



Operations Manual

Eagle T400R Carton Sealer



**READ ALL INSTRUCTIONS CONTAINED IN THIS
MANUAL PRIOR TO MACHINE INSTALLATION!**

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1. Safety and Warnings



WHILE OPERATING THE MACHINE, OPERATORS MUST REFRAIN FROM WEARING CLOTHING OR ACCESSORIES THAT MAY GET CAUGHT IN THE MOVING PARTS OF THE MACHINE (WATCHES, RINGS, BRACELETS, TIES, LOOSE CLOTHING, ETC...)

The Eagle T400R is an automatic case sealing machine using pressure-sensitive tape such as PVC or BOPP. It automatically adjusts to the size of the box to seal the top and bottom.

This machine has a wide range of applications including the following industries: chemical fiber, pharmaceutical, publication, refrigeration and air-conditioning, household appliances, ceramics, produce, meats, poultry.

Prior to setting up the machine

1. Verify the model number matches the model number addressed in this manual.
2. Verify that no parts of the machine have been removed or are missing.
3. Remove all packaging or shipping materials used during transport or storage of the machine.
4. Check for any damage that may have occurred during shipping or transport.

Prior to operating the Eagle T400R, verify

- Protective shielding and covers are properly installed
- Top and side transfer rollers are present and properly installed
- Machine is on stable ground and casters are in the locked position.

The Eagle T400R is designed to automatically shut down if the control panel is opened while the machine is in operation.



DO NOT USE TO SEAL CARTONS CONTAINING HAZARDOUS SUBSTANCES OR EXPLOSIVE MATERIALS

2. Specifications

Power Requirement	110VAC, 50/60Hz (Single Phase)
Air Consumption	1cfm @ 80psi
Sealing Speed	15 cartons per minute
Max. Carton Weight	88lbs (40kg)
Tape Width	2-3in (48-72mm)
Carton Length	6in to infinite
Carton Width	4.7-19.68in
Carton Height	4.7-17.7in
Machine Length	45.3in
Machine Width	39.5in
Machine Height	48.4in
Weight	661lbs
Operational Environment	32-104°F (0-40°C) @ ≤ 98% Humidity
Machine Noise Levels	≤ 75db

3. Machine Setup and Installation



**TAKE CARE TO AVOID DAMAGE TO THE MOTOR AND ASSEMBLY
WHILE LIFTING OR TRANSPORTING THE MACHINE!**

3.1 Transportation

Use a fork lift or tow motor to remove the machine from its shipping container or pallet.

3.2 Working Height Adjustment

While elevated, install the adjustable legs onto the machine. Set each leg to the same height to ensure the machine is level when placed onto the ground.

The working height should be set such that the operator is able to comfortably reach the roller table while maintaining approximately 4in (100mm) of distance from the machine.

3.3 Tape Head Installation

Rest the upper tape head on the carriage placing the notches in the rear of the tape head onto the supporting shaft. Pull out the draw rod by the key ring, lower the tape head and release the key ring. For the lower tape head, remove the front supporting shaft. Rest the rear of the tape head on the rear supporting shaft. Place the front supporting shaft on the angled notches in the front of the tape head and lower the tape head down guiding the pin into the notches in the frame.

Check tape cutter position and adjust as needed.

3.4 Connect Power Supply

Connect the machine to the power supply.

Note: Prior to connecting the machine to the power supply, verify that the power switch is set to the 'OFF' position and that the work area is clean and clear of any items.

4. Operation

4.1 Standard Operation

Prior to operating the machine, please confirm that

1. The proper voltage is being supplied to the motor
2. All fasteners and protective covers are securely in place
3. All electronic components are dry

Machine Operation

1. Plug the machine into the power source
 - a. DO NOT hard wire the machine to the power source
2. Adjust horizontal and vertical guides to accommodate cartons to be sealed
3. Press the button labeled 'Start'
4. Verify belt movement direction
5. Place carton to be sealed into the feed side of the machine
 - a. Cartons must be placed in the center of the roller table for proper feed through the machine

After operating the machine for two to five minutes, check the following

1. Horizontal guide adjustment lever is firmly in place and belts do not have excess slack
 - a. Belt deviation (slack) should be checked once every ten days
 - b. Adjust belt tension as needed
2. Vertical guide adjustment is firmly in place and belts do not have excess slack
 - a. Belt deviation (slack) should be checked once every ten days
 - b. Adjust belt tension as needed
3. Verify that tape is being dispensed in a consistent manner that ensures a smooth application onto the carton being fed through the machine.



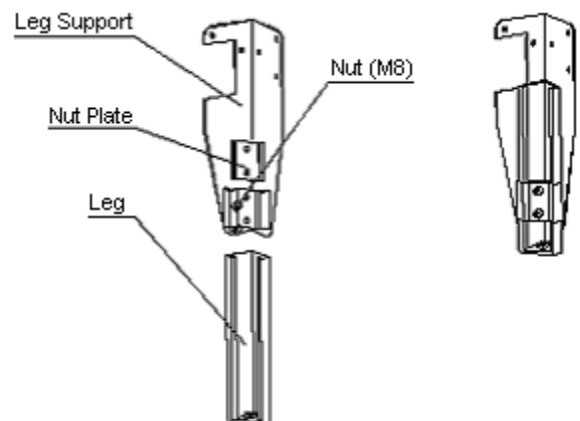
TURN OFF MACHINE AND DISCONNECT IT FROM THE POWER SOURCE PRIOR TO PERFORMING ANY MAINTENANCE OR SERVICE

4.2 Adjustable Work Height

Put the nut plate into the leg support according to the figure.

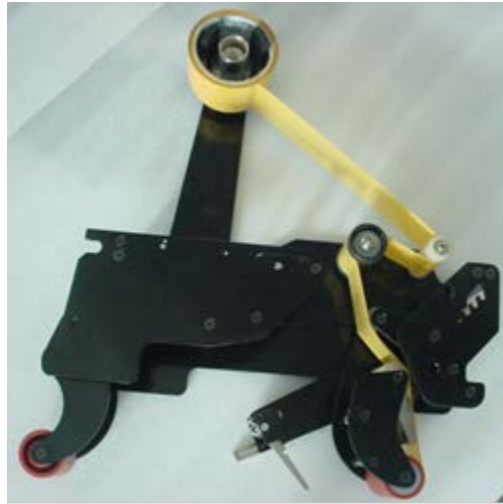
Then loosely connect the fastening piece and the nut plate with the socket head cap screws. Insert the leg between the leg support and nut plate. The leg can now be adjusted up and down as desired. Tighten the screws.

The working height should be set such that the operator is able to comfortably reach the roller table while maintaining approximately 4in (100mm) of distance from the machine.

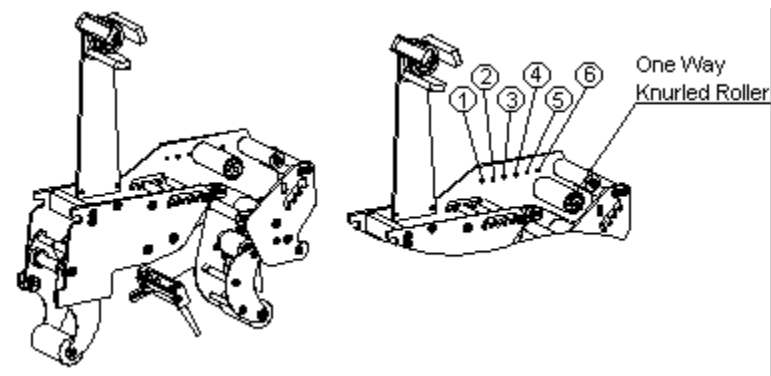


4. Operation

4.3 Feeding the Adhesive Tape



4.4 Adjusting Tape Length



Move the guiding tape wheel from hole #1 to hole #6 to shorten the tape length.

5. Maintenance and Troubleshooting



TURN OFF MACHINE AND DISCONNECT IT FROM THE POWER SOURCE PRIOR TO PERFORMING ANY MAINTENANCE OR SERVICE

5.1 Regular Maintenance & Cleaning

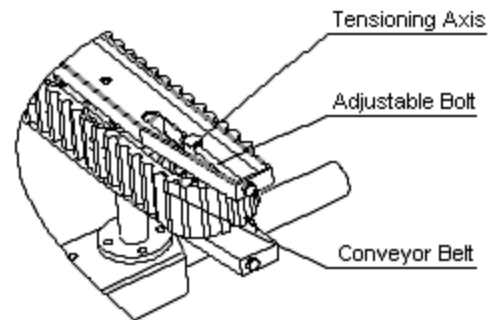
1. Check all bolts and screws regularly to ensure smooth, malfunction-free operation of the machine.
2. Lubricate moving parts of the machine on a regular basis.
3. Clean the machine surfaces.
4. Clean off any tape residue from the cutting blade daily.
5. If the machine is to be stored for an extended period of time, the cutting blade should be oiled prior to being placed in storage.

5.2 Lubrication

1. The driving chain should be lubricated once a month.
2. The bearings should be lubricated once a month.
3. The transmission axle, driving chain and bearing should be lubricated once a week.
4. All other moving parts should be lubricated on a regular basis.

5.3 Conveyor Belt Adjustment

Adjustments are made using the adjustable bolt located at the end of the side conveyor system.

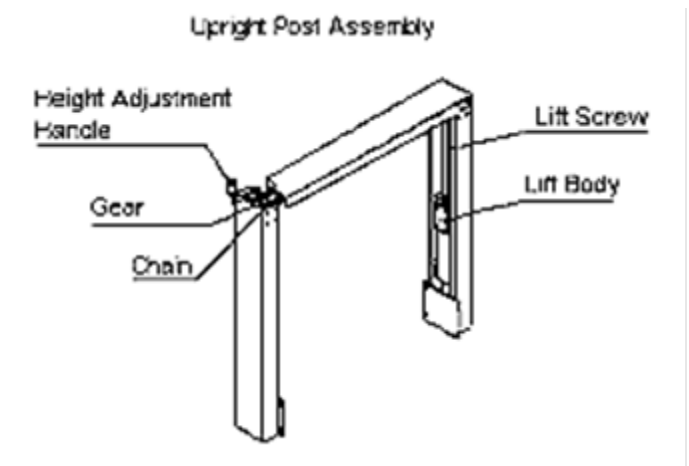


5. Maintenance & Troubleshooting

5.4 Carriage Height Adjustment

Rotate the height adjustment handle by hand to adjust the carriage height.

Rotate the handle clockwise to move the carriage up and counter clockwise to move the carriage down.



5.5 Typical Faults & Solutions

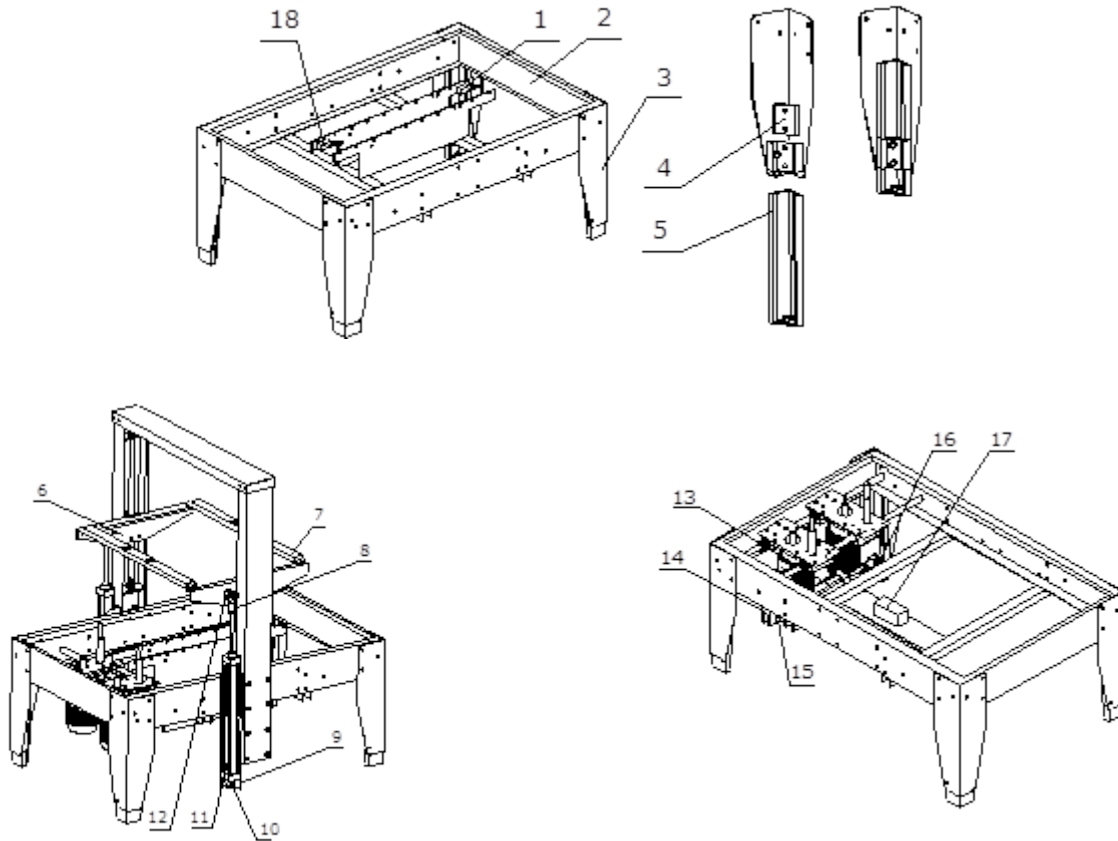
Fault	Solution
Tape is not centered on the carton.	Adjust the tape positioning knob on the tape head dispenser.
Scratched carton caused by tape cutting blade.	Adjust tape cutting blade position.
Tape is not properly adhering to the carton. (Caused by forward tape transfer wheel not applying sufficient force)	Adjust front wheel spring to increase force.

6. Illustrations & Parts List

6.1 Replacement Parts

	Description	Part Number	Qty
1	Roller Assembly	FJG-1A-182/183	-
2	Belt	-	1,520mm-1,867mm
3	Chain	06B	-
4	Wheel	FJG-1A-149	-
5	Drive Wheel Shaft	FJ-2A-122	-
6	Drive Roller	FJG-1A-148	-

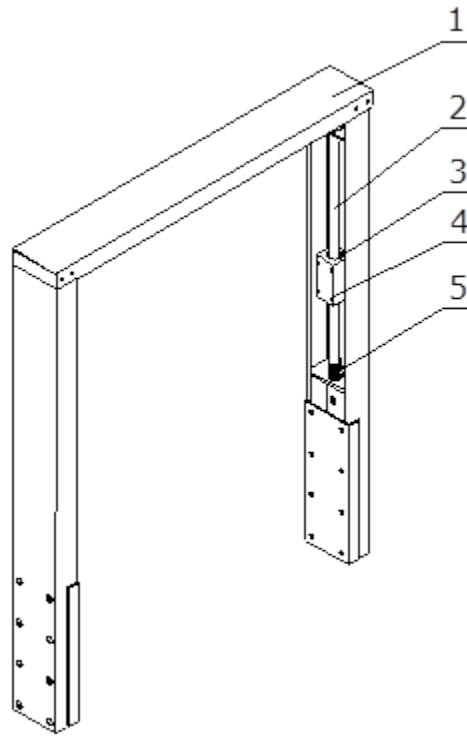
6.2 Main Frame Components



	Description	Part Number	Qty
1	Travel Switch	-	1
2	Machine Frame	FJ-2A-100	1
3	Leg Support	FJG-1A-110	4
4	Connection Plate	FJG-1A-112	4
5	Leg	FJG-1A-113	4
6	Bracket (Left/Right)	FJ-2A-141	1/ea
7	Support Bar	FJ-2A-142	2
8	Bearing	SI M12T/KM1.25	2
9	Cylinder Bracket	FJ-2A-110	2
10	Cylinder Lower Shaft	FJ-2A-120	2
11	Cylinder	SC40X400	2
12	Cylinder Upper Shaft	FJ-2A-119	2
13	Cylinder	SC40X200	1
14	Fixed Bracket	FJ-2A-164	1
15	Shaft	FJ-2A-165	1
16	Shaft	-	1
17	Solenoid Valve	-	3
18	Start Switch	-	1

6. Illustrations & Parts List

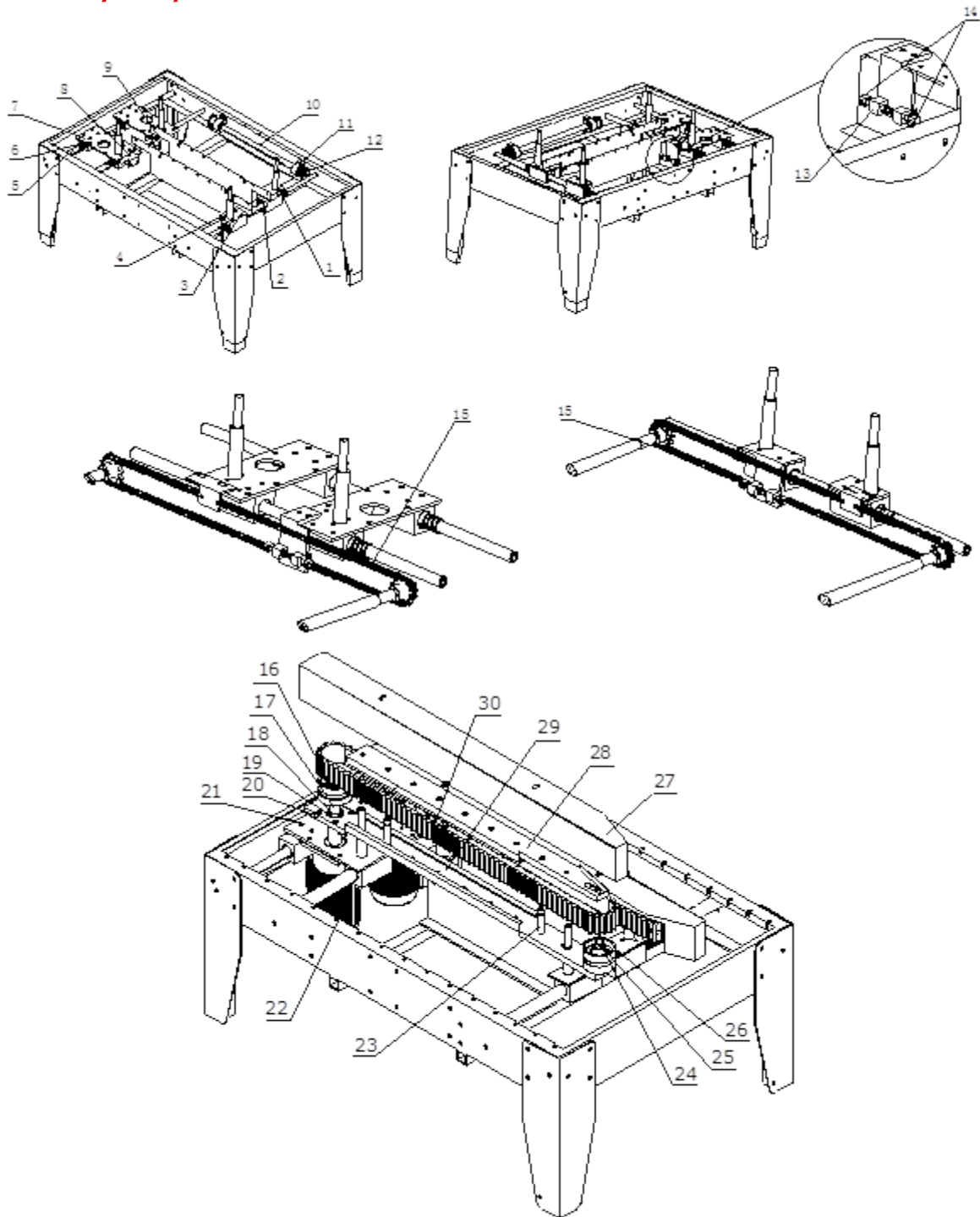
6.3 Upright Post Assembly



	Description	Part Number	Qty
1	Beam	FJG-1A-176	1
2	Guide Bar	FJ-2A-114	2
3	Linear Bearing	LM20UU	4
4	Up and Down Linear Assembly	FJ-2A-116	2
5	Spring	FJ-2A-109	2

6. Illustrations & Parts List

6.4 Side Conveyor System



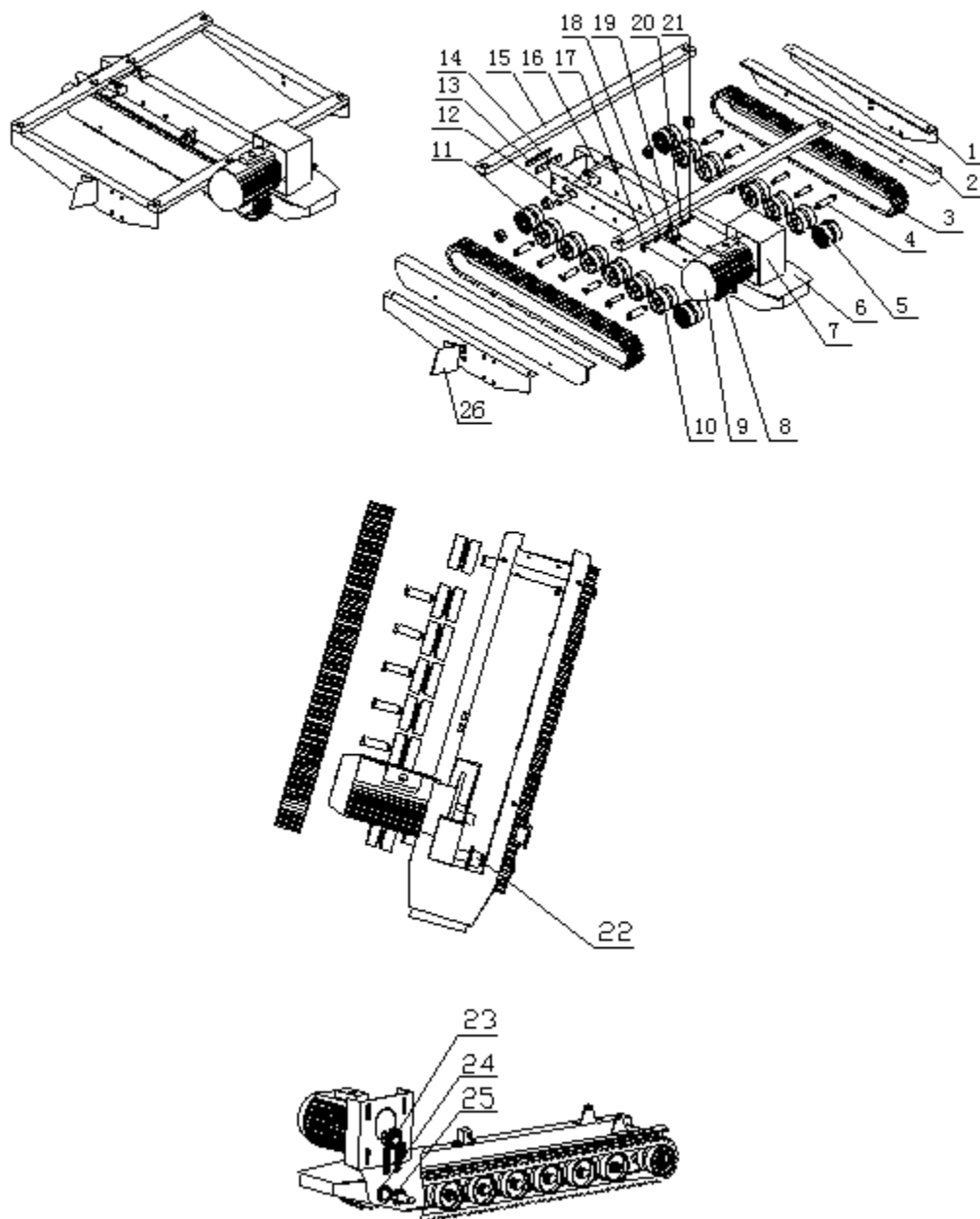
6. Illustrations & Parts List

6.4 Side Conveyor System (Continued)

	Description	Part Number	Qty
1	Locating Shaft	FJ-2A-149	1
2	Linear Bearing Base	FJ-2A-108	6
3	Locating Shaft	FJ-2A-152	1
4	Chain Connection Base	FJ-2A-157	1
5	Shaft	FJ-2A-107	3
6	Spring	FJ-2A-109	6
7	Connection Base	FJ-2A-146	1/ea
8	Chain Connection Base	FJ-2A-156	1
9	Chain Connection Base	FJ-2A-155	1
10	Connection Shaft	FJ-2A-117	2
11	Bearing Base	UCP204	4
12	Sprocket	FJ-2A-118	4
13	Fixed Block	FJ-2A-153	4
14	Chain Tension Adjuster	FJ-2A-154	4
15	Chain	08B	2
16	Drive Roller	FJG-1A-148	2
17	Transmission Shaft	FJ-2A-122	2
18	Drive Wheel Sleeve	FJG-1A-208	2
19	Conveyor Bearing	6005	2
20	Bearing Base	FJG-1A-153	2
21	Connection Base	FJ-2A-146	1/ea
22	Motor	CV200-20ZG3	2
23	Locating Pins	FJG-1A-160	4
24	Tensioning Shaft	FJG-1A-141	2
25	Tension Wheel Sleeve	FJG-1A-207	4
26	Wheel	FJG-1A-149	2
27	Cover Plate	FJG-1A-169	1/ea
28	Side Belt Cover	FJG-1A-152	1/ea
29	Conveyor Support Base	FJG-1A-150	1/ea
30	Belt	1,867mm	2

6. Illustrations & Parts List

6.5 Tape Head Carriage (Upper Belt Drive)



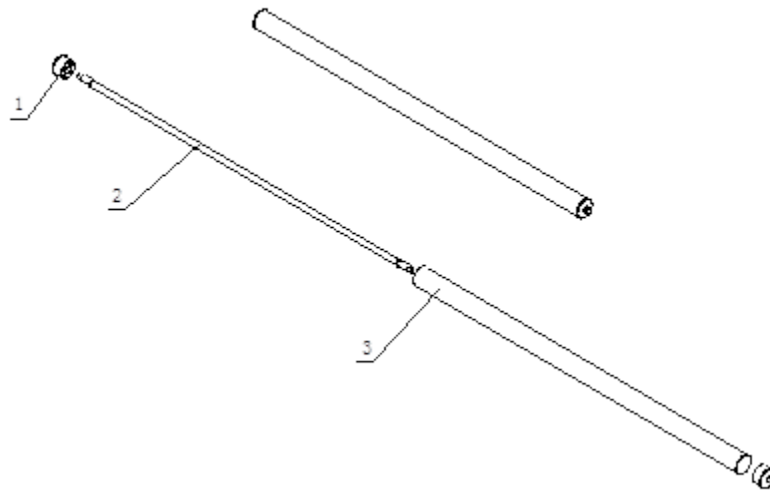
6. Illustrations & Parts List

6.5 Tape Head Carriage (Upper Belt Drive) [continued]

	Description	Part Number	Qty
1	Bracket	FJ-1AH-141	2
2	Belt Guard	FJ-2A-135	2
3	Conveyor Belt	1,520mm	2
4	Shaft	FJ-3A-415	12
5	Drive Wheel	FJ-3A-419	2
6	Motor Support	FJ-2A-126	1
7	Motor Cover	FJ-3A-437	1
8	Transmission Axle	FJ-2A-124	1
9	Motor	CV200-20ZG3	1
10	Drive Wheel	FJ-3A-416	12
11	Wheel	FJ-3A-413	2
12	Tensioning Axle	FJ-2A-123	1
13	Retaining Plate	FJ-1A-703	1
14	Brush Support	FJ-1A-701	1
15	Support Bars	FJG-2AH-131	2
16	Supporting Axle	FJ-1-440	1
17	Shaft	FJ-3A-807	1
18	Spring Holder	FJ-3A-808	1
19	Fixed Block	FJG-1A-127	1
20	Compression Spring	FJ-1A-930	1
21	Sliding Block	FJ-3A-806	1
22	Motor Sprocket	FJ-2A-132.1	1
23	Chain	06B	1
24	Bearing Bracket	FJ-1D-304	2
25	Lower Sprocket	FJ-2A-132	1
26	Stop Switch	FJ-3A-450	2

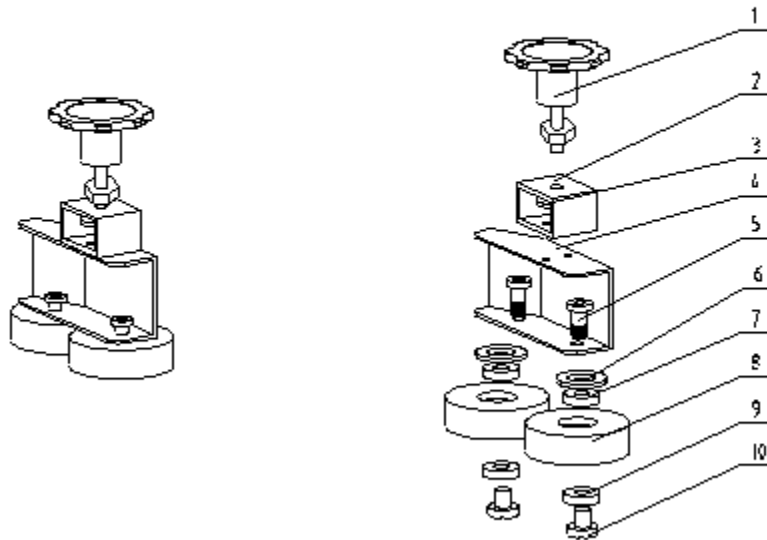
6. Illustrations & Parts List

6.6 Conveyor Roller



	Description	Part Number	Qty
1	Support Ring	FJG-1A-201	2
2	Long Shaft	FJG-1A-180	1
	Short Shaft	FJG-1A-181	1
3	Long Roller	FJG-1A-182	1
	Short Roller	FJG-1A-183	1

6.7 Top Box Squeezer

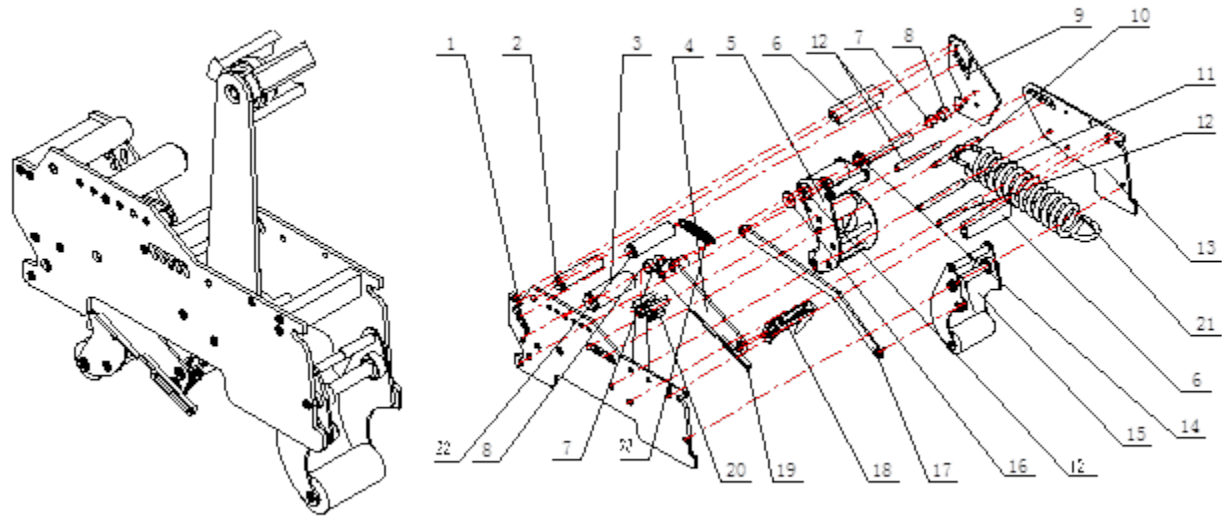


6. Illustrations & Parts List

6.7 Top Box Squeezer (Continued)

	Description	Part Number	Qty
1	Knob	FJG-1A-197	1
2	Locking Frame	FJG-1A-194	1
3	Backing Guard	FJG-1A-943	1
4	Frame	FJG-1A-116	1
5	Bolt	-	2
6	Gasket	-	2
7	Squeezer Bearing	6203-2Z	2
8	Contact Roller	FJG-1A-142	2
9	Round Nut	-	2
10	Spindle	FJG-3A-143	2

6.8 Tape Head



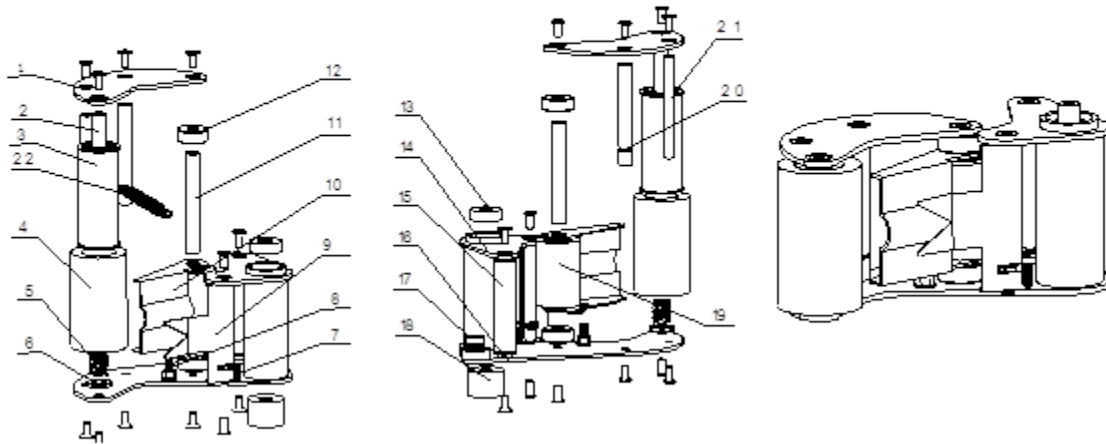
6. Illustrations & Parts List

6.8 Tape Head (Continued)

	Description	Part Number	Qty
1	Side Plate	FJ-01-17	1
2	Guide Pulley Assembly	-	1
3	One-Way Knurled Roller Assembly	-	1
4	Blade Carrier	FJ-01-04	1
5	Front Roller Assembly	-	1
6	Block	FJ-01-00	1
7	Shaft	FJ-00-12	2
8	Stop	FJ-40-00	2
9	Side Plate (x3)	FJ-01-02	1
10	Shaft	FJ-00-02	1
11	Shaft	FJ00-07	1
12	Shaft	FJ-00-06	4
13	Side Plate (x2)	FJ-01-16	1
14	Shaft Cover	FJ-02-09	1
15	Back Roller Side Plate Assembly	-	1
16	Brass Washer	FJ-02-04	1
17	Connecting Lever	FJ-01-14	1
18	Knife Back Plate Assembly	-	1
19	Knife Leveling Piece	FJ-01-01	1
20	Tape Hub Assembly	-	1
21	Extension Spring	FJ-H-07	1
22	Extension Spring Axis	FJ-00-01	1
23	Extension Spring	FJ-H-04	1

6. Illustrations & Parts List

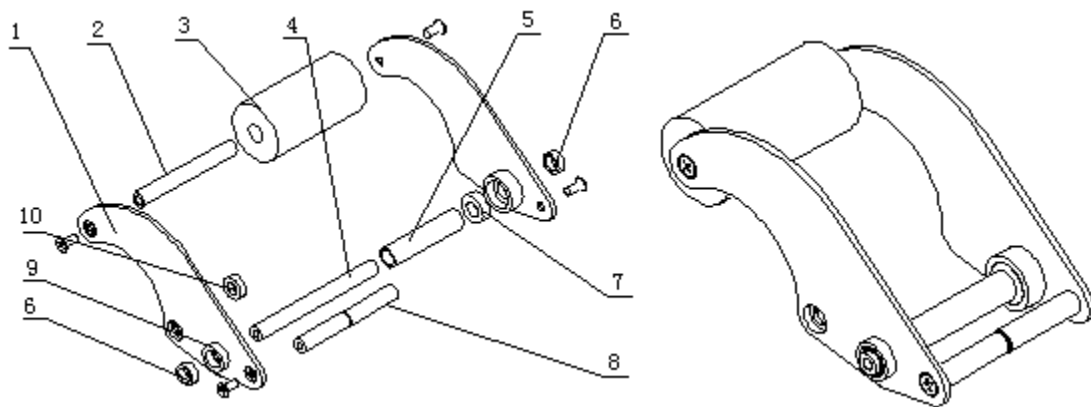
6.9 Front Tape Roller Assembly



	Description	Part Number	Qty
1	Front Plate	FJ-01-09	1
2	Shaft	FJ-00-08	1
3	Roller Shaft	FJ-E-38-01	1
4	Idler Wheel	FJ-E-41-01	1
5	Press Spring	FJ-11-00	1
6	Gasket	FJ-50-100	1
7	Phillips Flat Head Screw	M4x12	1
8	Phillips Flat Head Screw	M5x15	1
9	Tape Holder Assembly	-	1
10	Tape Guide Assembly	FJ-01-08	1
11	Shaft	FJ-00-10	1
12	Axle Sleeve	FJ-02-02	2
13	Bearing	6900Z (1080900)	1
14	Front Roller	FJ-50-00	1
15	Guide Tape Wheel Assembly	-	1
16	Washer	-	1
17	Bearing	688Z (208088)	1
18	Bearing	7942/20	1
19	Axle Sleeve	FJ-02-10	1
20	Shaft	FJ-00-11	1
21	Shaft	FJ-00-09	1
22	Return Spring	FJ-H-00	1

6. Illustrations & Parts List

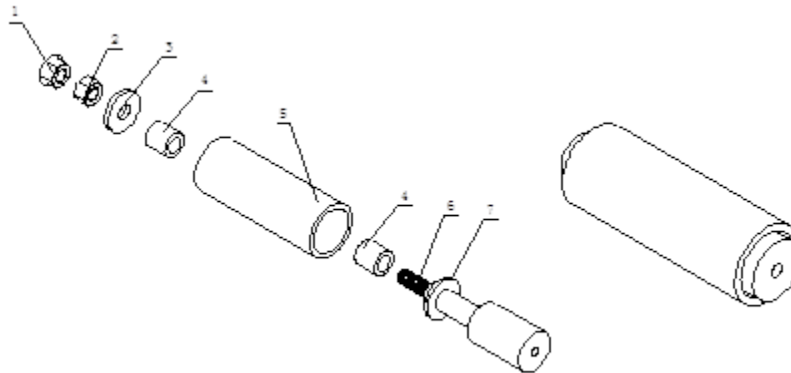
6.10 Back Roller Side Plate Assembly



	Description	Part Number	Qty
1	Back Plate	FJ-01-13	1
2	Shaft	FJ-00-10	1
3	Idler Wheel	FJ-40-03	1
4	Shaft	FJ-00-06	1
5	Axle Sleeve	FJ-02-05	1
6	Axle Sleeve	FJ-02-06	2
7	Bearing	6800Z (26800)	2
8	Shaft	FJ-00-05	1
9	Axle Sleeve	FJ-02-00	1
10	Bearing	688Z (208088)	1

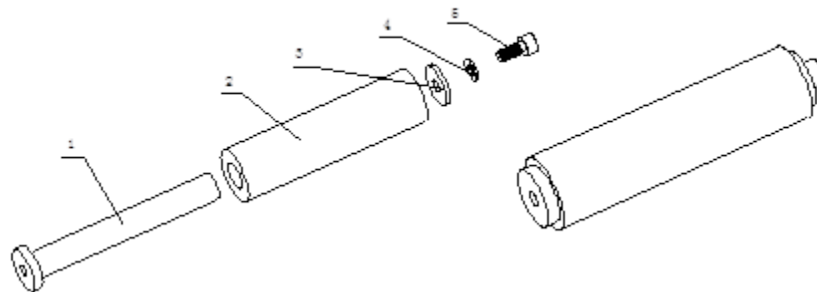
6. Illustrations & Parts List

6.11 One Way Knurled Roller Assembly



	Description	Part Number	Qty
1	Locknut	M8	1
2	Nut	M8	1
3	Washer	FJ-02-03	1
4	Bearing	HF1216	1
5	One Way Wheel	FJ-E-31-01	1
6	Shaft	FJ-00-04	1
7	Axle Sleeve	FJ-02-01	1

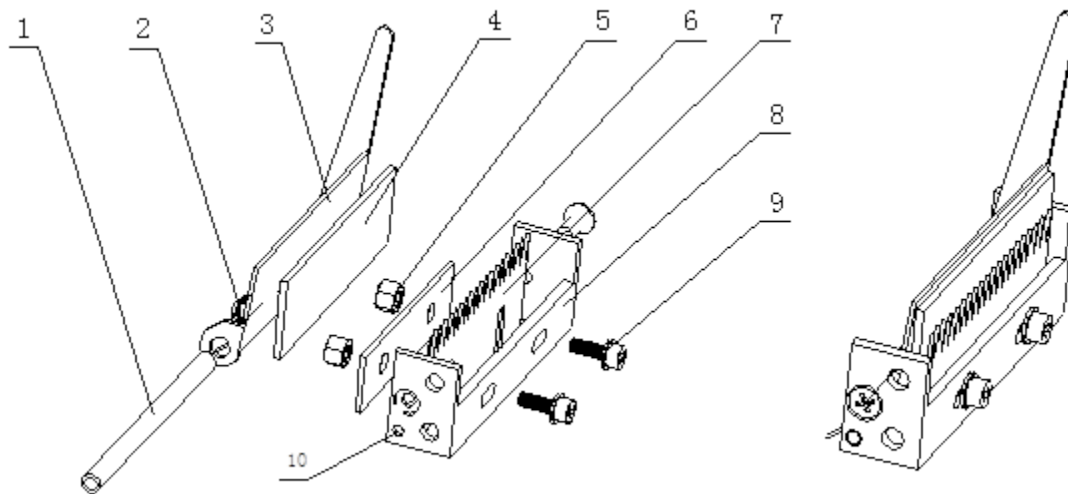
6.12 Guide Pulley Assembly



	Description	Part Number	Qty
1	Shaft	FJ-00-03	1
2	Axle Sleeve	FJ-02-07	1
3	Washer	5	1
4	Washer	5	1
5	Socket Head Cap Screw	M5x12	1

6. Illustrations & Parts List

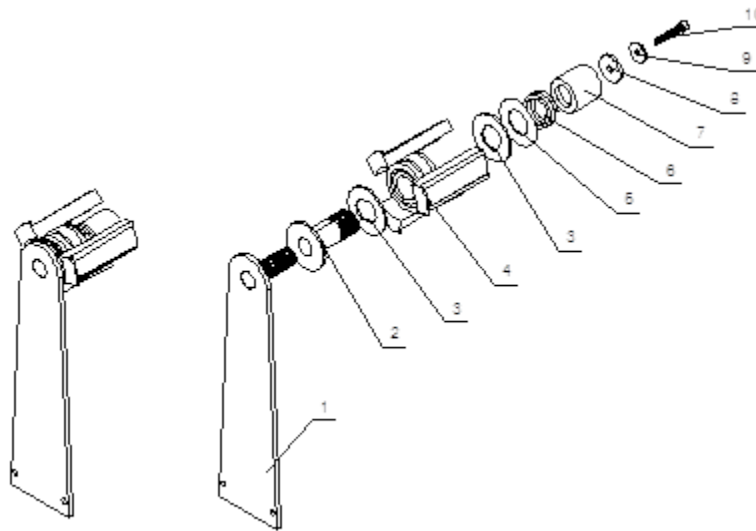
6.13 Knife Back Plate Assembly



	Description	Part Number	Qty
1	Shaft	FJ-00-00	
2	Torsion Spring	FJ-H-05	
3	Protecting Blade Carrier	FJ-01-06	
4	Sponges	-	
5	Nut	M4	
6	Knife Board	FJ-40-04	
7	Blade	-	
8	Blade Carrier Block	FJ-01-07	
9	Socket Head Cap Screw	M4x16	
10	Phillips Flat Head Screw	M4x12	

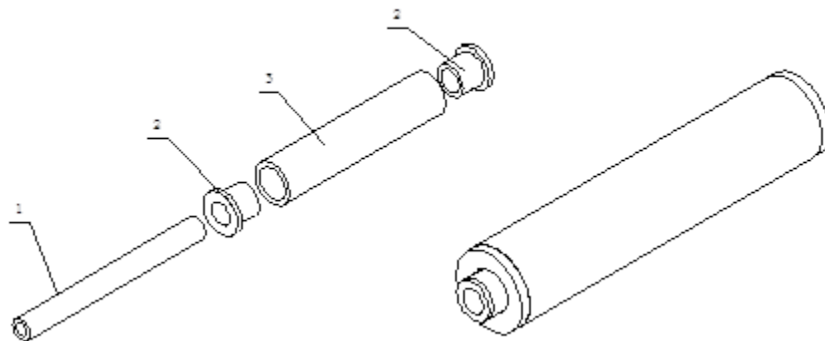
6. Illustrations & Parts List

6.14 Tape Hub Assembly



	Description	Part Number	Qty
1	Tape Frame	FJ-05-00	1
2	Axle Sleeve	FJ-02-12	1
3	Antiskid Slice	FJ-05-01	2
4	Tape Head Drum	FJ-02-05-03	1
5	Gasket	FJ-05-02	1
6	Press Spring	FJ-H-08	1
7	Shaft	FJ-00-14	1
8	Bearing Bush	FJ-02-08	1
9	Washer	5	1
10	Socket Head Cap Screw	M5x40	1

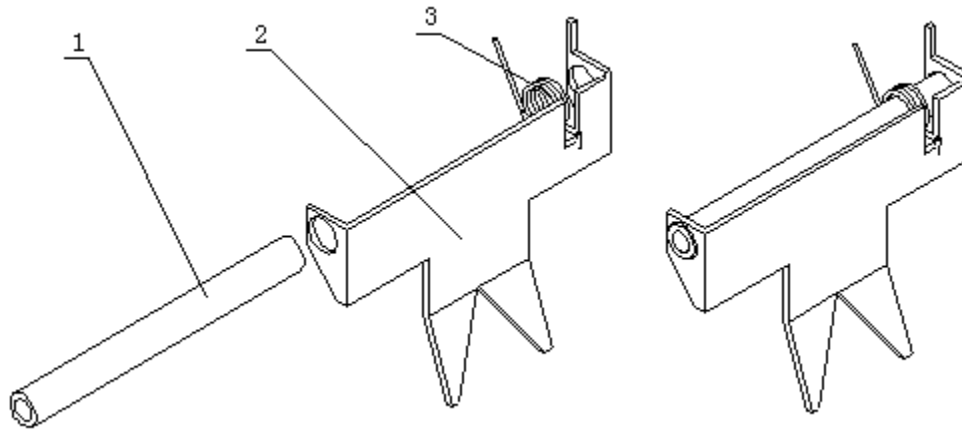
6.15 Guide Tape Wheel Assembly



	Description	Part Number	Qty
1	Shaft	FJ-00-09	1
2	Axle Sleeve	FJ-02-14	2
3	Guide Tape Wheel	FJ-02-13	1

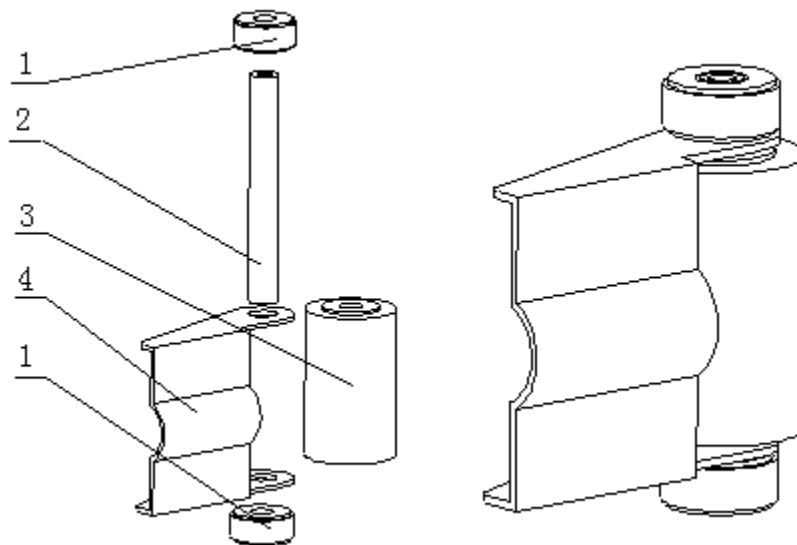
6. Illustrations & Parts List

6.16 Tape Holder Assembly



	Description	Part Number	Qty
1	Shaft	FJ-00-09	1
2	Press Tape Board	FJ-01-05	1
3	Torsion Spring	FJ-H-03	1

6.17 Tape Guide Assembly



	Description	Part Number	Qty
1	Axle Sleeve	FJ-02-02	2
2	Shaft	FJ-00-10	1
3	Axle Sleeve	FJ-02-10	1
4	Press Board	FJ-01-08	1