at the core axis (see P.4). pull out of the adhesive tape, circle around roller C, then circle around roller B, D, get through tape seating E and get out of the front side of

roller F. Pay highly attention that the side with glutinosity should face toward outside.



P.4

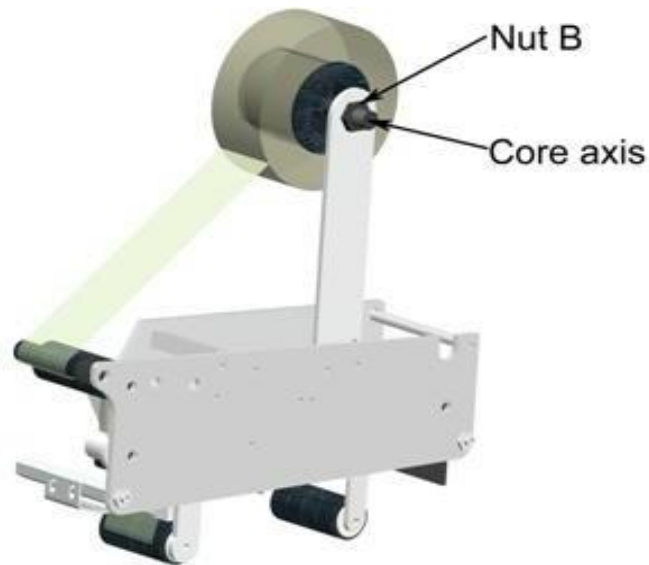
4.2 Drawing of the adhesive tape threading P.5



P.5

4.3 Adhesive Tape position adjustment P.6

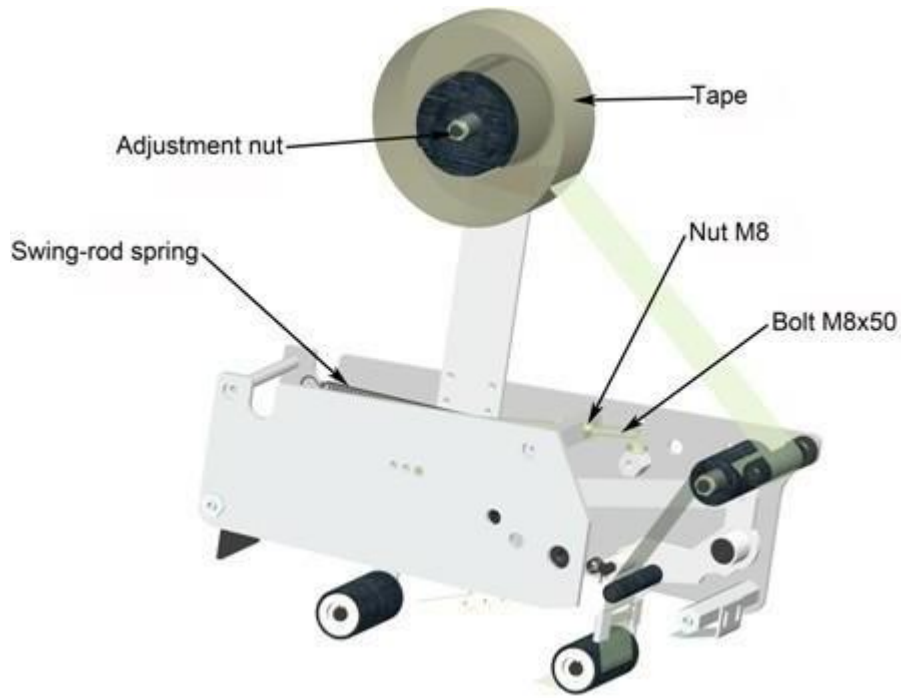
If the adhesive tape is not on the carton central line, please refer to below picture for adjustment. First, loosen the nut, then move the core axis with nut until the adhesive tape is moved to the carton central line.



P.6

4.4 Adhesive tape tension adjustment (P.7):

Turn the knob, loosen the nut M8, and adjust the bolt M8*50 to change the elasticity of swing-rod long extension spring so as to control the tape's tension. Turn the knob clockwise and the tension of adhesive tape will larger; turn the knob anticlockwise, and the tension of adhesive tape will lessen. When the bolt M8*50 is adjusted frontward, the strain of adhesive tape will larger; conversely, the strain of adhesive tape will lessen.

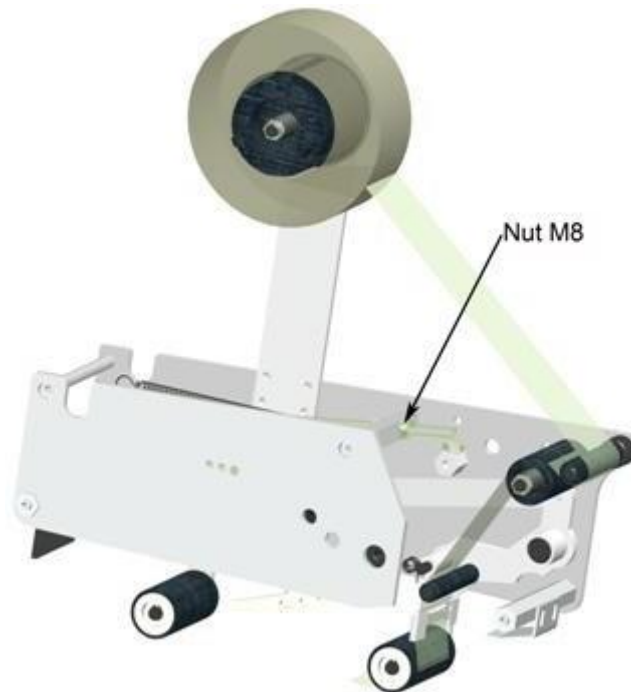


P.7

Malfunctions and solutions

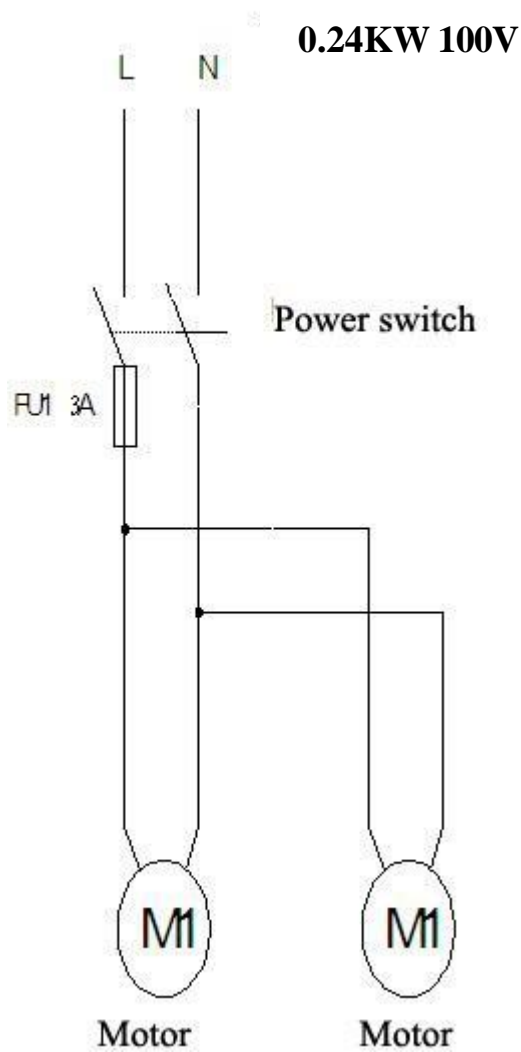
Malfunction	Possible reason	Solution
Adhesive tape can not be cut off	The reamer patch is not sharp enough. The reamer tine is jammed by the bond.	Change the reamer patch Launder the reamer patch
There is tail after the adhesive tape is cut off.	The reamer patch is not sharp enough. There is stem on the reamer seating. The pulling spring is too loose.	Check if the nut on the reamer seating is too loose or not. Lubricate the nut if necessary.
The adhesive tape can't stick to the carton completely.	Main spring is too loose and there is glue on the axis of the roller. The adhesive tape is disqualification	Adjust the pull of main spring and clear up the roller. Change the adhesive tape
The carton is locked in the midway.	The nut on the pasting wheel is too tight, the height adjustment of the carton's transporting line is not suitable, and the main spring is too tight.	Loosen the pasting wheel, regulate the nut, re-adjust the height and loosen the main spring.

The adhesive tape is often off the track.	The pressure of the guiding roller on the carton is not equal.	Re-adjust the space of the guiding roller.
There is jut before sealing and drape after sealing.		Adjust each transporting line's pull to be consistent so that the carton can be put at the correct place.
There is drape after sealing		decrease the strain of adhesive tape P8



P.8

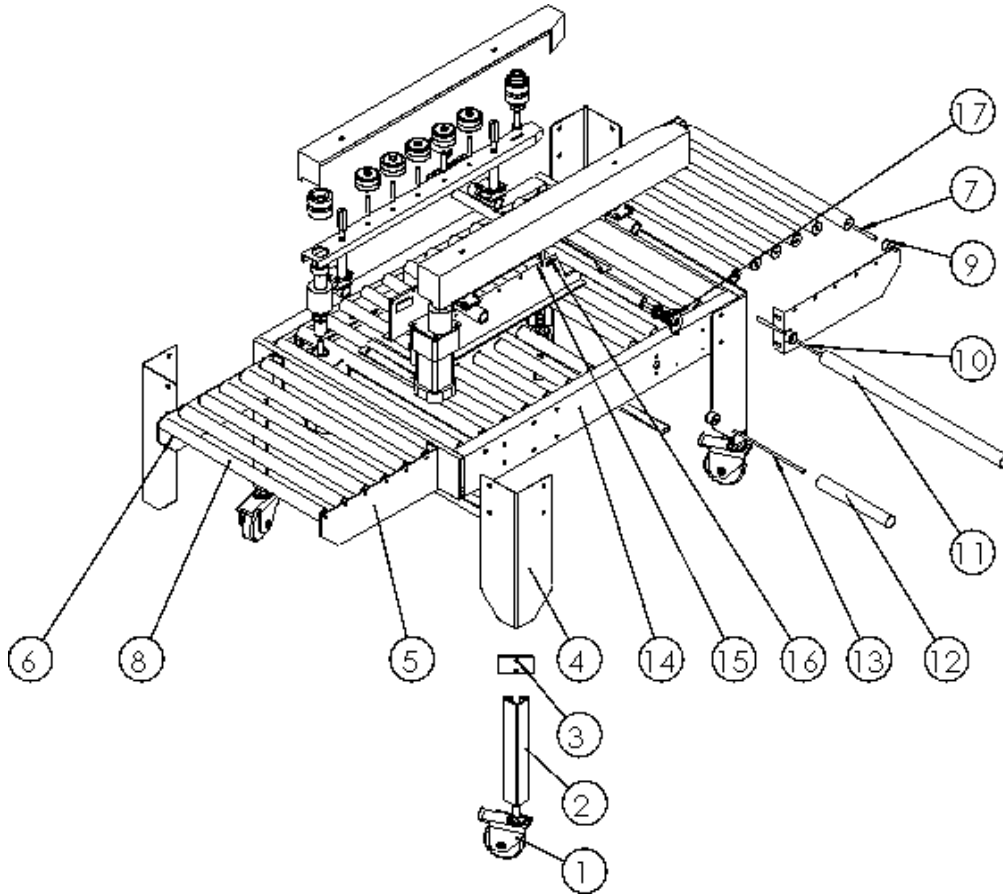
5. Circuit diagram (P.10):



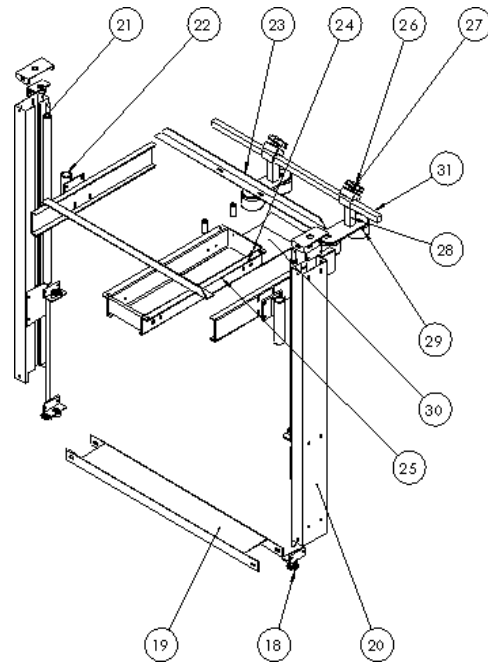
P.10

6. Exploded figure

6.1 Exploded figure of the body: (P.11, PARTS LIST 1)



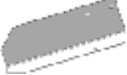







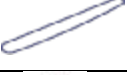




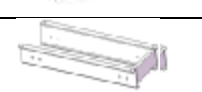



Lifting Section



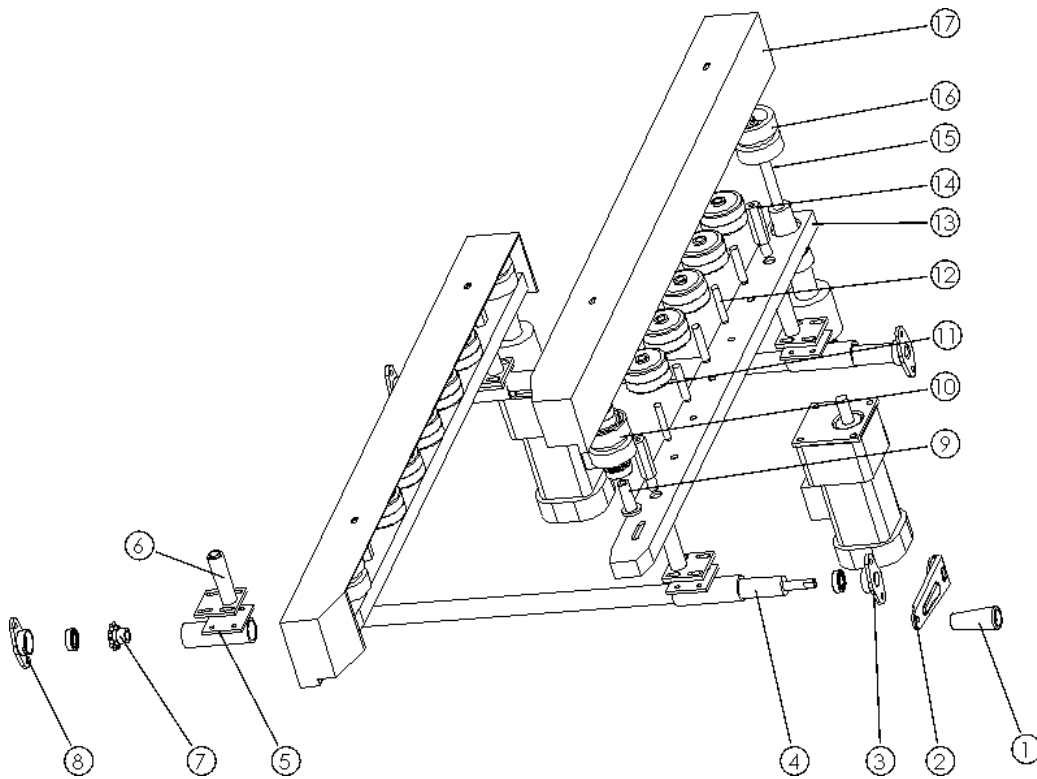
P.11

PARTS LIST 1 :

ON.	DRAW	DESCRIPTION	QTY	MEMO
1		Castor	4	With stop
2		Adjust under carriage	4	
3		Solid square	4	
4		Under carriage	4	
5		Bracket	2	
6		Bracket	2	
7		Axle	12	
8		Beam barrel	12	
9		Axle sleeve	62	
10		Axle	7	
11		Beam barrel	7	
12		Beam barrel	12	
13		Axle	12	
14		Frame	1	
15		Catch plate	2	
16		Pin	7	
17		Chain	1	
18		Chain wheel	2	


19		Cover plate	1	
20		Upright column	2	
21		Axle	2	
22		Axle sleeve	2	
23		Bracket	1	
24		Catch plate	2	
25		Bracket	1	
26		Start handle	2	
27		Lock block	2	
28		Clamping roller lever	2	
29		Clamping roller	4	
30		Guide plate	1	
31		Adjuster lever	1	













6.2 Driving parts: (P.12 PARTS LIST 2):



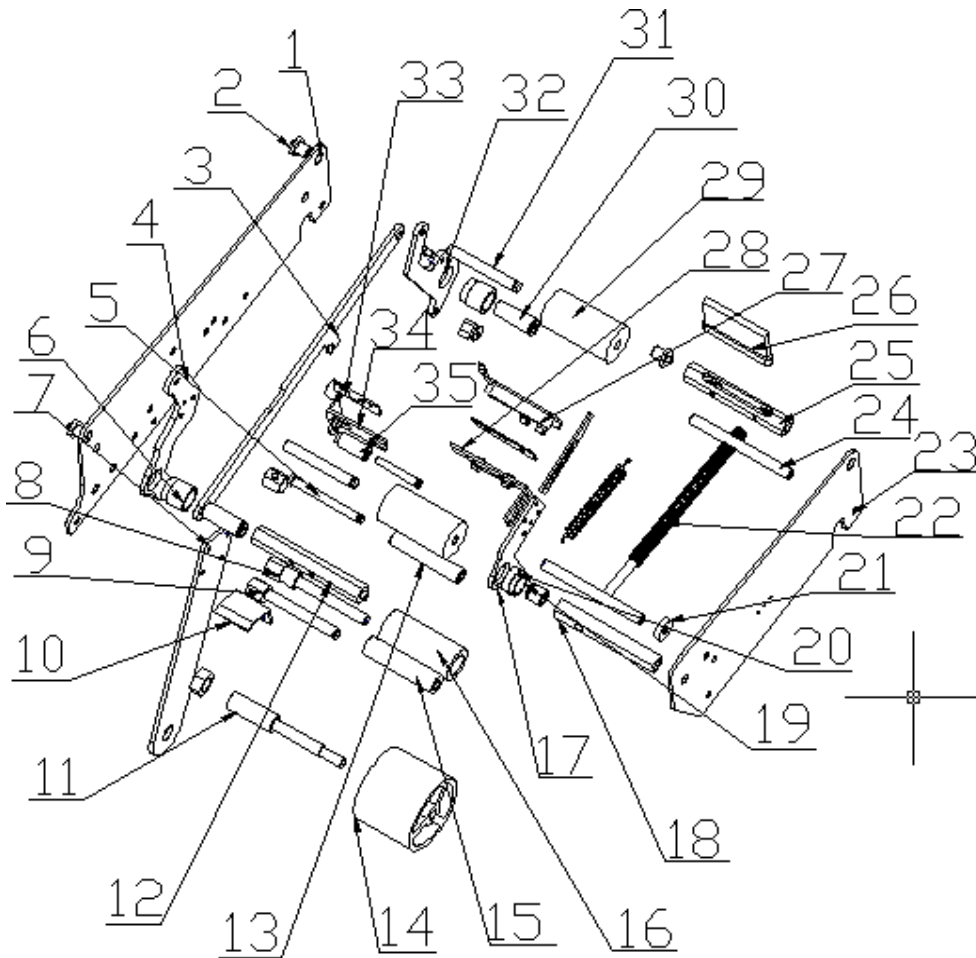
P.12

PARTS LIST 2 :

ON	DRAW	DESCRIPTION	QTY	MEMO
1		Handle	1	
2		Handle setting shaft	1	
3		Unit bearing assembly	2	
4		Screw rod	2	
5		Sliding base	4	

6		Belt bracket	4	
7		Chain wheel	2	
8		Unit bearing block	2	
9		Pin roll	2	
10		Driven wheel	2	
11		Idle wheel	20	
12		Single port idle shaft	10	
13		Belt bracket	2	
14		Belt cover support bar	4	
15		Drive axle	2	
16		Drive wheel	2	
17		Belt cover	2	

6.3 Exploded figure of adhesive tape: (P.13 PARTS LIST 3)



P.13

PARTS LIST 3:

No.	Description	QTY	MEMO
1	Left panel	1	
2	Hexagon shaft	1	
3	Connection link	1	
4	Front swing	1	
5	Knurling guide roller axle	1	

6	Stationary axle sleeve	2	
7	Adhesive tape supporting arm	1	
8	Unidirectional guide roller axle	1	
9	PE roller axle	1	
10	Front guide board	1	
11	Adhesive tape holder stationary axle	1	
12	Front support axle	1	
13	Knurling guide roller	1	
14	Adhesive tape roller	1	
15	PE roller	1	
16	Unidirectional knurling roller	1	
17	Cutter holder wedding board	1	
18	Main spring lock shaft	1	
19	Cutter holder stationary axle	1	
20	Cutter holder stationary axle sleeve	1	
21	Baffle roller	2	
22	Main spring	1	
23	Right panel	1	
24	Panel lock axle	2	
25	Brush lock axle	1	
26	Brush	1	
27	Cutter cover	1	
28	Bracket	1	
29	Back glue roller	1	
30	Stationary axle	2	
31	Glue roller axle	2	
32	Rear swing	1	
33	Top-plate	1	
34	Adhesive supporting bracket	1	
35	U-shape axle sleeve	1	