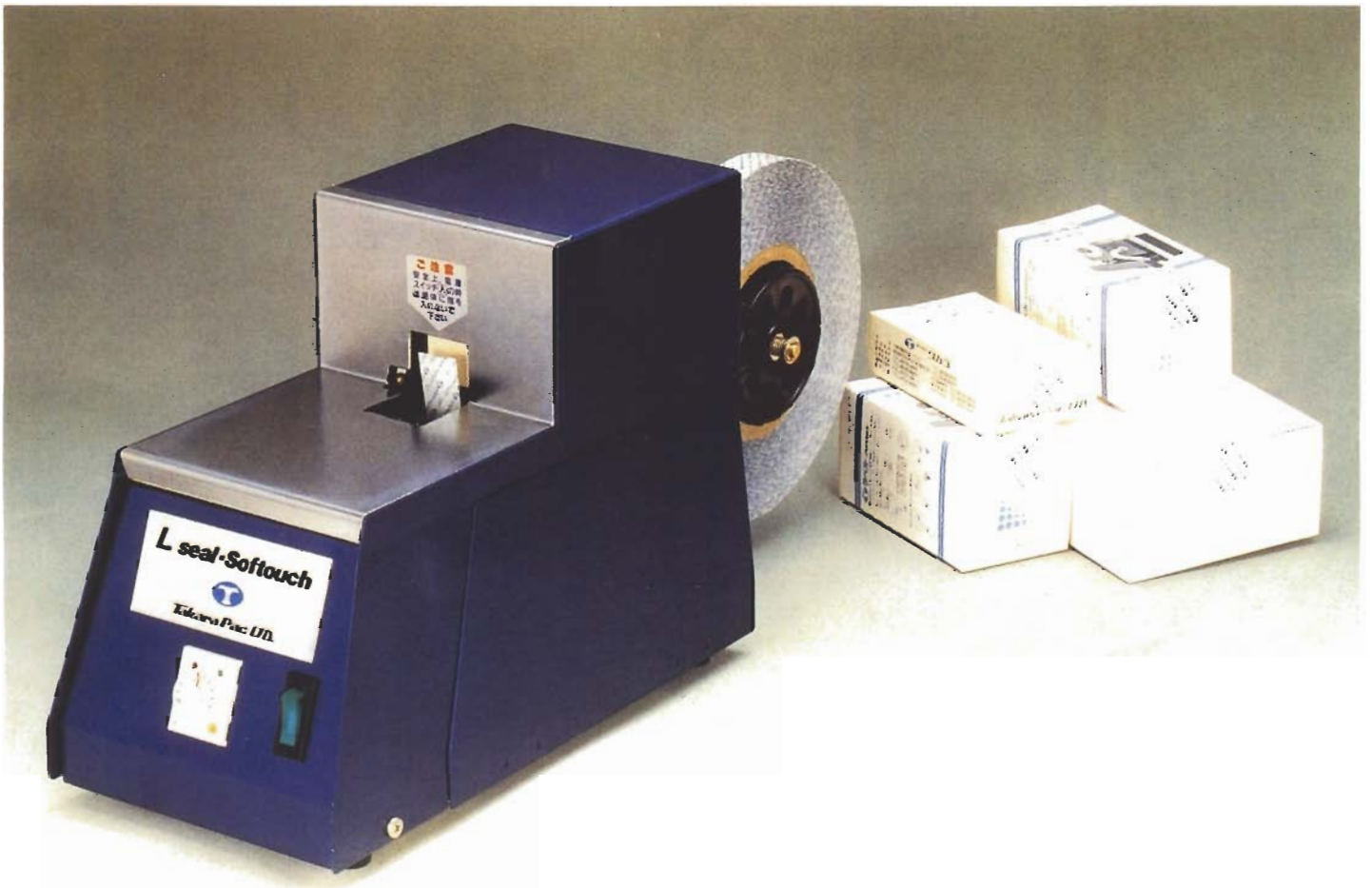


INSTRUCTIONS

Portable Box Sealer

L-SEAL "SOFTOUCH"



TAKARA PAC LTD

ADDRESS : 32-25 YUGA 4-CHOME
SETAGAYA-KU, TOKYO, JAPAN

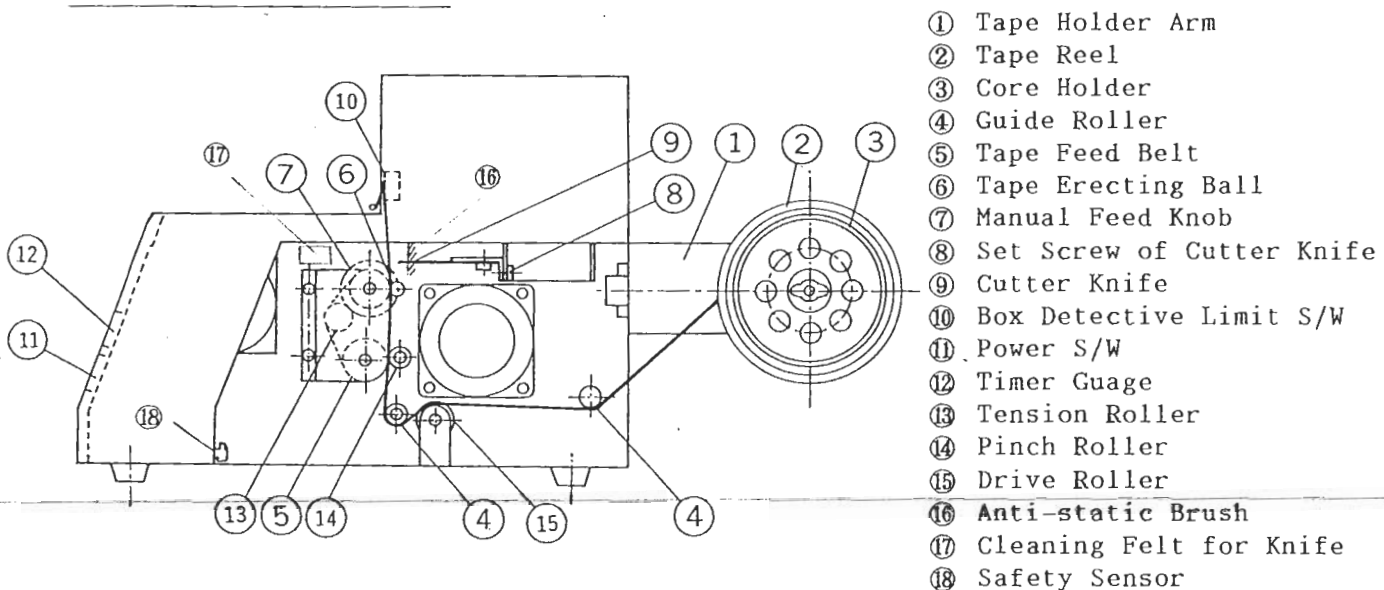
TEL : 001-813-3707-5140
FAX : 001-813-3707-5145

1. SPECIFICATIONS

Power Supply*	AC110V	
Capacity	Max. 50 boxes per munute. (Depends on skill)	
Tape	Material	Cellophane, P P, P E T
	Width	12 mm, 15 mm, 18 mm
	Core I.D.	76 mm (3 inches)
Cut Length	20 ~ 40 mm	
Size and Weight	285 mm(L) x 145 mm(W) x 220 mm(H), 5.3 Kg	

* Other voltages are available by option.

2. DIAGRAM & DESCRIPTIONS



- ① Tape Holder Arm
- ② Tape Reel
- ③ Core Holder
- ④ Guide Roller
- ⑤ Tape Feed Belt
- ⑥ Tape Erecting Ball
- ⑦ Manual Feed Knob
- ⑧ Set Screw of Cutter Knife
- ⑨ Cutter Knife
- ⑩ Box Detective Limit S/W
- ⑪ Power S/W
- ⑫ Timer Gauge
- ⑬ Tension Roller
- ⑭ Pinch Roller
- ⑮ Drive Roller
- ⑯ Anti-static Brush
- ⑰ Cleaning Felt for Knife
- ⑱ Safety Sensor

3. SET UP

a. Threading Tape

1. Set ② Tape Reel on ③ Core Holder and thread tape as per above diagram. (Same diagram is labeled inside of the door cover.) Adhesive side is facing downward.
2. Let adhesive side face to ⑤ Tape Feed Belt. Supporting tape with your finger, rotate ⑦ Manual Feed Knob until Tape comes ahead ⑤ Tape Feed Roller.
3. Tape goes up along with ⑤ Feed Roller and at last stands alone. Conditions of erecting (going up) tape is adjustable by ⑥ Tape Erecting Ball. Details are in Chapter 5 (c) on page 4.
4. When you splice or replace tapes, adhere 2 tape-ends and proceed as above.
NOTE: The joint portion should avoid to be applied on a box.

b. Tape Cut Length

⑫ Timer Gauge on front face defines tape cut length approximately.
Tape cut length is adjustable in 20mm ~ 40mm by ⑫ Timer Gauge.

*Even though at the same gauge, frequency(50 or 60Hz) varies cut length.
And also other factors, such as tape materials, may vary, so measure actual length after gauge tuning.

*As a reference, we introduce our test data.

Value of Gauge	Frequency	Tape Cut Length
0.4	60Hz	Approx. 20mm
0.45	50Hz	Approx. 20mm
0.8	60Hz	Approx. 40mm
0.9	50Hz	Approx. 40mm

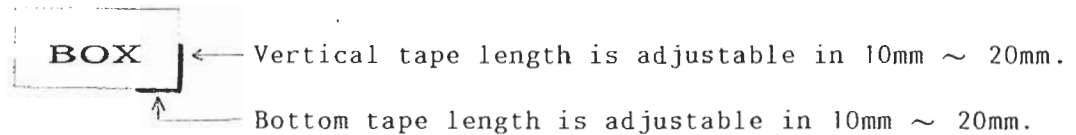
c. Applicating Position

Applicating position on a box (Balance of Vertical and Horizontal tape lengths) can be adjustable with the ⑨ Cutter Knife position (⑧ Set Screw of Knife).

1. Loosen ⑧ Set Screw and move ⑨ Cutter Knife up and down.

2. When select Upper, the Vertical length becomes longer than Bottom length.
When select Lower, the Vertical length becomes shorter than Bottom length.
Total tape cut length is not change by this arrangement.

3. Center position (if select this, tape's vertical length equals to bottom's) of each total length(20, 30, 40 mm) is marked on Mounting Fixture of ⑧ Set-Screw.



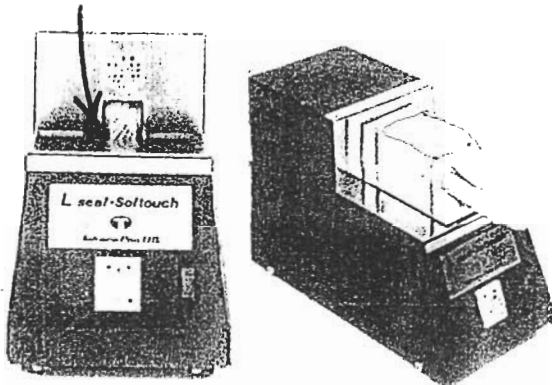
4. When the desired position is gained, tighten the ⑧ Set Screw firmly.

Above all is the preparation before operation. Now you are ready.

But prior to operations, try a few experimental tests and see applied tape length.

4. OPERATION

Press here with a box corner



a. Make sure that door cover is closed.
Depress ⑪ Power S/W at upper side.

Power turns ON and inner lamp of S/W lits up.
If door cover is opened, ⑬ Safety Sensor at door does not allow power ON.

b. Hold a Box with hand. Press ⑩ Limit S/W with a Box Corner lightly.

Then tape shall be cut in pre-set length and applied on box in L-Shape.

c. On releasing the sealed box from ⑩ Limit S/W tape shall be fed in selected length and waits next cycle.
This sequence is one cycle of application.

5. MAINTENANCE

a. Replacing Cutter Knife

1. Loosen ⑨ Set Screw and remove old Cutter Knife from the mounting fixture.
2. Place a new Cutter Knife at the same position on mounting fixture and tighten ⑨ Set Screw to secure the knife position.

b. Replacing Tape

1. Adhere each tape end. Rotating ⑦ Manual Feed Knob, feed it until the joint-portion comes out.
2. When tape widths are different, adjust the position of ① Tape Holder Arm. Loosen 2 screws on ① Tape Holder Arm. Referring to Guide Marking on surface, Re-locate ① Holder so that new tape can run center position on ④ Guide Roll and ⑤ Feed Belt.

If tape is not centered, tape may snake and cause mal-applications.

c. Adjusting Tape End's Erection

When tape is too soft. Tape end may tend not to erect but to fall down at applying area.

In this case you can control its erection by adjusting ⑥ Tape Erecting Ball's position (Ball's pressure on Tape).

1. If Tape End tends to fall toward Package Side, loosen the set screw of ⑥ Tape Erecting Ball and move ⑥ Ball LEFT and/or UP little by little. When the best position is gained, fasten the set screw firmly.

NOTE: At this time, if move too left, ⑥ Ball presses tape too strongly to make pressure mark on tape or to disturb tape feeding.

2. If Tape End falls toward Cutter Side, loosen the set screw and move ⑥ Ball RIGHT and/or DOWN little by little. When the best position is gained, fasten the set screw firmly.

d. Cleaning Knife Blade

Cutter Knife may not cut tapes well when contaminated with adhesive residue. In a such case, clean up Knife Blade with silicon oil or other solvent such as alcohol etc.

Make sure Power OFF before cleaning up.

6. CAUTIONS

Don't insert your finger into opening where dangerous cutter is working inside.

Be sure POWER OFF whenever you service around knife or inside of machine.

Tape may curl or deform in exposed portion (about 30 cm long) when it has been left long time on machine. Avoid applying such wrong portion.

When box to be sealed is too soft or deformed, box cannot actuate ⑩ Limit S/W.