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# Carton Sealer

## Model: CS-5050AC

**Distributed By:**

Version 1.0  
Last Updated: 1/18/2024



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Sealer Sales, Inc.  
8820 Baird Avenue  
Northridge, Ca 91324  
[www.sealersales.com](http://www.sealersales.com)

Printed in the United States of America

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## Preface

Thank you for purchasing our FXJ-5050A/C Series Semi-Auto Tape Carton Sealer.

### **This manual contains the following contents:**

- Product Description
- Safety
- Carriage And Storage
- Installation And Commissioning
- Operation
- Maintenance
- Troubleshooting

This manual describes the installation and use of products, including the following details: carriage and storage, installation, start-up, operation conditions, maintenance, troubleshooting and repair.

### **Please note that:**

- Before using the product, please read the instructions carefully and understand them fully.
- Ensure that the operator or equipment manager who ultimately uses the product has this instruction.
- After reading, please keep this instruction properly and keep it at your fingertips all the time for your reference.
- If you have any questions, please contact the supplier.

### **Responsibility:**

- The manufacturer shall not be liable for any consequences arising from non-compliance with the precautions specified in the instructions for use and installation or from any misunderstanding.
- The manufacturer shall not bear any damage or problems caused by the failure to adopt the required accessories.
- The manufacturer reserves the right to modify parameters or accessories without notice.

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## 1. Description

### 1.1 Product application

FXJ-5050A/C Series Semi-Auto Tape Carton Sealer provides you with modern sealing technology. It has strong and stable structure, light weight, easy operation and simple maintenance.

The Tape Carton Sealer is mainly used for carton packing. It can be used alone or with assembly line. It is widely used in the packaging of household appliances, textiles, food, beverage, medicine, cosmetics, books and periodicals. The Tape Carton Sealer uses adhesive tape to seal cartons, which is economical and fast. It is easy and fast to adjust different cartons at will. A Carton sealing machine that can complete both sides of the carton sealing drive, generally suitable for lighter cartons.

We require you to read this instruction carefully, keep the machine clean, operate and maintain according to the instruction to ensure the normal service life of the machine.

### 1.2 Technical parameters

Model	FXJ-5050A/C
Voltage (V/Hz)	AC220/110V, 50/60Hz,200W
Max. Carton Size (W x H x L)	∞×500×500 mm
Min. Carton Size (W x H x L)	150×120×120 mm
Sealing Speed	20m/min(25~37cartons/min)
Height of Table	730mm
Used Adhesive Tape	BOPP, water-free adhesive tape,PVC
Width of Adhesive Tape	60mm、48mm
Conveying Form	Drive by side conveying belts
Dimension (L×W×H)	620(1440 with bracket)×908×1220~1620
Net Weight	100Kg
Maximum Outside Diameter of Adhesive Tape	250mm

### 1.3 Product feature

This machine is very convenient to use. After adjusting the size according to the box, the device can complete the sealing action only by pushing the carton in.

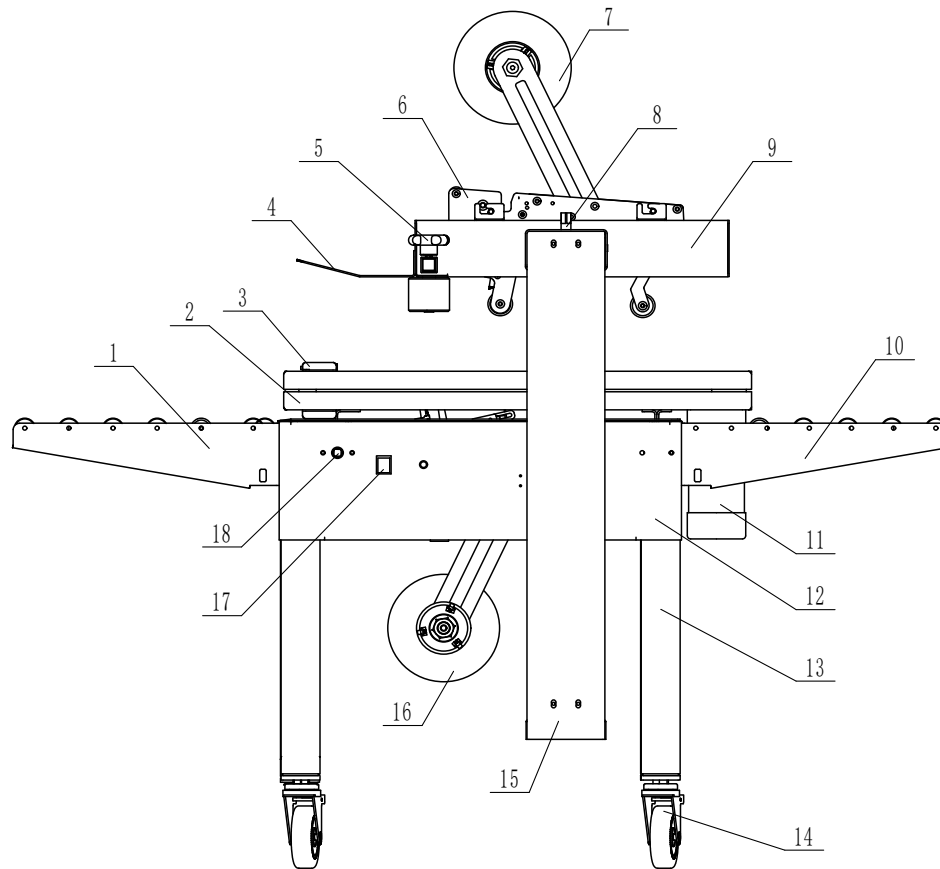
Box sizes adjustment range is wide, suitable for various specifications of carton packaging.

### 1.4 Working principle

After folding the carton lids, the carton is pushed into the sealing machine, driven by belts of two side

and the carton is sealed by the upper and lower sealing head mechanism.

### 1.5 Major components



No	Part Name	Remark
1	Front Brackets	
2	Side Conveying Assembly	
3	Tension Seat For Belt	
4	Guide Board	
5	Side Pressing Wheel Assembly	
6	Upper Tape Head Assembly	
7	Upper Tape	
8	Lift Adjustment Screw Rod	
9	Upper Frame Assembly	
10	Rear Brackets	
11	Reducer Motor	
12	Machine Frame	

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	Assembly	
13	Stand	
14	Caster	
15	Stand Column Assembly	
16	Bottom Tape Head Assembly	
17	Power Switch	
18	Width Adjustment Screw Rod	

## 2. Security

### 2.1 Prepare for use

This specification describes in detail the handling, storage, installation, start-up, operation conditions, maintenance, troubleshooting and repair of products.

Installation of machines is recommended by trained professionals.


**Be sure to follow the maintenance instructions**


- Before using the machine, please read the instructions carefully and understand them fully.
- If you have any questions, please contact the supplier.

### 2.2 Safety precautions

This product is manufactured according to the latest technical and safety standards. If used improperly, it may cause danger or injury. The key words "danger", "warning" and "caution" are used to annotate safety precautions.

**For example:**

	<p><b>DANGER!</b></p> <p>Ignoring this safety precaution will lead to serious and even fatal injury accidents.</p>
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	<p><b>Warning!</b></p> <p>Ignoring this safety precaution will lead to serious and even fatal injury accidents.</p>
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	<p><b>Caution!</b></p> <p>Ignoring this safety precaution will result in personal injury or property loss.</p>
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### 2.3 Using environment

This product is designed to operate at ordinary temperature. If the environment is terrible (such as corrosive ambient atmosphere, ambient temperature higher than 30°C or lower than 5°C), please contact the manufacturer or supplier.



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### 3. Movement and Machine Downtime

#### 3.1 Wooden package

If the machine is packed with wooden case

- Take out plastic film dust bag, foam packaging, etc from wooden case.



**Be careful! Danger of machine damage!**

Be careful not to damage the machine when taking apart the wooden case.



**Be careful! Danger of machine falling!**

Pay attention to the balance of the machine to avoid it from falling when removing the machine from the wooden case.

**Note:** Pay attention to the balance of the machine when moving it to avoid injury and damage to the machine.

#### 3.2 Short downtime

- Turn off the power switch and cut off the power.
- If possible, put a plastic bag on the machine to prevent dust.

#### 3.3 Long downtime

Before the machine leaves the factory, the interior has been treated with anti-corrosion processing, there is no need to apply protective oil, unless the storage condition is terrible (for example, corrosive atmospheric condition, high temperature, or frequent temperature change). If you have any questions, please contact the manufacturer or supplier.

- Turn off the power switch, unplug the power supply, and plug out the power cord.
- Lower the upper frame assembly and place a support underneath.
- Cover the machine with plastic film for dust proof.
- Apply grease to every driving component.
- Keep the machine in a dry and clean room.

#### 3.4 Start-up after shutdown

Please operate in accordance with the "Installation" and "Start up" section of this instruction manual.

### 4. Installation

Please read this manual carefully before installing. Through this manual, learn how to install, start, maintain, and use machine. The manufacturer will not be liable for any machine problems caused by not referring to the instructions.

The manufacturer hopes that customer can use the machine for a long time without any trouble after purchasing. If you have any questions, please feel free to contact the manufacturer or supplier.

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## 4.1 Essential condition for installation



**Be careful! It may damage the machine !**

**Without essential condition for installation, machine will be damaged.**

**Be careful injured!**

**Please obey the essential condition for installation.**

**Please ensure that the assembly environment complies with basic safety regulations.**

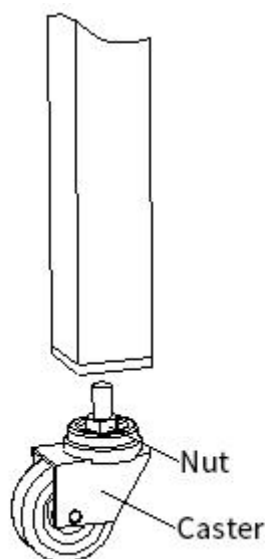
## 4.2 Installation environment

- The surrounding environment must not have flammable or explosive gases.
- Ambient temperature: 5-30 °C. If you need to operate the machine in other environments, please contact the manufacturer or supplier firstly.
- Environmental pressure: standard atmospheric pressure.
- Ensure that the power supply environment meets the requirements (see the nameplate on the machine).
- The machine must be kept upright when moving or transporting. Tilting the machine may damage the lifting mechanism.
- Ensure that the machine is placed horizontally, which is one of the elements of the machine's trouble-free operation.

**In order to ensure heat dissipation, there must be enough space around the machine for good ventilation, at least 100cm spacing.**

## 4.3 Caster Installation

- **Screw the caster into the threaded hole at the bottom of the stand, and tighten the nut upward after the machine is leveled.**



## 4.4 Electrical connection



**Danger! Electric shock !**

Assure all socket equipped with protective grounding wire.

Caution! Mismatching power supply damage machine!

Please check all parameter for machine power (refer to nameplate).

Please obey operation safety guidelines and national accident prevention measures.

#### **4.5 Power/Grounding**

- Check that the power supply voltage used is the same as the voltage specified on the machine nameplate.
- When the machine is connected to a three-phase power supply, please check the direction of rotation of the drive belt.
- Ensure that the machine is properly connected to a grounded outlet to avoid fire or electric shock (the ground wire is yellow-green).
- The cable must be free to move to avoid squeezing.
- If the cable is damaged, replace it immediately.
- When the machine is faulty or needs maintenance, please cut off the power firstly.
- When machine will be left idle for a long period of time, please collect the power line.

##### **If the machine uses a single-phase power plug**

- Connect the plug to the machine accurately. (if it has)
- Connect the other end of the power cord to a wall socket.

##### **If the machine uses three-phase power**

- Connect the power cord to the power correctly.
- Connect protective ground wire.



**Be careful! It may damage the machine!**

Before starting the machine, please make sure the rotation direction of power roller and drive belt is correct.

##### **For reducer motor with three-phase power supply**

- Make sure the rotation direction of drive belt.

##### **For changing the rotation direction:**

- Exchange any two phases of the three-phases power. (for motor employing three phases)

## **5. Startup and operation**



**Be careful! Danger of injury!**

**Please operate the machine against the manual.**



**Be careful! Mechanical injury!**

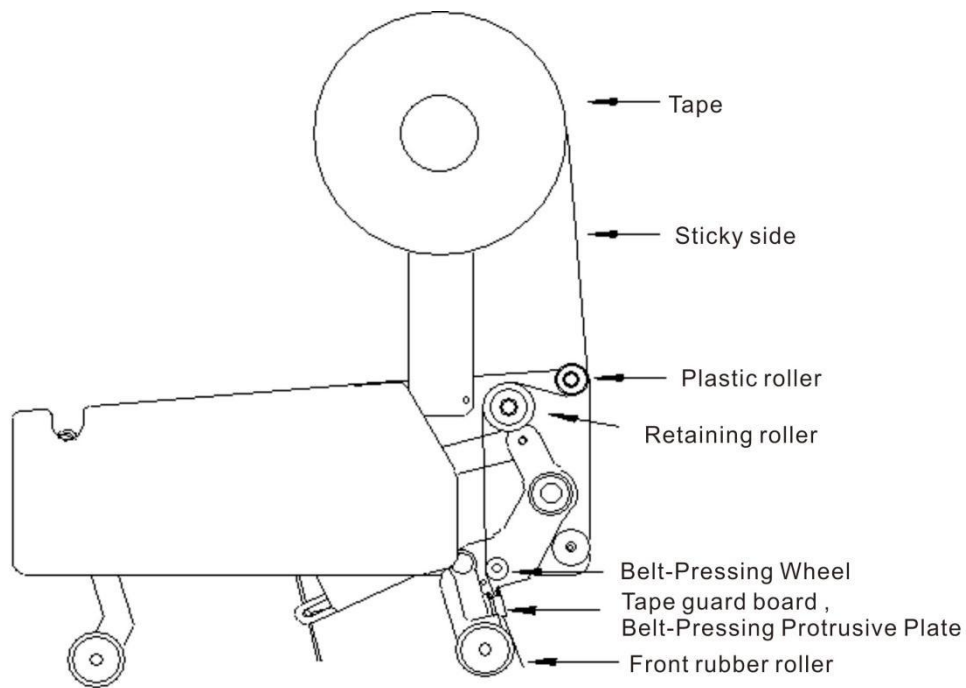
**There is a cutting blade on the sealing head of the machine to prevent scratches.**

**The drive belt components of the machine have a gear structure to prevent pinching hands.**

- If you have any questions about the operation and function of the machine, please contact the manufacturer or supplier if the instructions do not provide relevant information.
- If the machine is not operating properly or makes strange noises, turn off the power immediately, stop the machine and turn off the power.
- In the event of a malfunction, please contact the manufacturer or supplier.

### **5.1 Tape threading**

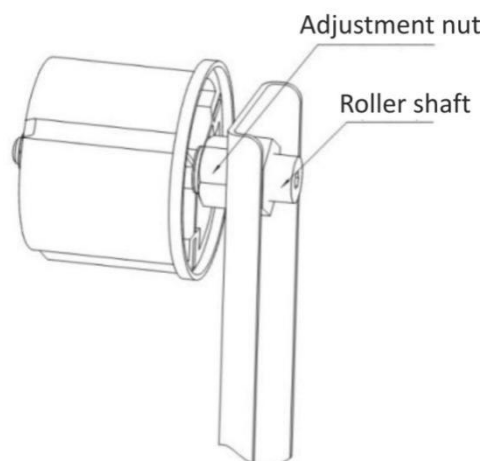
- Fix the tape roll on the tape roller before starting up.
- Pull out the adhesive tape to go around the plastic roller and then around the retaining roller, around the belt-pressing wheel, and finally pass the tape through tape guard board and belt-pressing protrusive plate, and then pass through the front rubber roller.
- Please note that the sticky side of the tape must face outward.



**Diagram of Tape**

## 5.2 Adjustment of tape location

- If the upper and lower width of the tape is not same, adjust as per picture below
- Loose nut and adjust with reel position to adjust tape position
- Fasten nut after adjustment.



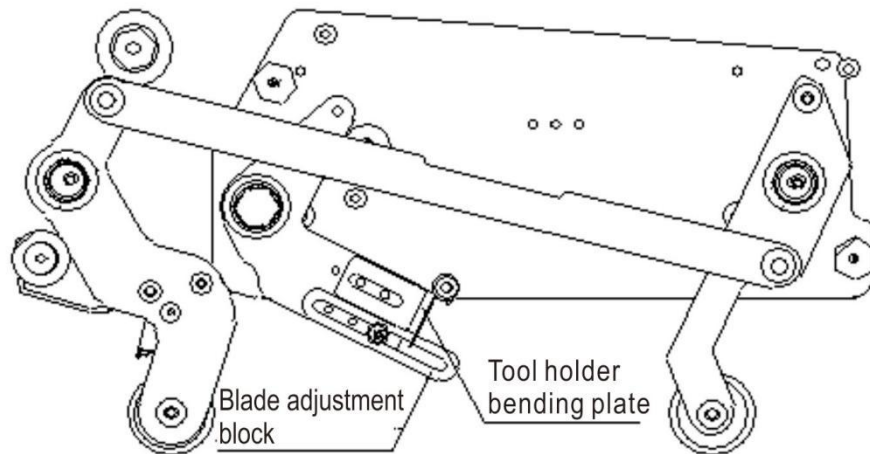
## 5.3 Adjustment of tape tension and cutting force

- Rotate the adjusting nut to make the tape roll speed moderate.
- Turn the adjusting nut clockwise to increase the tension of the tape, and vice versa.
- Switch the position of the main tension spring adjustment lever to adjust the pressure of the rubber roller on the tape.

- Switch the position of the cutter tension spring adjustment lever to control the cutter speed and cutter force.

#### 5.4 Adjustment of tape length(minor adjustment)

- Loosen the screw and pull out the blade adjustment block to increase the length of the tape head at the back of the carton, and vice versa. Tighten the screws after adjustment.
- Loosen the screw and pull out the knife holder bent plate to increase the length of the tape head at the front of the carton, and vice versa. Tighten the screws after adjustment.



#### 5.5 Reducer motor

- The gear box is filled with long-life grease, hence no need to add or replace oil, no need for maintenance

#### 5.6 Start up

- Start the machine by turning on the "power switch", which is located on the frame. Turn the "power switch" to position “ | ” to start the machine, and turn to position “o” to stop working.

#### 5.7 Standard Operation procedures

- Use the adjustment handle to adjust the width, so that the distance between the side drive belts is slightly smaller than the width of the carton by about 4mm.
- Use the adjustment handle to adjust the height, so that the distance between the upper sealing belt guide plate and the table roller is slightly higher than the height of the carton by about 2mm.
- Press the power switch to start the machine.
- Push the carton well folded to the side conveyor belt.
- If necessary, turn the power switch to the “O” position to stop working completely.
- Working circularly as above.

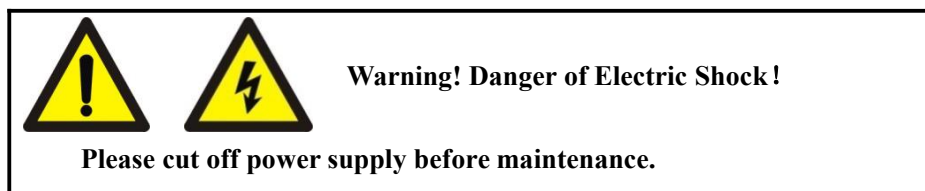
### 5.8 Requirement for the carton

- The outer layer of the carton should not be plastic material
- The carton must be dry. ( the wet carton is not suitable for sealing by tape.)
- No dust and debris should be on the surface of the carton
- Deformed cartons cannot be sealed with tape, especially those with wavy crease.
- The crease of carton should be deep and clear.

### 5.9 Requirement for the tape

- Please use tape with correct width ONLY.

## 6. Maintenance



In order to extend the service life of the machine, prevent malfunctions, and achieve optimal packaging results, routine maintenance of the machine is a must. If the machine is used frequently (more than 4 hours a day), then it is recommended to carry out professional maintenance every six months. And if it's working less than 4 hours per day, a complete maintenance once a year is needed, depending on working location, environment and product.

However, the user should do some small maintenance work regularly, including but not limited to below:

- Cut off power supply before maintenance.
- If the machine is not running properly or making a lot of strange noises, please turn off the power immediately and contact the manufacturer or supplier.
- Non-professionals are not allowed to carry out the major maintenance work.
- If the user fails to maintain the machine according to the instructions in this manual, and cause malfunction or damage of the machine, the manufacturer will not bear the relevant responsibilities.

### 6.1 Standard maintenance Schedule

Frequency	Maintenance needed
Daily	<ul style="list-style-type: none"><li>● Clean the cutting blade after finish using the machine.</li></ul>
Weekly	<ul style="list-style-type: none"><li>● Lubricate shaft and gears every week</li></ul>
Every 2 months	<ul style="list-style-type: none"><li>● Lubricate the driving parts of the sealing head.</li><li>● Check all the screws and nut. Tighten them if any loose is found.</li></ul>
Every 6 months	<ul style="list-style-type: none"><li>● Replace the cutting blade at least 6 months a time.</li></ul>
Every year	<ul style="list-style-type: none"><li>● Replace the conveyor belt.</li></ul>

## 6.2 Routine maintenance

- Keep the inside and outside of the machine clean and dry at all times.
- Do not place wet or dirty objects on the machine.
- The power cord should be put away when it's not in use, avoiding being rolled.
- Turn off the power before repairing and adjusting the machine.
- The blade must be cleaned and lubricated before use.

## 7. Troubleshooting

### 7.1 Sealing head failure and elimination

Problem	Reason	Solution
Tape does not cut cleanly	Blade is not sharp enough	Replace blade
	Adhesive is attached to blade	Clean blade
Tape is not trim after cutting off	Screw is loose so that knife rest is out of position as screws	Tighten the screws on the cartridge
	Blade spring tightness	Replacement of blade spring
	Swing arm tension spring is too loose	Adjusting the swing arm spring screw
Irregular tooth shape on the cutting area (tearing).	Blade is dull	Replace blade
	Blade is installed in wrong direction.	Re-install
	Knife spring too weak	Replace spring
The tape has been cut but the lead is too long	The knife seat is stuck, the movement is not flexible or the elasticity is not enough	Check the screws on each part of the sealing head to adjust the tension of the tension spring
Tape cut but unbonded carton	The main tension spring is too loose, and the rear rubber roller rebound speed cannot be synchronized with the belt speed.	Moderately tighten the main tension spring screw
Carton is blocked	Main tension spring is too tight	Adjust the main tension spring
	Tape roller adjustment nut is too tight	Adjust the adjustment nut
	Improper adjustment of drive unit and carton height and width	Re-adjust the height and width of the drive unit
Tape is broken or cut off while sealing carton	Too high position of blade	Lower the position of blade
Carton deviation and box cover angle after sealing	Carton is not pushed	Before the box is folded, the box leaves on both sides should be aligned with the box to be pushed into the box sealing machine
Too long tape leg	Shorten the installation position of the blade adjustment block and the blade holder bending plate	See 5.4 Adjustment of tape length



Too short tape leg	Lengthen the installation position of the blade adjustment block and the blade holder bending plate	See 5.4 Adjustment of tape length
Tape adheres to carton in too loose	Tension spring on tape head is too weak	Adjust the position of the main tension spring to increase the spring force

## 7.2 General faults and troubleshooting

Problem	Reason	Solution
The machine does not start	Power switch is damaged	Replace the power switch
	Loose wires	Rewiring
Drive belt does not turn	No power	Check the power supply
	Reducer motor damage	Replace the reduce motor
	Reducer motor capacitor damage	Replace the capacitor
	Bearing damage	Replacement bearing
	Toothed conveyor belt is damaged	Replace the toothed belt with damage
	Toothed conveyor belt is too loose	Adjust the tension of the tooth surface conveyor belt

## 8. Circuit Diagram

