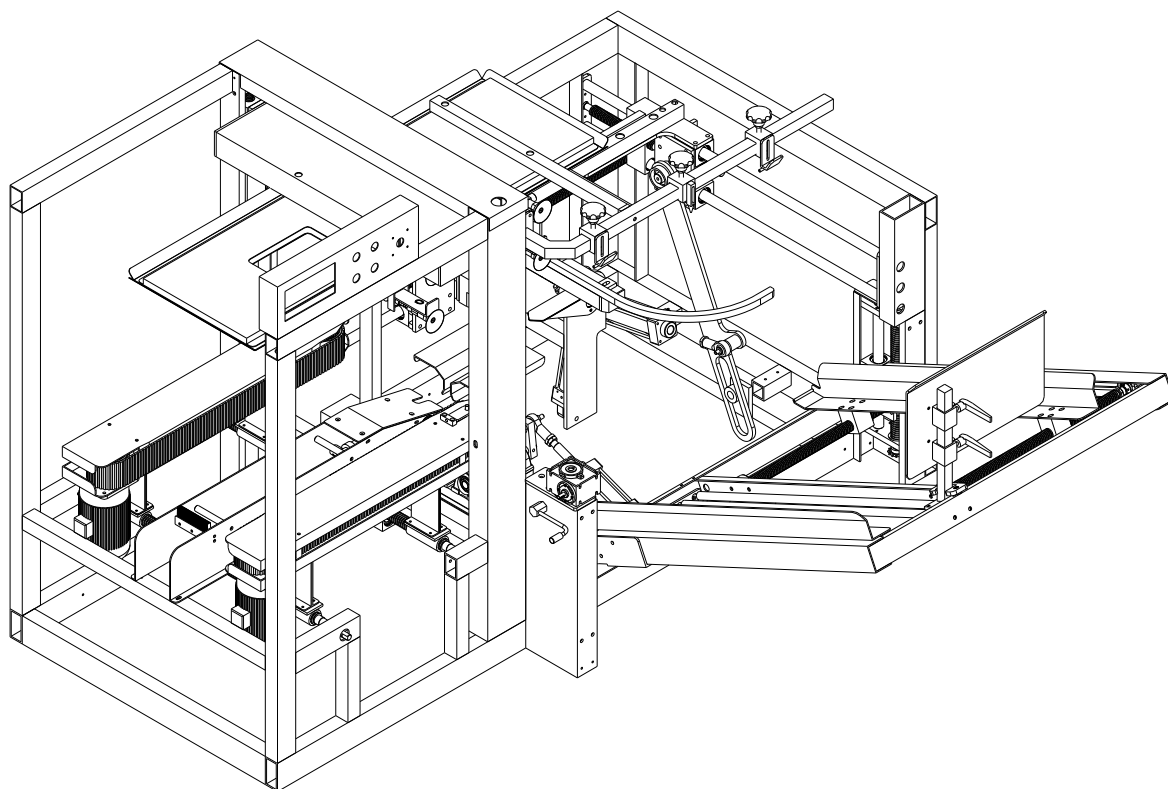

CASE ERECTOR

YPK-4012





Only allow professional to operate the machine

Daily safety notices:

If you need to operate or service the machine, please refer to the following points:

Before

- Read the instructions to prepare
- Check all the cover plates on the machine.
If there is any breakage, please replace the new parts immediately.
- Please make sure there are not tools or other things on the machine,
And keep the machine clean.
- Read the instructions carefully,
- Read the descriptive phrases and important marks about the machine application.

Operating

- Don't wear loose clothes, in case of tie into the machine
- Don't barefoot to repair operation
- Please let the hands away from the work area.
- Please don't use carton packaging the machine, because the machine excess of carton weight scope

After

- please turn the main switch to "OFF" ,and shut down the machine.



Only allow professional to operate the machine

Service and safe regulation

- Please retain the service contents. (As shown in the fifth part)
- Don't set or add lubricant during the machine running.
- Please cut off power supply when open the protection cover.
- Don't s install unauthorized and additional components
- Please use the original accessories

Useful instructions

- Please use the proper power supply system
- Don't tear or cover the machine instructions
- Please use the manual if necessary



Only allow professional to operate the machine

Notice:

In order to let the machine run normally, please keep the machines and parts clean,
Add lubricant to the lubrication part and examine pneumatic device regularly.

Part 1	Detailed introduction
	Machine Technical Specification

Part 2	Preparation for the use
	Pretreatment
	Machine nameplate Specification
	Machine installation space
	Safety
	Connect the motor
	Installation and threading of the tape head

Part 3	Set
	Check before operation
	Idling
	Replace the cartons

Part 4	Service
	Daily maintenance regulations
	Common fault and solution
	Projects about repair or replace components by professional person

Part 5	Parts content
	Parts content

Part 6	Electrical wiring diagram and schematic diagram
	Electrical wiring diagram and schematic diagram

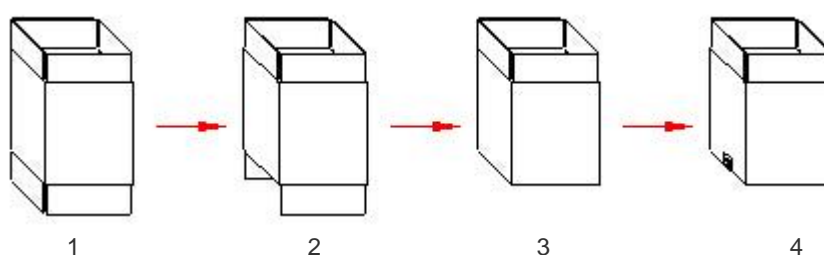
Part 1 Detailed Introduction

1. Introduction

Work step:

1. adjusting and setting the machine parameters according to the carton size.
2. Put the boxes into machine box shelf neatly.
3. Suction box,
Folding the front and back covers, right and left covers,
Sealing box bottom

Working theory



- 1、Open box
- 2、Fold front and back covers
- 3、Fold right and left covers
- 4、Sealing the box bottom

1.	Technical Parameter	KX-01
	machine weight	400Kg
	Machine dimension	L2005×W1955×H1290mm
	Tape	kraft paper · BOPP Tape
	Installed power	0.4 KW
	Air supply	≥6Kgf/cm ²
	Current protection	IP54
	Noise	≤75DB
	Environmental condition	humidity≤98% · temperature -10℃~40℃
	Sealing speed	0-10 boxes/min
	Power supply	1P · 220V · 50Hz

Notice:

In order to reduce the damage rate of the boxes, improve speed, it is recommended to use good quality boxes.

Part 2 Preparation before operate

1、pretreatment

Dismantle the machine packing

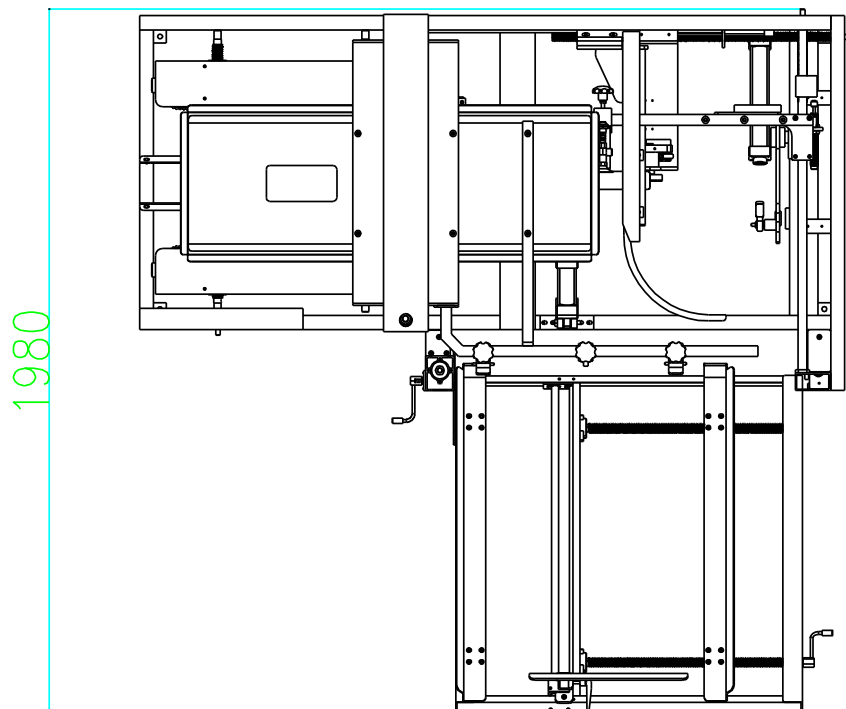
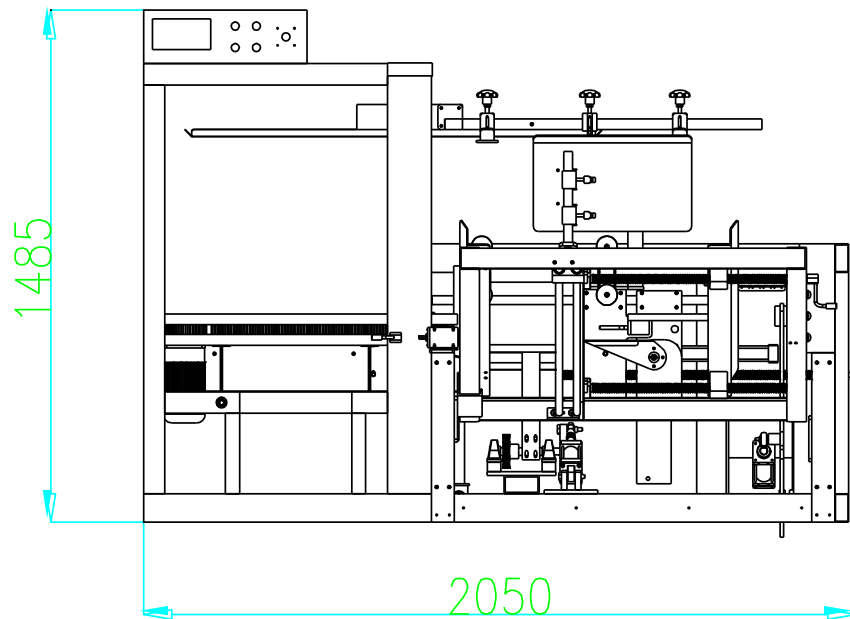
Please check

- Is there any exutive parts in the machine
- Remove the binder in the machine
- Check the machine model is correct
- A service manual operation
- please report if there is damage caused by transportation

2、Machine nameplate parameters

If you want to use your nameplate, please contact the manufacturer, and provide your LOGO and machine model.

1. Machine install space



Picture 2-2

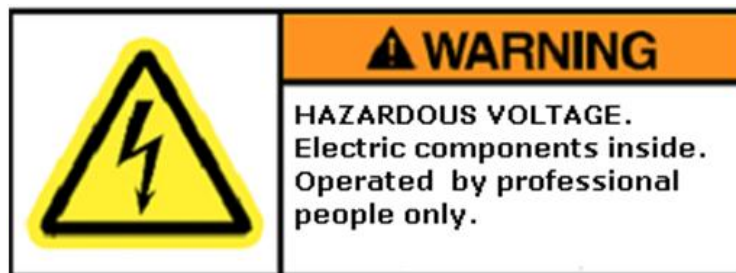
2. safety

4.1. Precautions

1. Please make sure the machine power supply, don't put the wrong power supply ;
2. When machine working, forbidden to put your finger or head into the machine;
3. Don't allow to install the machine in the soft ground ;
4. Unplug the power supply after the work ;
5. Under emergency situation , press the urgent stop switch, disconnect the motor power, and the machine will emergency stop.
6. After finish the work, should clean the machine ;
7. In order to ensure safety, please don't take electrical equipment apart; Only electrical technician can repair the electrical equipment;

4.2. Electric marks

This mark is posted on the electrical door,. And after the Indicating door is removed, there is a risk of electric shock, Please don't replace and remove it.



3. Link Power

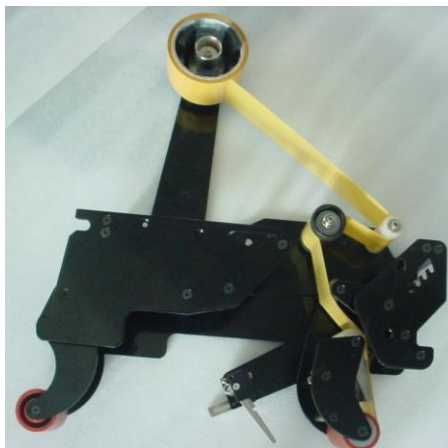
Notice :

Before connect the machine power, Please make sure the main switch in the OFF position.
The machine is single phase motors.

- Confirm the voltage is correct, and the voltage can be found on the nameplate °



4. The installation of the tape head, and the method of stall



Part III Settings

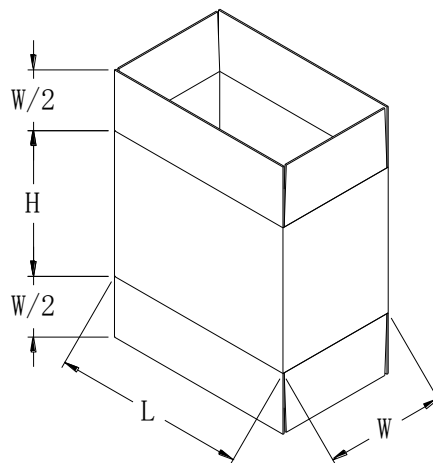
1. Check before working

- Check if the fasteners are loose.
- Check if the external power and air source are conform to the machine's requirement.
- Check if the motor and electrical equipments are dry, if insulation is in good status.
- Check if the gas circuit is normal.

2. Idling

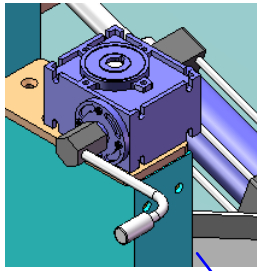
- Operate the belt manually, check if the belt is off tracking, adjust the tightness of the belt.
- Check if every motion of operation is ok by manually control.
- Check if Single step working is normal.
- Check if the tape goes smoothly in the tape head.

3. Change the box

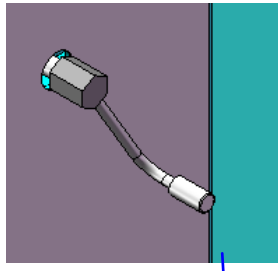


Picture 3-3

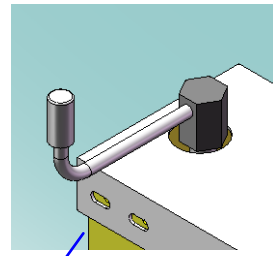
(Picture 3-4) Adjusting the machine to adapt the new box and unpack the box, to satisfy the production need.



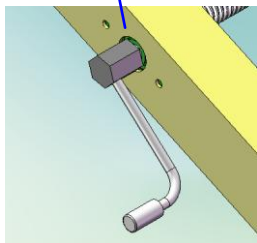
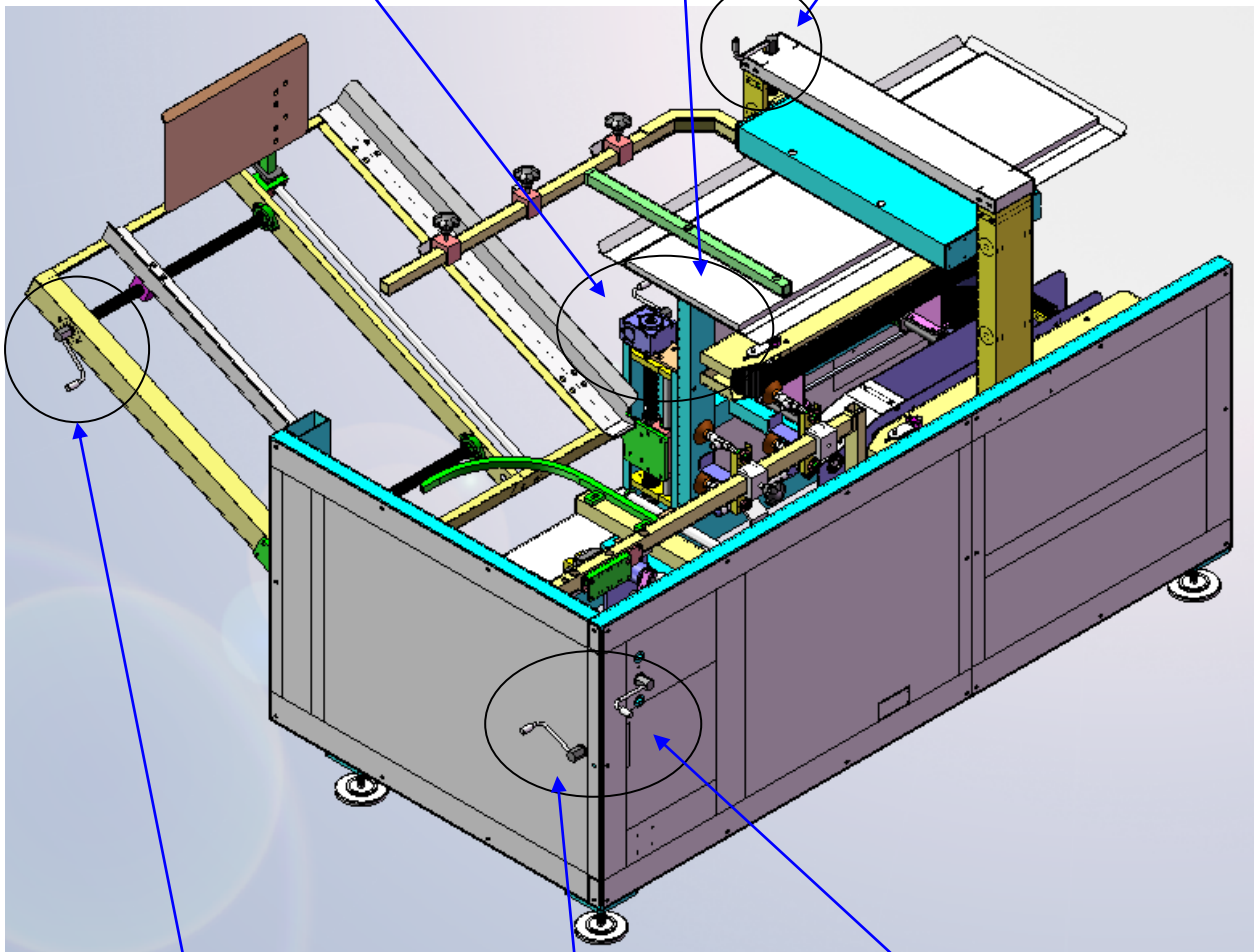
Adjust $W/2$



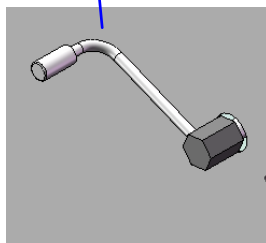
Adjust W



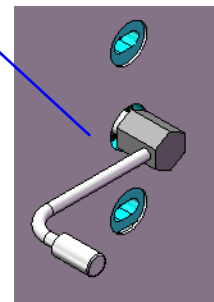
Adjust the height of the pressing plate ($H+W/2$)



Adjust $(L+W)$



Adjust L



Adjust W

Picture 3-4

Part IV Service

1. Routine maintenance rules

1.1 Safety Warning for Maintenance

- ① · Be sure the power has been cut off.
- ② · Maintenance personnel is not allowed to repair with barefoot.

1.2 Maintain and clean regularly

- ① · Check regularly if the screws of all parts loose or not
- ② · Lubricate the main parts of the machine regularly by grease
- ③ · Keep the machine surface clean.
- ④ · Clean up the foreign matter of the blade everyday.
- ⑤ · The blade should be oiled for protection when the machine is not used regularly.

1.3 Maintain the machine correctly and frequently, not only could prolong its service life, but also can reduce the fault happening, so increase the production efficiency. Check the main parts(sucker/belt/chain) of the machine regularly.

The parts need to be greased regularly:

- (1) Chain
- (2) Screw rod
- (3) Guide rail(sliding block)
- (4) Guide rod

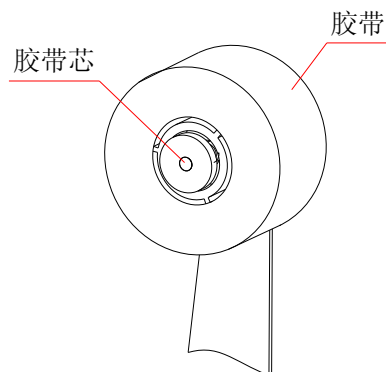
Grease properly and carefully on the chain(wheel), screw rod, guide rail(sliding block) and guide rod.(We suggest to maintain once every three months.

2. Common faults and solutions

2.1 Sealing effect is not good

2.1.1 The tape off the box's center

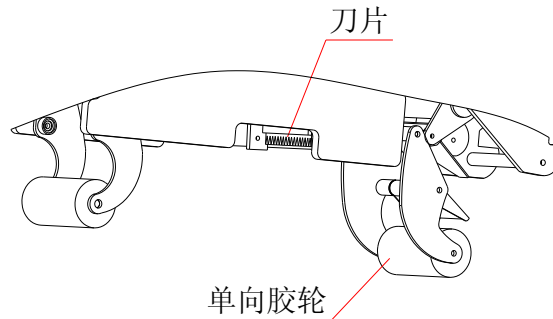
Adjust the tape position(See picture 4-1)



Picture 4-1

2.1.2 The tape cannot be cut off

- ① · The blade is too high and will scrape the box easily.
- ② · The blade is too low and will cause the tape cannot be cut off(See picture 4-2)
- ③ · The force of the slitter is too small, adjust the spring force.



Picture 4-2

2.1.3 The tape cannot seal on the box closely

- ① · The tape quality is not good or the single-track rubber wheel is broken
- ② · The end of the tape is not stick on the box: adjust the throttle of cylinder, to accelerate the speed.
- ③ · The tape is wrinkled: adjust the spring force of the front rubber wheel

2.2 The carton was stuck when delivering

- ① · The space of the blocking rod is too small
- ② · If the carton deformed
- ③ · If the sucker is in good condition

2.3 The carton was stuck when vertically unpacking the carton

- ① · The base level and the carton bottom are in the horizontal line.
- ② · The dynamic height of up and down is not the same.
- ③ · Up and down folding is not good.
- ④ · Front and back folding is not good.

2.4 Something wrong with the sucking and lifting

- ① · Check if the air pressure is correct.
- ② · Check if the sucker is in good condition
- ③ · Check if the cartons are in order
- ④ · The sucking and lifting center line and the lateral folding surface are not at the same line

Reminder:

Please pay attention to the sequence when change the old parts, replace them according to the graphic illustration.

Please use the original parts to avoid malfunction and damage.

Notice:

If the machine appears any malfunction or damage, it needs to be repaired by maintenance personnel, who should be expert at the motor, air pressure and machinery. Please do the repair in the spacious area, to avoid the personnel being hurt during repairing.

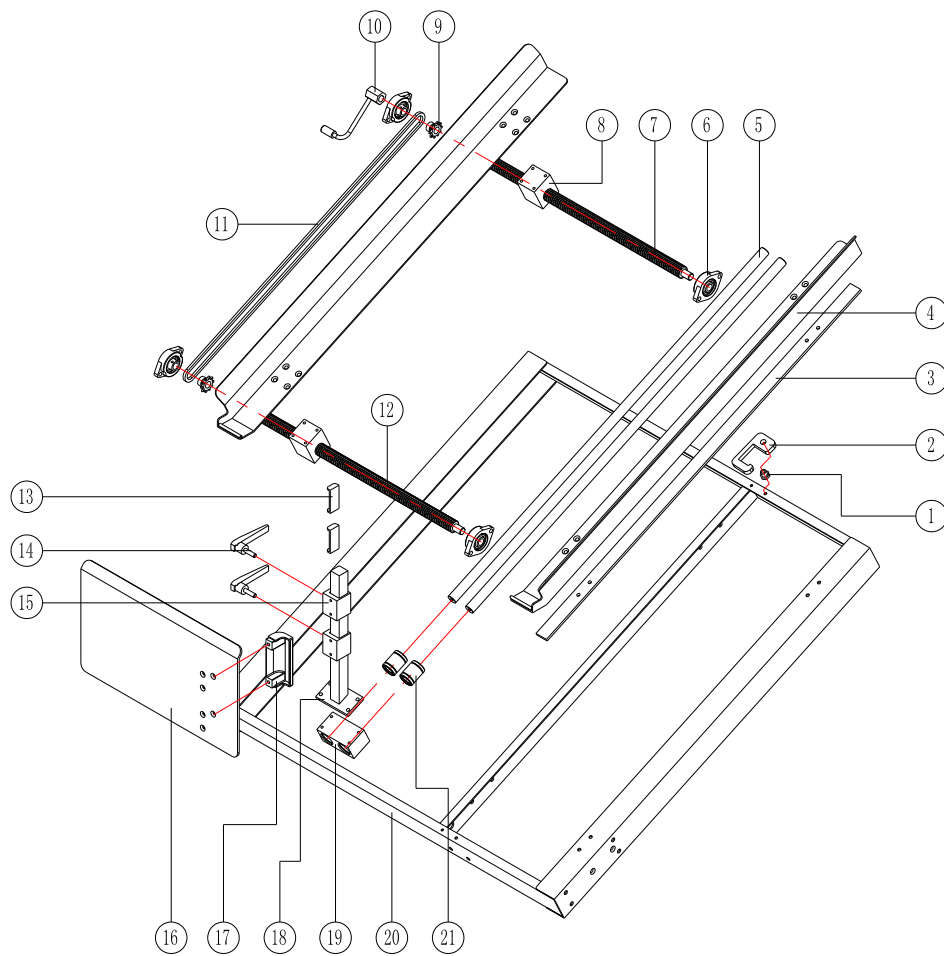
3. Below components should be repaired and replaces by professionals

NO.	PART NAME	REMARK
1	Carton Sealing Blade	
2	Movement tension spring	
3	Chain	
4	Solenoid valve	
5	Travel Switch	
6	Fuse	
7	Magnetic induction switch	
8	Vacuum chuck	
9	Motor	
10	Belt	

Notice: If the machine is damaged, please refer to the regional rules!

PART V ACCESSORY CONTENTS

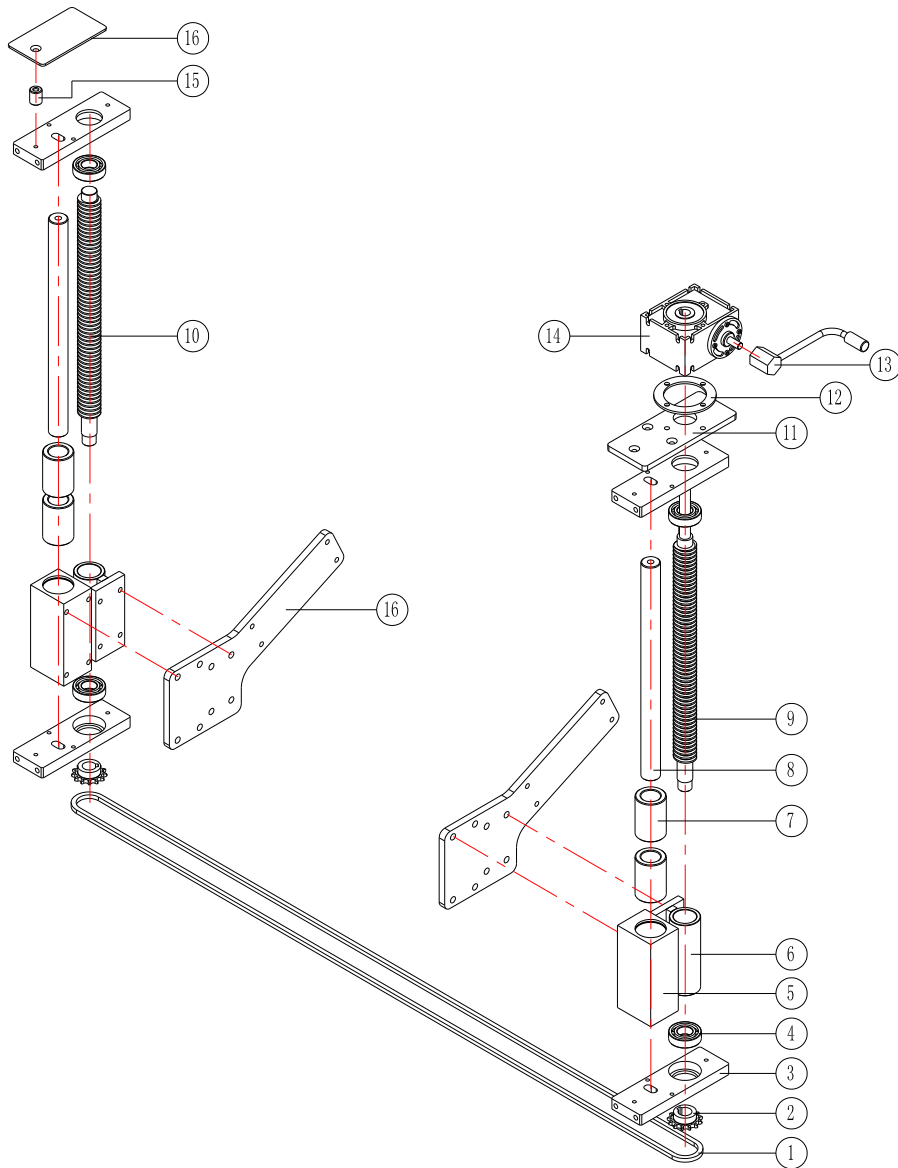
1. WORKBENCH MECHANISM



ACCESSORY LIST

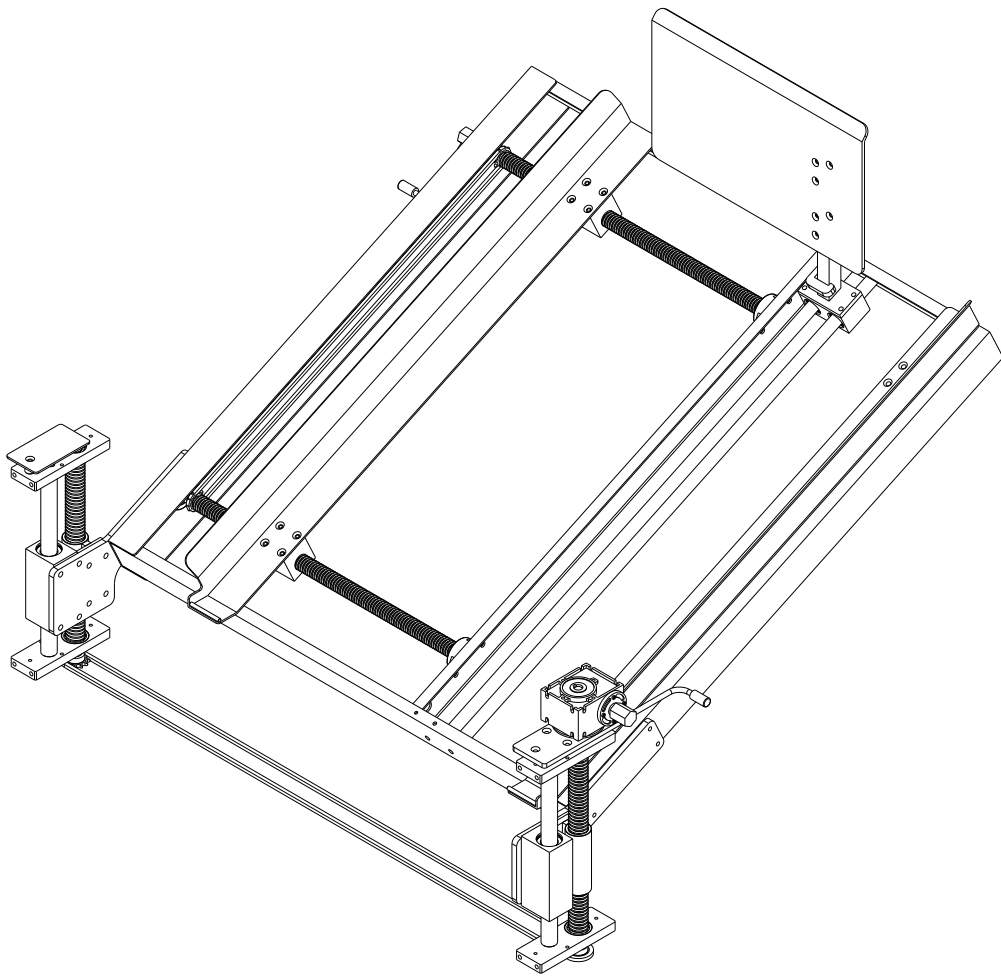
NO.	PART NAME	PART NO.	QTY	REMARK
1	RETRACTOR SEAT	SDW-K20TX-159	1	
2	RETRACTOR	SDW-K20TX-60	1	
3	GUIDE CASE BOARD STRIP	SDW-K20TX-57	1	
4	GUIDE CASE BOARD	SDW-K20TX-56	2	SYMMETRY
5	DELIVERY BOX GUIDE BAR	SDW-K20TX-58	2	
6	BEARING SEAT	SBLF 202	4	
7	WORKBENCH SCREW I	SDW-K20TX-62	1	
8	SCREW	SDW-20T-H-01	2	
9	CHAIN WHEEL	SDW-MA-60	2	
10	HANDLE		1	
11	CHAIN			06B
12	WORKBENCH SCREW	SDW-K20TX-61	1	
13	FIXED BLOCK PAD	SDW-K20TX-51	2	
14	HAND WHEEL		2	
15	DELIVERY BOX FIXED BOARDS	SDW-K20TX-50	2	
16	PUSHING BOX BOARD	SDW-K20TX-63	1	
17	HANDLE		1	
18	DELIVERY BOX UPRIGHT COMPONENTS	SDW-K20TX-53	1	
19	DELIVERY BOX LINEAR SEAT	SDW-K20TX-48	1	
20	WORKBENCH	SDW-K20TX-68	1	
21	LINEAR BEARING	LM20UU	2	

2. WORKBENCH LIFTING MECHANISM

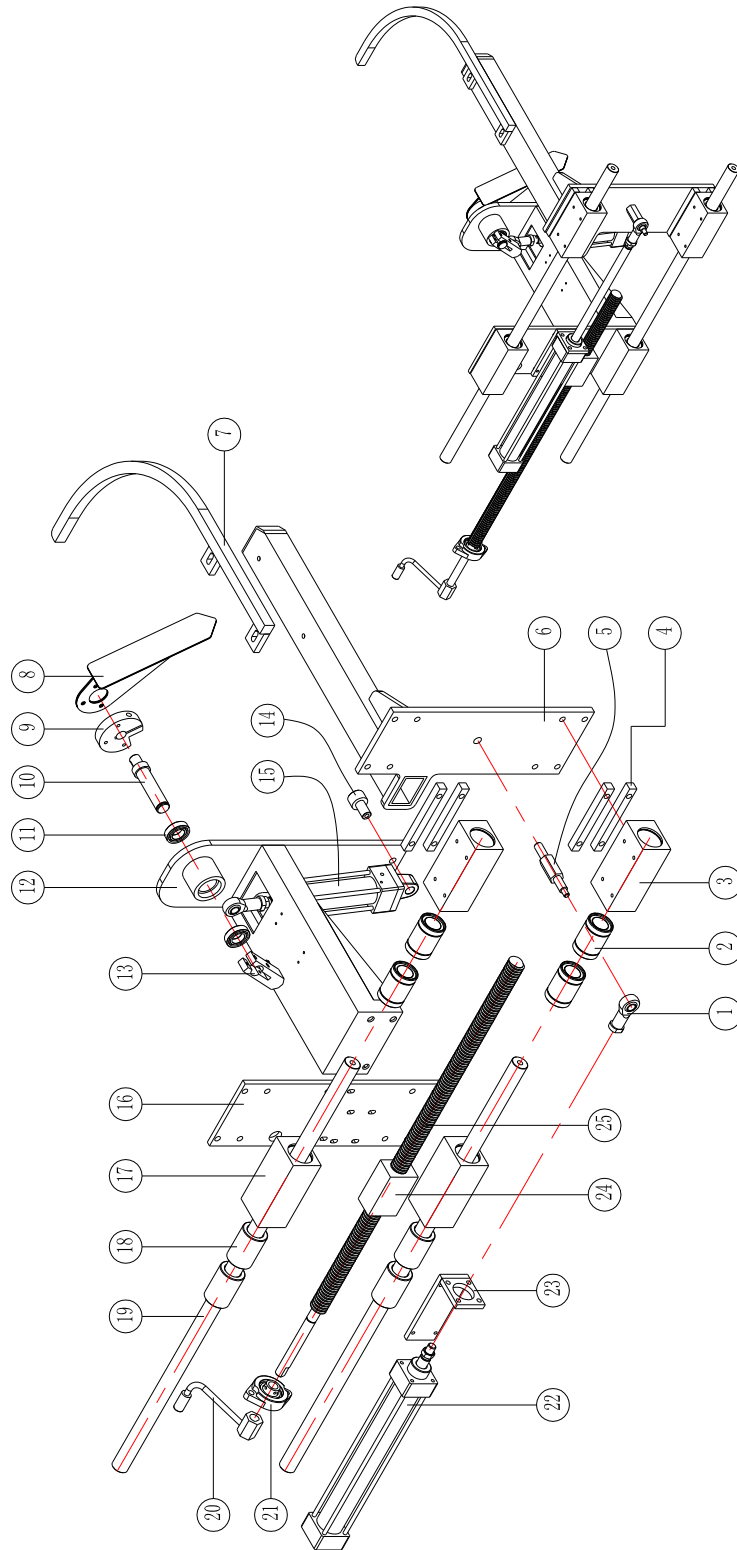


ACCESSORY LIST

NO.	PART NAME	PART NO.	QTY	REMARK
1	CHAIN		1	06B
2	LIFTING SCREW CHAIN WHEEL	SDW-1A-130	2	
3	LIFTING STAND	SDW-K20TX-69	4	SYMMETRY
4	BEARING		4	6004
5	STRAIGHT SLIDE SEAT	SDW-01-04-047	2	
6	LIFTING NUT SEAT	SDW-1A-150	2	
7	SLIDE SLEEVE	SDW-K20TX-178	4	
8	WORKBENCH SUPPORT ROD	SDW-K20TX-84	2	
9	LIFTING SCREW	SDW-K20TX-85	1	
10	LIFTING SCREW I	SDW-K20TX-86	1	
11	REDUCTION BED PLATE	SDW-K20TX-177	1	
12	REDUCTION WASHER	SDW-K20TX-176	1	
13	HANDLE		1	
14	REDUCTION DRIVE	NRW 030	1	1 : 7.5
15	WORKBENCH BED PLATE	SDW-K20TX-64	2	



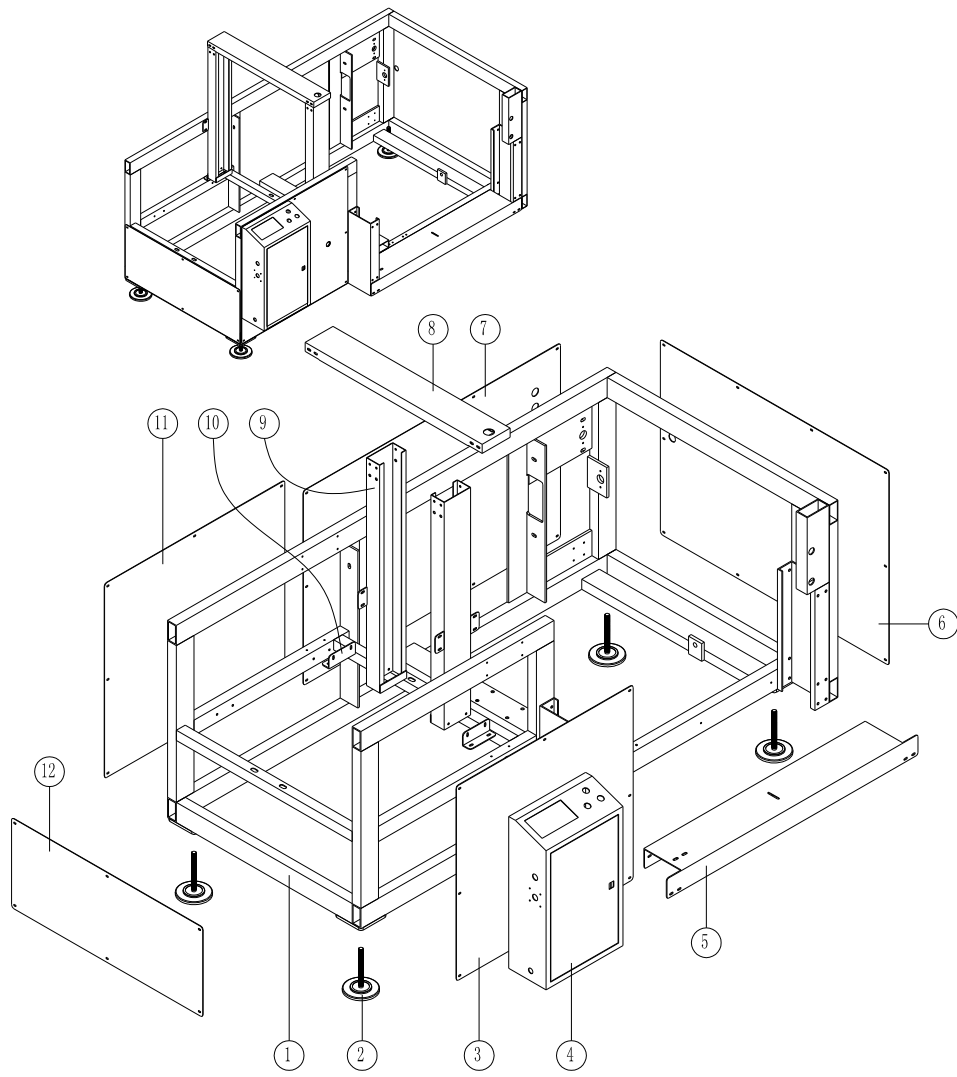
3. REAR FOLDING AND CASE PUSHING MECHANISM



ACCESSORY LIST

NO.	PART NAME	PART NO.	QTY	REMARK
1	SPLICE		2	SC40
2	STRIGHT BEARING	LM25UU	4	
3	STRIGHT SLIDE BASE	SDW-K20TX-38	2	
4	STRAIGHT SEAT STRIP	SDW-K20TX-21	4	
5	FRONT AXLE OF CASE PUSHING CYLINDER	SDW-K20TX-28	1	
6	CASE PUSHING ROD COMPONENTS	SDW-K20TX-33	1	
7	MOLDING BEND BAR	SDW-K20TX-36	1	
8	REAR FOLDING SWING COMPONENTS	SDW-20T-G-14	1	
9	REAR FOLDING CLAMP	SDW-01-04-21.1	1	
10	PENDULUM SHAFT	SDW-01-04-25.4	1	
11	BEARING		2	61904
12	REAR FOLDING SEAT	SDW-K20TX-27	1	
13	SWING	SDW-20T-09	1	
14	REAR FOLDING CYLINDER TAILSHAFT	SDW-01-04-198.1	1	
15	CYLINDER	SC40x80-S	1	MATCH SC40-CA
16	LENGTH BED PLATE	SDW-K20TX-46	1	
17	STRAIGHT SLIDE III	SDW-01-04-047.2	2	
18	SLIDING SLEEVE	SDW-K20TX-178	4	
19	LENGTH GUIDE BAR	SDW-K20TX-47	2	
20	HANDLE		1	
21	BEARING SEAT	SBLF 202	1	
22	CYLINDER	SC40x250-S	1	
23	CASE PUSHING CYLINDER SEAT	SDW-K20TX-24	1	
24	LENGTH NUT	SDW-K20TX-45	1	
25	LENGTH SCREW ROD	SDW-K20TX-81	1	

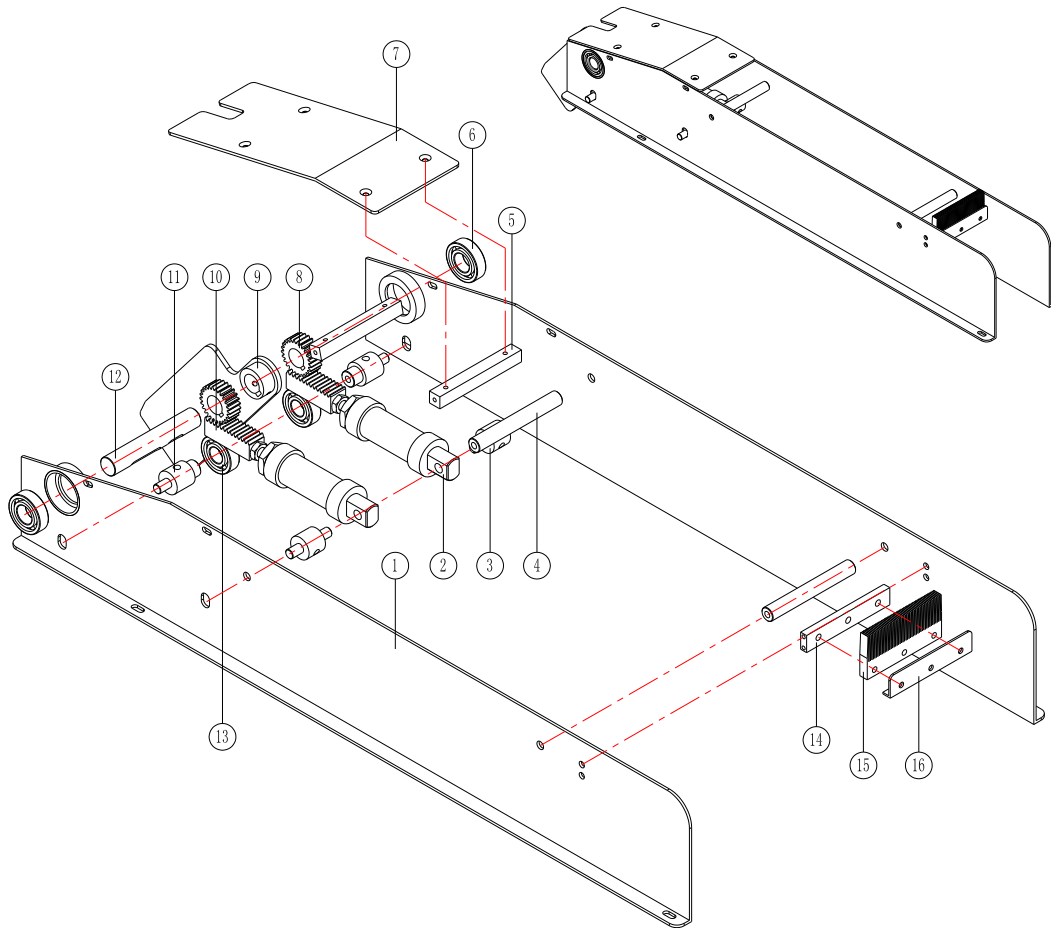
4. FRAME



ACCESSORY LIST

NO.	PART NAME	PART NO.	QTY	REMARK
1	FRAME	SDW-K20TX-174	1	
2	FOOT CUP		4	M16
3	SIDE SEAL PLATE	SDW-K20TX-180	1	
4	ELECTRICAL BOX	SDW-20T-2-3	1	
5	CHAIN COVER PLATE	SDW-K20TX-96	1	
6	END SEAL PLATE	SDW-K20TX-181	1	
7	SIDE SEAL PLATE II	SDW-K20TX-183	1	
8	STULL	SDW-K20TX-118	1	
9	STAND COLUMN COMPONENTS	SDW-K20TX-123	1	
10	STAND COLUMN "L" SHAPED PLATE	SDW-K20TX-119		
11	SIDE SEAL PLATE I	SDW-K20TX-182	1	
12	END SEAL PLATE	SDW-K20TX-179	1	

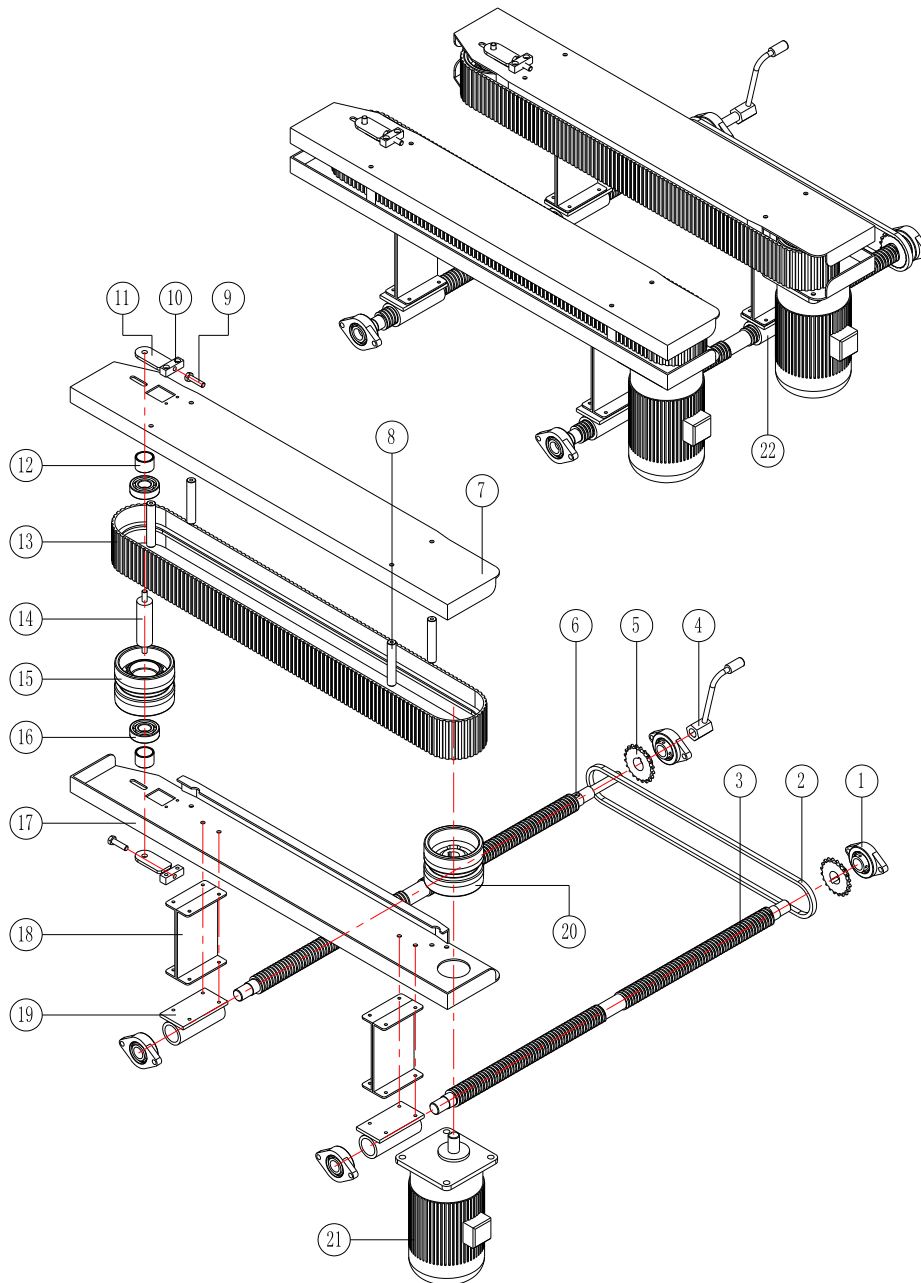
5. FRONT FOLDING MECHANISM



ACCESSORY LIST

NO.	PART NAME	PART NO.	QTY	REMARK
1	MOVEMENT SUPPORT PLATE	SDW-K20TX-15	2	SYMMETRY
2	CYLINDER	MAL32x30-CA	2	
3	FRONT FOLDING CYLINDER REAR AXLE	SDW-K20TX-4	2	
4	JOINT LEVER	SDW-01-04-190	2	
5	TRANSITION PLATE FIXED STRIP	SDW-K20TX-13	2	
6	BEARING		2	6004
7	TRANSITION PLATE	SDW-K20TX-14	1	
8	FRONT FOLDING GEAR	SDW-K20TX-3	2	
9	FRONT PLATE COMPONENTS	SDW-K20TX-7	1	
10	FRONT FOLDING RACK	SDW-K20TX-2	2	
11	FRONT FOLDING RACK BEARING SHAFT	SDW-K20TX-5	2	
12	FRONT FOLDING SHAFT	SDW-K20TX-8	1	
13	BEARING		2	6203
14	BRUSH CARRIER	SDW-20T-201	1	
15	BRUSH		1	
16	PRESSING PLATE	SDW-2A-134	1	

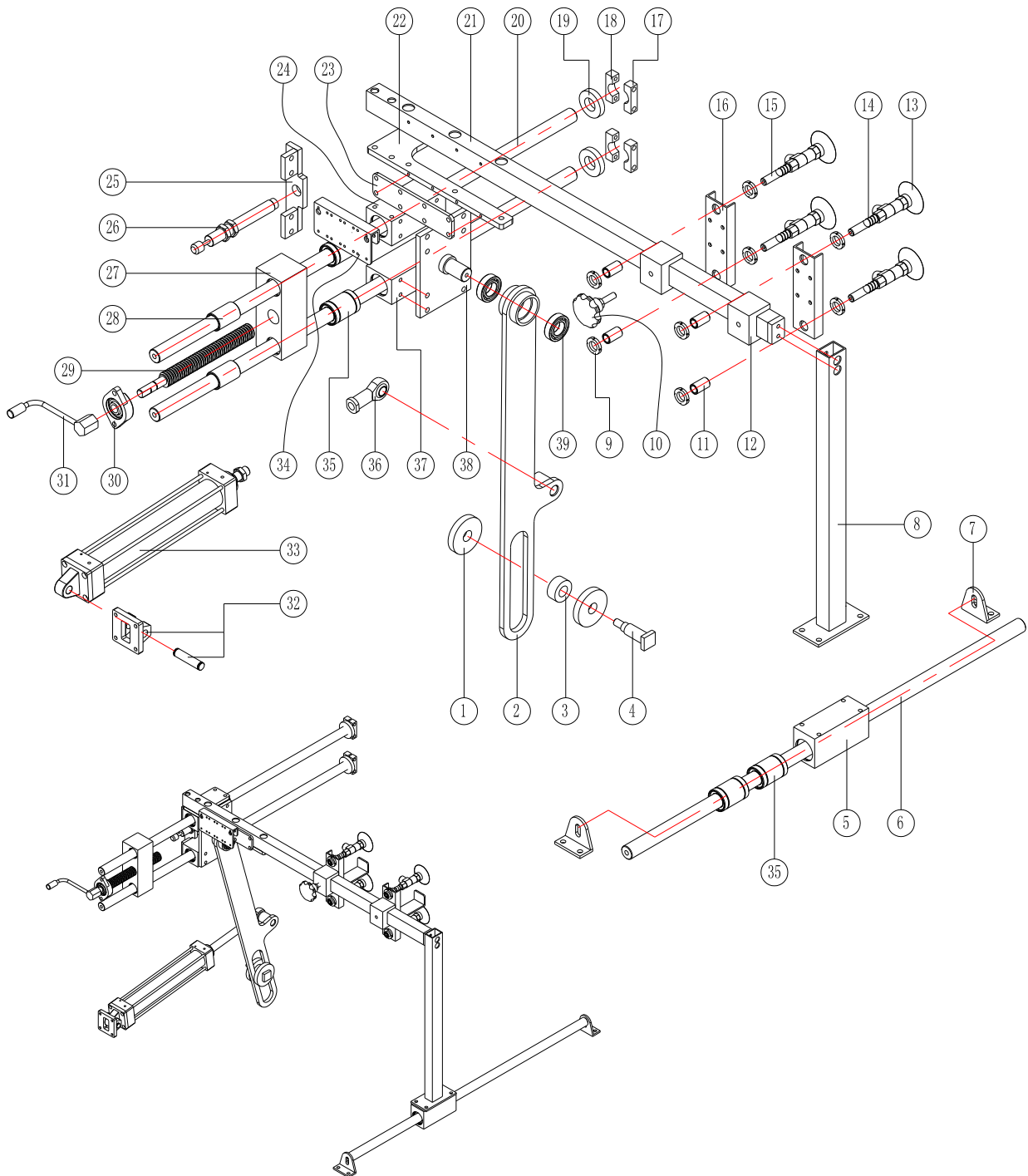
6. TRANSMISSION MECHANISM



ACCESSORY LIST

NO.	PART NAME	PART NO.	QTY	REMARK
1	BEARING PEDESTAL	SBLF 204	4	
2	CHAIN		1	06B
3	LEFT & RIGHT SCREW I	SDW-1A-55	1	
4	HANDLE		1	
5	DRIVE SPROCKET	SDW-01-05-3.1	2	
6	LEFT & RIGHT SCREW II	SDW-K20TX-12	1	
7	SIDE DRIVE UPPER PLATE	SDW-K20TX-11	2	SYMMETRY
8	COVER PLATE BRACE	SDW-18T-159	8	
9	BOLT		4	M8
10	TOP BLOCK	SDW-18T-1	4	
11	DRIVEN PULLEY PRESSING PLATE	SDW-18T-2	4	
12	DRIVEN PULLEY SLEEVE	SDW-18T-161	4	
13	SIDE DRIVE GUIDE BELT		2	1690×73×5
14	DRIVEN WHEEL SHAFT	SDW-18T-160	2	
15	DRIVEN WHEEL	25-636-1	2	
16	BEARING		4	6005
17	SIDE DRIVE LOWER PLATE	SDW-K20TX-10	2	SYMMETRY
18	HEIGHTENING NUT PLATE	SDW-K20TX-9	8	
19	LEFT NUT BASE	SDW-1A-95	2	
20	CAPSTAN	25-002-1	2	
21	SIDE DRIVE MOTOR	CV200-15AZ	2	G4
22	RIGHT NUT BASE	SDW-1A-94	2	

7. SUCTION MECHANISM

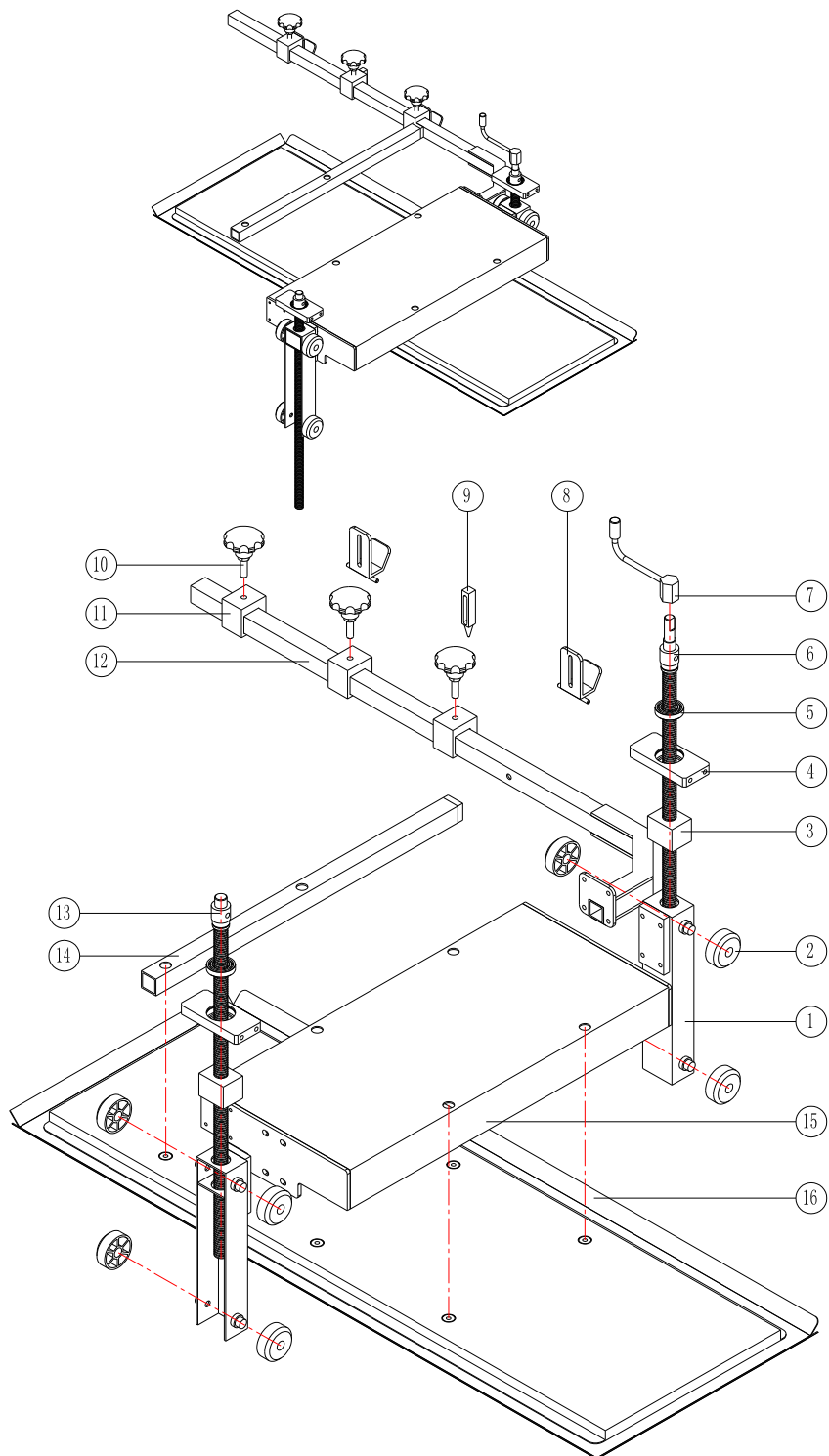


ACCESSORY LIST

NO.	PART NAME	PART NO.	QTY	REMARK
1	LARGE PULLEY	SDW-K20TX-127	2	
2	CONNECTING ROD ASSEMBLY	SDW-K20TX-132	1	
3	SMALL PULLEY	SDW-K20TX-128	1	
4	PULLEY SHAFT	SDW-K20TX-133	1	
5	STRAIGHT SLIDE	SDW-01-04-047	1	
6	WIDTH GUIDE BAR	SDW-K20TX-94	1	
7	GUIDE BAR "L" SHAPED PLATE	SDW-K20TX-93	2	
8	SUCKER UPRIGHT SLIDE BAR	SDW-K20TX-92	1	
9	SUCKER CAP	SDW-K20TX-18	8	
10	HAND WHEEL		1	
11	SUCKER SLIDE SLEEVE	SDW-K20TX-17	4	
12	SLIDE SEAT	SDW-01-04-039	2	
13	SUCKER	ESS-80-GT-G1/4	4	
14	SUCKER PRESSURE SPRING	SDW-K20TX-19	4	
15	SUCKER SLIDE BAR	SDW-K20TX-20	4	
16	SUCKER MOUNTING PLATE	SDW-K20TX-37	4	
17	LIMIT WIDTH CLAMP SPLICE	SDW-K20TX-147	2	
18	LIMIT WIDTH CLAMP SPLICE I	SDW-K20TX-148	2	
19	WIDTH BUFFER CIRCLE	SDW-K20TX-149	2	
20	WIDTH GUIDE ROD I	SDW-K20TX-95	2	
21	SUCKER CROSS SLIDE BAR	SDW-K20TX-89	1	
22	SLIDE BAR BED PLATE	SDW-K20TX-79	1	
23	SLIDE BAR CONNECTING PLATE	SDW-K20TX-199	1	
24	WIDTH STRAIGHT SEAT	SDW-K20TX-73	1	
25	BUMPER SOLEPLATE	SDW-K20TX-77	1	
26	OIL PRESSURE BUMPER	AC-2020-2	1	
27	WIDTH LIMIT SLIDING SEAT	SDW-K20TX-70	2	
28	WIDTH SLIDING SLEEVE	SDW-K20TX-71	2	
29	WIDTH SCREW	SDW-K20TX-80	1	
30	BEARING SEAT	SBLF 202	1	
31	HANDLE		1	
32	CYLINDER ACCESSORY	SC50-CB	1	

33	CYLINDER	SC50x80-S	1	MATCH SC50-CA
34	VACUUM PLATE	SDW-01-04-146	1	
35	STRAIGHT BEARING	LM25UU	6	
36	CYLINDER SPLICE HOLE		1	SC50
37	WIDTH STRAIGHT LINE I	SDW-K20TX-74	1	
38	CONNECTING ROD AXLE SEAT	SDW-K20TX-126	1	
39	BEARING		2	6005

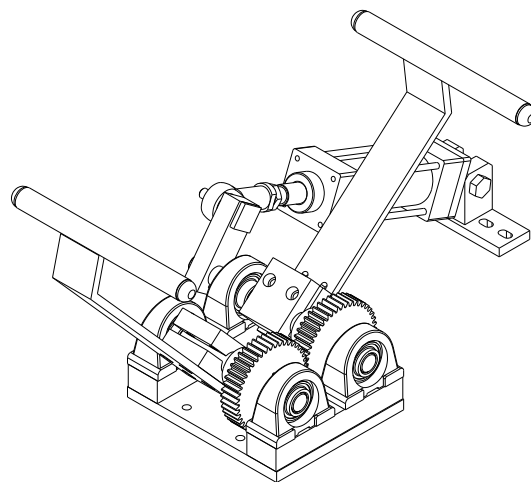
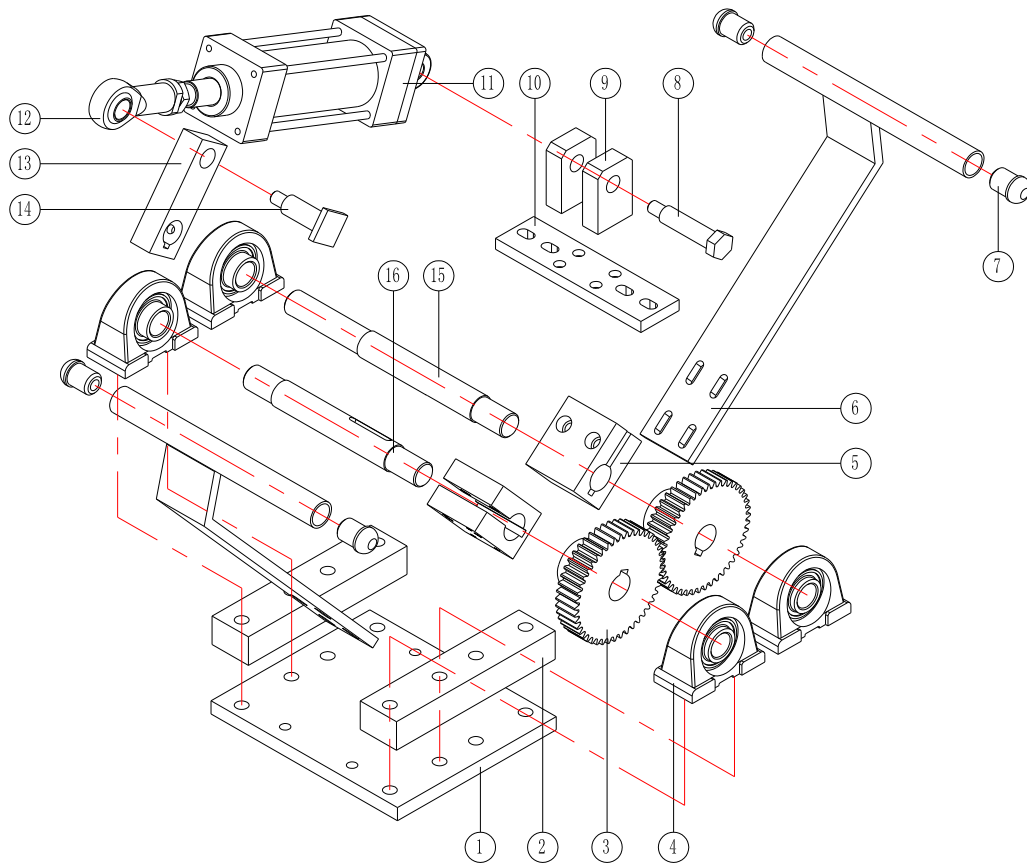
8. SHIELD PIN & PRESSING PLATE MECHANISM



ACCESSORY LIST

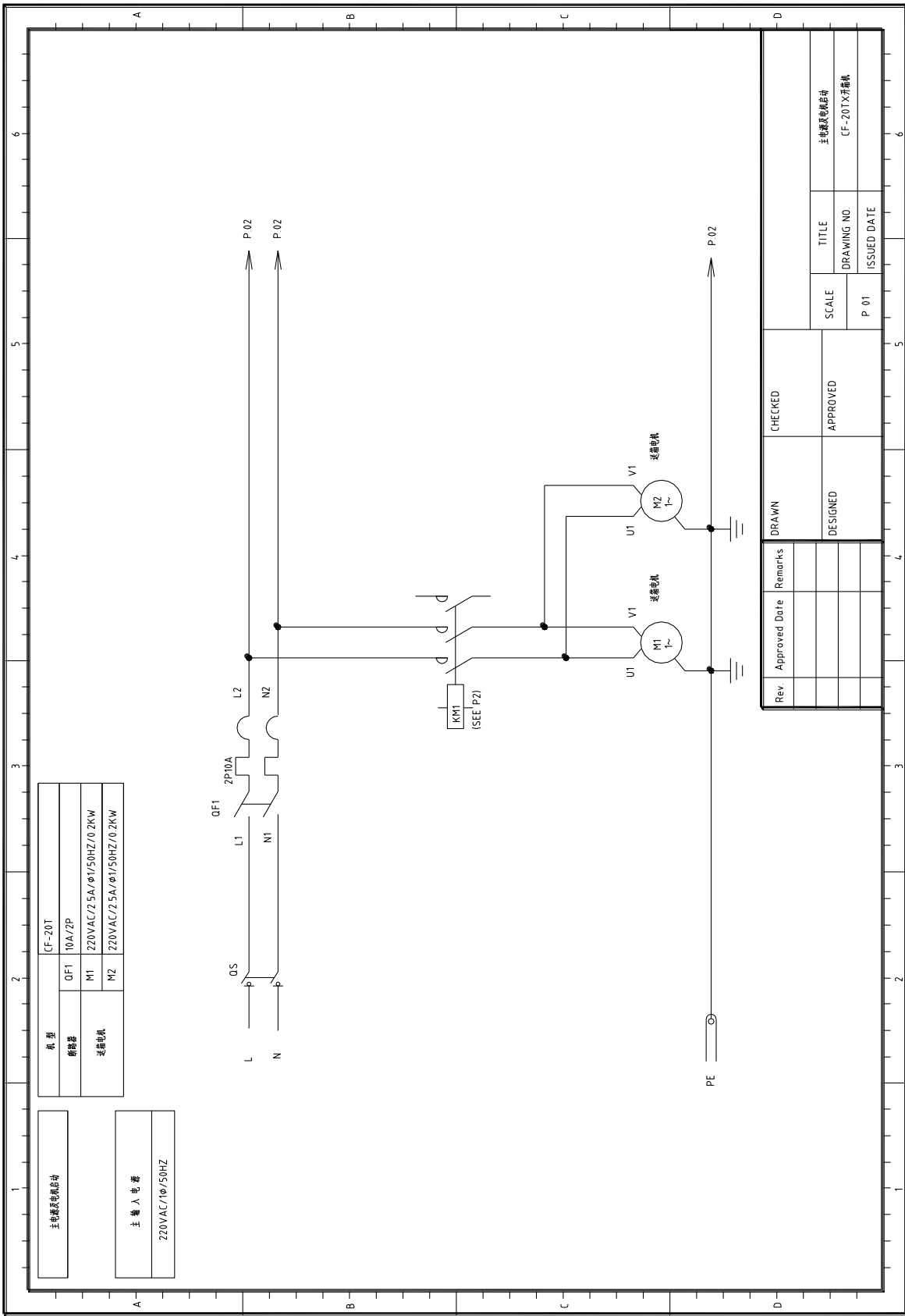
NO.	PART NAME	PART NO.	QTY	REMARK
1	LIFTING BAR	SDW-1A-30	2	
2	PILLAR ROLLER	SDW-1A-105	8	
3	NUT	SDW-1A-106	2	
4	SUPPORT PLATE	SDW-1A-69	2	
5	BEARING		2	61905
6	LIFTING LEAD SCREW II	SDW-1A-71	1	
7	HANDLE		1	
8	GEAR BOX HOLDER	SDW-K20TX-100	2	
9	SHIELD PIN	SDW-K20TX-98	1	
10	HAND WHEEL		3	
11	GEAR BOX SLIDE	SDW-K20TX-97	3	
12	SHIELD PIN HOLDER	SDW-K20TX-198	1	
13	SHIELD PIN HOLDER STAY TUBE	SDW-K20TX-193	1	
14	LIFTING LEAD SCREW I	FJ-1A-70	1	
15	CROSS ARM COMPONENTS	SDW-K20TX-186	1	
16	PRESSING PLATE	SDW-K20TX-189	1	

9. LEFT & RIGHT COVER FOLDING MECHANISM



ACCESSORY LIST

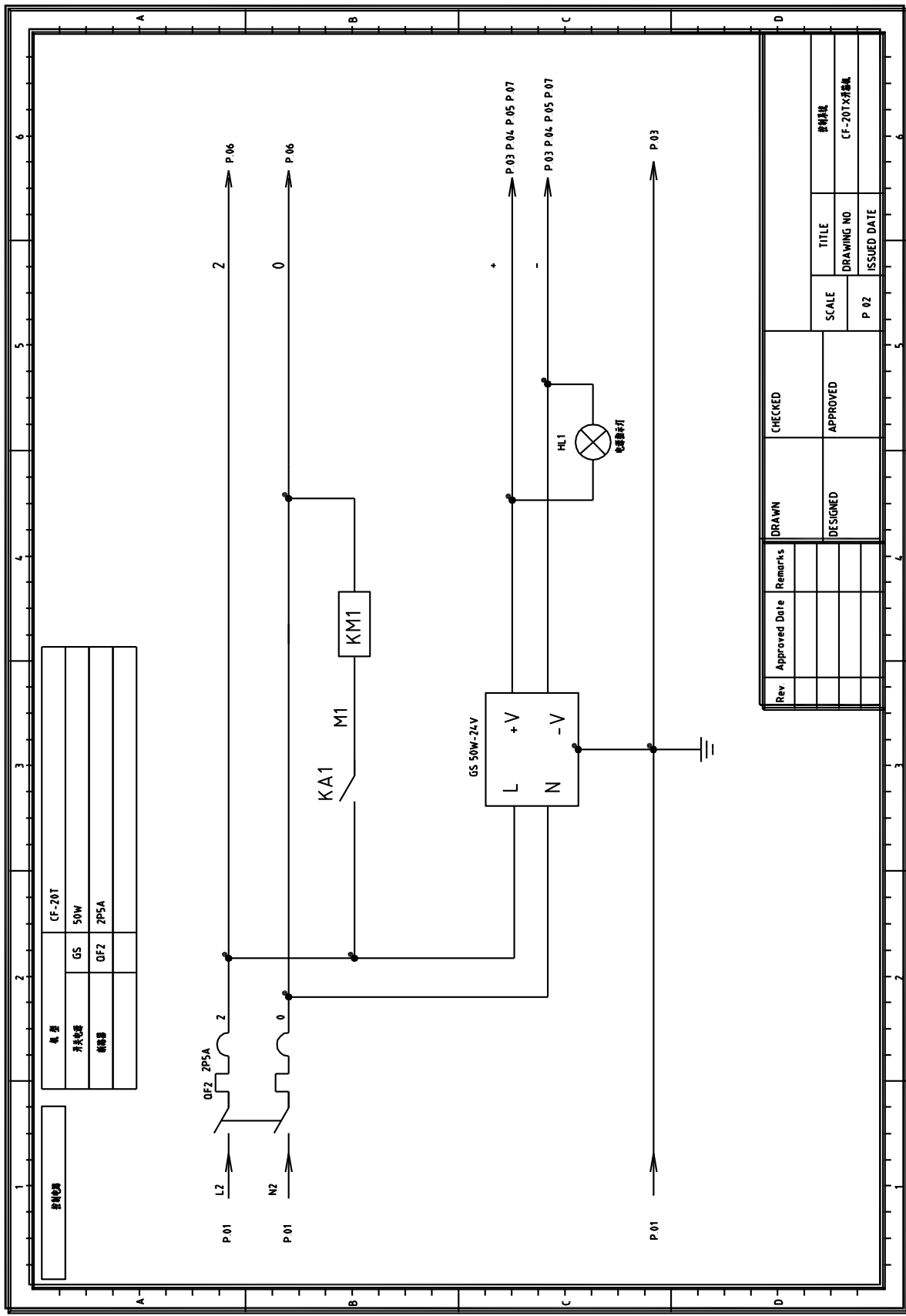
NO.	PART NAME	PART NO.	QTY	REMARK
1	LEFT & RIGHT FOLDING STAND	SDW-K20TX-150	1	
2	BEARING STAND PAD	SDW-K20TX-136	2	
3	TRANSMISSION GEAR	SDW-K20TX-135	2	
4	BEARING STAND	UCPA 204	4	
5	CLAMP SPLICE	SDW-K20TX-134	2	
6	LEFT & RIGHT FOLDING BAR	SDW-K20TX-144	2	SYMMETRY
7	FOLDING BAR PLUGS	SDW-K20TX-141	4	
8	CYLINDER REAR AXLE	SDW-K20TX-151	1	
9	CYLINDER REAR BLOCK	SDW-K20TX-145	2	
10	CYLINDER REAR PLATE	SDW-K20TX-146	1	
11	CYLINDER	SC50×80-S	1	MATCH SC40-CA
12	CYLINDER SPLICE HOLE		1	SC50
13	SWAYING BLOCK	SDW-K20TX-137	1	
14	CYLINDER FRONT AXLE	SDW-K20TX-138	1	
15	FOLDING BAR MOVING AXIS	SDW-K20TX-140	1	
16	FOLDING BAR AXIS	SDW-K20TX-139	1	



机型	CF-20T
断路器	QF1 10A/2P
电动机	M1 220VAC/2.5A/φ1/50HZ/0.2KW
	M2 220VAC/2.5A/φ1/50HZ/0.2KW

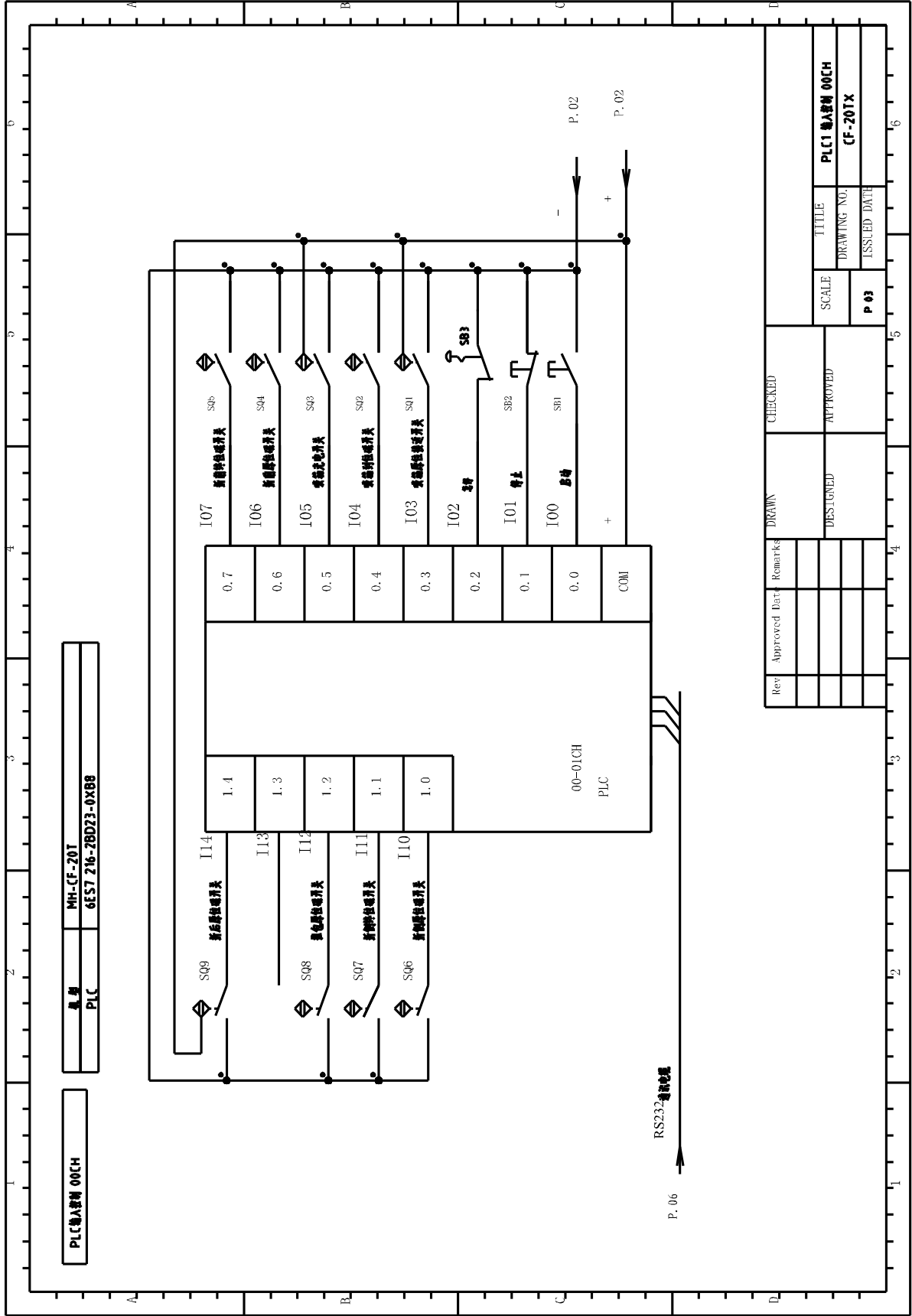
主输入电压	220VAC/1φ/50HZ
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Rev.	Approved Date	Remarks	DRAWN	CHECKED	SCALE	TITLE
			DESIGNED	APPROVED	P 01	主电源及机站图
						DRAWING NO
						ISSUED DATE
						CF-20T开柜图



控制电路	CF-20T
开关电器	GS 50W
继电器	OF2 2P5A

Rev	Approved Date	Remarks	DRAWN	CHECKED	SCALE	TITLE
			DESIGNED	APPROVED	P.02	DRAWING NO
						ISSUED DATE
						CF-20T控制电路

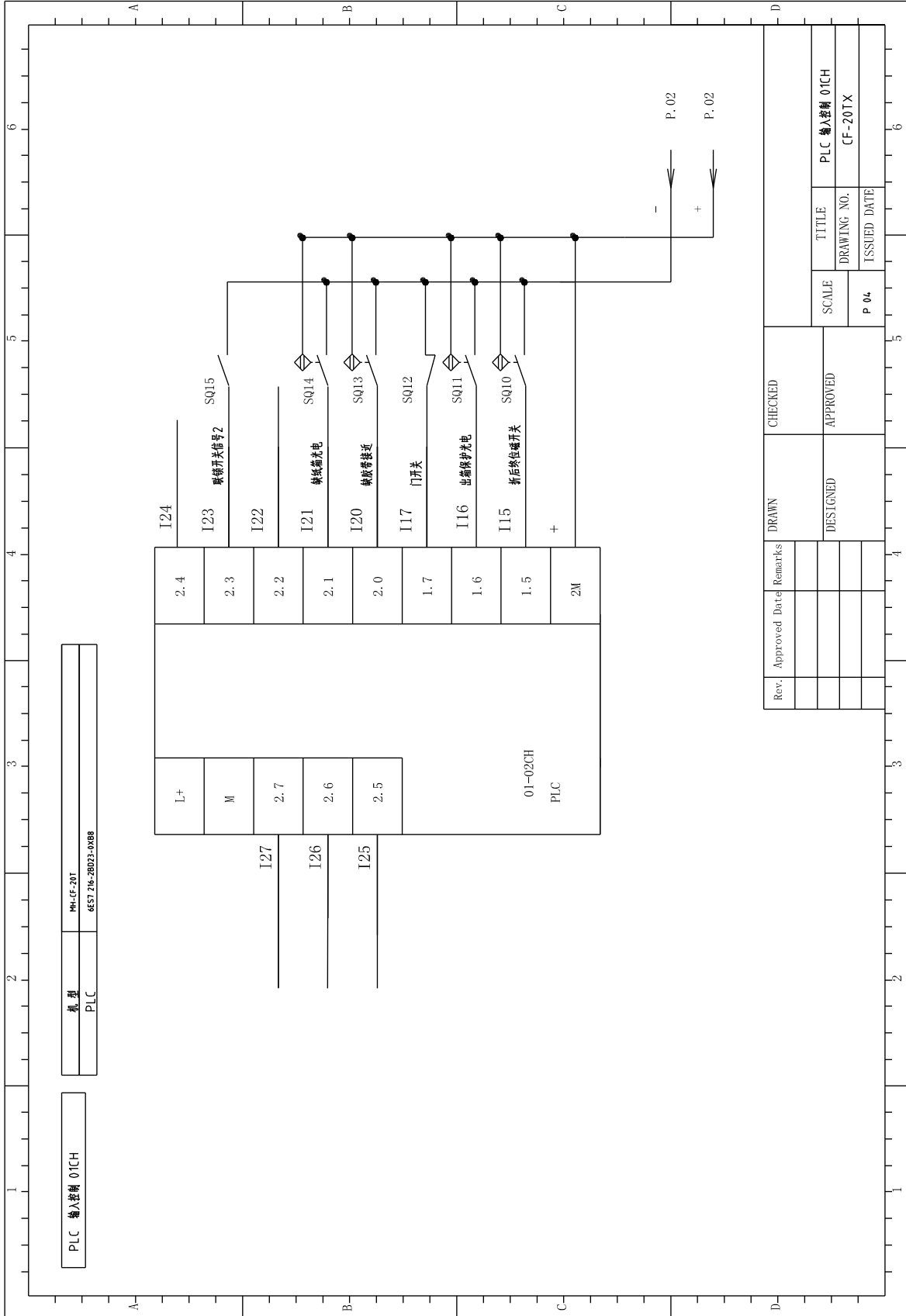


PLC输入模块 00CH	型号 MH-CF-20T 6ES7 216-2BD23-0XB8
PLC	

Rev	Approved Date	Remarks	DRAWN	CHECKED	TITLE	
			DESIGNED	APPROVED	SCALE	PLC1 输入模块 00CH
					P 03	DRAWING NO: CF-20TX
						ISSUED DATE

P. 06

RS232 通信电缆



PLC 输入控制 01CH	机型 PLC	MH-CE-20T 6ES7 216-2BD03-0AB8
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L+	2.4	I24
M	2.3	I23 限位开关信号2
I27	2.2	I22
I26	2.1	I21 轴端光电
I25	2.0	I20 轴端接近
01-02CH PLC	1.7	I17 门开关
	1.6	I16 出轴保护光电
	1.5	I15 折后终位碰开关
	2M	+

Rev.	Approved Date	Remarks	DRAWN	CHECKED
			DESIGNED	APPROVED
			SCALE	TITLE
			P 04	PLC 输入控制 01CH
			DRAWING NO.	CF-20TX
			ISSUED DATE	

