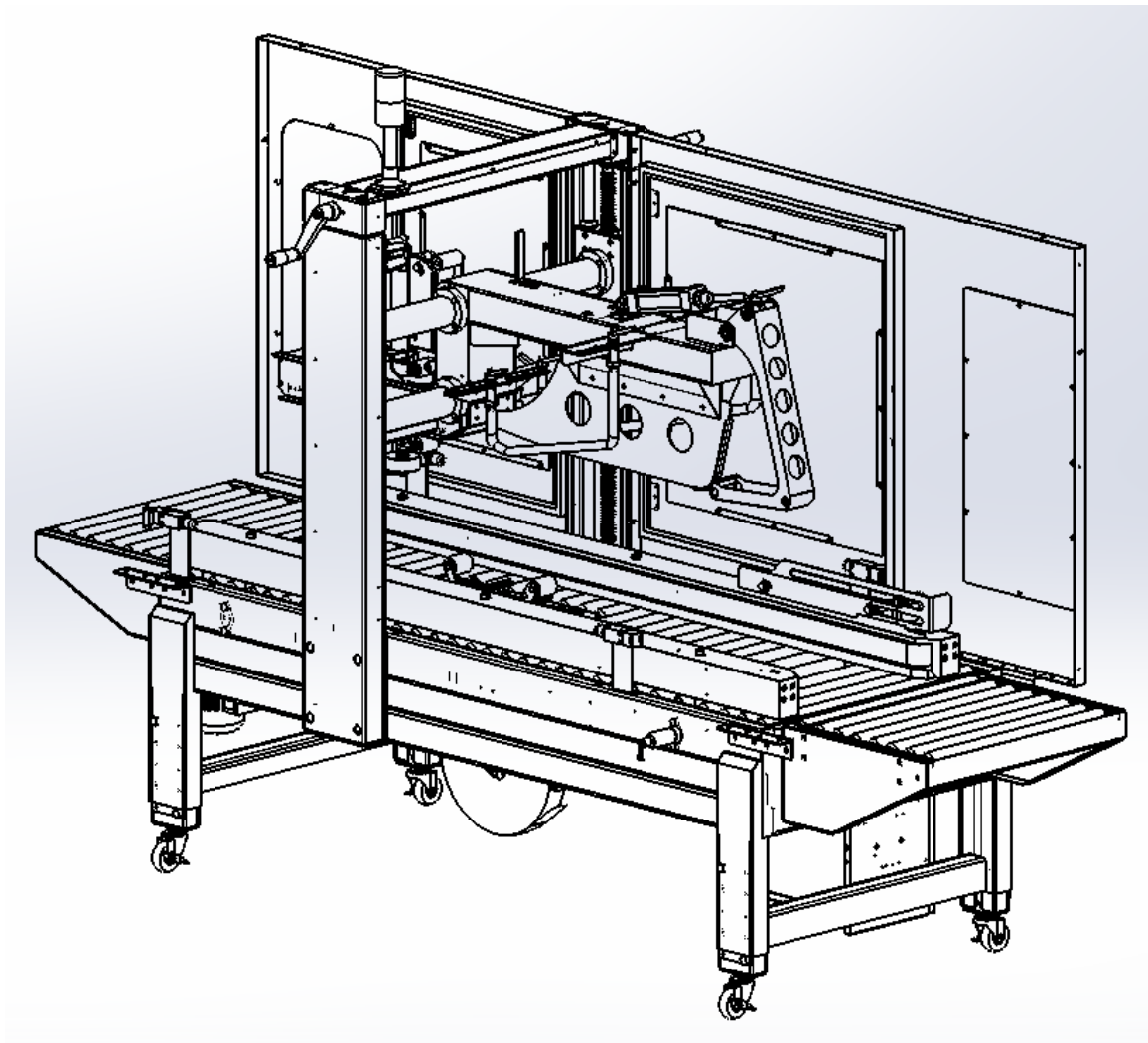




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CARTON SEALER 2-GPEXC-138SDF AND TAPE HEAD 2-GPEXC-101



OPERATION MANUAL

2025-10-16



EC Declaration of Conformity

According to the following EU Directives:

- Machinery Directive: 2006/42/EC
- Electromagnetic Compatibility Directive 2014/30/EU

We,

Declare that the machines mentioned hereafter:

◎**Product: Carton Sealing Machine**

◎**Model: EXC-138SDF**

◎**Serial No.:**

◎**Functions: They are designed and manufactured to be used for sealing of carton**

The person who compile technical file established within the EU:

Name: SGS UK

Address: SGS United Kingdom Rossmore Business Park, Ellesmere Port, Cheshire CH65 3EN

They are designed and manufactured in compliance with the essential health and safety requirements of the Machinery Directive and Electromagnetic Compatibility Directive, and are based on the following European harmonized standards:

- EN ISO 12100: 2010 / Safety of Machinery - General principles for design / Risk Assessment and Risk reduction
- EN 60204-1:2016/ Safety of machinery - Electrical equipment of machines - Part 1: General requirements
- EN 415-3:1999+A1:2009 / Safety of packaging machines - Part 3: Form, fill and seal machines
- EN 415-10:2014 / Safety of packaging machines - Part 10: General Requirements
- EN ISO 13849-1:2008/AC:2009 /Safety of machinery — Safety-related parts of control systems Part 1: General principles for design
- EN 61000-6-2:2005 / Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments
- EN 61000-6-4:2007/A1:2011 / Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments.

Authorized representative in European Community: (if applicable)

Representative _____
: *Robert Lai / President*

Place / *Taichung City, Taiwan. / September 22, 2020.*

Date :

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1. GENERAL SAFETY INSTRUCTIONS

1.1 Basic Operation

- The manual and the safety remarks are to be read before use. The operator manual should be kept with the machine at all times. Intervals for maintenance and inspections are to be adhered to.
- This machine was built with state of the art technology and rigid adherence to safety standards.
- Unless used properly, it can cause injury to operators or persons in close proximity to the machine. In addition, improper use can cause damage to the machine or property around the machine.

1.2 Basic Safety Precautions

- The user is to be instructed in all other generally applicable legal and other mandatory regulations relevant to accident prevention and environmental protection in addition to the operating instructions.
- For safety reasons, long hair must be tied back or otherwise secured, garments must be close fitting and no jewelry may be worn.
- Use protective equipment whenever required by circumstances or by law.
- Carefully observe all safety instructions and warnings attached to the machine and make sure that they are always complete and perfectly legible.
- Always make certain that persons being trained and instructed in working on or with the machine are permanently supervised by an experienced person.
- Work on the electrical system and equipment of the machine is only to be carried out by a skilled electrician or by persons under the supervision and guidance of a skilled electrician and in accordance with the rules and regulations of electrical engineering.



1.3 Safety Instructions Governing Specific Operational Phases

- Avoid any operation mode that might be unsafe.
- All necessary precautions to ensure that the machine is only used being in a safe and reliable state are to be taken. The machine is only to be operated if all protective and safety devices, including removable safety devices, emergency shut-off equipment, noise-protection elements and exhaust systems are in right place and fully functional.
- The machine is to be checked for damage and defects at least once per work shift. Any changes including the working behavior of the machine are to be reported to competent persons immediately. If necessary, the machine is to be stopped and locked immediately.
- In case of any malfunction the machine must be stopped and locked until the defect has been eliminated.
- Generally make sure that nobody is at risk before starting up the machine.
- All personnel that will be operating this machine should be thoroughly trained in all phases of operation and safety.
- Always tighten unscrewed connections after maintenance and repair.
- After completing maintenance and repair all safety devices removed for setting up or repairing the machine must be reinstalled and checked for functionality prior to putting the machine back into service.
- To minimize the environmental impact all consumables and replaced parts must be disposed of safely.
- Before starting the machine check that the accessories have been stowed away safely.
- Do not attempt any operation that may be a risk to the stability of the machine.



2.1 Warning of Electrical Dangers

- Immediately remove power to the machine in case of trouble in the electrical system.
- Replace a fuse with one with the same style and ratings; pay particular attention to matching the specified current.
- Any electrical work performed on the equipment must be conducted by a skilled electrician or under the supervision of a skilled electrician. All work must be observed good electrical engineering practice and follow safety rules and local wiring standards.
- Inspect the electrical equipment of the machine at regular intervals. Tighten any loose connections. Check wiring for scorch marks; replace scorched wiring and determine and correct the reason for the overheating.
- When working on live equipment, ensure that a second person is available to cut power in case of an emergency. When appropriate, secure the working area with safety tape and a warning sign. Use insulated tools for electrical work.
- Before working on high-voltage assemblies, turn off the power supply. Carefully discharge the supply cable and short-circuit any energy-storage components such as capacitors.
- If the equipment was moved, carefully refit and refasten all parts removed for transport before reapplying power.
- Before moving the machine, remember to disconnect the power cable.

3.1 Grounding Instructions Shall Include the Following

- This product must be grounded. In the event of an electrical short circuit, grounding reduces the risk of electric shock. This product is equipped with a cord that has a grounding wire and an appropriate grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.
- If repair or replacement of the cord or plug is necessary, connect the ground wire to the ground terminal of the plug. The wire with green insulation (with or without yellow stripes) is the grounding wire.
- Check with a qualified electrician or service person if the grounding instructions are not clear or if in doubt about the proper grounding of the machine. Do not modify the plug provided; if it will not fit the power outlet, have the proper outlet installed by a qualified electrician.
- This product is designed for use on a nominal AC circuit and has a grounding plug.

DANGER!

Improper installation of the grounding can result in electrocution.

4.1 Before Operating

- Verify that the power line voltage is correct.
- The machine must be properly grounded to avoid a shock hazard. All wiring must be in accordance with local wiring standards.
- The Carton Sealing machine can only be operated with OPP tape.

4.2 During Operation

- The size of the package should be under dimension in specification list.
- While running, check the unit for any unusual sounds or smoke emissions.
- Keep away from the moving part like belt and blade of tape head. Do not put your hands or body around belt or blade of tape head when the machine is running.

4.3 After operating

- Remove dust and dirt from the unit
- Turn off the power when the machine is not in use.

5.1 Signs

	Caution! Electric Shock Hazard.
	Caution! Hot Surface.
	Caution! Moving Parts Can Crush Hand.
	Caution! Pinch Point Entanglement
	Caution! Blade. Cutting of Fingers or Hand
	Wear Eye Protection
	Refer to Operator Manual

7. MACHINE INFORMATION

7.1 Areas of Application

Packaging Limitation

It's not possible to pack:

- Products larger or heavier than that allowed.
- Wet Products
- Flammable products
- Explosive products
- Agri-foodstuffs
- Pharmaceuticals
- Hazardous products

7.2 Environmental Information

The strapping machine shall be installed in the following conditions:

- Supply voltage: +-10% nominal supply voltage
- Source frequency: +-10% nominal frequency
- Ambient temperature: 5°C - 40°C (41°F-104°F).
- Relative humidity: not exceed 35~85%RH
- Please provide a suitable illumination around the machine for safety operation.

Conditions For Use

Make sure there is room for easy application and maintenance

The machine must be installed in a closed, well-ventilated area where there are no explosions or fire hazards Position the machine in a place free of humidity, flammable materials, gas or explosives. Make sure that it is level.

Please do not spray water or wet wipe machine body.

Noise - characteristic values

The noise emission values determined according to EN ISO 3746 for the sound power level or EN ISO 11202 for the sound pressure level at the workplace on the basis of the working conditions are as below:

A measurement uncertainty allowance of $K = 4 \text{ dB(A)}$ applies to the stated emission values.

Sound power level $L_{WA} = 88.7 \text{ dB(A)}$

Emission sound pressure level at the workplace $L_{PA} = 75.3 \text{ dB(A)}$

To minimize the emission sound pressure level, machine is equipped with a timer standby mode that can be adjusted by technician.

Demolition and Waste Disposal

The machine does not contain dangerous components or substances which require special disposal procedure. For that which concerns material elimination, comply with the Standards in the country where the machine has been disassembled.

7.3 Machine Description

This machine is automatically operated to close top flaps and sealing OPP tape onto carton boxes. The box will be driven into the machine by the transit belt system, and the tape head unit will tap tape onto box and then do sealing & cutting, at the same time kicker & center blade will close flaps on top of box. It is suitable for manual feed or automation line for single or continuous boxes with closing box and tape sealing to ensure the box is sealed well to avoid product falling off from the box.

7.4 Safety Devices

DANGER!

Operate the machine only when all safety devices are at their place and are functioning correctly.

The machine has been constructed in accordance with the applicable legal regulations.

The machine is reliable in operation. Nevertheless the machine may constitute a danger if it is operated in improper or undue condition.

Danger points that cannot be avoided due to equipment design are equipped with safety devices. If necessary, these points are marked on the machine with warning signs, and in

the manual under working safety instructions.

The machine is equipped with safety devices as:

- Warning labels
- Live parts are covered

The belt system operates at a very high speed (23 meters/min) to transit boxes into machine to offer good efficiency of box taping performance.

The tape head unit operates with high efficiency with tape tapping, sealing and cutting. The blade is sharp to be able to reach good cutting behavior.

The kicker unit operates with pneumatic control. After entrance sensor is activated, the kicker will automatically swing down in high speed in order to close flaps in time.

To prevent danger, avoid to touch the belt (1) and tape head (2) and reach into kicker operating area (3) when machine is running.

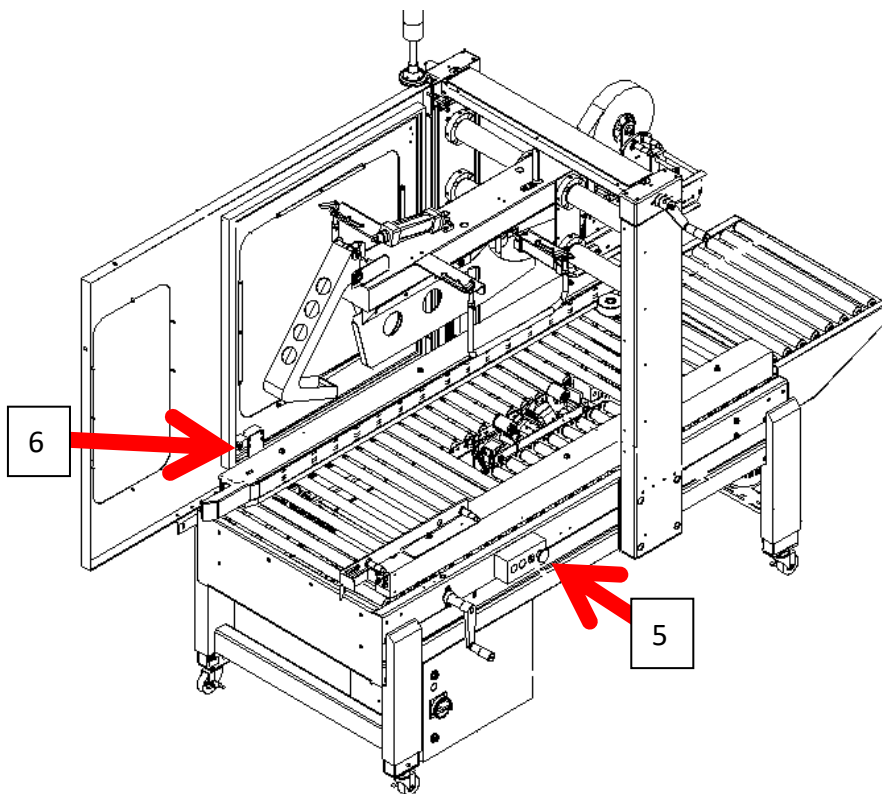
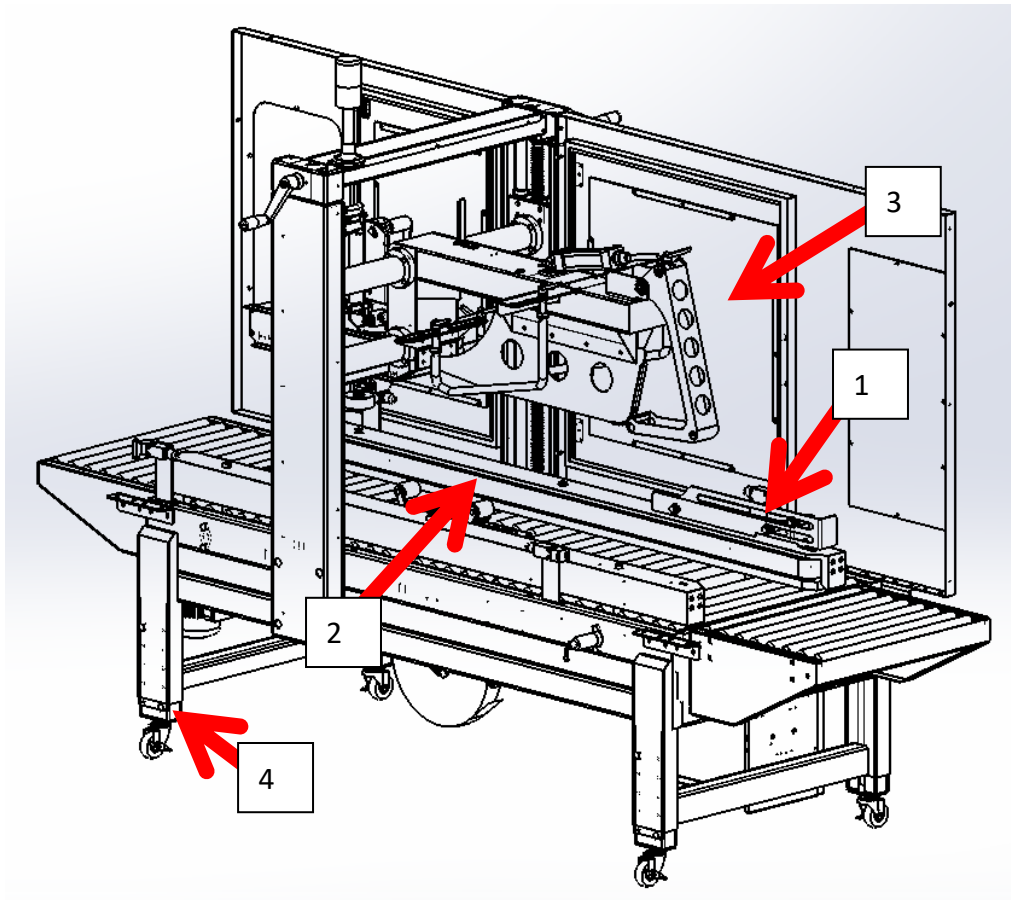
To remove jammed box or tape, ensure to press emergency stop or open safety switch lock firstly, and avoid to directly reach your hand into blade area though there is cover already cover around the blade area.

To move the machine, the four lockable casters (4) must be unlocked. Relock the four casters when the machine is in its new position.

In certain condition, you could press the emergency stop (5) or open doors (6) to release safety switch lock for safety.



Caution!



7.5 Technical Specification

7.5.1 Electrical Specification

System Configuration	L1+N+PE (GROUND)	3-Phase+PE (GROUND):220V 3-Phase+N+PE (GROUND):380-415V
Nominal Power	0.45kW	0.45kW
Rated Current	4.1/2.0/1.9 A	1.2A/0.7A/0.6A
Rated Voltage	110V/220-230V/240V	220V/60Hz, 380V/50, 60Hz 400V,415V/50Hz
Rated Frequency	50 /60Hz	50 /60Hz
Type of Current	AC- single phase	AC- Three phase

Air supply:

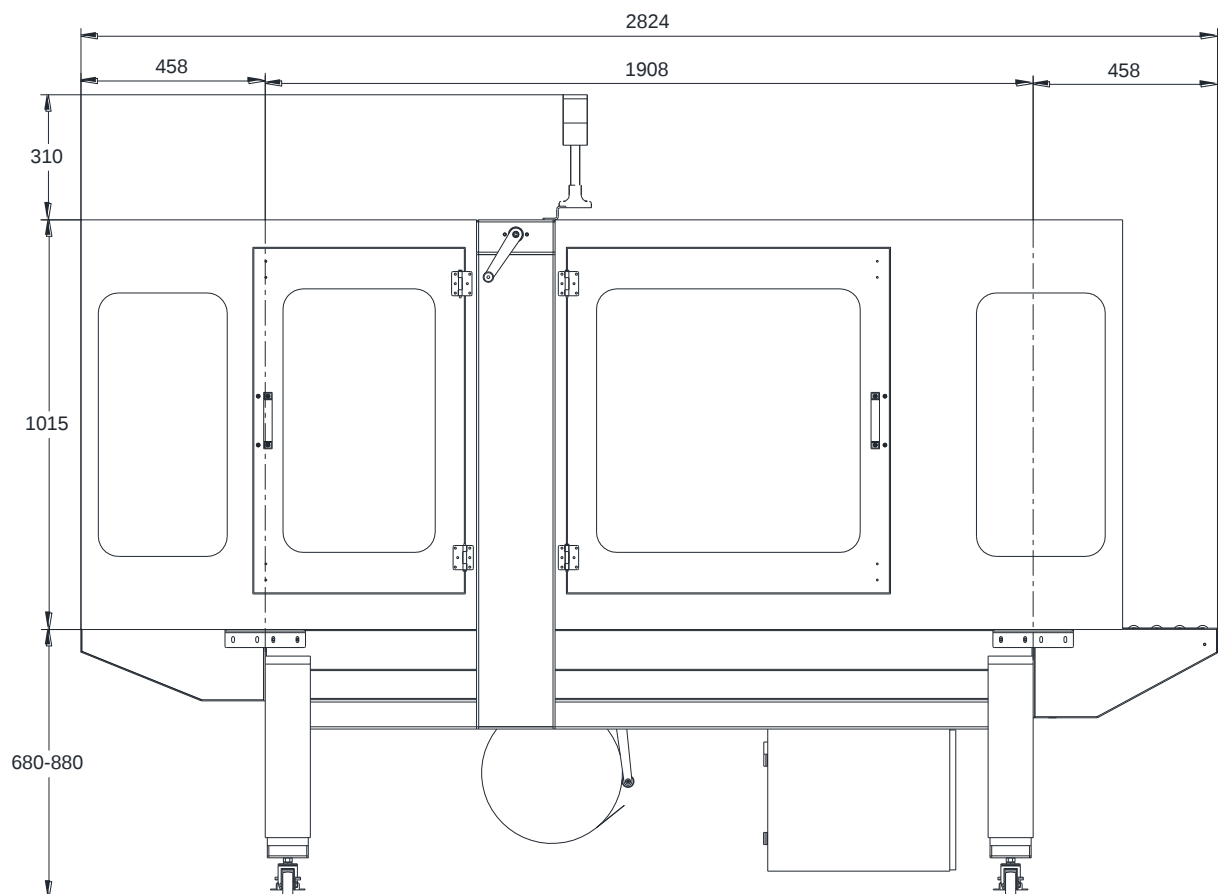
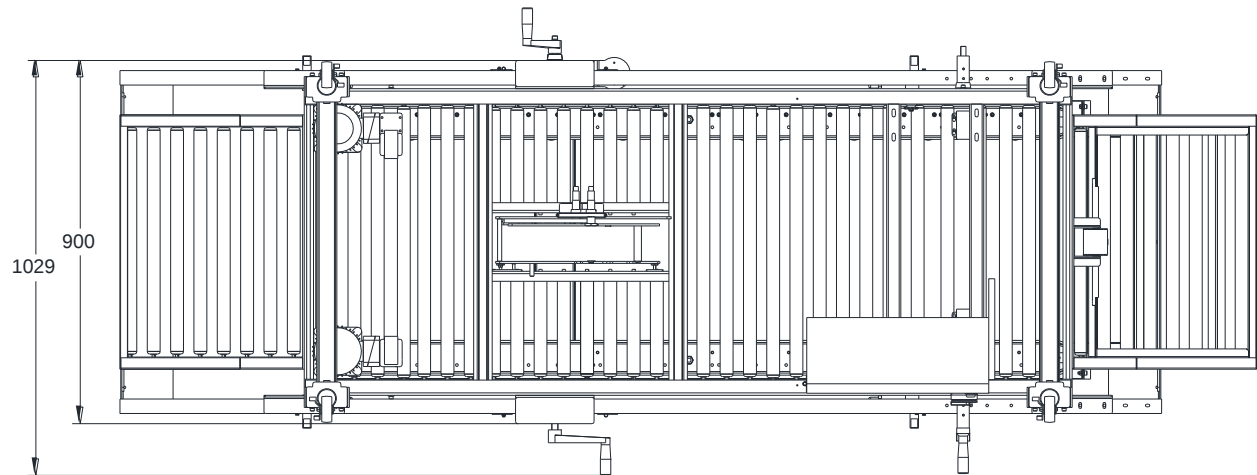
Air capacity 9960 cm²/min

Pressure setting 6 Kg/cm²

Inspect periodically to check if the drain system is functional & oil lubrication is needed.

7.5.2 Technical information

TAPE WIDTH	50 mm (2") as standard 36 mm (1.5") as option 75 mm (3") as option
TAPE LEG LENGTH	50 mm tape : 50 ± 5 mm 75mm tape : 60 ± 5 mm
TAPE CORE DIAMETER	76.2 mm
TAPE OUTER DIAMETER	356 mm (14")
BELT SPEED	23 meter/min
BOX CAPACITY	(MAX) L: 610mm W: 500mm H: 500mm (MIN) L: 120mm W: 110mm H: 120mm
BOX WEIGHT	0.5 Kg ~ 30 Kg
POWER CONSUMPTION	450 W
AIR CONSUMPTION	Max 76 l/min, 6Kgs
NOISE EMISSION	60 dB
AMBIENT TEMP.	5°C - 40°C
WORKING HEIGHT	680~ 880mm (adjustable)
MACHINE SIZE	1908mm(L) 900mm(W) 1681mm(H)
MACHINE WEIGHT	310Kgs
OPTION	3" tape head Safety guard (front / rear) Roller table (infeed / outfeed) Stopper (Index) mount on infeed table Tape low & out detector



8.1 Identification Data of the Machine

Each model is provided with a plate where it is easy to recover data which must be communicated to the manufacturer in case of problem or when requesting spare parts etc. This plate also carries electrical technical data for installation of the machine.

 EXTEND 20F, No. 309, Sec. 2, Taiwan Blvd., Taichung, Taiwan, R.O.C.			
CARTON SEALING MACHINE			
MODEL:	EXC-138SDF		
SERIAL:	C1701H016		
YEAR:	2017		
DOC. NO.	EXC-138SDF-01-A		
Volt	Hertz	Phase	Watt
230V	50Hz	1~	0.45kW
Ampere	Short Circuit Rating		Weight
2.0A	20A		310 kg

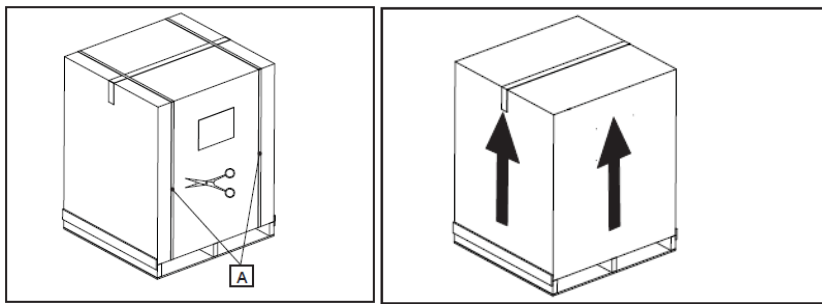
10. BEFORE OPERATING THE MACHINE

10.1 Shipping

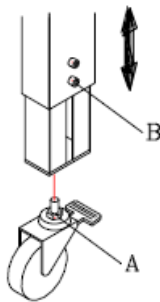
The machine is delivered as a transport unit. The machine is loaded onto a wooden pallet with Polyester strap secured. Outside with carbon box also with Polyester strap secured.

10.2 Unload Machine from Pallet & Installation

Cut Polyester strap and then move the carbon box upward.



Transport the machine with a fork lift truck to the operation position.

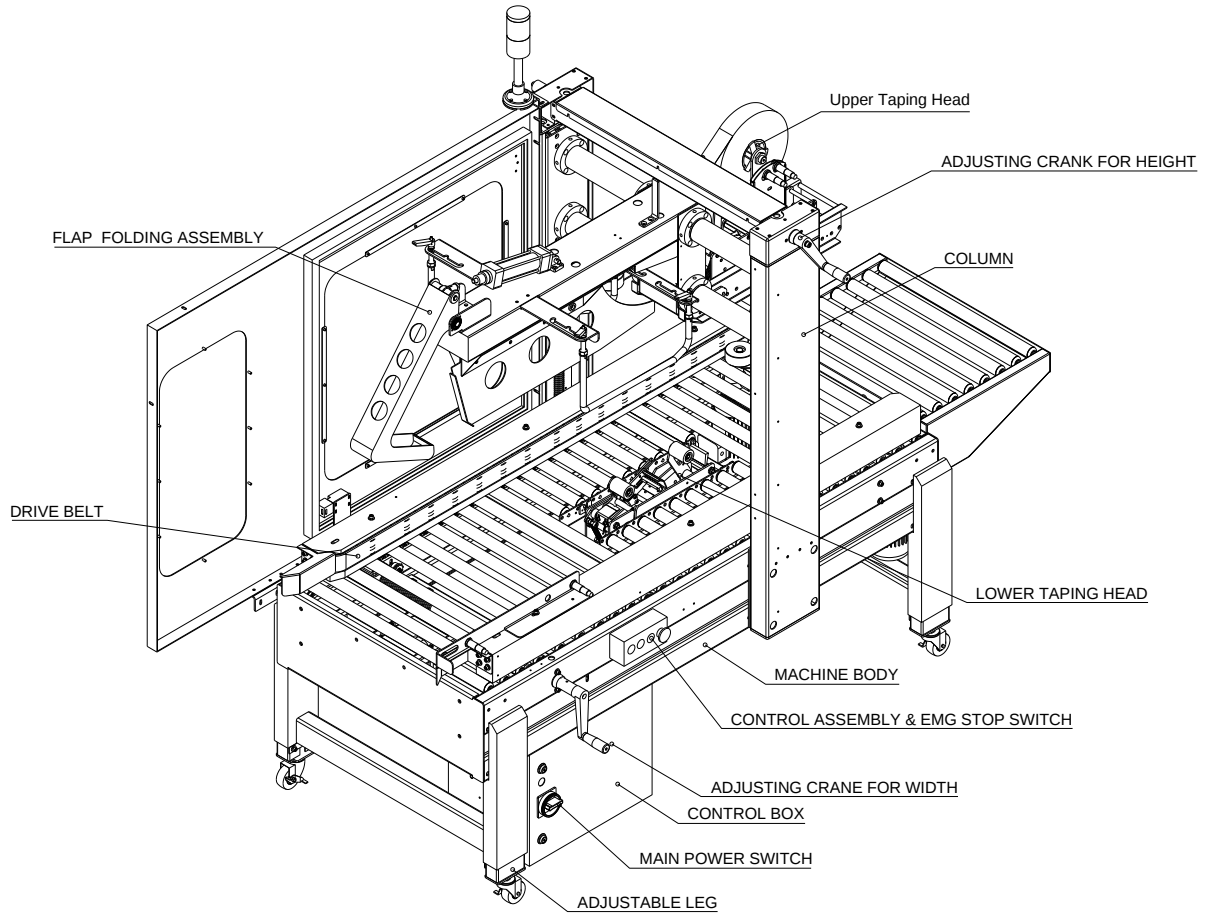


Fix castor thread (A) onto legs, then adjust two screws (B) to adjust table height.

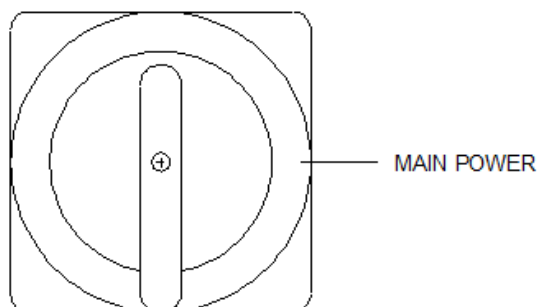
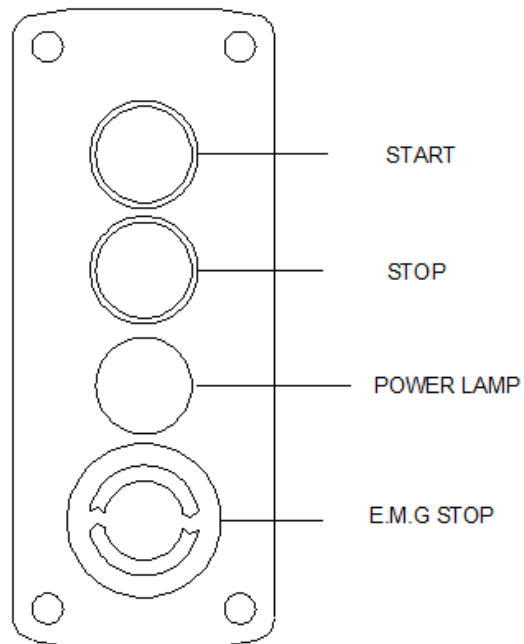
- ✂ Noted: Please ensure to lock the castor before assembling next castor
- ✂ Noted: Please ensure to lock two screws (B) to avoid table sliding down

Mount air pressure meter onto the 3-function element and finally connect with air supply.

10.3 Construction and Units



10.4 Operate Panel



➤ POWER LAMP

As the main power switch is “ON”, the power lamp should also be “ON”. While the lamp is ON, it indicates the machine is ready to run. When power lamp is flashing, it indicates error code (please reference to trouble shooting in manual)

➤ START

Press the button to run

➤ STOP

Press the button to stop machine running from next cycle

➤ **EMERGENCY STOP BUTTON**

Press Emergency stop button (as called E-stop) to stop machine right away in any condition. This E-stop is with safety circuit. Once you release the E-stop, the machine will not automatically ON for safety reason, you need to press START button again to make machine run.

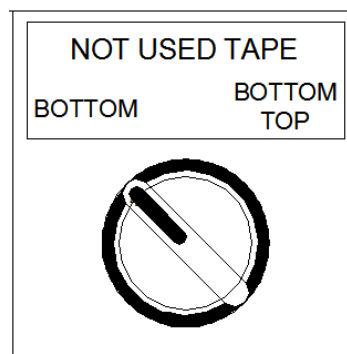
➤ **MAIN POWER**

To switch power ON and OFF

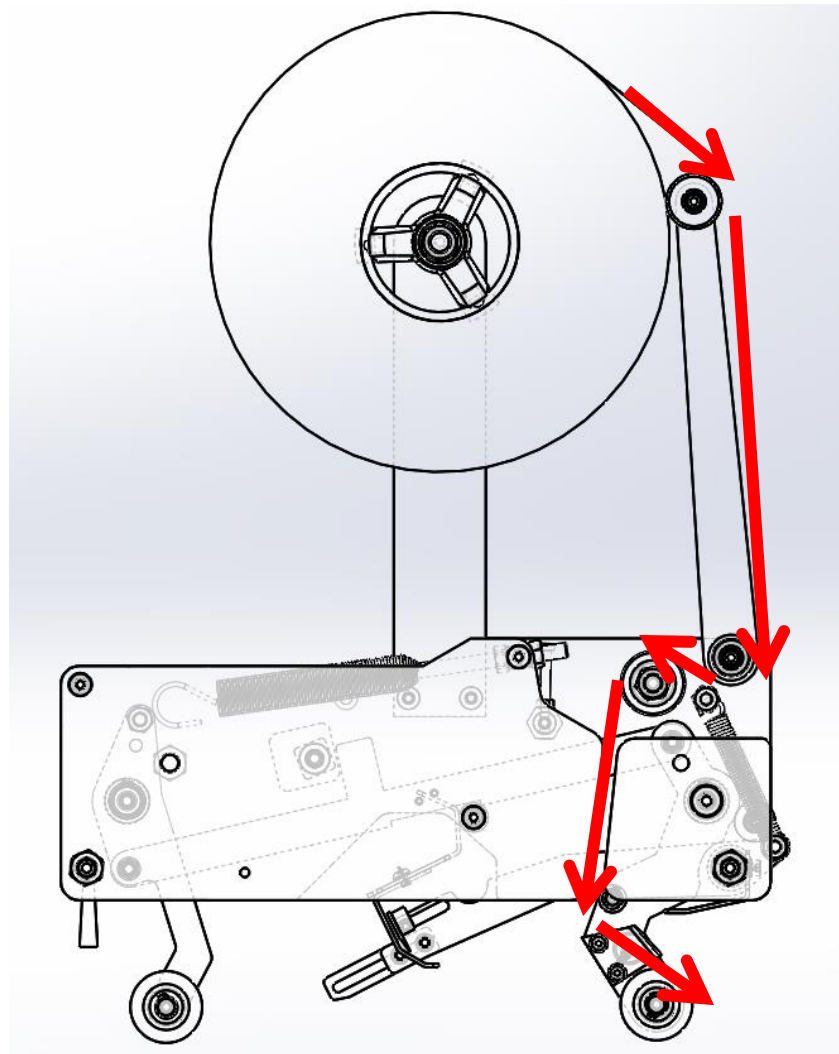
For safety reason, the main power also has safety switch behind, when you open the electric cabinet, then you are not able to directly switch ON the main power

➤ **TAPE LOW & OUT DETECTOR SWITCH (OPTION)**

1. Switch to **BOTTOM** position, the bottom tape detector will not activate. For application that only top taping is applied.
2. Switch to **BOTTOM/TOP** position, the top & bottom detector will not activate. For application that no taping is applied (by pass function)



10.5 Tape Threading

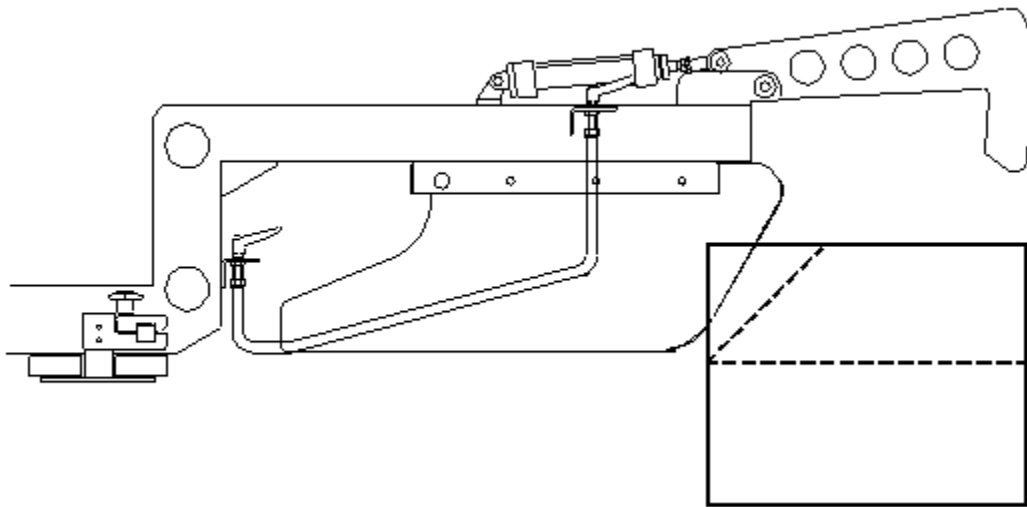


11.MACHINE OPERATION

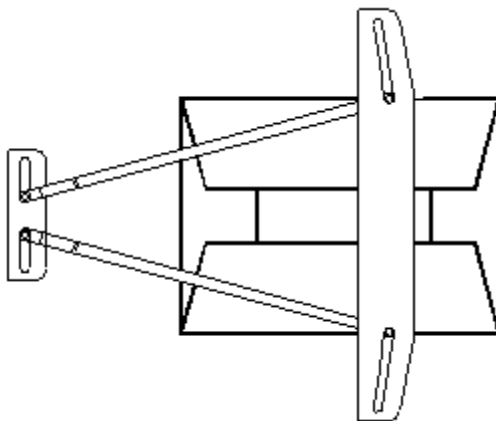
11.1 Machine Operation

The box will feed into the machine (either by manual push or by automatic in-feed conveyor), the box will be driven by side belts to transit into machine.

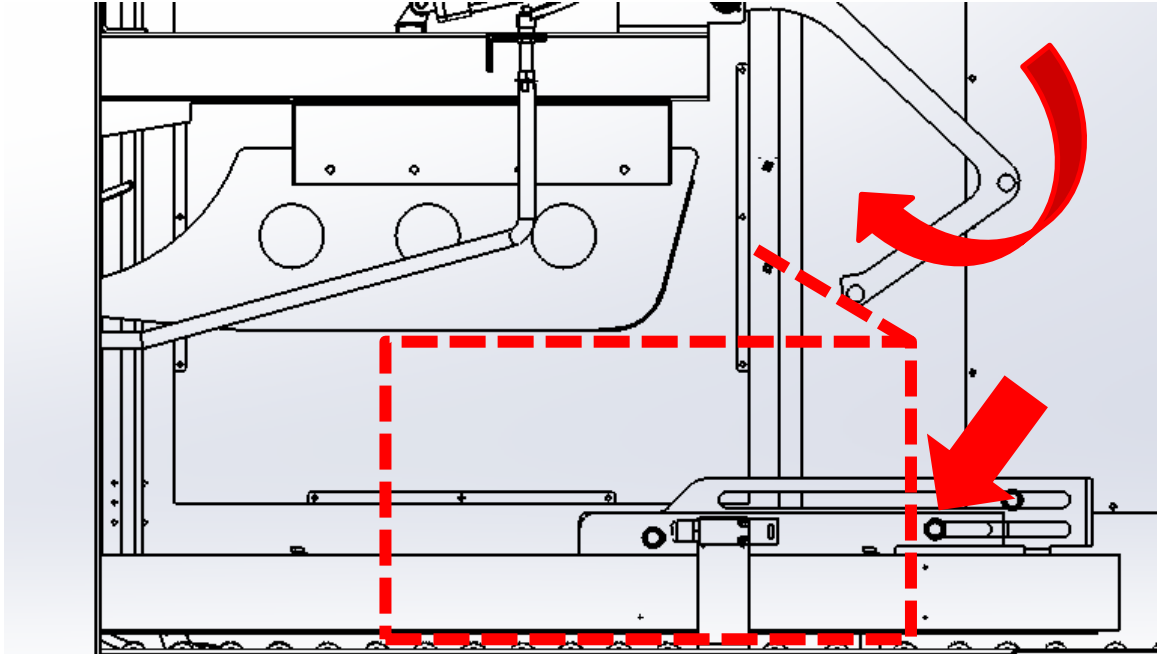
The front flap of box will hit the center blade to be closed.



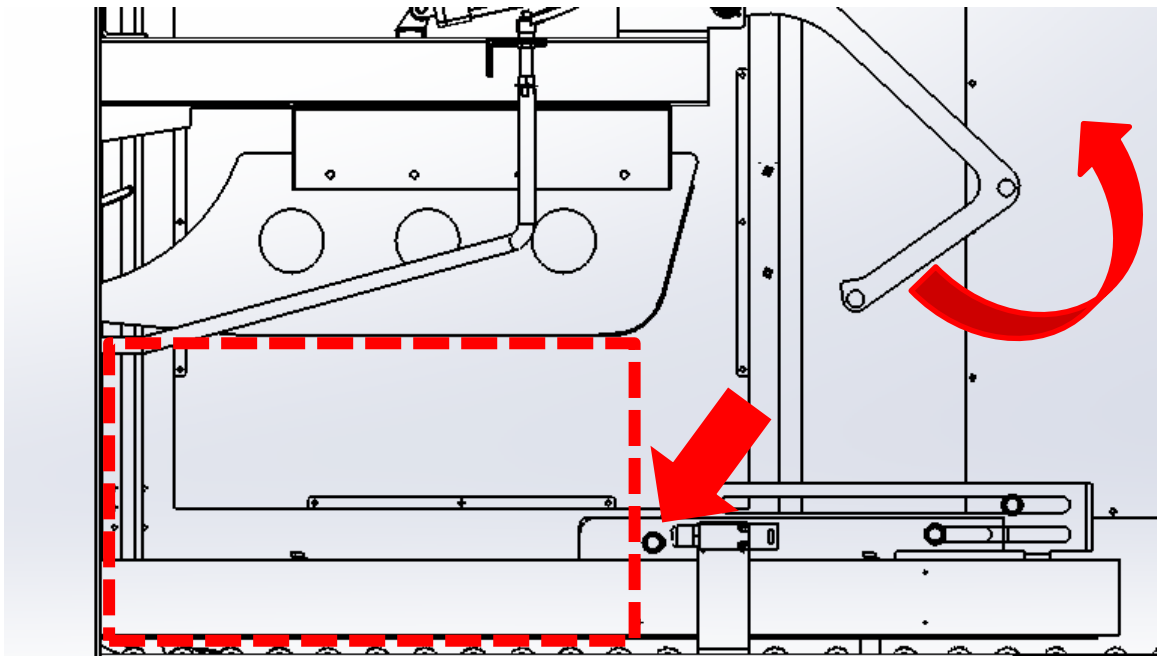
The side flaps of box will hit the closing poles to be closed.



When the box leaves the sensor A detection area, the kicker will swing downward to close rear flap of box, and then kicker will stay in down position to hold the flap until box successfully transit inward.

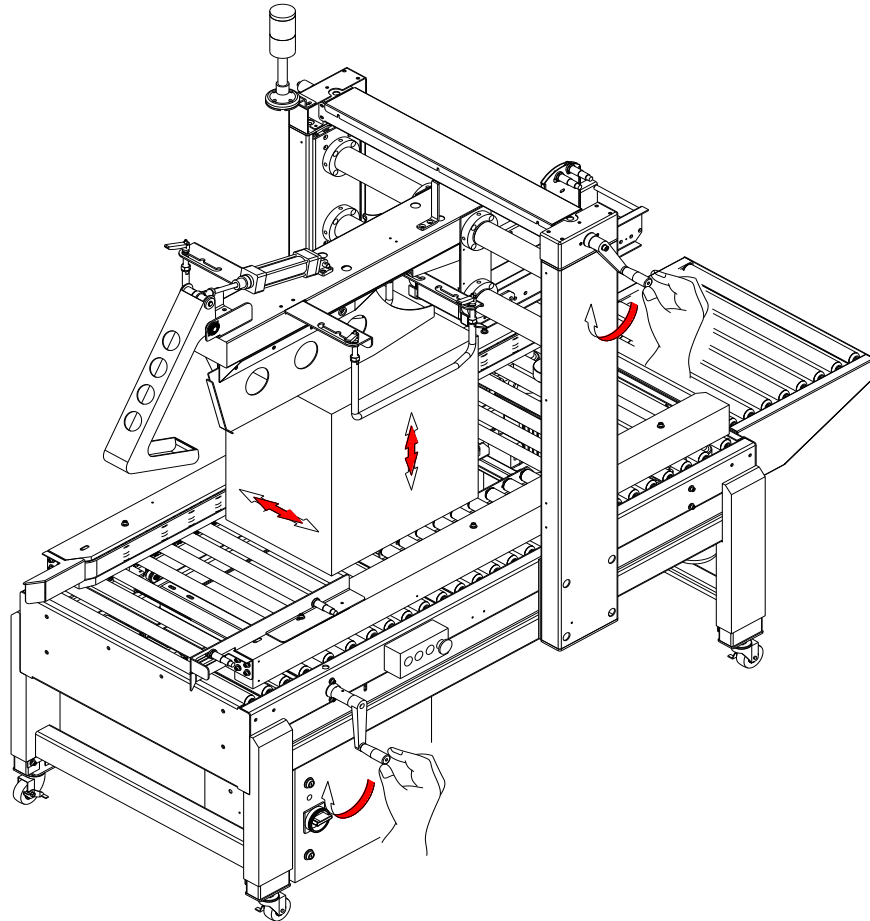


When the box leaves the sensor B detection area, the kicker will swing upward to home position to get ready for next box.

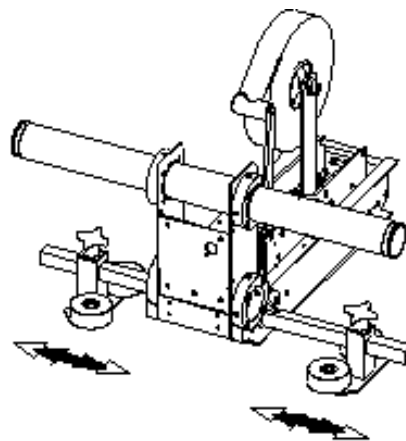


11.2 Adjustment for box

Place a box filled with product on the in feed conveyor, position on the side drive belts and top section to accommodate the desired box width and height by width and height adjust hand cranks.

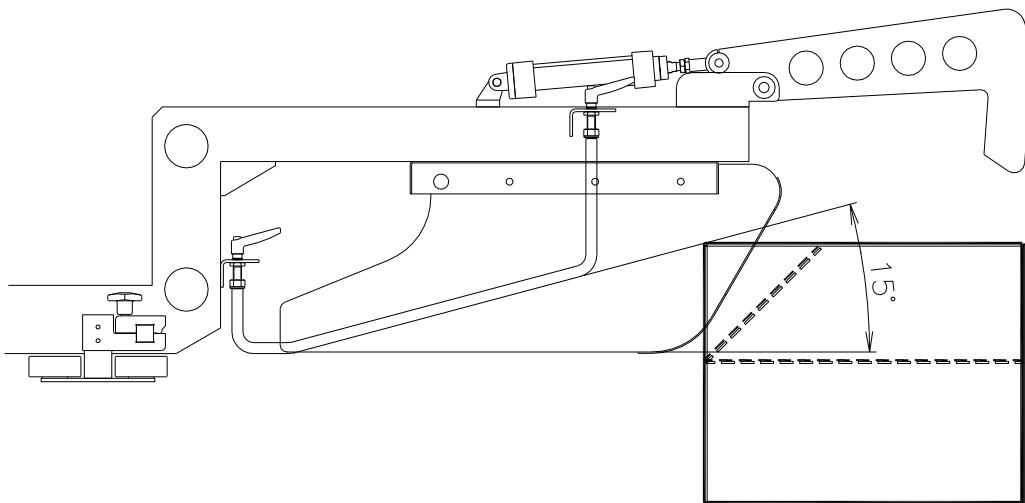
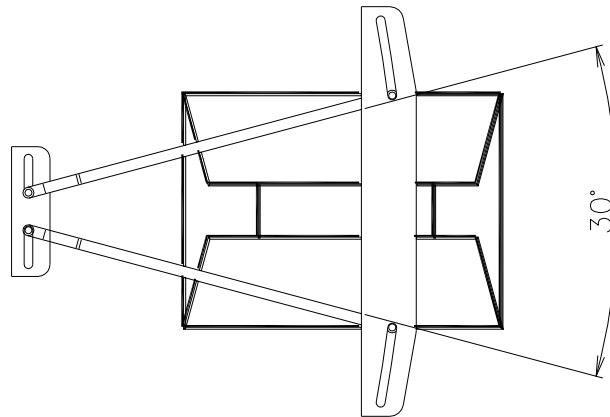


Follow by adjusting the two handle knobs against the sides of carton to secure the carton center.



11.3 Adjustment for side flap closer

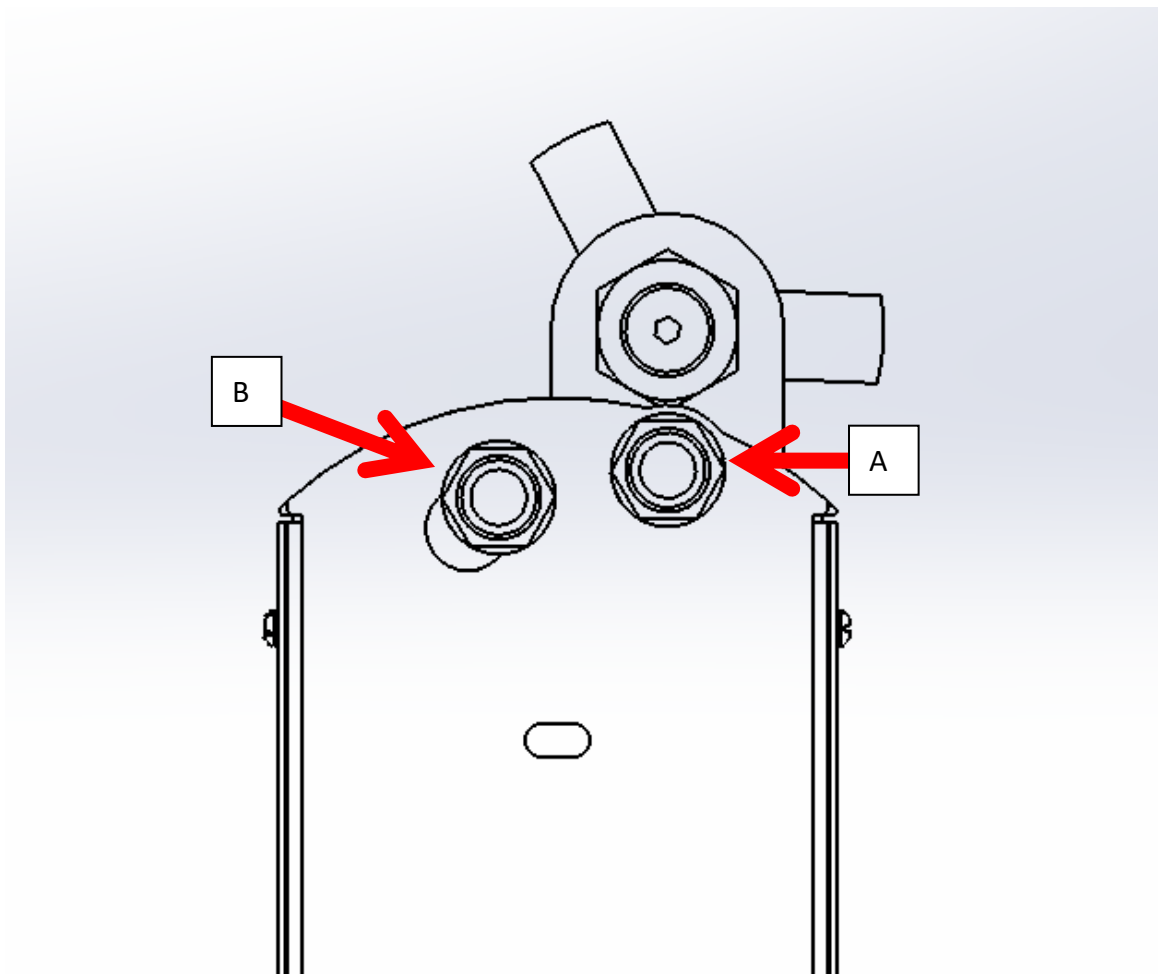
Side flaps will be closed while carton is driven and reaching the two closing bars. The most ideal angles for the two closing bars is 30 degree. The closing bars are set on an angle of 15 degree (note: The bars are movable and adjustable in two ways both height & width)



11.4 Change setting of tape sensor (option)

There are two sensors for tape, one is tape out sensor (A) and the other one is tape low sensor (B). When the tape out sensor is detected, it means the tape is out or broken, the indicate light will go RED and then machine stops. When the tape low sensor is detected, it means the tape is almost ran out, the indicate light will go YELLOW to remind the operator.

The operator could adjust tape low sensor (B) depend on the tape core dimensions.

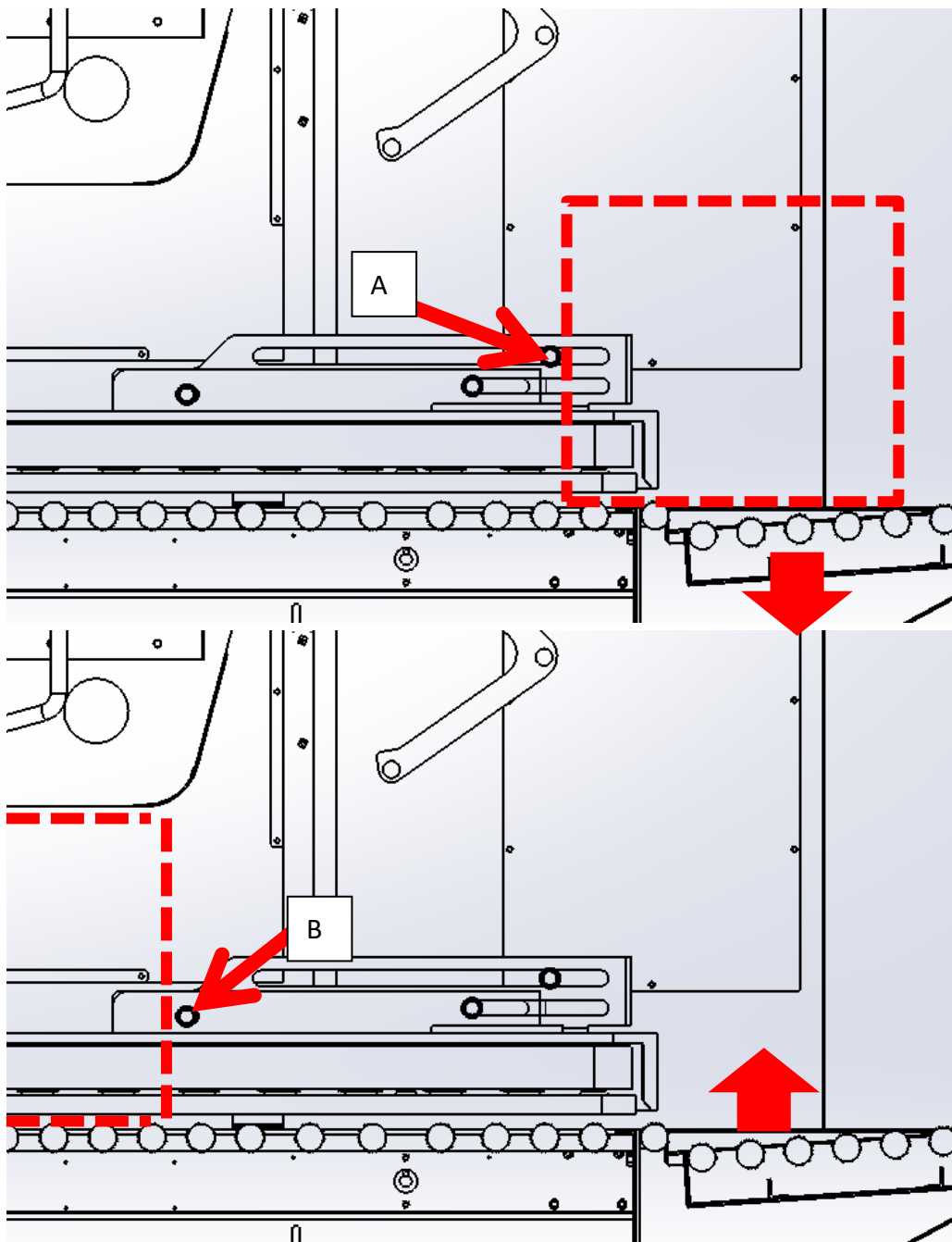


11.5 Index roller table (option)

The option of index roller table has not only index function (stopper function), but also have self-separate boxes function.

When the 1st box is detected by the Index Sensor (A), the roller table will automatically go down to make 2nd box stopped.

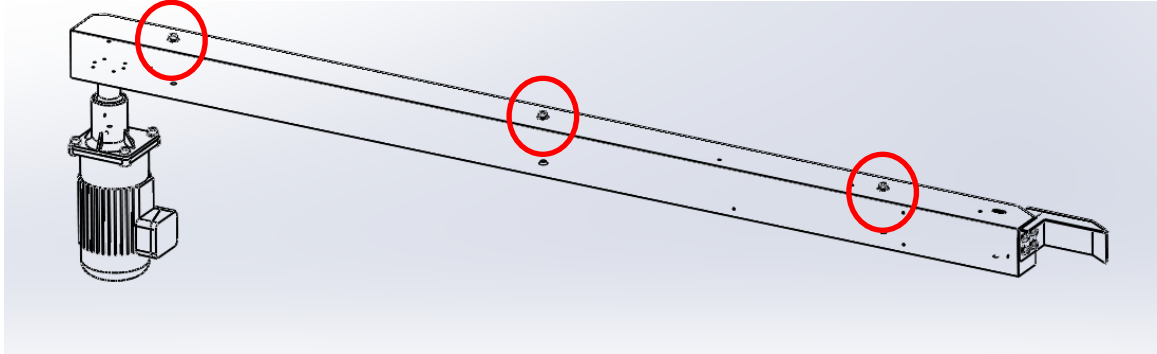
When the 1st box leaves the sensor B, the roller table will automatically go upward again to transit 2nd box inward.



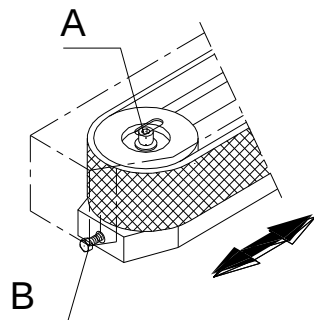
12. TROUBLE SHOOTING

➤ Belt tension adjustment:

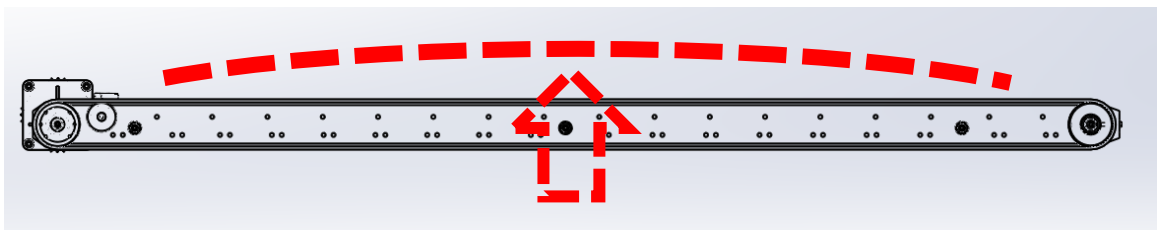
Remove belt cover, then loose screw (A), adjust the belt tension through screw (B)



Then you could loosen screw A and adjust screw B for belt tension



Regarding to belt tension, make sure it's around 3Kg with 25mm gap pulled in the middle of belt



➤ Q&A:

Machine trouble	POSSIBILITIES	Solution
If machine is not functional.	The air force may be not sufficient.	Adjust the air Pressure.
If the air cylinder on the flap closing system does not work.	Complex hoses & wirings.	Please re-position the hoses & wirings.
If the indexing gate (stopper), doesn't operate.	a) Complex hoses & wirings. b) Defective infeed or exit photo eyes sensors.	a) Re-position hoses & wirings. b) Adjust the position of photo eye, or replace a new one.
If machine cannot accomplish the operation of taping on cartons.	The forces from the side belts are insufficiently given to the box.	Please crank the handle for width in order to give enough forces.
Press START button	START button flashes 1 time.	Machine runs.
Error signal		
	START button flashes 2 times.	Motor overloaded.
	START button flashes 3 times.	STOP button is on. Or wirings may be discounted. Check wirings.
	START button does not flash.	(a) Turn on the power, power indication light will be on. (b) Release the E-STOP. (c) Then close the security guards (optional) properly

13. MAINTENANCE

Warning:

- a. Wear safety glasses with side shields which conform to ANS Standard Z87.1
- b. Failure to wear safety glasses could result in severe personal injury or blindness.
- c. Wear Ear Protection.
- d. Only trained personnel should service machine.
- e. Unless specified, shut off and disconnect all electrical power.
- f. Follow all service instructions.
- g. Caution for moving parts can crush.
- h. Caution for pinch point entanglement.
- i. Caution for cutting of finger or hand from straight blade.
- j. Use the correct tools.

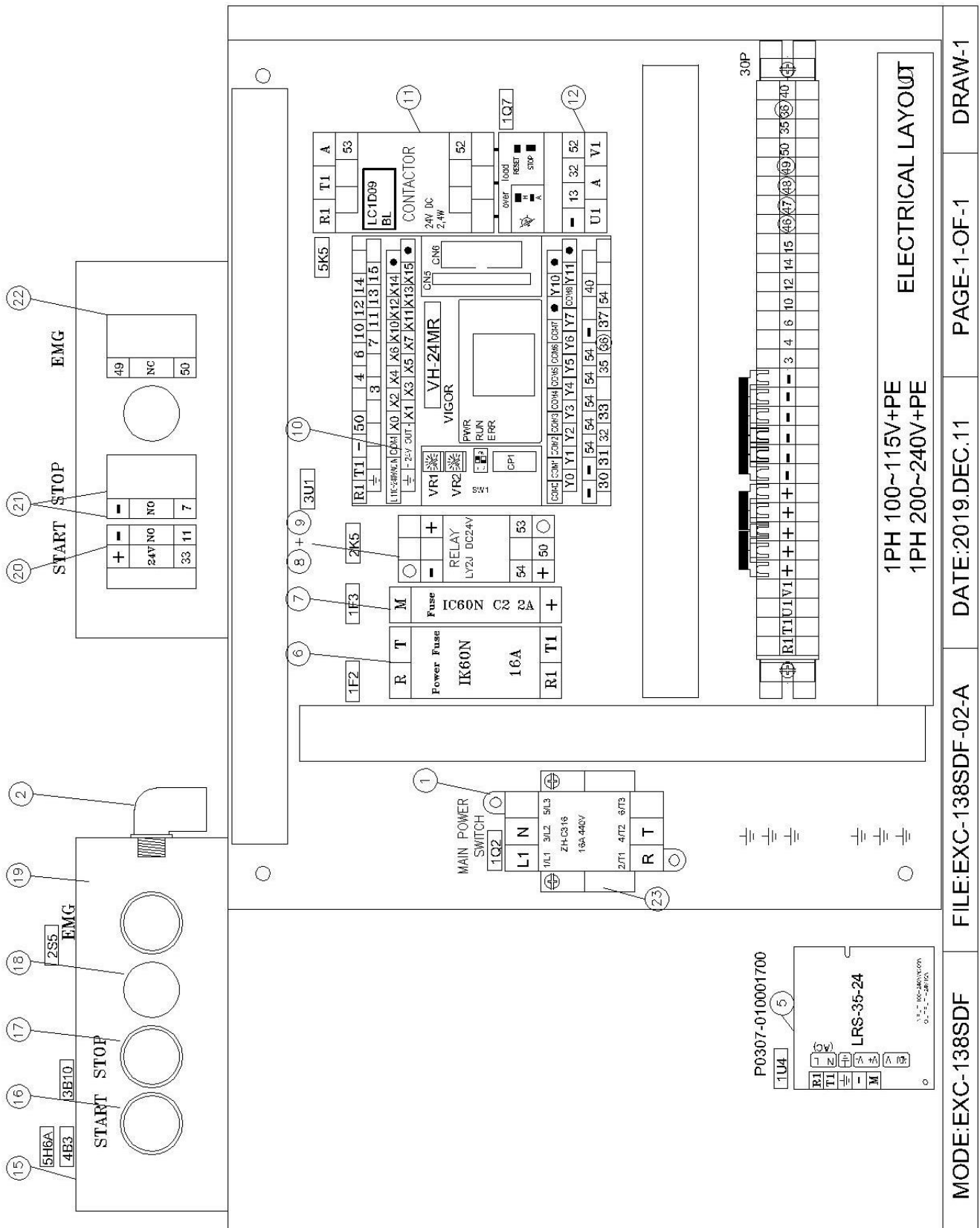
Cleaning & Lubricate

- A weekly cleaning with dry rags or diluted detergents is necessary. Cardboard boxes produce a significant quantity of dust and paper chips when processed or handled in case sealing equipment. If this dust is allowed to build up on machine components, it can cause component wear and over-heating of drive motors. The dust buildup is best removed from the machine with a vacuum cleaner. Depending on the number of cartons processed, this cleaning should be done weekly. Excessive buildup that cannot be removed by vacuuming should be removed with a damp cloth.
- Should tape adhesive buildup occur, carefully wipe clean with oily cloth or brush. Oil prevents the buildup of tape adhesive
- Worm or damaged cutter blades must be replaced promptly in order to guarantee a perfect cut of the tape.
- Most of the machine bearings, including the drive motor, are permanently lubricated and sealed and do not require additional lubricant.

Frame points which should be lubricated every 250 hours of operation. Lubricate the rotating and pivoting points with Silicone. At the same time, a small amount of silicone should be applied to the end of each spring where the loop is secured to an eyelet.

- ✂ Wipe off excess silicone. It will attract dust which can cause premature equipment wear and jamming. Take care that silicone is not left on the surface of rollers around which tape is threaded, as it can contaminate the tape's adhesive

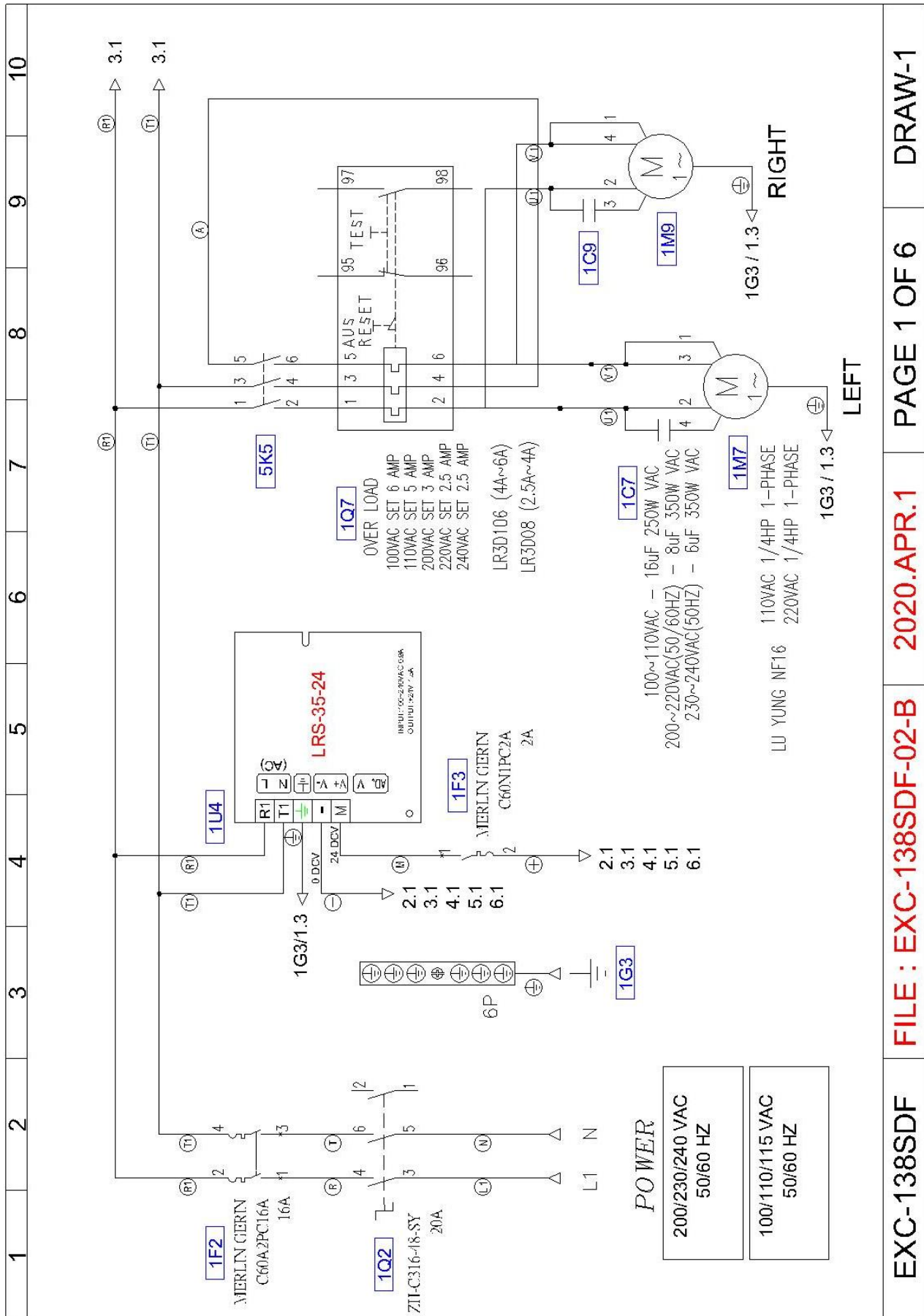
14. ELECTRIC WIRING DIAGRAM & PART

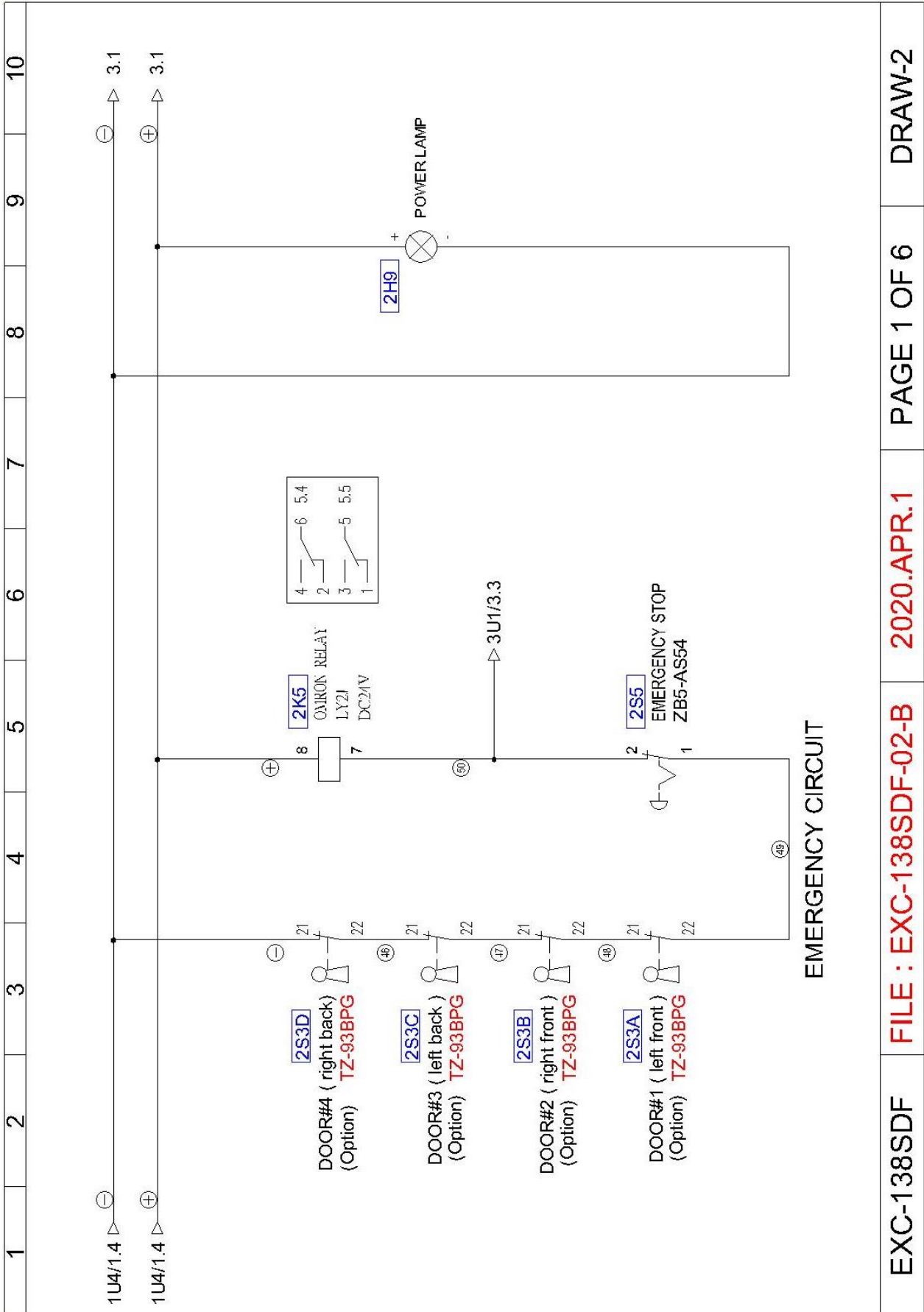


ELECTRIC PARTS LIST FOR EXC-138SDF

KEY NO	PART NO.	DESCRIPTION	Q'TY
1	P0311-020000700	SEPARATED POWER → ON/OFF	1
2	P0401-0000500	1/2"90°CONNECTOR (BVWD-G027GT)	2
4			1
5	P0307-010001700	POWER SUPPLY LRS-35-24	1
6	P0305-010001200	CIRCUIT BREAKER IK60N2PC16A	1
7	P0305-010001500	CIRCUIT BREAKER IC60N1PC2A	1
8	P0306-020000200	RELAY LY2 DC24V	1
	P0316-050000100	FIXING PLATE PYCA1	2
9	P0306-030000100	RELAY SEAT LY2	1
10	P0308-010000900	PLC VIGOR VH-24MR	1
11	P0306-010000100	CONTACTOR LC1-D09BL (DC24V)	1
12	P0306-040000500	THERMAL OVERLOAD RELAY (110V)(4~6A)	1
	P0306-040000200	THERMAL OVERLOAD RELAY (220V)(2.5~4A)	1
	P0306-040000400	THERMAL OVERLOAD RELAY (400V 50Hz 3PH)	1
13	P0304-010007300	TERMINAL POST 30P	1
15	P0323-0000100	ON/OFF SWITCH BOX XALD04	1
16	P0313-010001300	AUTO RUN GREEN LAMP→COVER	1
17	P0313-010001100	BUTTON RED ZB5-AL432	1
18	P1114-02HP220	SLEEVE § 22	1
19	P0313-010004300	EMG.SWITCH	1
20	P0313-010001400	AUTO RUN GREEN LAMP ZB5-AW061	1
	P0312-010001400	LED LAMP DL1-LED241	1
21	P0313-020000800	(START)(STOP)BUTTON SEAT CONTACTOR(NOx1) ZB5-AZ101	2
22	P0313-020000900	EMG. BUTTON SEAT CONTACTOR NCx1	1
23	P0316-060000100	FIXING PLATE TBR-F	2
24	P0302-020000400	PHOTO SENSOR CDR-10X	3
25	P0313-010006700	White LAMP XA2BVB1C	1
26	P0302-020000600	PHOTO SENSOR CDR-10X-M12 (option)	4
27	P0302-050000200	PHOTO SENSOR CONTACTOR LINE (option)	4
28	P0313-010006100	SELECTOR SWITCH XA2ED33 (option)	1
29			

KEY NO	PART NO.	DESCRIPTION	Q'TY
30	P0311-020000100	SAFETY SWITCH TZ-93BPG	2
30-1	P0311-030000100	SAFETY SWITCH KEY TZ93-K3	2
31	P0312-010001900	ALARM LIGHT TOWER(option)	1
31-1	P0312-020000200	ILLUMINATED UNIT XVMC33 (Green) (option)	1
31-2	P0312-020000100	ILLUMINATED UNIT XVMC34 (Red) (option)	1
31-3	P0312-020000300	ILLUMINATED UNIT XVMC35 (Orange) (option)	1
31-4	P0312-030000300	BASE UNIT XVM-C29B (option)	1
31-5	P0312-040000100	SEAT SHAFT XVM-Z02 (option)	1
31-6	P0312-010001700	LED LC1-EDBS5W/24V (option)	3





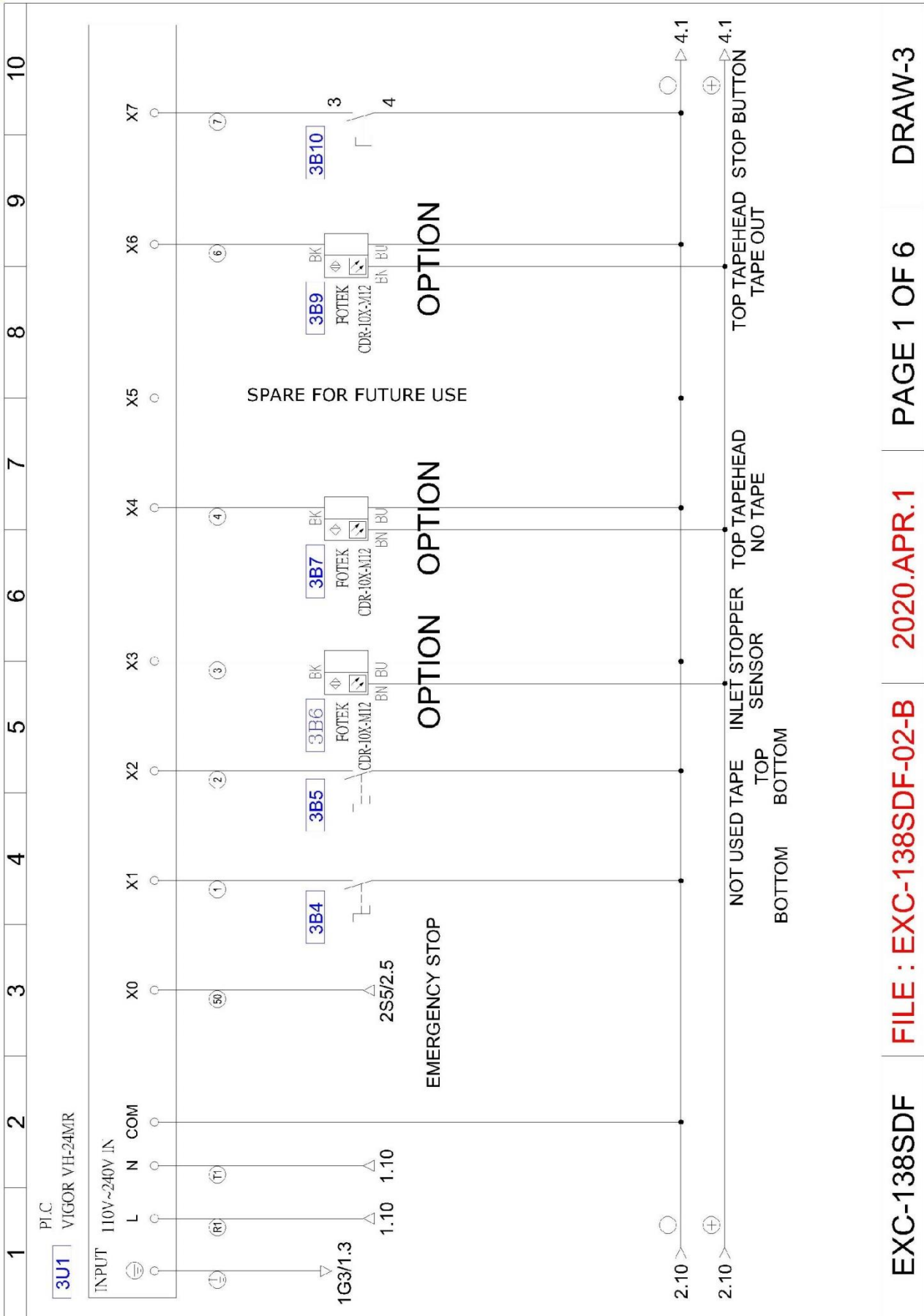
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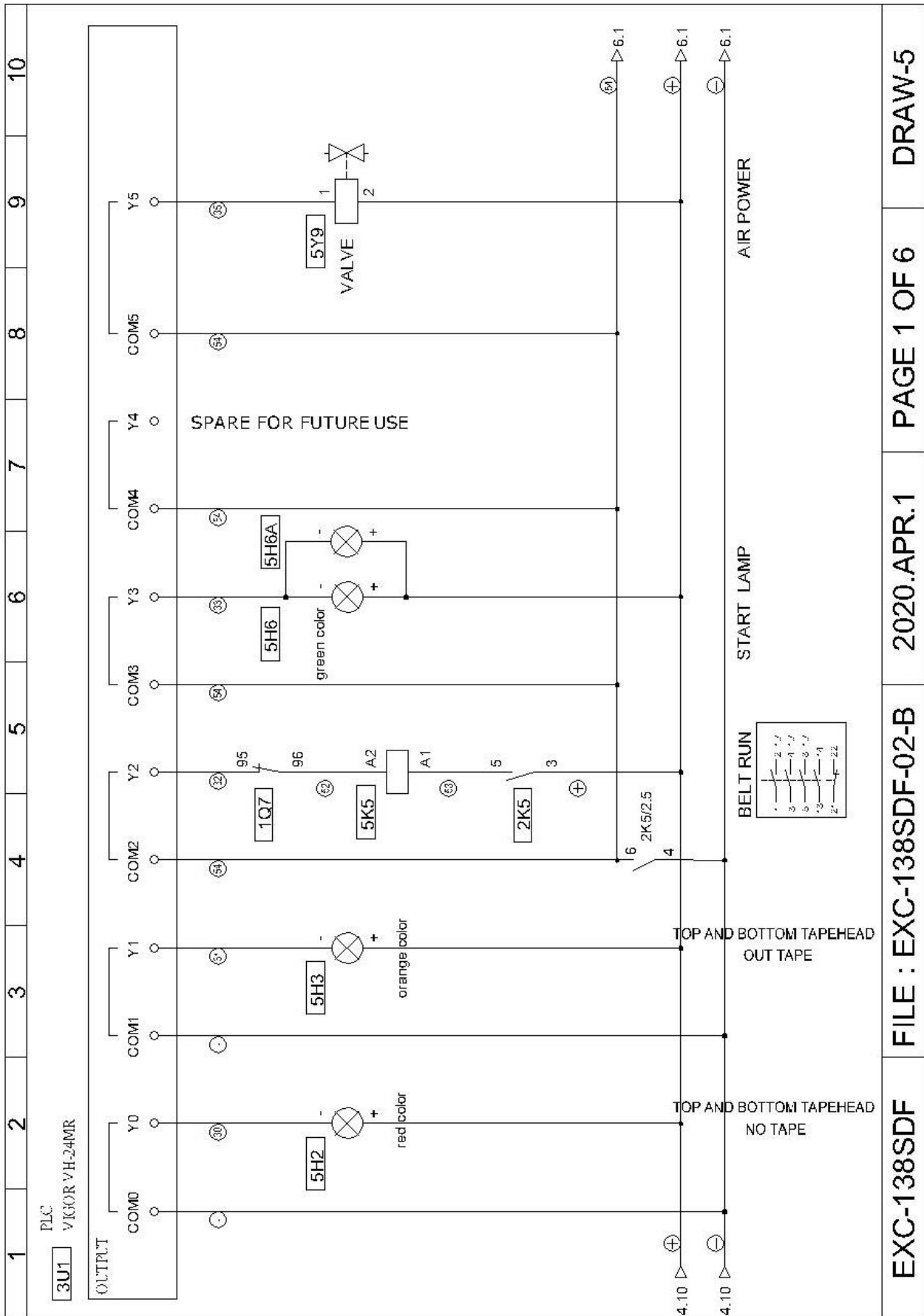
PAGE 1 OF 6

2020.APR.1

FILE : EXC-138SDF-02-B

EXC-138SDF





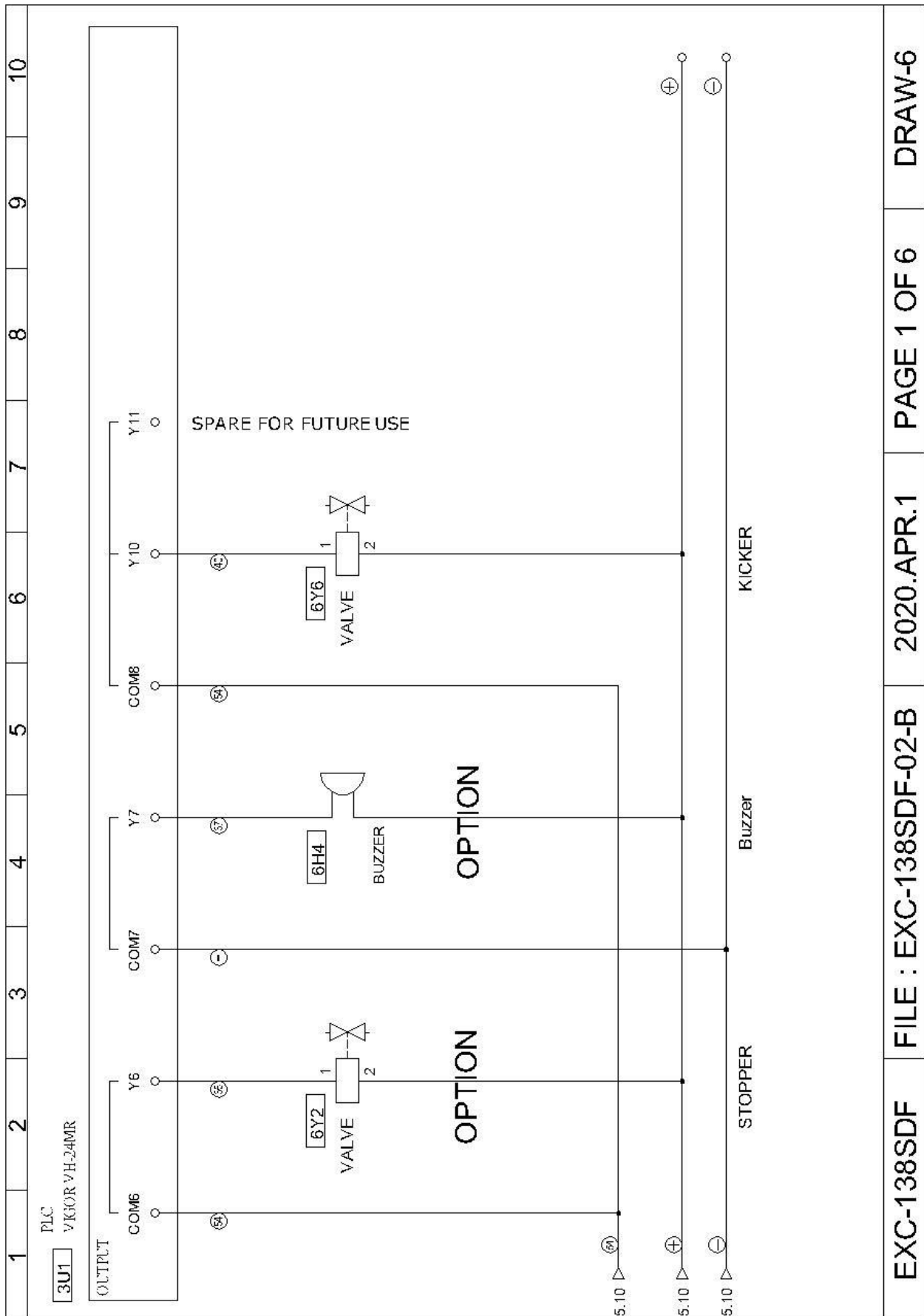
DRAW-5

PAGE 1 OF 6

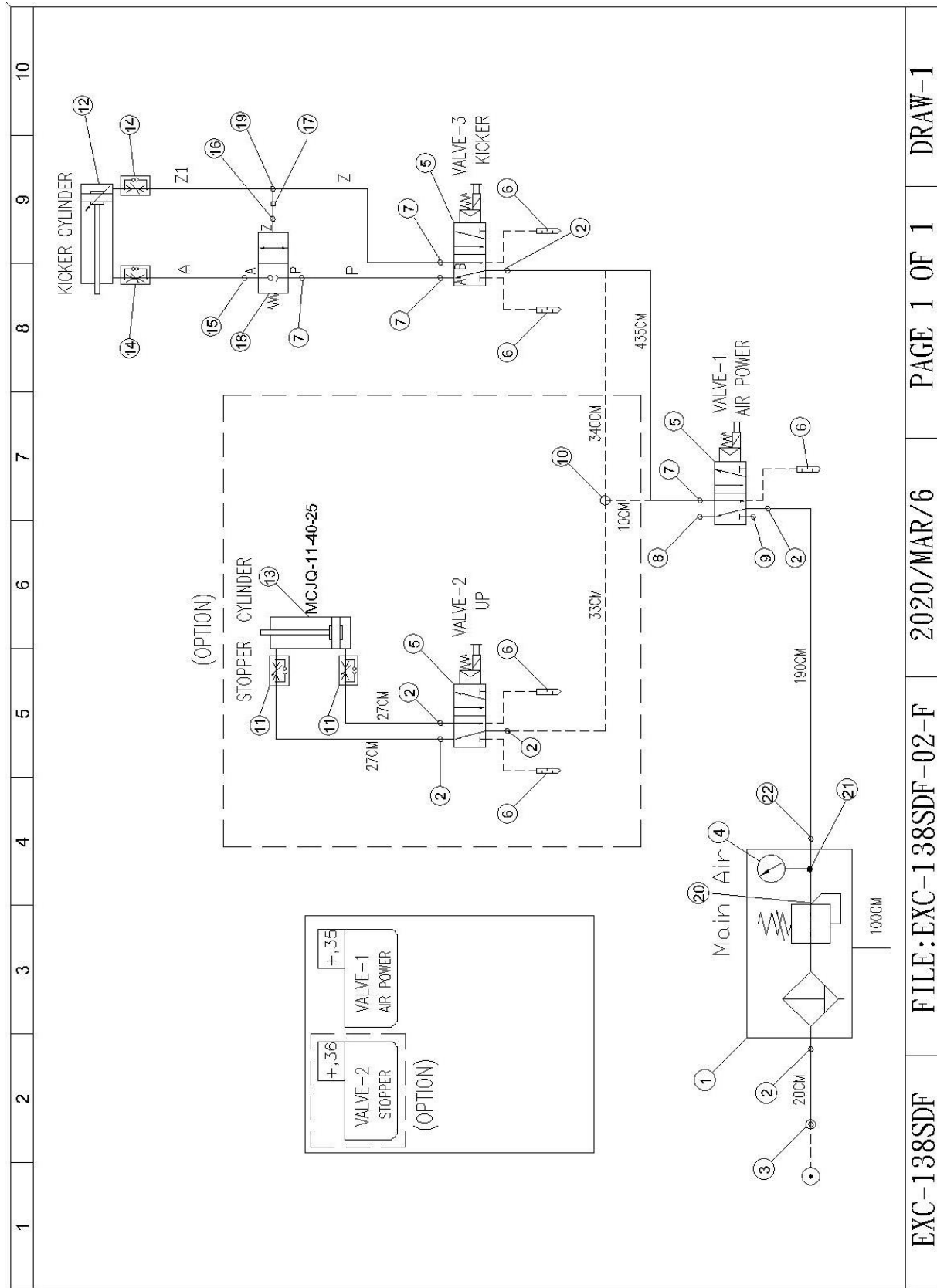
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FILE : EXC-138SDF-02-B

EXC-138SDF



PNEUMATIC DIAGRAM & PART

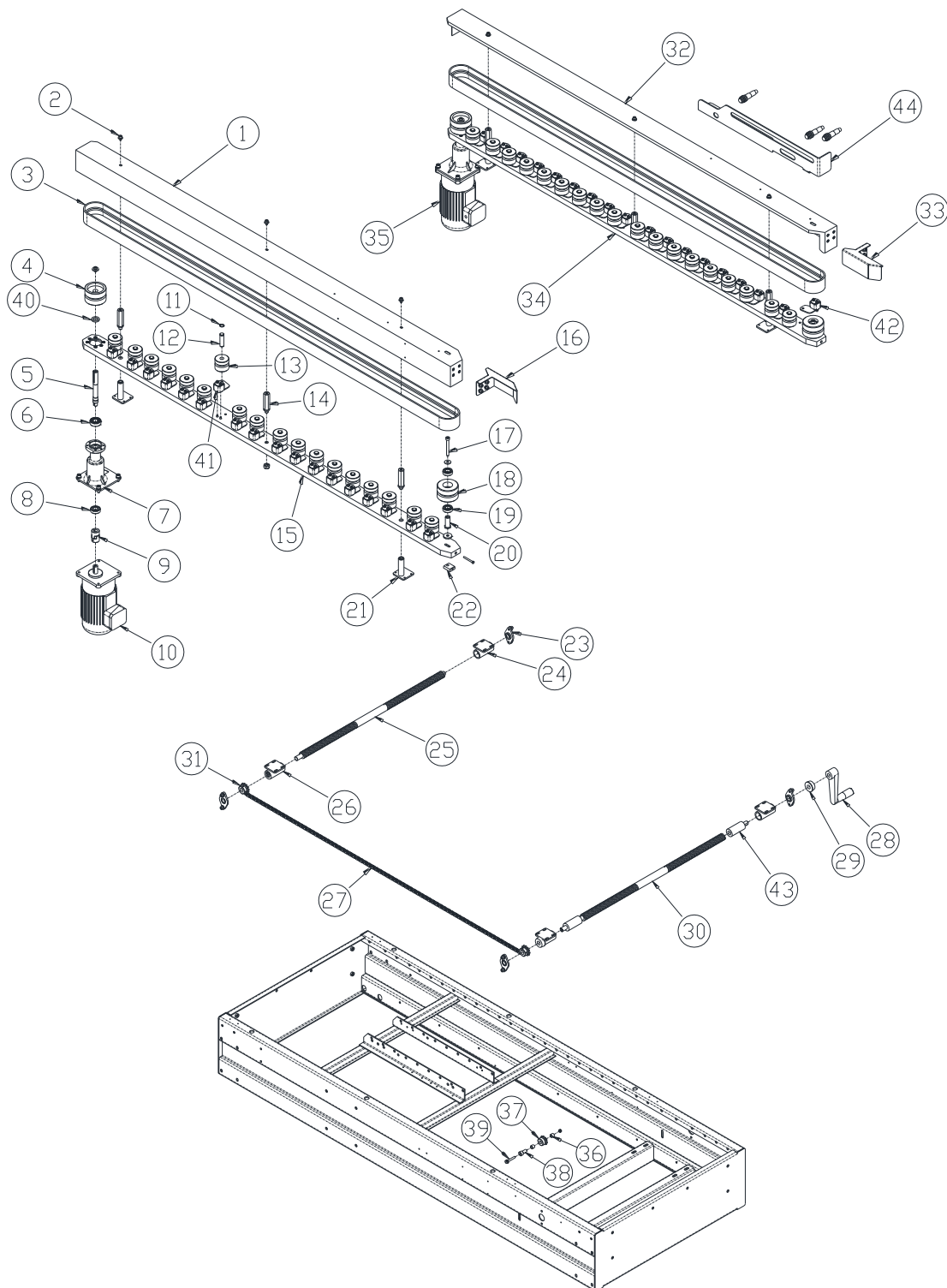


PNEUMATIC PARTS LIST FOR EXC-138SDF

KEY NO	PART NO.	DESCRIPTION	Q'TY
1	P0405-000011A	AIR F.R.L UNITS (MAFR300L-8A-D)	1
2	P0401-0001200	CONNECTOR (PL8-02)	7
3	P0401-0000800	MPP-20 CONNETCOR	1
4	P0407-040000100	PRESSURE GAUGE	1
5	P0404-010000200	SOLENOID VALVE	3
6	P0401-0002100	BRASS SILENCER	5
7	P0401-0006800	CONNECTOR (PC8-02)	4
8	P0406-0000100	(1/4")SLEEVE	1
9	P0406-0000200	(1/8")SLEEVE	2
10	P0401-0007100	CONNECTOR (PE8)	1
11	P1101-0406012AN	CONNECTOR (JSC8-01A)	2
12	P0402-000140A	ISO CYLINDER (MCQV2-11-40-100)	1
13	P0402-0007400	ISO CYLINDER MCJQ-11-40-25	1
14	P0401-0006900	CONNECTOR JSC8-02A	2
15	P0401-0003300	CONNECTOR ,PLF8-02	1
16	P0401-0001500	CONNECTOR , PL6-M5	1
17	P0401-0011800	CONNECTOR , PG8-6	1
18	P0401-0001300	CONNECTOR, PC-1/4	1
19	P0401-0011700	CONNECTOR ,PY8	1
20	P0401-0006500	CONNECTOR , BCN-0201	1
21	P0401-0006600	CONNECTOR , BTF-001	1
22	P0401-0008100	CONNECTOR, PC8-1,	1

15.PART LIST

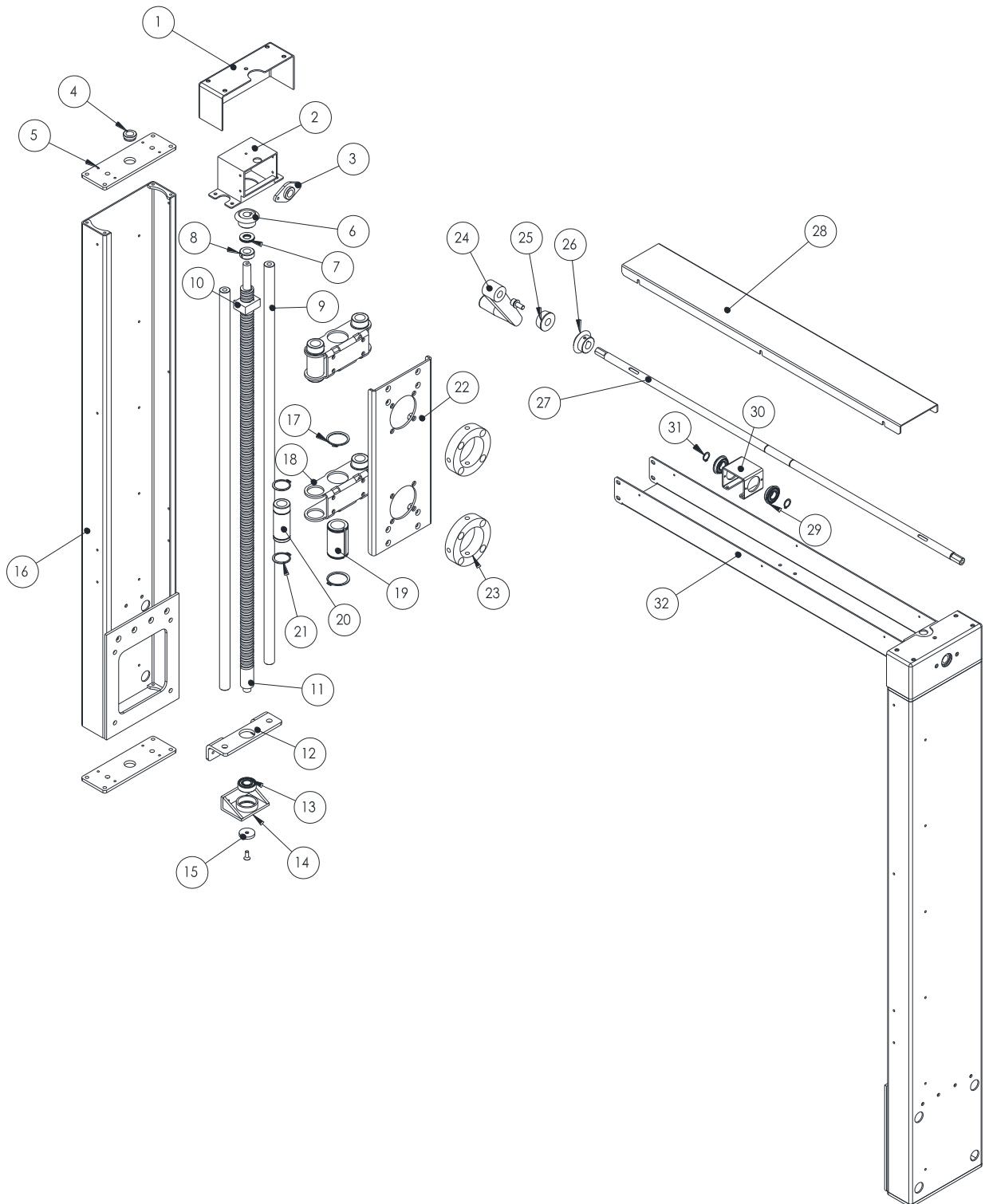
16.SIDE BELT



SIDE BELT			
#	PART NUMBER	DESCRIPTION	Q'TY
1		BELT COVER	1
2	P1101-0906012AN	SCREW M6*12L	6
3	P0902-001020A	BELT	1
4	P0703-0003400	PULLEY DRIVER	2
5	P02-008020B	MOTOR SHAFT	2
6	P1104-0262032RS0	BEARING 6203	2
7	P02-0080300	MOTOR SEAT	2
8	P1104-026003ZZ0	BEARING 6003ZZ	2
9	P1121-0000100	UNIVERSAL JOINT	2
10	P0503-000990A	MOTOR 110V/60HZ,T18:1	1
	P0503-001110A	MOTOR 220V/60HZ,T18:1	1
	P0503-001120A	MOTOR 220V/50HZ,T15:1	1
	P0503-001230A	MOTOR 240V/50HZ,T15:1	1
	P0503-001320A	MOTOR 380V/50HZ,T15:1	1
	P0503-001390A	MOTOR 400V/50HZ,T15:1	1
11	P1105-0114B	RING S-14	40
12	P02-0079600	PULLEY SHAFT	40
13	P0703-0003300	PLASTIC PULLEY	40
14	P02-0085300	SUPPORT SCREW	6
15		SUPPORT COLUMN	1
16		GUIDE PLATE	1
17	P1101-0508070AN	SCREW M8*70L	2
18	P0703-0003200	PULLEY FOLLOWER	2
19	P1104-026003ZZ0	BEARING 6003ZZ	4
20	P02-0079500	PULLEY SHAFT	2
21	P02-0284500	SUPPORT SHAFT	4
22	P02-0080100	ADJUSTMENT BLOCK	2
23		SHAFT SEAT	4
24	P02-0079700	SPINDLE SUPPORT	2
25	P02-0079300	SPINDLE WIDTH ADJUSTMENT	1
26	P02-0079800	SPINDLE SUPPORT	2
27	P0901-0001600	CHAIN #35x328	1
28	P1112-000060A	HANDLE CRANK ARM	1

SIDE BELT			
#	PART NUMBER	DESCRIPTION	Q'TY
29	P06-0022600	HANDLE RING	2
30	P02-007920A	SPINDLE WIDTH ADJUSTMENT	1
31	P0702-0004800	CHAIN SPPOCKET 12T	2
32		BELT COVER	1
33		GUIDE PLATE	1
34		SUPPORT COLUMN	1
35	P0503-001060A	MOTOR 110V/60HZ,T18:1	1
	P0503-001190A	MOTOR 220V/60HZ,T18:1	1
	P0503-001200A	MOTOR 220V/50HZ,T15:1	1
	P0503-001270A	MOTOR 240V/50HZ,T15:1	1
	P0503-001360A	MOTOR 380V/50HZ,T15:1	1
	P0503-001450A	MOTOR 400V/50HZ,T15:1	1
36	P02-0080400	BUSHING	2
37	P0702-0004700	CHAIN WHEEL	1
38	P02-0079000	CHAIN WHEEL SHAFT	1
39	P1101-1006025AZ	SCREW M6x25L	1
40	P06-0046200	WASH	4
41	P02-0282500	CUSHION ASSEMBLY (L)	15
42	P02-0282600	CUSHION ASSEMBLY (R)	15
43	P02-007940A	SHAFT	1
44		SENSOR SEAT	1

COLUMN



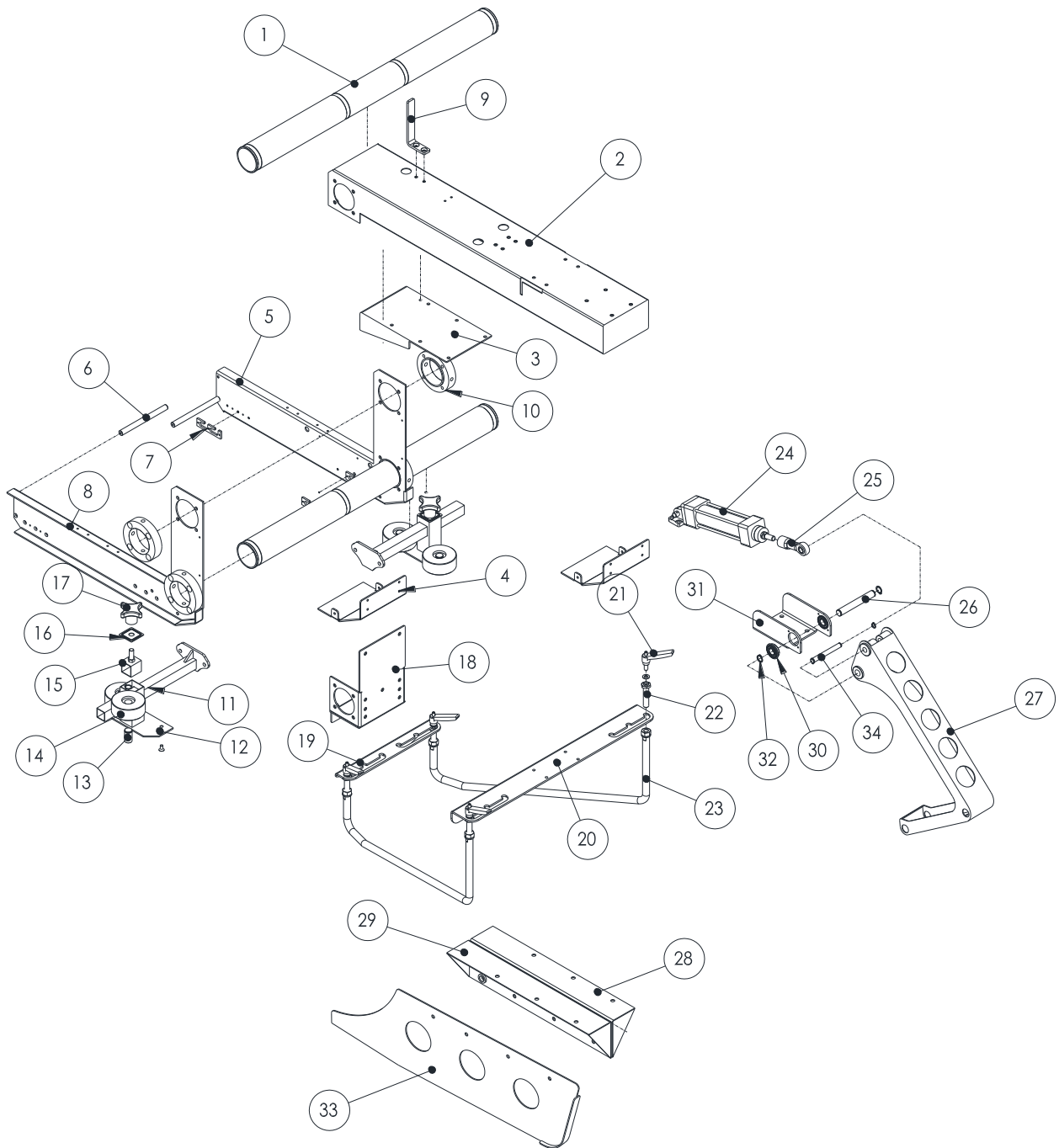
**EXTEND**

Extend the partnership

COLUMN			
#	PART NUMBER	DESCRIPTION	Q'TY
1		COLUMN COVER FRAME	2
2		FIX SEAT	2
3		SHAFT SEAT	2
4	P02-0088800	COPPR RING	2
5		TOWER FRAME COVER	4
6	P0701-0004400	GEAR (POM)M=1.5,T=30	2
7	P1104-18AXK15280	BEARING AXK1528	2
7	P1104-19AS15280	WASHER AS1528	4
8	P02-004780A	SWITCH CAM	2
9	P02-0073900	SHAFT	4
10	P06-0023800	SCREW (RIGHT)	1
10	P06-0025400	SCREW (LEFT)	1
11	P02-007370A	COLUMN SCREW (RIGHT)	1
11	P02-007380A	COLUMN SCREW (LEFT)	1
12	P01-0125900	FIX SEAT	2
13	P1104-026202ZZ0	BEARING 6202ZZ(CWB)	2
14		COLUMN BEARING SEAT	2
15		WASHER	2
16	P01-0125700	COLUMN	2
17	P1105-0140B	C-RING S-40	4
18		BRACKET	4
19	P02-007410A	SCREW (RIGHT)	1
19	P02-007420A	SCREW (LEFT)	1
20	P1104-01200	LINEAR MOTION BEARING LM-20UU	8
21	P1105-0132B	C-RING S-32	8
22		BRACKET BASE	2
23	P02-0074300	SWITCH CAM	4
24	P1112-0000300	CRANK HANDLE	1
25	P06-0022600	HANDLE RING	2

COLUMN			
#	PART NUMBER	DESCRIPTION	Q'TY
26	P0701-0003000	GEAR (S45C) M=1.5, T=30	2
27	P02-007400A	TRANSMISSION SHAFT	1
28		COVER FRAME (TOP)	1
29	P1104-076002ZZ0	BEARING 6002ZZ-NR(CWB)	2
30		FIX SEAT	1
31	P1105-0115B	C-RINGS-15	2
32		COVER FRAME	1

TOP SEAT

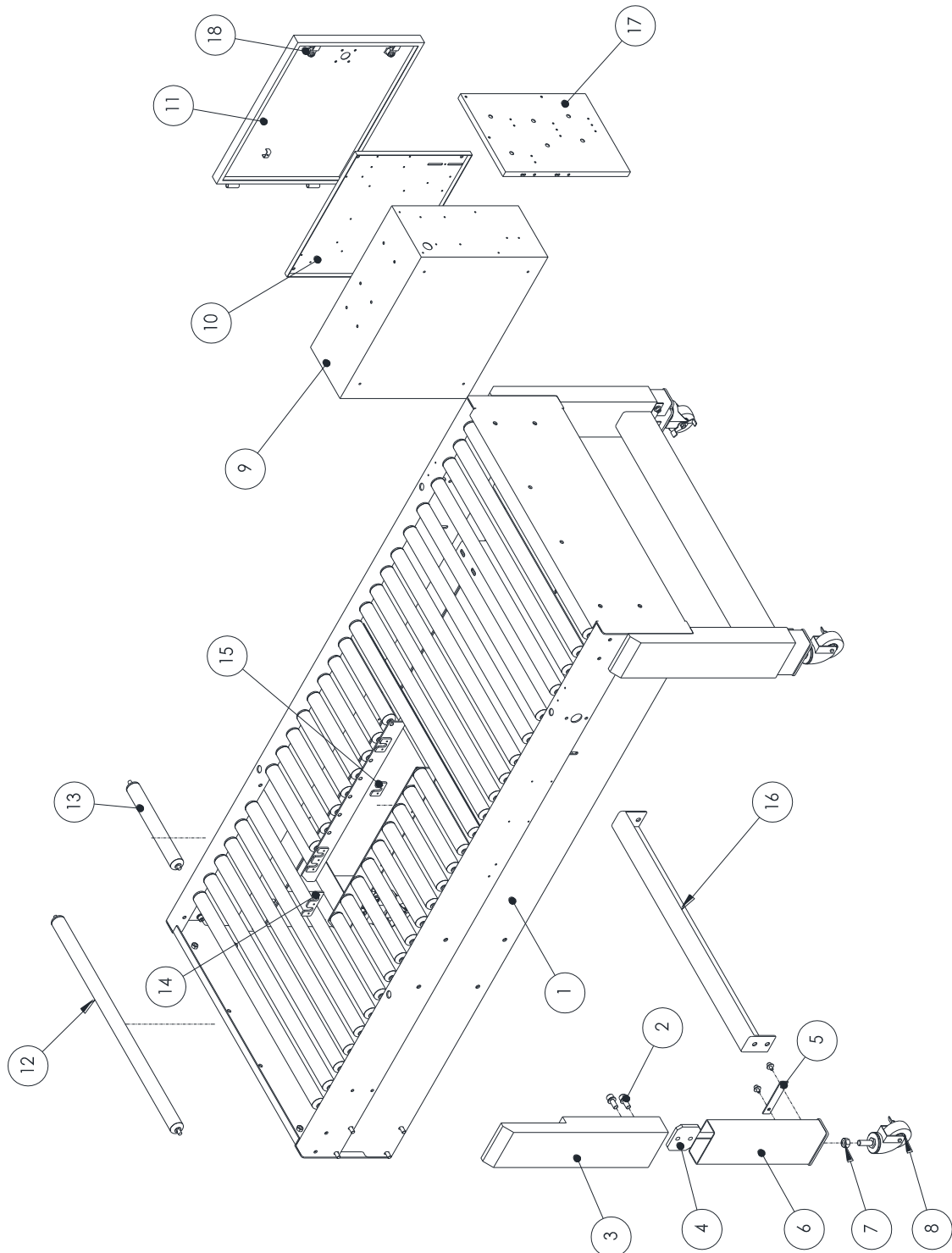


**EXTEND**

Extend the partnership

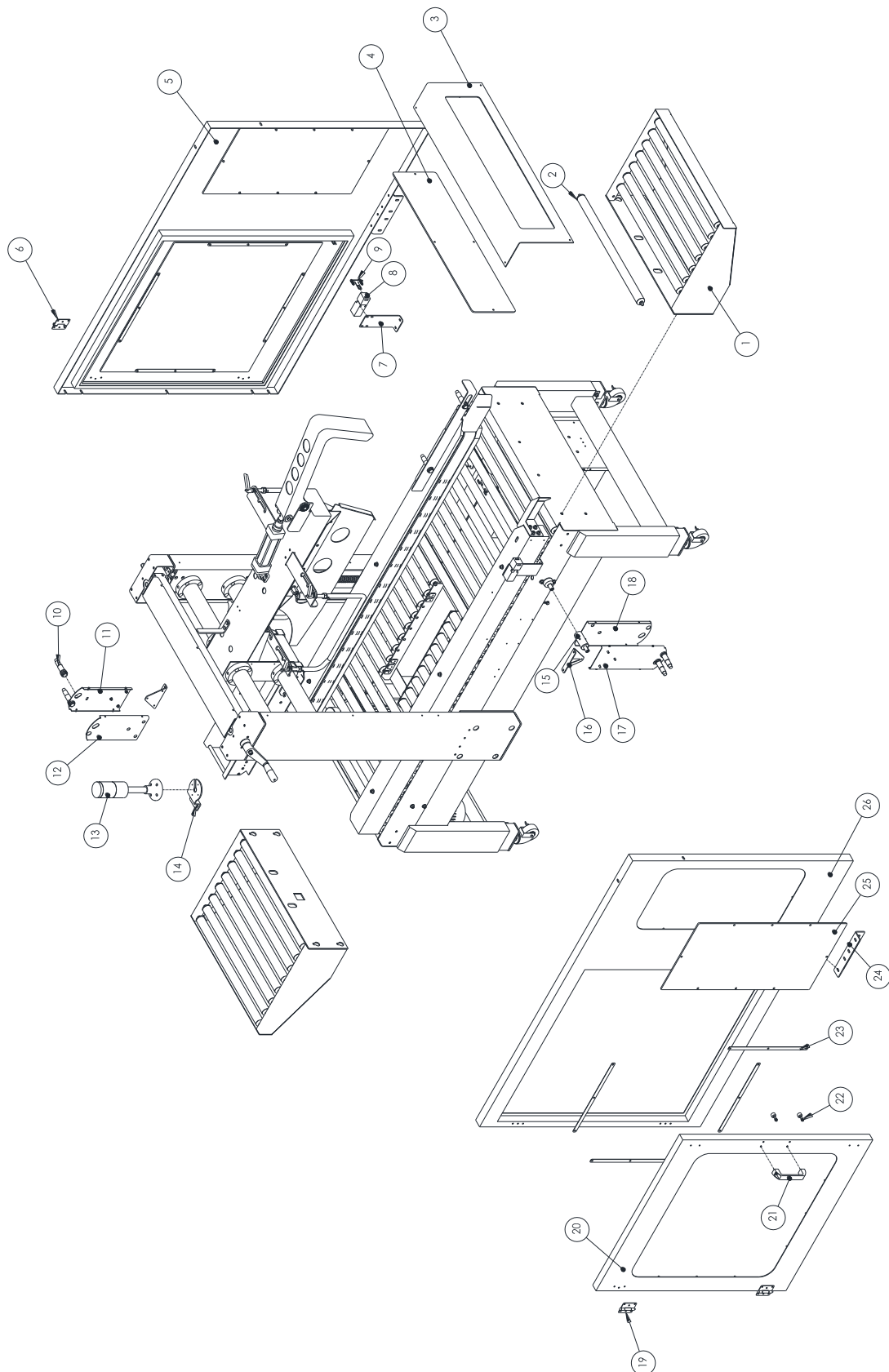
TOP SEAT			
#	PART NUMBER	DESCRIPTION	Q'TY
1	P02-0074400	SUPPORT BAR	2
2		FOLDING DEVICE SEAT	1
3		SUPPORT PLATE	1
4		GUIDE PLATE	1
5		UPPER TAPE HEAD SEAT (LEFT)	1
6	P02-0069400	CONNECT BAR	2
7		B PLATE	4
8		UPPER TAPE HEAD SEAT (RIGHT)	1
9		TUBE FIXED SEAT	1
10	P02-0074300	FIXED RING	4
11		COMPRESSION ROLLER BAR	2
12		COMPRESSION ROLLER SEAT	2
13	P02-0078600	COMPRESSION ROLLER SHAFT	4
14	P06-0022400	COMPRESSION ROLLER	4
15		KNOB SCREW	2
16		LOCKING BRACKET	2
17	P1113-0003900	HANDLE KNOB M10x63	2
18		CONNECT SEAT	1
19		FOLDING DEVICE SEAT	1
20		FOLDING DEVICE BRACKET	1
21	P1112-0003000	FIXED HANDLE	4
22	P02-0069100	FIXED SCREW	4
23	P02-0069000	FOLDING DEVICE	2
24	P0402-000140A	ISO CYLINDER MCQV-11-40-100	1
25	P1104-060000500	ROD END PHS12EC M12x1.25	1
26	P02-006890A	ARM SHAFT	1
27		FOLDING ARM	1
28		FLAP DIVIDER SUPPORT	1
29		FLAP DIVIDER SUPPORT	1
30	P1104-076002ZZ0	BEARING	1
31		FIXED SEAT	1
32	P02-0074500	FIXED PIN	1
33		FLAP DIVIDER	1
34	P02-006880A	CYLINDER CONNECT SHAFT	1

MACHINE BODY



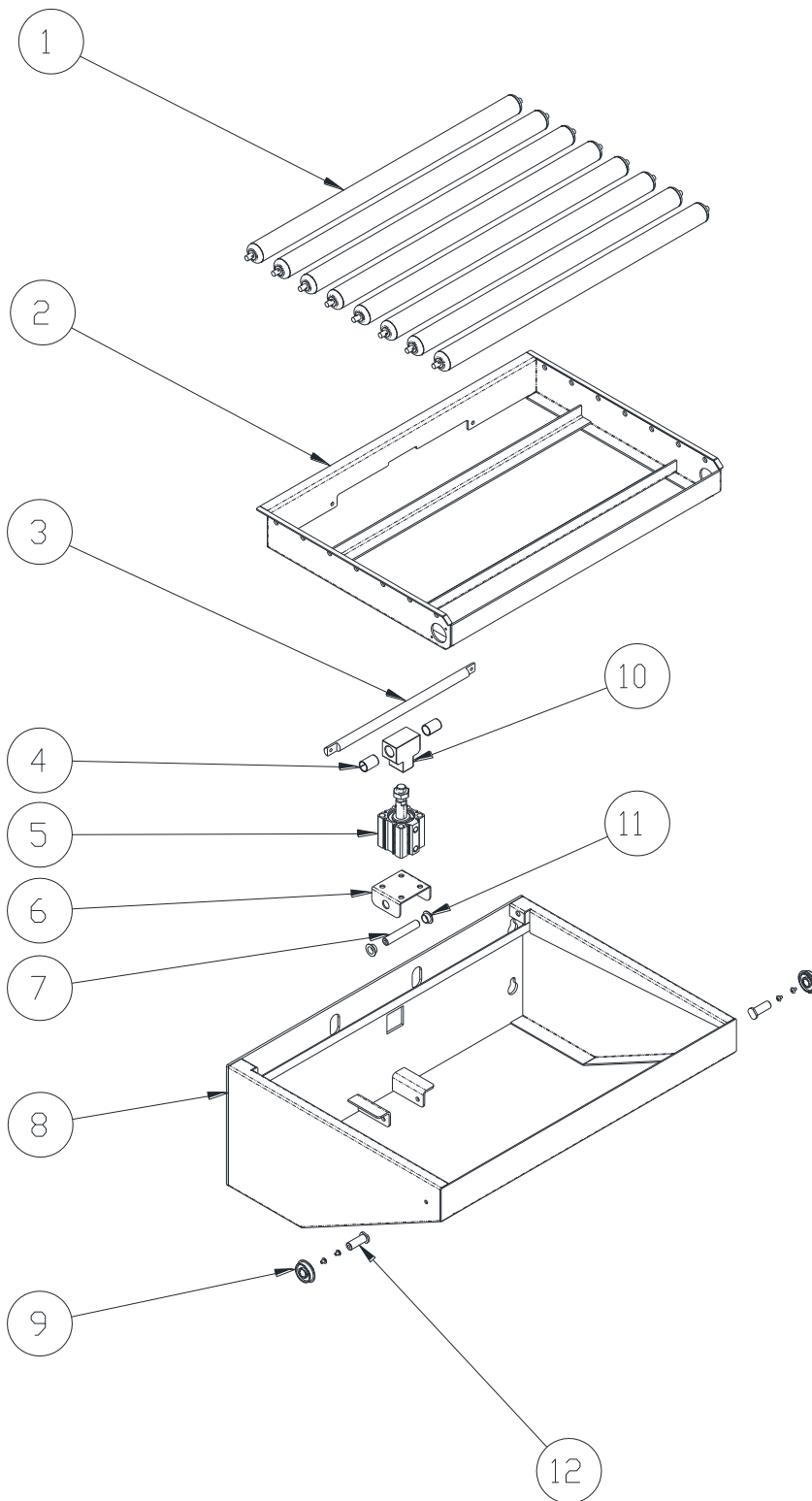
MACHINE BODY			
#	PART NUMBER	DESCRIPTION	Q'TY
1		MACHINE FRAME	1
2	P1101-0906012AN	SCREW M6*12L	8
3		MACHINE LEG	4
4		CLAMP	4
5		FIXED PLATE	4
6		ADJUSTABLE LEG	4
7	P1102-01B4AZ	NUTN 1/2"	4
8	P1107-0000300	CASTER	4
9		CONTROL BOX	1
10		WIRING PLATE	1
11		CONTROL BOX DOOR	1
12	P08-0005000	ROLLER(LONG)	18
13	P08-0004900	ROLLER(SHORT)	18
14		B-PLATE	2
15		A-PLATE	2
16		SUBSIDYLEG	2
17		RADIOTUBE PLATE	1
18	P1118-010000100	LOCK	2
18	P1118-020000100	KEY	2
18	P1118-030000100	PLATE	2

SAFETY DOOR & TAPE DETECTOR & INDEX TABLE (OPTIONS)



SAFETY DOOR & TAPE DETECTOR			
#	PART NUMBER	DESCRIPTION	Q'TY
1		INFEED/OUTFEED TABLE FRAME	2
2	P08-0004900	ROLLER(SHORT)	16
3		DOOR SUPPORT	1
4	P06-0046100	ACRYLIC DOOR	1
5		SAFETY DOOR FRAME (R)	1
6		HINGE (L)	1
7		SAFETY SWITCH SEAT	2
8	P0311-020000100	SAFETY SWITCH TZ-93BPG	2
9	P0311-030000100	SAFETY SWITCH KEY TZ93-K3	2
10	P0302-020000600	PHOTO EYE SENSOR	4
11		PHOTO EYE SENSOR SUPPORT (INNER)	1
12		PHOTO EYE SENSOR SUPPORT (OUTER)	1
13	P0312-010001900	ALARM LIGHT SET	1
14		ALARM LIGHT SEAT	1
15	P02-0088900	EXTENDED SHAFT BUSH	2
16		FIXED SUPPORTING SEAT	2
17		PHOTO EYE SENSOR SUPPORT (INNER)	1
18		PHOTO EYE SENSOR SUPPORT (OUTTER)	1
19		HINGE (R)	2
20		SAFETY DOOR	2
21	P1112-000070A	DOOR HANDLE	2
22	P1106-020000100	MAGNET	4
23		PLATE	12
24		SUPPORTING PLATE	2
25	P06-0010400	ACRYLIC DOOR	2
26		SAFETY DOOR FRAME (L)	1

INDEX ROLLER TABLE (OPTIONAL)



INDEX ROLLER TABLE (OPTIONAL)			
#	PART NUMBER	DESCRIPTION	Q'TY
1	P08-0005100	ROLLER	8
2		ACTIVE TABLE	1
3	P02-036330A	SUPPORT SHAFT	1
4	P1104-0315250	BUSHING	2
5	P0402-0007400	CYLINDER	1
6		CYLINDER FIX PLATE	1
7	P02-0363500	PIVOT SHAFT	1
8	P01-0615500	FRAME	1
9	P1104-076201ZZ0	BEARING	2
10	P02-0394800	CYLINDER SEAT	1
11	P1104-0312060	BUSHING	2
12	P02-0363400	SHAFT	2



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TAPE HEAD 2-GPEXC-101

OPERATION MANUAL

1.SPECIFICATIONS

1.1 TAPE HEAD DIMENSIONS	2
1.2 MACHINE DESCRIPTION	3

2.OPERATION DESCRIPTION

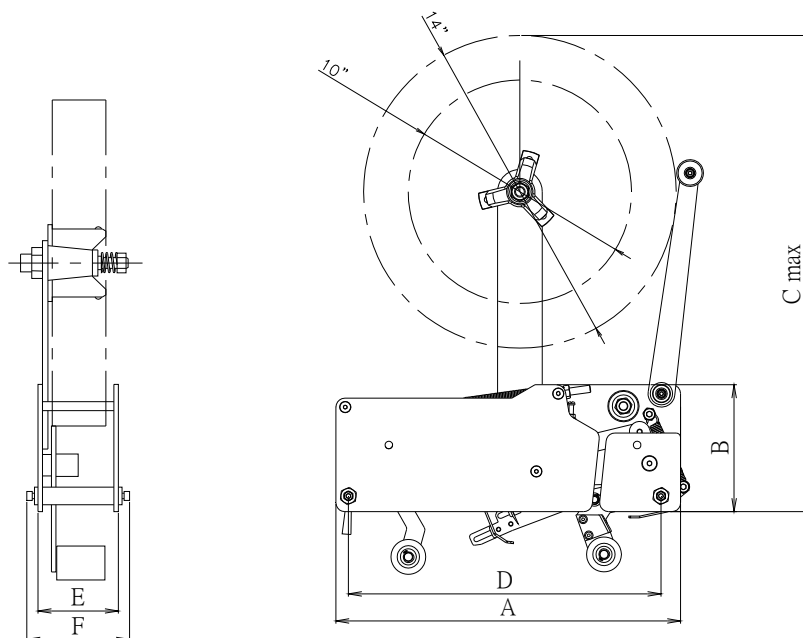
2.1 ADJUSTMENTS	4
2.2 TAPE LEG ADJUSTMENT	6
2.3 RESOLVING TAPING ISSUES	8

3. PARTS LIST

3.1 PARTS LIST	10
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1. SPECIFICATIONS

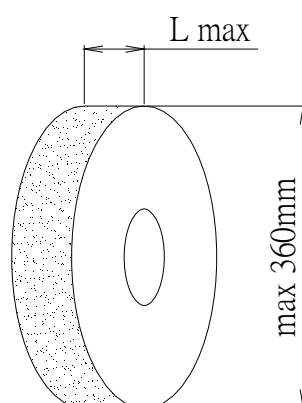
1.1 TAPE HEAD DIMENSION



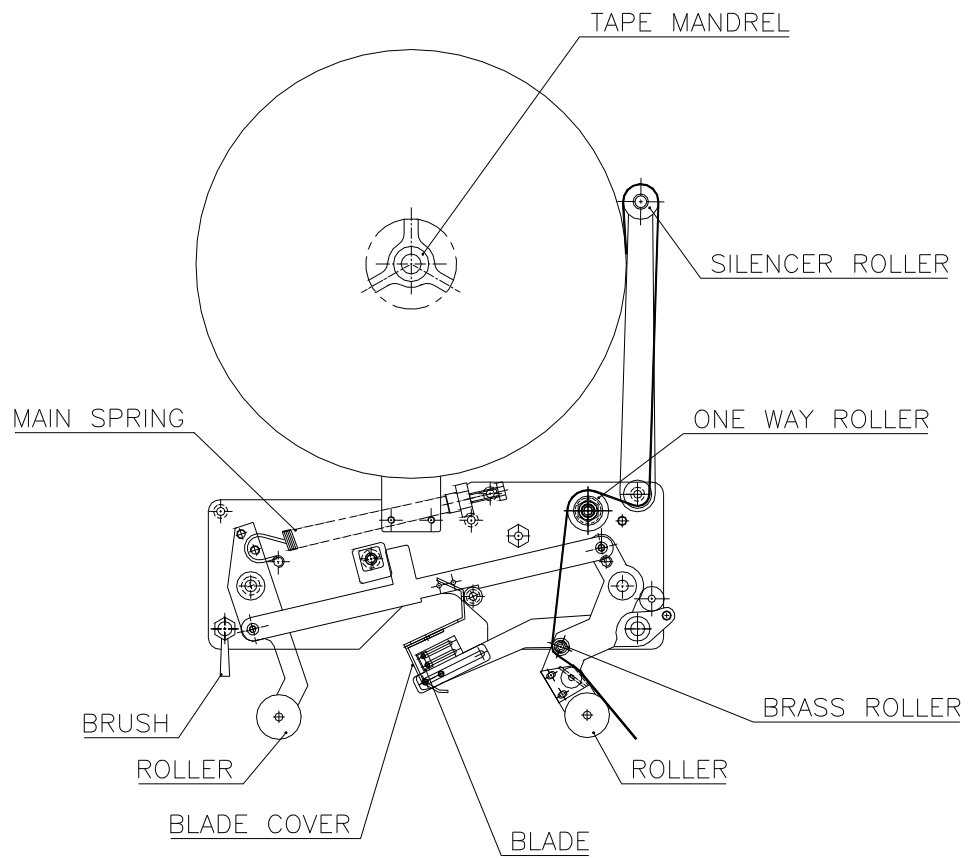
	A	B	C max	D	E	F
2"	386mm	142mm	485~540mm	350mm	90mm	115~145mm
3"	408mm	160mm	485~540mm	383mm	115mm	140~170mm

PVC/Polypropylene/Paper

	L max
2"	50mm
3"	75mm



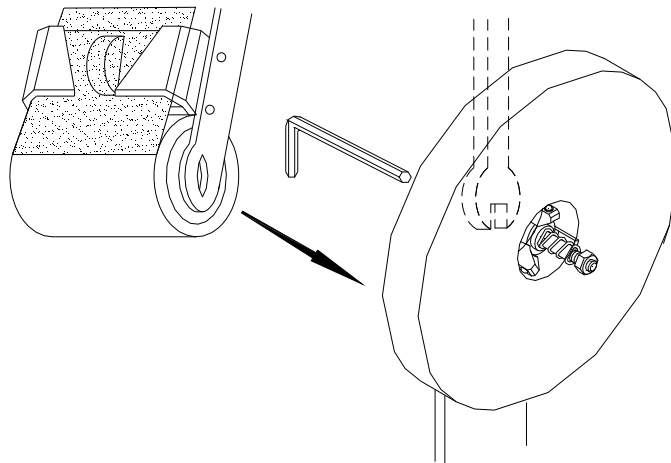
1.2 MACHINE DESCRIPTION



2. OPERATION DESCRIPTION

2.1 ADJUSTMENTS

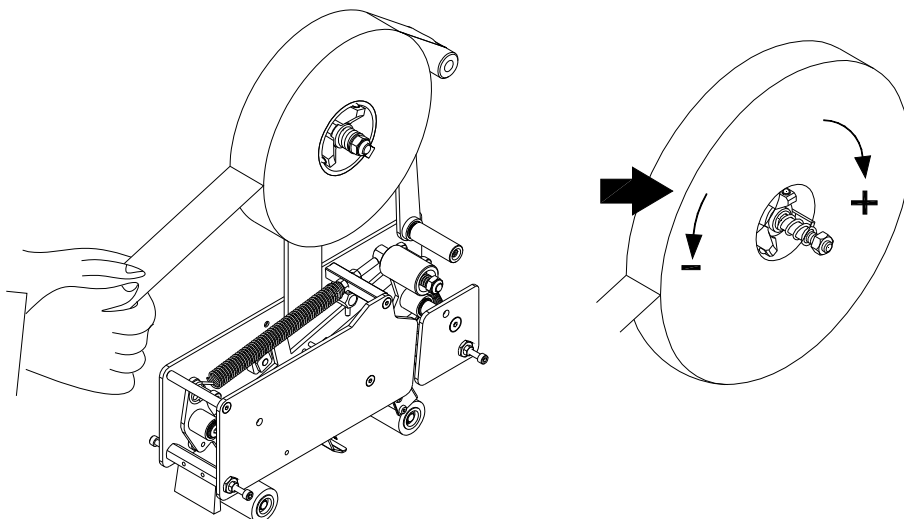
1) Check the center position of the tape on all rollers.



2) Check the tape position for tension

PVC tape: core-holder adjust to the loosen position.

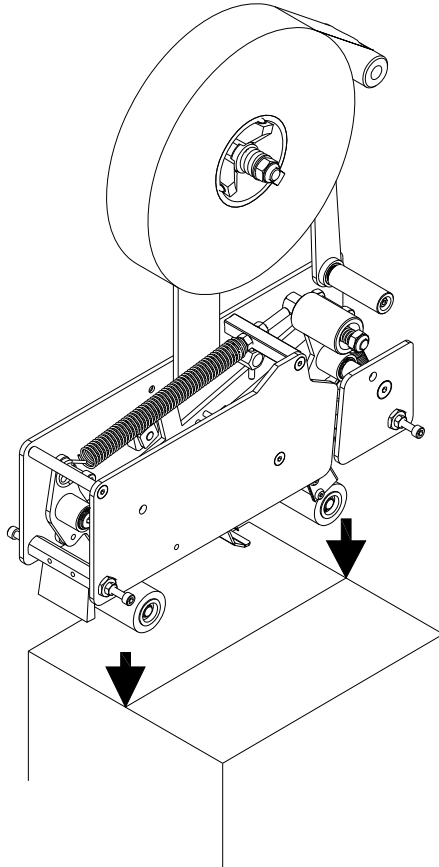
P.P tape: core-holder adjust to the tighten position.



3)Adjust the main spring:

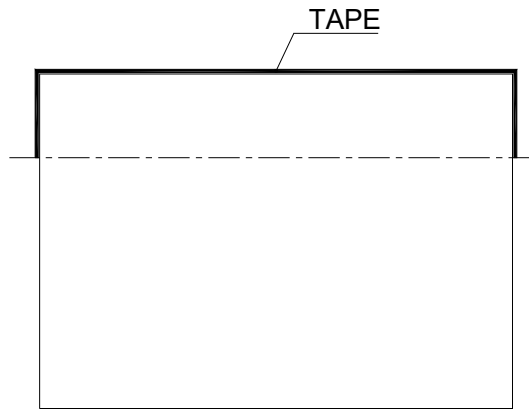
When using light boxes, decrease the spring tension.

When using strong boxes, increase the spring tension.



2.2 TAPE LEG ADJUSTMENT

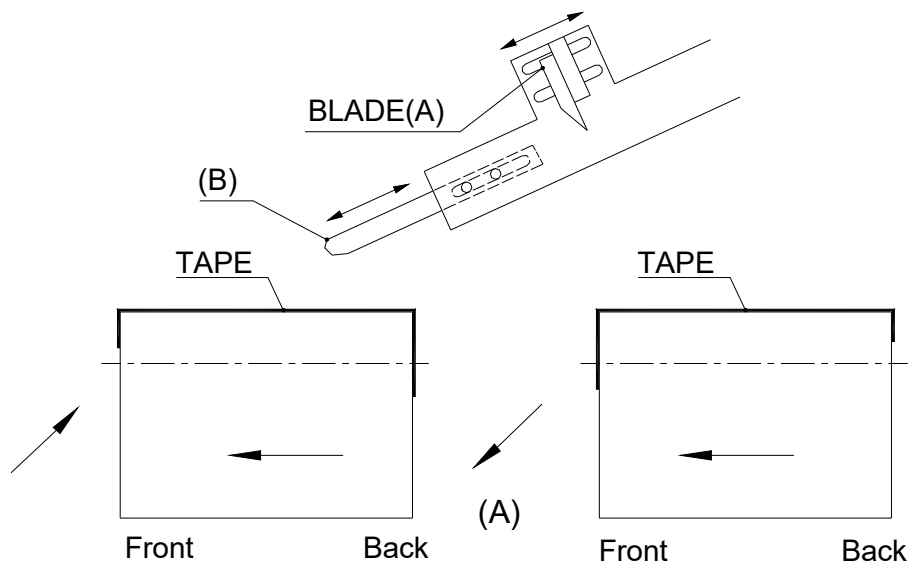
If operator requires to adjust the length of the tape legs, please refer to the following indication on the drawings.



Adjustment of the tape legs

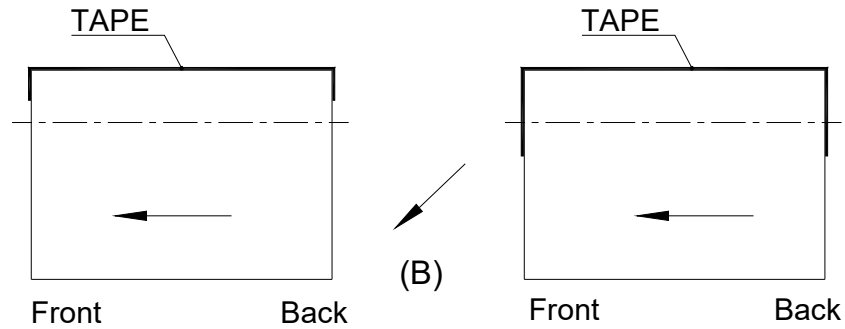
Move the position on blade A. To balance out the tape legs On both ends.

- 1) Move blade upward, operator will get longer rear leg.
- 2) Move blade downward, operator will get longer front leg.



Adjustment on the length of tape spacing

- 3) Adjust position (B). Upward in order to shorten the length of the tape.
- 4) Adjust position b. Downward to obtain longer length of tape.



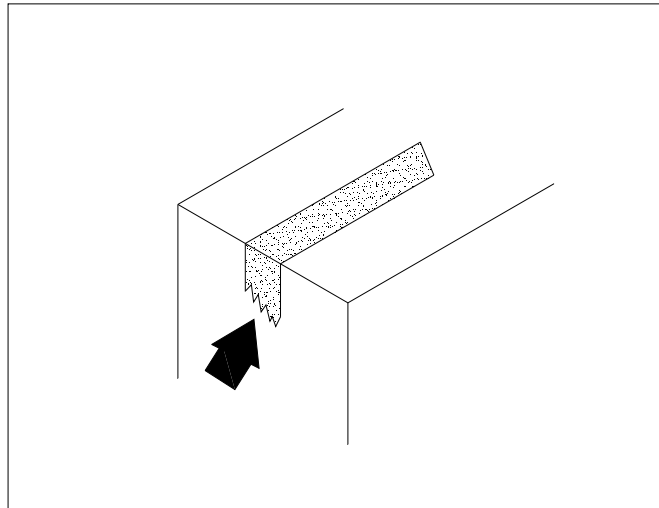
2.3 RESOLVING TAPING ISSUES

Issues

Solutions

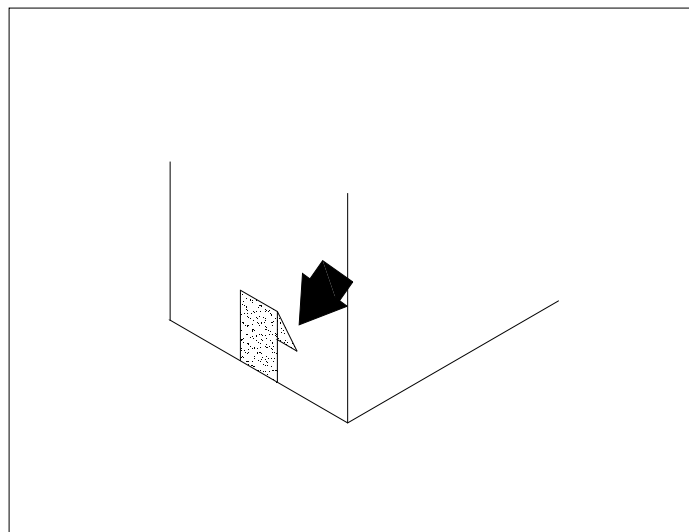
indented cut

● clean the blade or replace it.



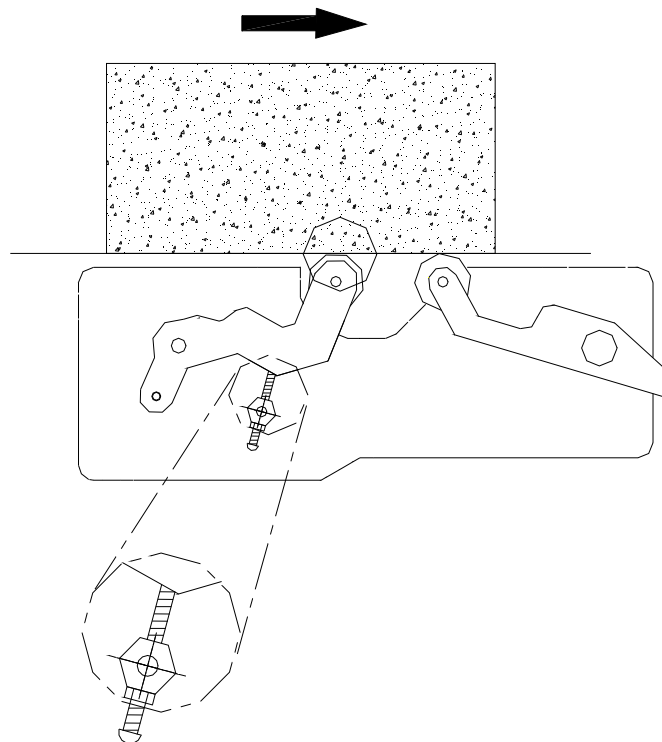
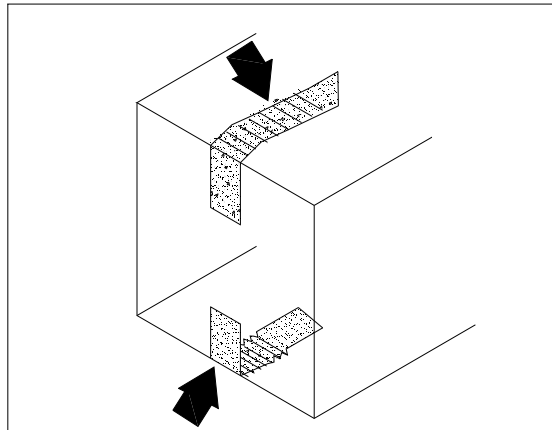
Tape folding

● check all rollers turn freely.



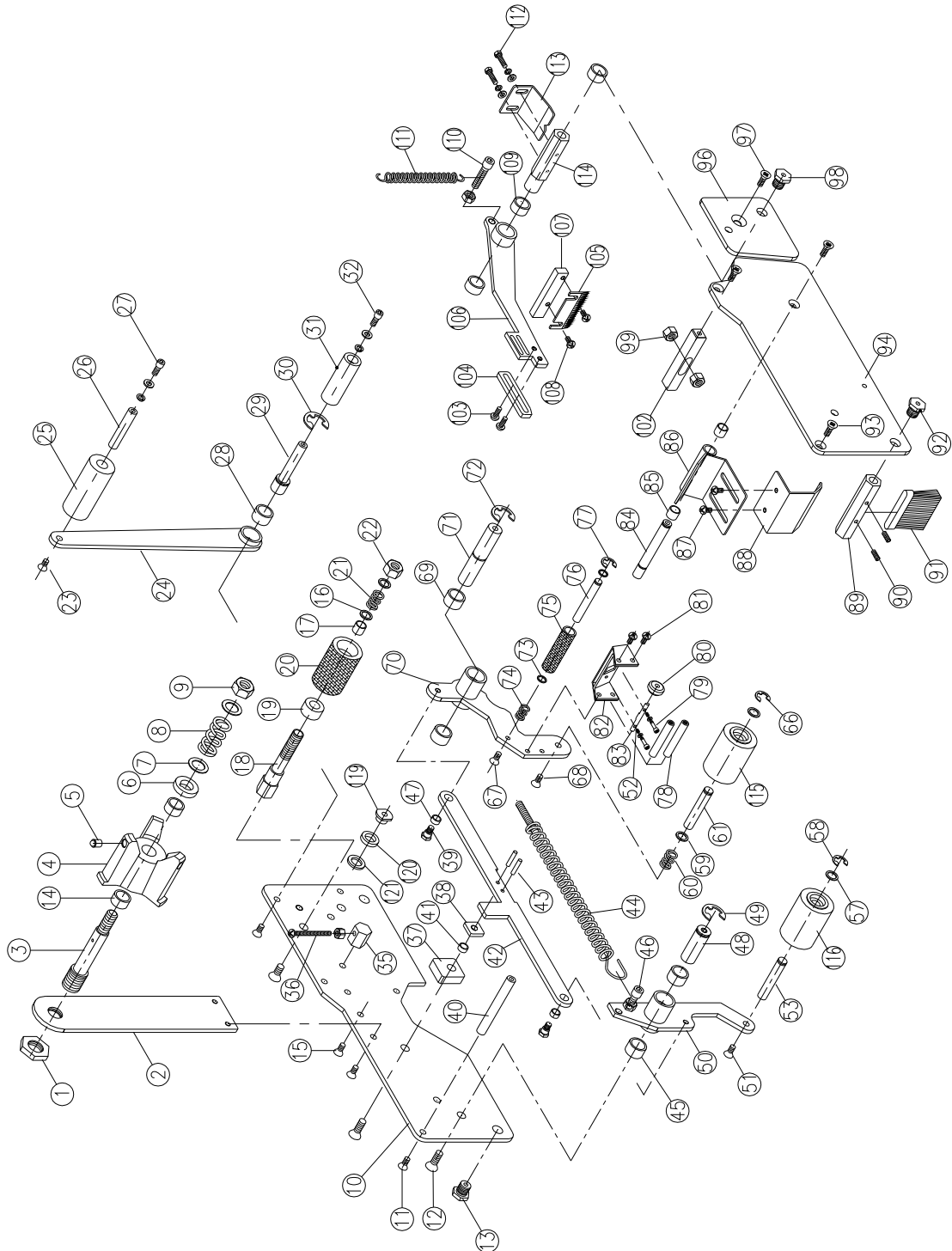
Tape scrambling

● adjust the tape head height.
(approx.1.5mm from box)

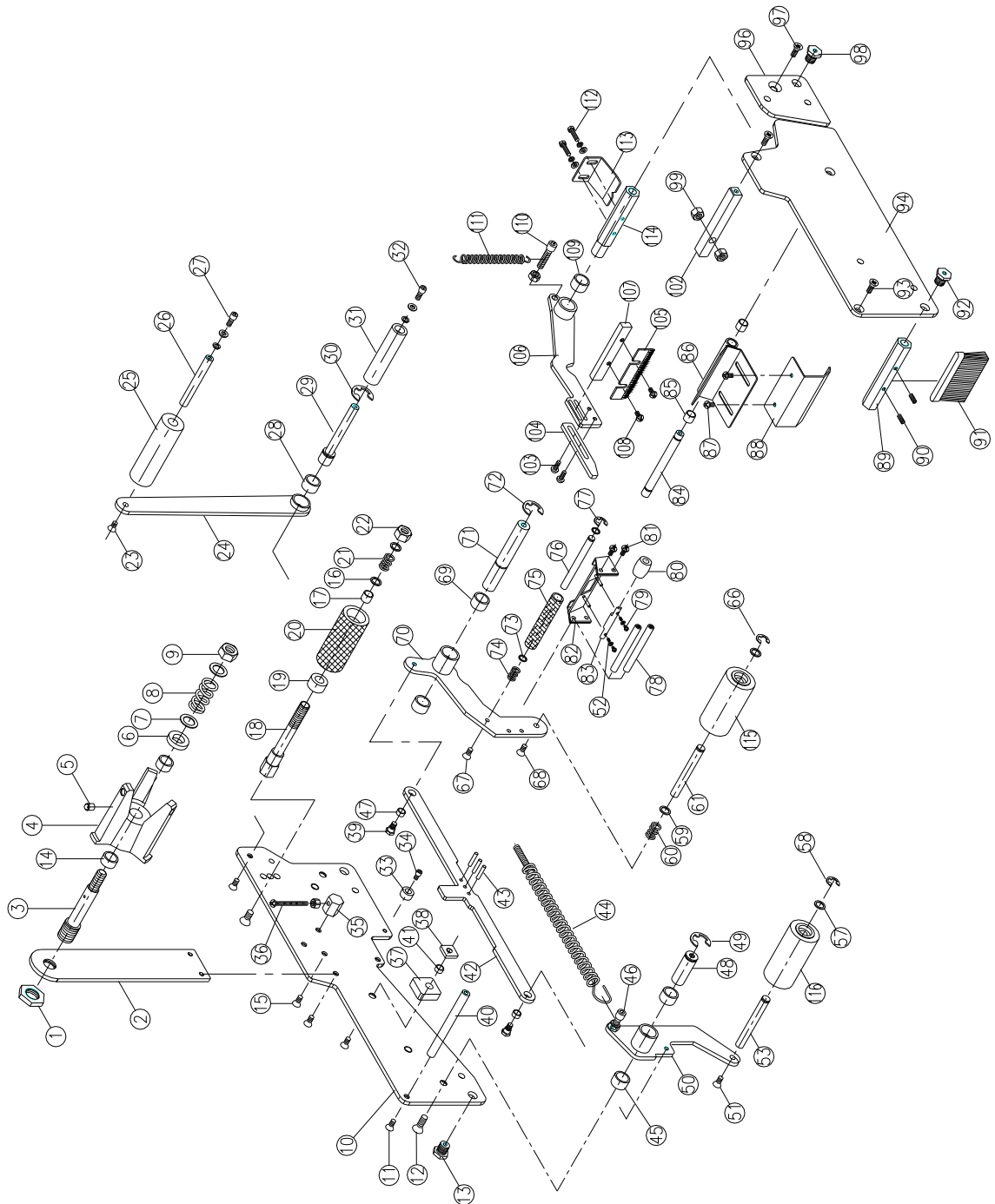


3.PARTS LIST

2"TAPE HEAD



3"TAPE HEAD



PARTS LIST FOR EXC-101

KEY NO	PART NO.	DESCRIPTION	Q'TY
1	P02-008070A	ADJUSTABLE NUT	1
2	P01-0137300	TAPE MANDREL BRACKET	1
3	P02-008060A	TAPE MANDREL SHAFT	1
4	P02-0080500	TAPE MANDREL (2")	1
	P02-0085400	TAPE MANDREL (3")	1
5	P1122-0000100	SPRING PLUNGERS	3
6	P06-0022700	RING WASHER	1
7	P06-0023000	WASHER	2
8	P1201-0003800	SPRING	1
9	P1102-0112BZ	NUT M12	1
10	P01-0130400	SIDE PLATE-R (2")	1
	P01-014580B	SIDE PLATE-R (3")	1
11	P1101-0406012AN	SCREW M6x12L	6
12	P1101-0406016AN	SCREW M6x16L	4
13	P02-0082100	HOLDING SCREW	2
14	P1104-081519100	BUSH Ø15 x Ø19 x 10L	2
15	P1101-0406012AN	SCREW M6x12L	2
16	P06-0023700	WASHER	2
17	P1104-081012100	BUSH Ø10 x Ø12 x 10L	1
18	P02-008110A	ONE WAY ROLLER SHAFT (2")	1
	P02-0086000	ONE WAY ROLLER SHAFT (3")	1
	P1104-161216160	SPACE COLLARS	1
19	P1104-17HF16160	ONE WAY BEARING	1
20	P02-0081200	ONE WAY ROLLER (2")	1
	P02-0086100	ONE WAY ROLLER (3")	1
21	P1201-0004000	SPRING	1
22	P1102-0110BZ	NUT M10	1
23	P1101-0406012AN	SCREW M6x12L	1
24	P02-0313600	ROLLER ARM (2")	1
	P01-0145700	ROLLER ARM (3")	1
25	P06-002280A	SILENCER ROLLER (2")	1
	P06-0024300	SILENCER ROLLER (3")	1
26	P02-0080800	SILENCER SHAFT (2")	1
	P02-0085500	SILENCER SHAFT (3")	1
27	P1101-0505012BN	SCREW M5x12L & S.W & W	1
28	P1104-081620120	BUSH Ø16 x Ø20 x 12L	1
29	P02-0082700	SHAFT (2")	1
	P02-0085600	SHAFT (3")	1
30	P1105-0116B	RING STW-16	1

S.W: SPRING WASHER

W: WASHER

PARTS LIST FOR EXC-101

KEY NO	PART NO.	DESCRIPTION	Q'TY
31	P06-0022900	SILENCER ROLLER (2")	1
	P06-0024400	SILENCER ROLLER (3")	1
32	P1101-0505012BN	SCREW M5x12L & S.W & W	1
33	P06-002470A	FIXED RING (3")	1
34	P1101-0505008AN	SCREW M5x8L (3")	1
35	P02-0081900	ADJUSTMENT SHAFT	1
36	P1101-0305045AZ	SCREW M5x45L	1
37	P06-002350A	FIXED PIECE (2")	1
38	P01-013800A	PLATE	1
39	P02-0081600	SIMULTANEOUS BAR SHAFT	2
40	P02-0082400	PLATE HOLDING SHAFT (2")	1
	P02-0087000	PLATE HOLDING SHAFT (3")	1
41	P1104-080810050	BUSH Ø8 x Ø10 x 5L	1
42	P01-013050A	SIMULTANEOUS BAR (2")	1
	P01-014610B	SIMULTANEOUS BAR (3")	1
43	P1109-0105025B	PIN Ø5x 25L (2")	2
	P1109-0104025B	PIN Ø4 x 25L (3")	3
44	P1202-000550A	MAIN SPRING	1
45	P1104-081620120	BUSH Ø16 x Ø20 x 12L	2
46	P1101-0508020AN	SCREW M8x20L & NUT	1
47	P1104-080810050	BUSH Ø8 x Ø10 x 5L	2
48	P02-008170A	ARM ASSEMBLY SHAFT	1
49	P1105-0116B	RING STW-16	1
50	P02-0313400	REAR ROLLER ARM ASSEMBLY (2")	1
	P02-0085900	REAR ROLLER ARM ASSEMBLY (3")	1
51	P1101-0406016AN	SCREW M6x16L	1
52	P1201-000410A	SPRING	2
53	P02-0081500	ROLLER SHAFT (2")	1
	P02-0086400	ROLLER SHAFT (3")	1
54			
55			
56			
57	P06-0023700	WASHER	1
58	P1105-0110B	RING STW-10	1
59	P06-0023700	WASHER	2

S.W: SPRING WASHER

W: WASHER

PARTS LIST FOR EXC-101

KEY NO	PART NO.	DESCRIPTION	Q'TY
60	P1201-0004000	SPRING	1
61	P02-0081500	ROLLER SHAFT (2")	1
	P02-0086400	ROLLER SHAFT (3")	1
62			
63			
64			
65			
66	P1105-0110B	RING STW-10	1
67	P1101-0405010AN	SCREW M5x10L	3
68	P1101-0406010AN	SCREW M6x10L	1
69	P1104-081620120	BUSH Ø16 x Ø20 x 12L	2
70	P02-0313300	FRONT ROLLER ARM ASSEMBLY (2")	1
	P01-014590A	FRONT ROLLER ARM ASSEMBLY (3")	1
71	P02-008180A	ARM ASSEMBLY SHAFT (2")	1
	P02-008650A	ARM ASSEMBLY SHAFT (3")	1
72	P1105-0116B	RING STW-16	1
73	P06-0023600	WASHER Ø8.2 x Ø10.5 x 1t	2
74	P1201-0003900	SPRING	1
75	P02-0081300	BRASS ROLLER (2")	1
	P02-0086200	BRASS ROLLER (3")	1
76	P02-0081400	BRASS ROLLER SHAFT (2")	1
	P02-0086300	BRASS ROLLER SHAFT (3")	1
77	P1105-0108B	RING STW-8	1
78	P02-0080900	TAPE HOLDER SUPPORT SHAFT (2")	2
	P02-0085700	TAPE HOLDER SUPPORT SHAFT (3")	2
79	P1101-0703A35AZ	SCREW M3x13L	2
80	P06-002340A	TAPE HOLDER SUPPORT ROLLER (2")	1
	P06-0024500	TAPE HOLDER SUPPORT ROLLER (3")	1
81	P1101-0605010BN	SCREW M5x10L	2
82	P02-0130800	TAPE HOLDER SUPPORT (2")	1
	P02-0150000	TAPE HOLDER SUPPORT (3")	1
83	P02-0081000	HOLDER SHAFT (2")	1
	P02-0085800	HOLDER SHAFT (3")	1
84	P02-0082300	BLADE COVER SHAFT (2")	1
	P02-008680A	BLADE COVER SHAFT (3")	1
85	P1104-081012100	BUSH Ø10 x Ø12 x 10L	2
86	P01-013830A	BLADE COVER (2")	1
	P01-014640C	BLADE COVER (3")	1
87	P1101-0605006BN	SCREW M5x6L	2

S.W:SPRING WASHER

W:WASHER

PARTS LIST FOR EXC-101

KEY NO	PART NO.	DESCRIPTION	Q'TY
88	P01-0138400	BLADE COVER (2")	1
	P01-014650B	BLADE COVER (3")	1
89	P02-0082600	BRUSH SUPPORT (2")	1
	P02-0087200	BRUSH SUPPORT (3")	1
90	P1101-0705006AB	SCREW M5x6L	2
91	P13-0000500	BRUSH (2")	1
	P13-0000600	BRUSH (3")	1
92	P02-0082100	HOLDING SCREW	2
93	P1101-0406012AN	SCREW M6x12L	3
94	P01-019720A	SIDE PLATE-L (2")	1
	P01-014660B	SIDE PLATE-L (3")	1
96	P01-013860A	PLATE-L (2")	1
	P01-014670A	PLATE-L (3")	1
97	P1101-0408012AN	SCREW M8x12L	1
98	P02-0082100	HOLDING SCREW	1
99	P1102-0108AZ	NUT M8	2
102	P02-0082500	BRUSH HOLDER SHAFT (2")	1
	P02-0087100	BRUSH HOLDER SHAFT (3")	1
103	P1101-0605010BN	SCREW M5x10L	2
104	P06-0051100	BLADE ARM ADJUSTABLE BAR (2")	1
	P01-014630A	BLADE ARM ADJUSTABLE BAR (3")	1
105	P02-0082000	BLADE (2")	1
	P02-0086700	BLADE (3")	1
106	P02-0313500	BLADE ARM (2")	1
	P01-014620A	BLADE ARM (3")	1
107	P02-0079100	BLADE SEAT (2")	1
	P02-008660C	BLADE SEAT (3")	1
108	P1101-0605010BN	SCREW M5x10L	2
109	P1104-081519100	BUSH Ø15 x Ø19 x 10L	2
110	P1101-0508030AN	SCREW M8x30L & NUT	1
111	P1202-0005400	BLADE ARM SPRING	1
112	P1101-1005010AZ	SCREW M5x10L & S.W & W	2
113	P01-0138700	GUIDE PLATE	1
114	P02-0082200	HOLDER SHAFT (2")	1
	P02-0086900	HOLDER SHAFT (3")	1
115	P06-0023200	ROLLER SET (FRONT) (2")	1
	P06-0024800	ROLLER SET (FRONT) (3")	1
116	P06-0023300	ROLLER SET (REAR) (2")	1
	P06-0024900	ROLLER SET (REAR) (3")	1
119	P02-007590A	FIXED SHAFT (2")	1
120	P06-0020800	BUMPER (2")	1
121	P01-0130600	WASHER (2")	1

S.W: SPRING WASHER

W: WASHER