



Carton Sealer

Model: CS-6050

Distributed By:

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Preface

Thank you for purchasing our CS-6050 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.
- All rights reserved by the manufacturer. No part of the manual may be reprinted without written permission.

1. Description

1.1 Product application

CS-6050 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. If it can be used reasonably according to this instruction, it will have many years of trouble-free working time.

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. It can also complete the action of top and bottom sealing box at the same time. Three-sided drive packing machine, generally suitable for heavy 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	CS-6050
Voltage (V/Hz)	AC 220/50,110/60
Power (W)	200
Max. Carton Size (W x H x L) (mm)	500×500×∞
Min. Carton Size (W x H x L) (mm)	180×130×130
Sealing Speed (m/min)	20
Height of Table (mm)	635-780
Width of Adhesive Tape (mm)	48/60/76
Used Adhesive Tape	BOPP, water-free adhesive tape, PVC adhesive tape
Conveying Form	Drive by two sides conveying belts
Dimension (L×W×H) (mm)	1755×800×(960 to 1650)
Net Weight (kg)	150
Maximum Outside Diameter of Adhesive Tape (mm)	250

1.3 Product feature

- This machine is very convenient to use. After adjusting the size of the sealing box, the device can complete the sealing action only by pushing the carton in.
- Seal box size adjustment range is wide, suitable for various specifications of carton packaging.

1.4 Working principle

After folding the carton blades, the carton is pushed into the sealing machine, driven by parts up and down, and the carton is sealed by the upper and lower sealing head mechanism.

1.5 Major components

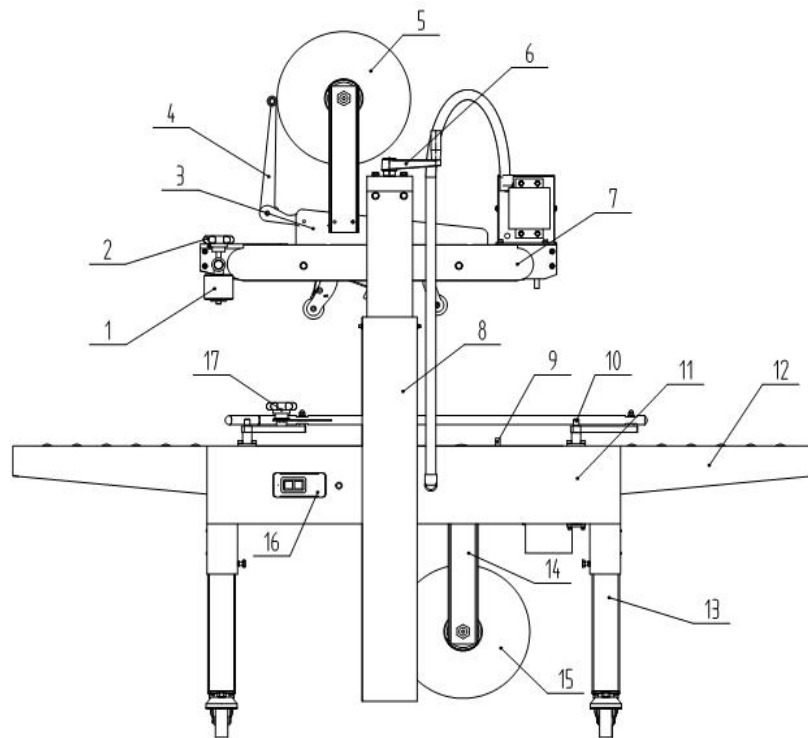


Fig 1-1

No	Part Name
1	Side roller
2	Side press wheel adjusting handwheel
3	Top seal head
4	Long handle arm assembly
5	Upper tape
6	Lift adjusting handle
7	Upper drive part
8	Column assembly
9	Lower drive part
10	Left and right guide rod
11	Frame
12	Front and rear brackets
13	Scaffold assembly
14	Lower seal head
15	Lower tape
16	Power switch
17	Guide rod adjusting handwheel

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:



DANGER!

Ignoring this safety precaution will lead to serious and even fatal injury accidents.



Warning!

Ignoring this safety precaution will lead to serious and even fatal injury accidents.



Look out!

Ignoring this safety precaution will result in personal injury or property loss.

2.3 Using environment

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

3. Movement and Machine Downtime

3.1 Wooden package

If the machine is packed with wooden case with foam protection.

- Take out the foam from the 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 put away the power cord.

If possible, place a plastic bag over 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 poor (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 remove the power cord.
- 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.

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.

Make sure there is enough space to replace the tape or replace the wear parts.

4.3 Foot stand assembly and height adjustment

- Loose the cotter pin of hinge pin to pull it out, after adjusting the height of foot stand assembly, insert the hinge pin back. Then adjust the machine's level through regulating the pedal plate assembly.
- Adjust the machine's height and level through rotating the bolt of the pedal plate assembly if the adjustment is in small range.

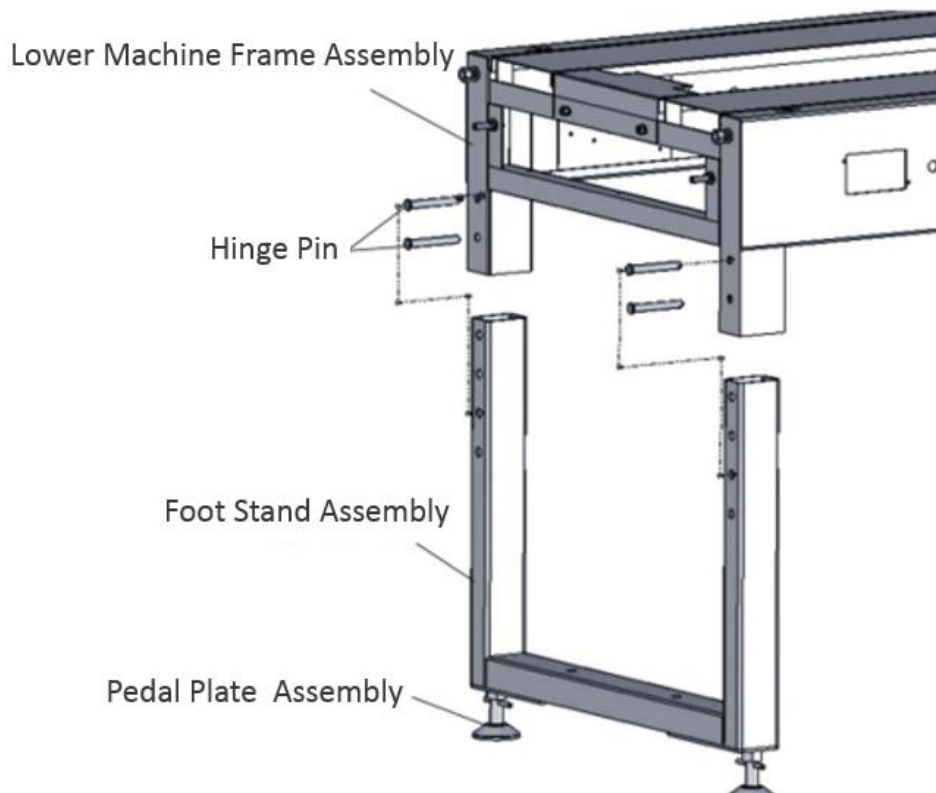


Fig 4-1

4.4 The installation of front and rear bracket assembly

- Install front and rear bracket assembly on machine frame and use M10 nut and washer to fix it on upper two screws. Use screw , washer and nut to tighten.

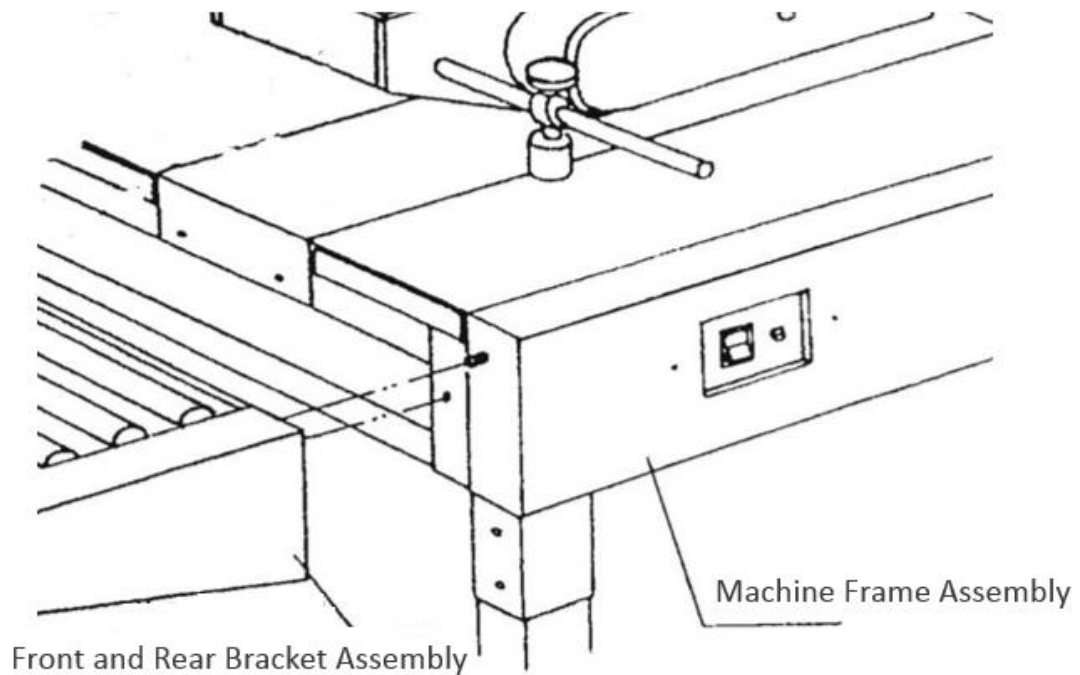


Fig 4-2

4.5 The installation of Long-arm assembly and tape roll support assembly

- Respectively demount the Hexagon socket head cap screw ④、⑤, long-arm assembly③ and tape roll support assembly② and install in relevant position of sealing head① as below picture shows, then tighten up Hexagon socket head cap screw ④、⑤.

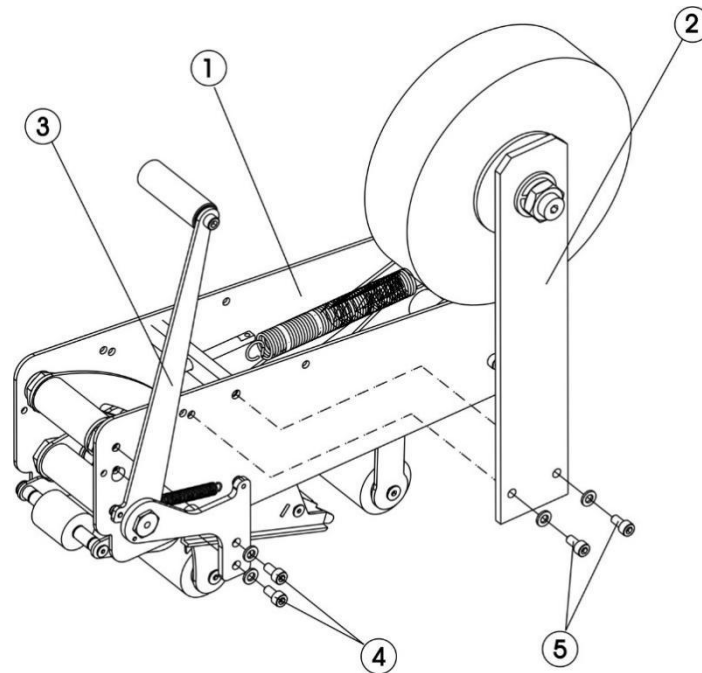




Fig 4-3

4.6 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.

4.7 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, 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 any)
- 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.

If it is necessary to change 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 ! Danger of getting hurt due to mechanical components !

Be careful of the blade to cut the tape!

Be careful of getting clamped by driving gears.

- 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, please 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 feeding

- Secure the tape roll on the tape roller before turning on the machine.
- Pull out the tape by passing the copper roller, then the tension roller, the copper wheel, and finally the pressing plate and the front rubber wheel.
- Note: The sticky side should face outward.

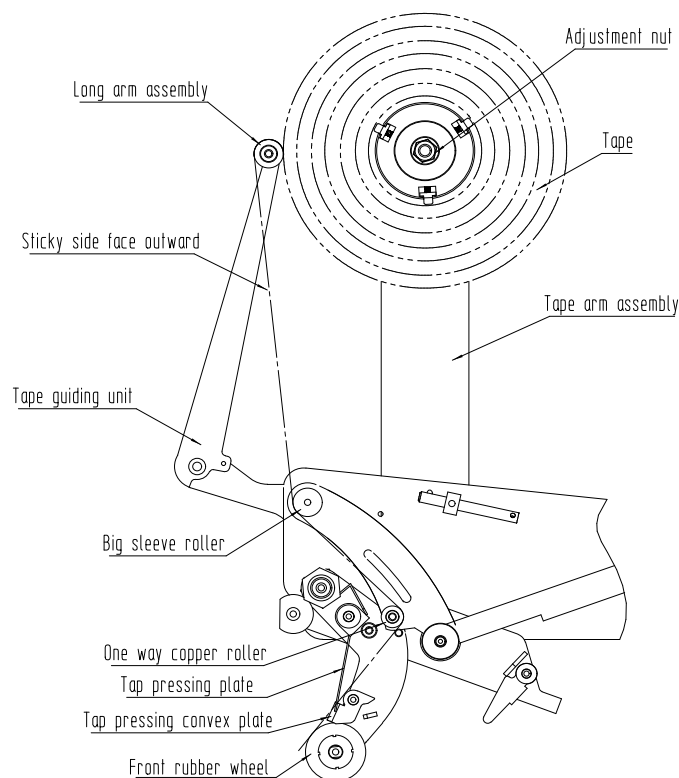


Fig 5-1 Tape feeding route

5.2 Adjustment of tape location (as per picture)

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

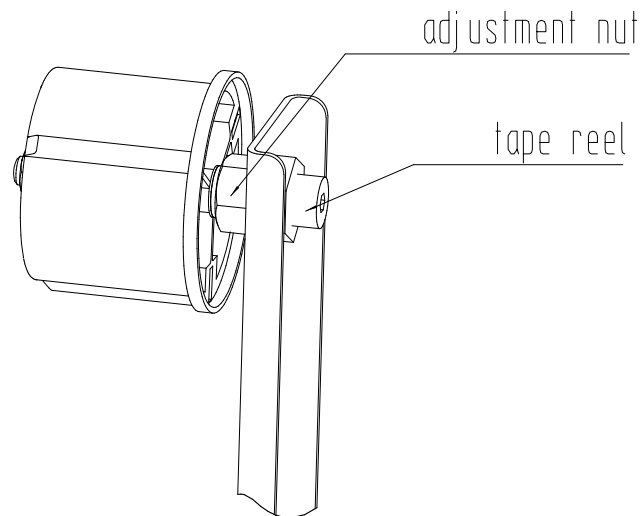


Fig 5-2

5.3 Adjustment of tape tension

- Turn the adjustment nut to make sure the tape roll speed is moderate
- Turn clockwise the adjustment nut to intensify the tape tension, vise loosen the tension
- Adjust the position of the nut on the main pull reed to adjust the pressure of the rubber roller to the tape

5.4 Gear motor

- The gearbox is filled with long-life anti-wear grease, no need refueling, oil change or maintenance.

5.5 Start up

- Start the machine by turning on the "power switch" and the power switch is on the machine frame.
- Press the power switch to ON and start the machine. Press the power switch to OFF, the machine will stop.

5.6 Standard operation procedures

- Adjust the width of guiding bar with a handwheel, make sure that the width of the two guide bars is around 1mm smaller than the width of the carton.
- Adjust the height with a handwheel, the distance from the front opening of the upper sealing head to the rollers on the working table should be around 4mm smaller than the height of the carton.
- Press the power switch to start the machine.
- Place and push the folded carton forward to the upper and lower conveyor belt.
- If necessary, press the OFF button to completely stop the machine.
- Repeat the cycle again.

5.7 Requirement for the carton

- The outer layer of the carton should not be plastic material.
- The carton must keep 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.

5.8 Requirement for the tape

- Please use tape with correct width ONLY.

6. Machine Maintenance



Warning ! Danger of electric shock!

The power must be completely disconnected before servicing the machine.

In order to extend the 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 does not exceed 4 hours per day, a complete maintenance once every year (depending on location, environment and product). However, some small maintenance work that the user can be responsible for, must be carried out frequently. The following is an overview of these activities.

- **Complete power outage 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, resulting in the failure or damage of the machine, the manufacturer will not assume the relevant responsibilities.**

6.1 Standard maintenance schedule

Time	Maintain Content
Every Day	Pay attention to cleaning the cutting blade residue after the machine is used up.
Every Week	Screws and gears are lubricated every week.
Every Two Months	Lubricate the various transmission parts on the sealing head every two months. Check all the screws and nuts every two months. If it is loose, tighten it in time.
Every Six Months	Change the cutting blade at least once every six months.
Every Year	Replace the toothed conveyor belt.

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 table.
- The power cord should be kept from rolling and should be wound when not in use.
- Turn off the power before repairing and adjusting the unit.
- The blade must be cleaned and lubricated before use.

7. Troubleshooting

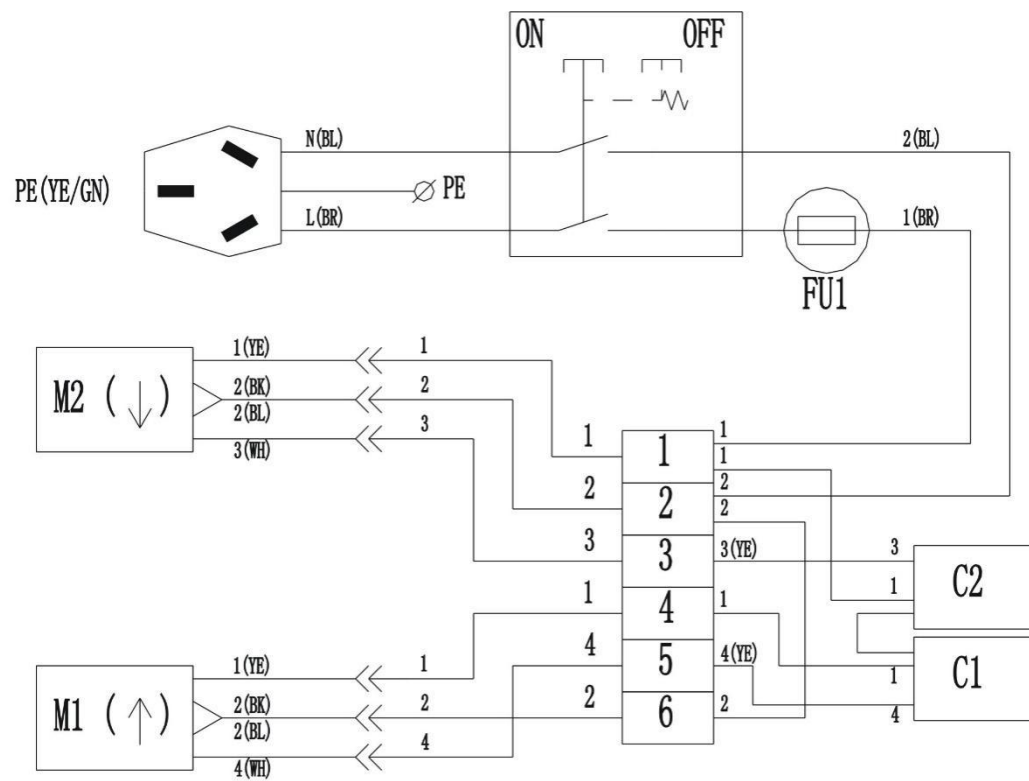
7.1 Sealing head failure and elimination

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	Too low the position of blade	Rise the position of blade
Too short tape leg	Too high the position of blade	Lower the position of blade
Tape adheres to carton in too loose	Tension spring on tape head is too weak Friction of tape roller is lessened after dozen times of tape sealing operation	Adjust the friction of the tape mount

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
	Geared motor damage	Replace the geared motor
	Chain shedding	Reinstall the chain
	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
Machine alarm	Carton stuck	Take out the carton

8. Circuit Diagram



CS-6050 SEMIAUTOMATIC CARTON SEALER
Breakdown Drawing of Knife Rest Unit in Tape Head

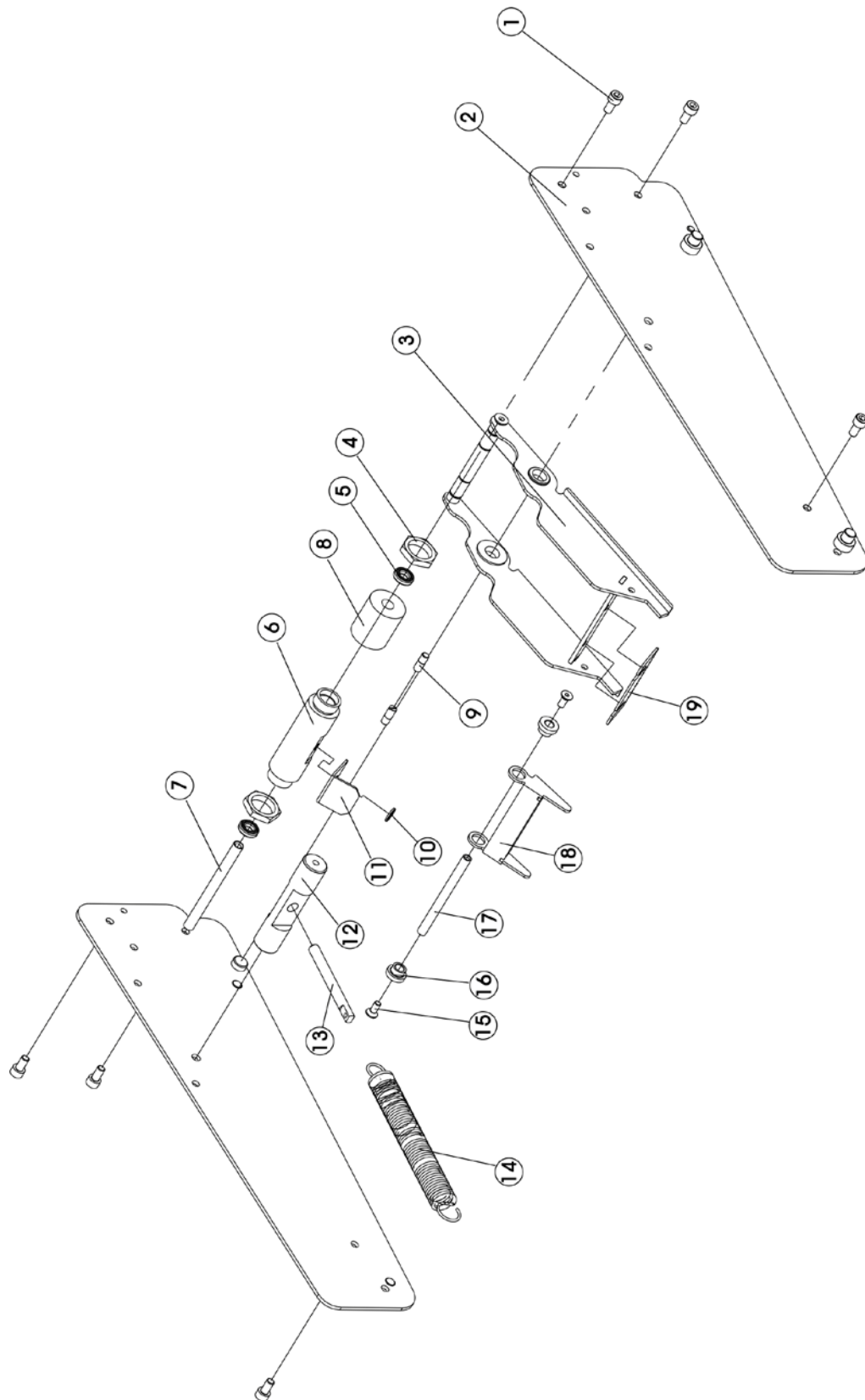


Figure 1

[illegible]

Breakdown Drawing of Roller Unit in Tape Head

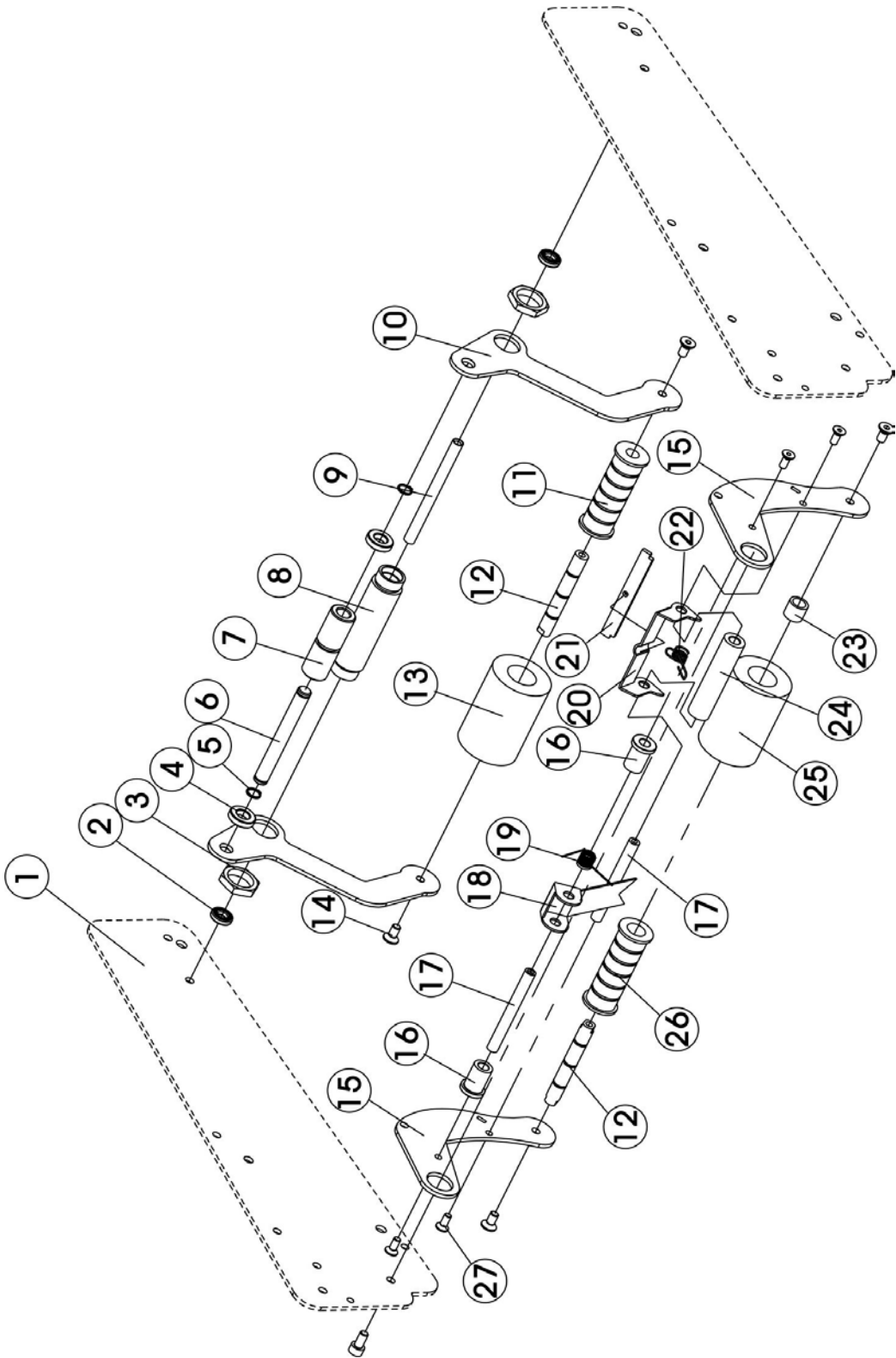


Figure 2

Item	Part number	Quantity	Description	Remark
2-1	521019	2	clamp plate assembly	bilateral symmetry
2-2	935600-8	2	628/8-2Z bearing	8X16X5
2-3	521007	2	jam nut	
2-4	521008	2	cover	
2-5		2	Φ10 circlip for shaft	
2-6	521020	1	tension spring shaft	
2-7	521009	1	tension spring housing	
2-8	521021	1	shaft sleeve of rear plate	
2-9	521006	1	chord axis	
2-10	521034	2	small backing plate	bilateral symmetry
2-11		1	iron core of rear rubber roller	
2-12	521005	2	shaft	
2-13	521024	1	rear rubber roller	
2-14		2	M6X10 sunk screw	
2-15	521022	2	C-shaped plate assembly	bilateral symmetry
2-16	910631-01	2	shaft sleeve	
2-17	521041	1	shaft	
2-18	521037	1	backup plate	
2-19	936430.8-11	1	torsional spring	
2-20	521042	1	flange	
2-21	521044	1	plate for torsional spring	
2-22	936431-11	1	torsional spring	
2-23		1	HF1012 unilateral bearing	
2-24	910631-02	1	bush	
2-25	521023	1	front rubber roller	
2-26	521041	1	iron core of front rubber roller	
2-27		1	M5X10 sunk screw	
2-28		1		
2-29		1		
2-30		1		
2-31		6		

Note: Item 27 and 29 are welded together.
Item 11 and 13 are welded together.

Breakdown Drawing of Sleeve Unit in Tape Head

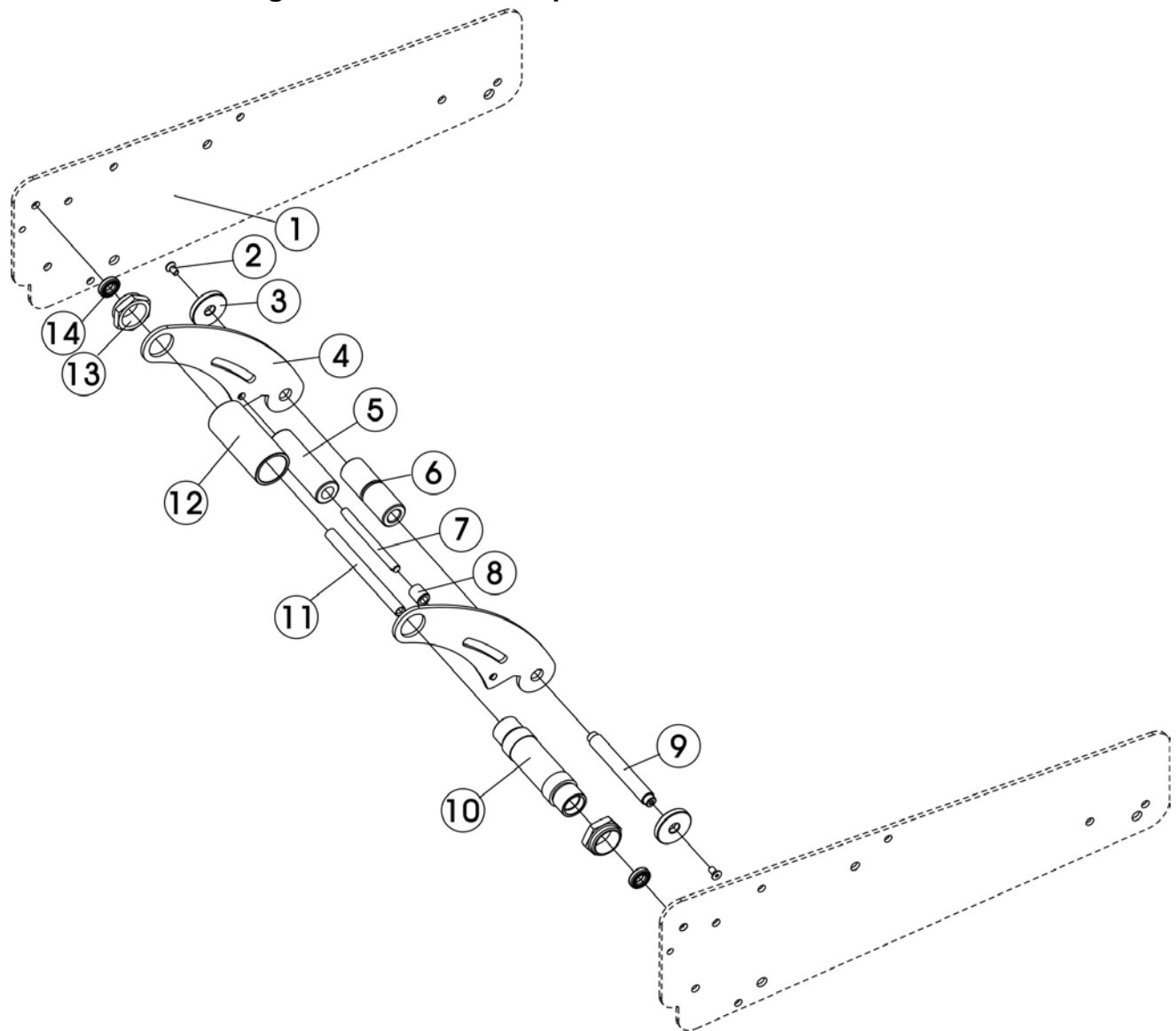


Figure 3

Item	Part number	Quantity	Description	Remark
3-1	521019	2	clamp plate assembly	bilateral symmetry
3-2		2	hexagon socket cap head screw	M4X10
3-3	521012	2	copper wheel	
3-4	521014	2	arc-shaped plate	
3-5	521018	1	retaining copper bush	
3-6	521009	1	tension spring housing	
3-7	521013	1	shaft of retaining copper bush	
3-8		1	HF0612 unilateral bearing	
3-9	521011	1	shaft	
3-10	521017	1	inner shaft sleeve	
3-11	521006	1	chord axis	
3-12	521015	1	large sleeve	
3-13	521016	2	stepped nut	
3-14		2	628/8-28 bearing	8X16X5

Breakdown Drawing of Upper Tape Head

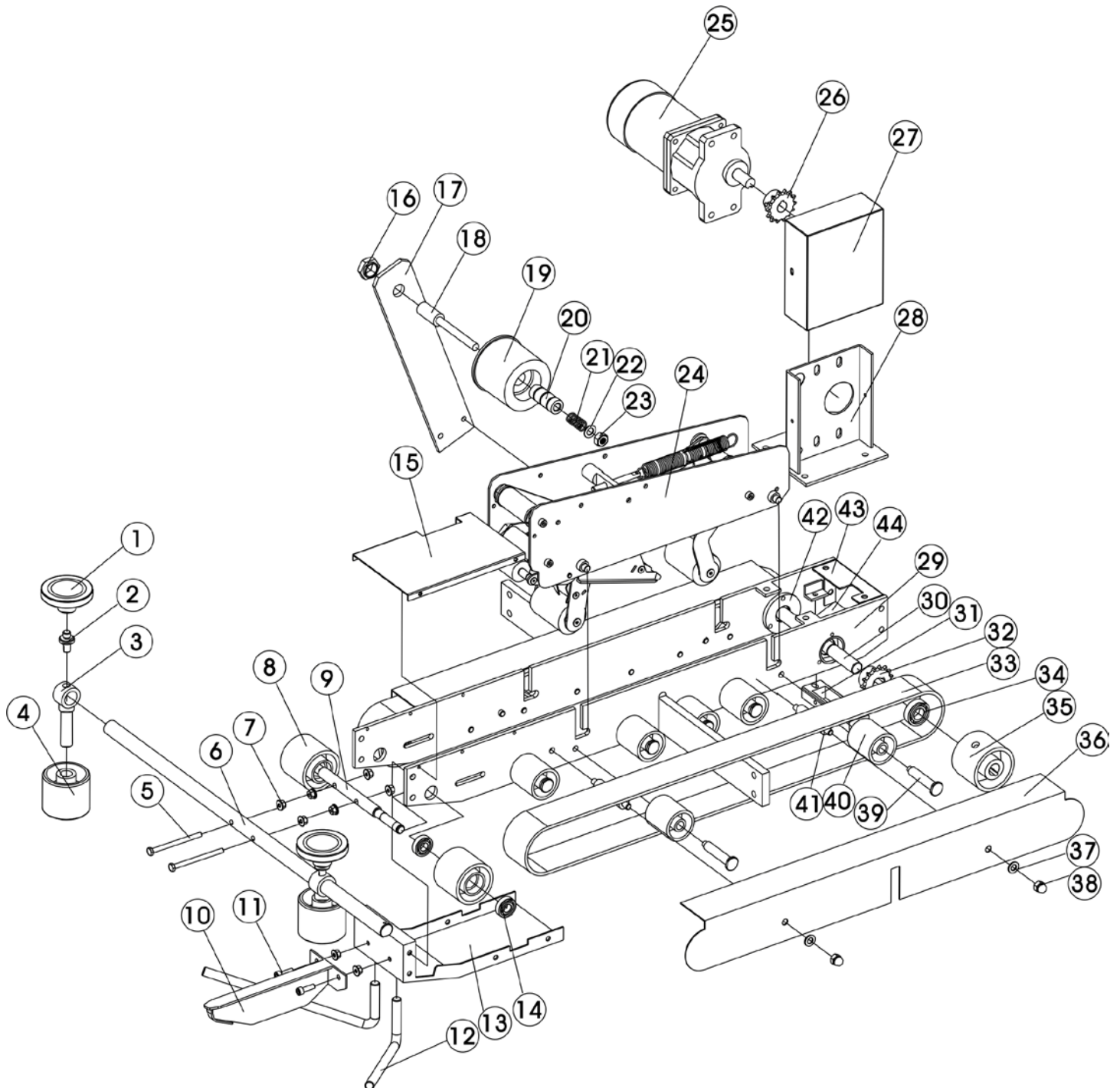


Figure 4

Item	Part number	Quantity	Description	Remark
4-1	521203	2	width knob	
4-2	521204-2	2	pin	
4-3	521512	2	upper guide wheel shaft assembly	
4-4	521504	2	guide nylon wheel	
4-5		2	tension bolt M6	full thread
4-6	521503	1	long rod	
4-7		6	M6 flange nut	
4-8	521304	2	front roller	
4-9	521303	1	front shaft	
4-10		1	flap fold sheet	
4-11		2	bolt	
4-12	521507	2	guide rod	
4-13		1	front clamp plate assembly	
4-14	935601-01	2	6001-28 bearing	12X28X8
4-15		1	front cover plate	
4-16		1	hexagon nut	M18X1.5
4-17	521321	1	tape roll plate	
4-18	521325	1	tape roll shaft	
4-19	521322	1	tape roller assembly	
4-20		1	mandrel	
4-21	936411.6-14.4	1	small pressure spring	
4-22	521323	1	small washer	
4-23		1	hexagon nut	M10
4-24	F52101-3	1 set	upper tape head assembly	
4-25	921032	1	reducing motor	5RK90GU-CF 15GS15-K
4-26	521320	1	sprocket of upper motor	
4-27		1	upper reducer cover	
4-28		1	upper reducer holder	
4-29		2	clamp plate assembly	bilateral symmetry
4-30	521305	1	rear shaft	
4-31	521301	1	brush-retaining bracket	
4-32	521302	1	sprocket (Z=15)	
4-33	910741-11B	2	transmission belt 1368X50 conveyor belt	black
4-34		2	6003-2Z bearing	17X35X10
4-35	521309	2	rear roller	
4-36		2	cover of upper transmission belt	bilateral symmetry
4-37		2	Φ6 washer	Φ8

4-38		2	cap nut	M8
4-39	521308	12	transmission roller shaft	
4-40	521307	12	transmission roller	
4-41	521501	4	shaft	
4-42	521306	2	end cover of rear shaft	
4-43		1	rear clamp plate assembly	
4-44		1	small cover plate	
4-45	939115	1	brush	

Note: Item 19 and 20 are welded together.

Breakdown Drawing of Bottom Tape Head

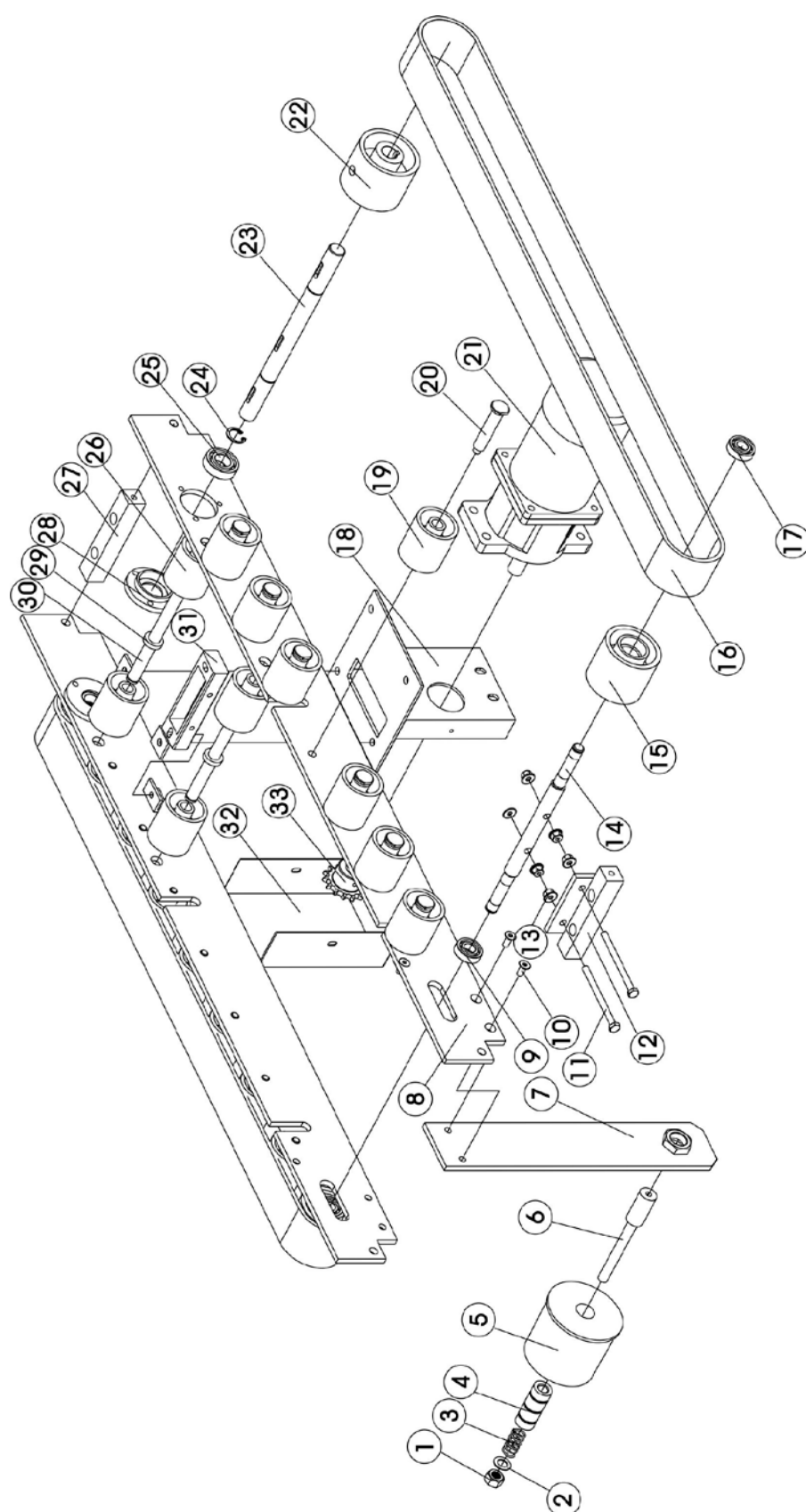


Figure 5

Item	Part number	Quantity	Description	Remark
5-1		1	M10 hexagon nut	M10
5-2	521323	1	washer	
5-3	936411.6-1414	1	small pressure spring	
5-4	521322	1	mandrel	
5-5		1	tape roller	
5-6	521325	1	tape roll shaft	
5-7	521321	1	tape roll plate	
5-8		2	clamp plate assembly	bilateral symmetry
5-9		2	6001-2Z bearing	12X28X8
5-10		2	M6 sunk screw	
5-11		2	tension bolt	M6X1 full thread
5-12	521317	1	front mounting block assembly	
5-13		6	M6 hexagon flange nut	M6
5-14	521303	1	front shaft	
5-15	521304	2	front roller	
5-16	910741-12B	2	1565X50 conveyor belt	black
5-17	935601-01	2	6001-2Z bearing	12X28X8
5-18	521314	1	bottom reducer holder assembly	
5-19	521307	22	transmission roller	
5-20	521308	14	shaft of transmission roller	
5-21	921032	1	speed reducer	5RK90GU-CF1 5GS15-K
5-22	521309	2	rear roller	
5-23	521305	1	rear shaft	
5-24		2	circlip for shaft	17
5-25		2	6003-2Z bearing	17X35X10
5-26			(same as item 5-19)	
5-27		1	rear mounting block	
5-28	521306	2	end cover of rear shaft	
5-29		2	set collar of middle shaft	
5-30	521310	2	middle shaft	
5-31	521301	1	brush-retaining bracket	
5-32		1	cover of bottom reducer	
5-33	521320	1	sprocket of upper motor (Z=14)	

Breakdown Drawing of Rack Assembly & Upright Post Assembly

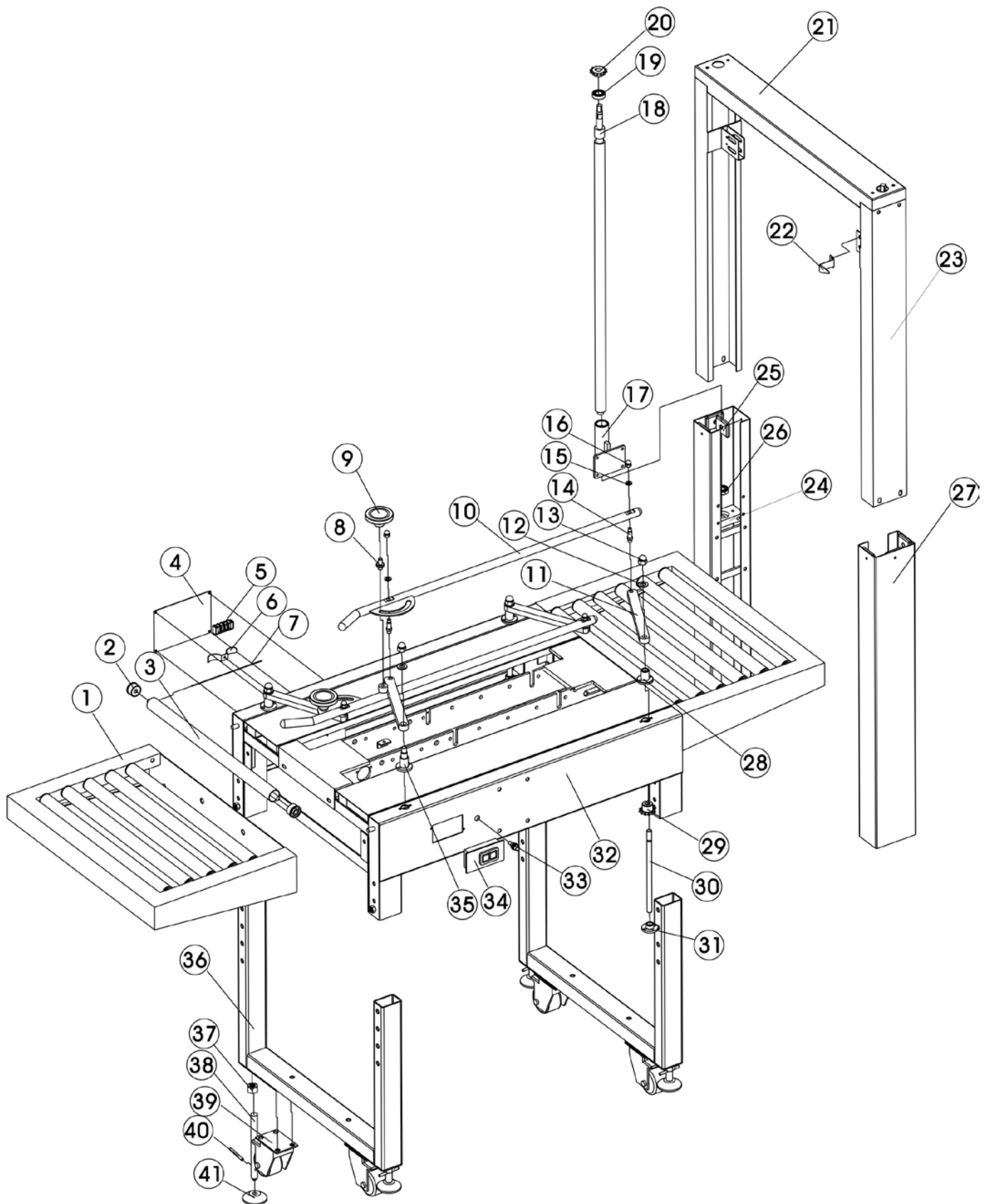


Figure 6

Item	Part number	Quantity	Description	Remark
6-1		2	bracket	
6-2		24	end cover of roller	
6-3	521606	12	aluminum roller	
6-4		1	cover of electric cabinet	
6-5		1	connecting terminal	
6-6		1	clamp of capacitor	
6-7	936491.5-210	4	spring	
6-8	521204	2	pin	
6-9	521203	2	width knob	
6-10	521201	2	bottom guide rod assembly	
6-11	521207	2	rear cross arm	
6-12		4	Φ12 washer	
6-13		4	M12 cap nut	
6-14	521202	4	pin roll	
6-15		4	Φ10 washer	
6-16		4	M10 cap nut	
6-17		2	holder of elevating screw mandrel	
6-18	521406	2	elevating screw mandrel	
6-19		4	6002-2Z bearing	15X32X9
6-20		2	sprocket of upright post	
6-21		1	upper cross beam	
6-22		1	pointer	
6-23		2	inner upright post assembly	
6-24	521411	4	upper block of upright post	
6-25		4	lining board of upright post	
6-26			6002-2Z bearing	
6-27		2	outer upright post assembly	
6-28	521208	2	holder of rear cross arm	
6-29	521210	2	width sprocket (Z=12)	
6-30	521209	2	straight sprocket shaft	
6-31	521215	2	sprocket seat	
6-32		1	bottom rack assembly	
6-33	920469	1	fuse socket (RH1-20)	
6-34	920548	1	power switch	TBSY-315
6-35	521206	2	holder of front cross arm	
6-36		2	support	
6-37		4	nut	

6-38	521101	4	fang bolt	
6-39	910205-2	4	caster	black
6-40		4	straight pin	
6-41	521102	4	foot plate	