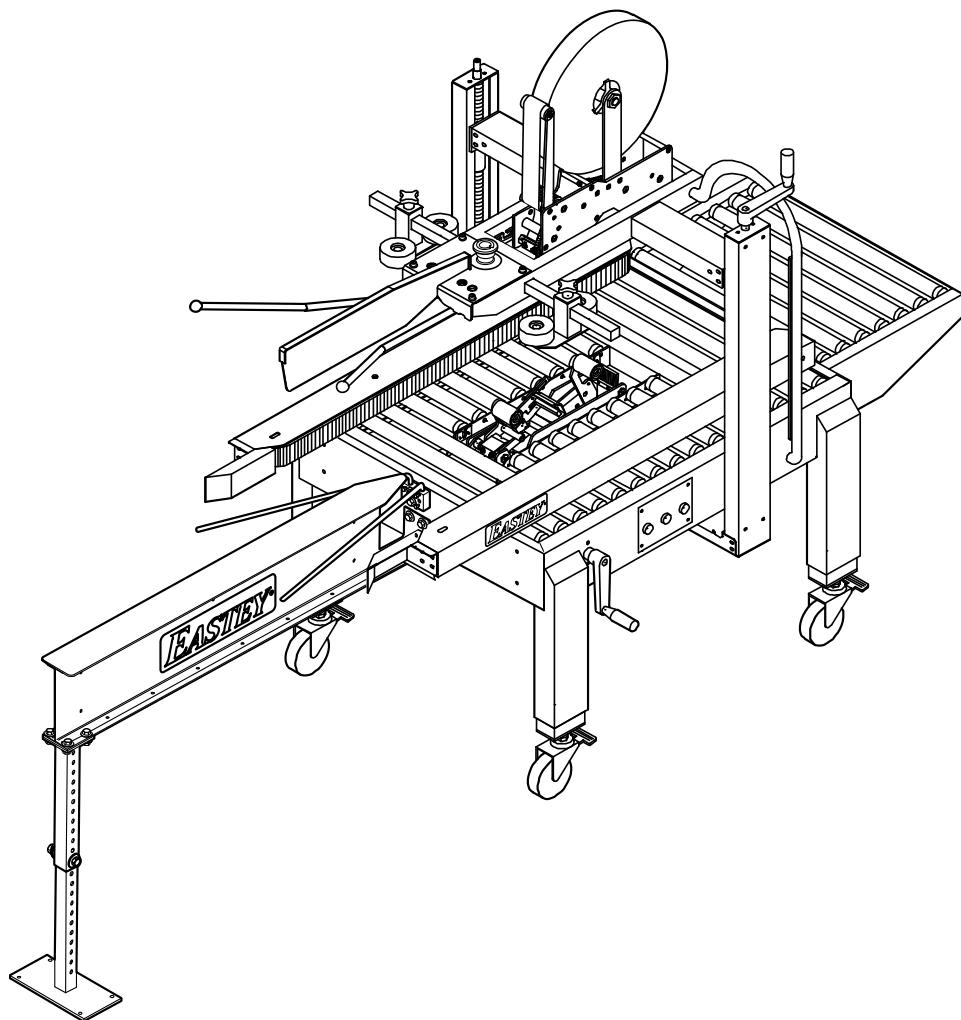


# Easy Packer

---

**Industrial  
Case Taping System**

## User Guide



---

 **EASTEY**<sup>®</sup>

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

# Easy Packer

## Industrial Case Taping System

### User Guide



Revised 06/26/2023

P/N 5001695 Rev. B

#### **Copyright and Trademarks**

Copyright ©2012-2023 Engage Technologies Corporation  
All rights reserved. All trademarks and registered names  
are the property of their respective owners.

Eastey  
7041 Boone Ave. N.  
Brooklyn Park, MN 55428

Phone: (763) 428-4846; Fax (763) 795-8867; 1-800-835-9344  
[www.eastey.com](http://www.eastey.com)

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

# Contents

<b>Who We Are: We Help Companies Deliver Products to the World .....</b>	<b>8</b>
This User Guide is available online .....	8
<b>Safety .....</b>	<b>9</b>
Safety Precautions .....	9
Explanation of Symbols .....	10
<b>Introduction .....</b>	<b>11</b>
Easy Packer Industrial Case Taper Overview .....	11
Easy Packer Case Taper Overview Online Video .....	12
Instructional Videos Online .....	12
Specifications .....	12
Machine Serial Number .....	14
Typical Applications .....	14
<b>Installation .....</b>	<b>15</b>
Install Locking Casters and Adjust Height .....	15
Location Requirements .....	16
Install the Exit Roller Pack Table .....	17
Install the Box Entrance Guide .....	17
Next Steps .....	21
<b>Operation .....</b>	<b>22</b>
Loading the Tape Cartridges .....	22
Check Tension .....	23
Thread Tape .....	23
Main Spring Adjustment .....	25
Power .....	27
Control Panel .....	27
Emergency Stop .....	28
<b>Adjustments .....</b>	<b>29</b>
Height and Width Adjustments .....	29
<b>Maintenance .....</b>	<b>37</b>
Rollers .....	37
Cutting Knives .....	37
<b>Troubleshooting .....</b>	<b>38</b>
<b>Parts .....</b>	<b>40</b>
Electrical .....	40
Side Belt Assembly .....	44
Vertical Column .....	47
Machine Body .....	50
Easy Packer Anvil Box Guide .....	52

<b>Video Library .....</b>	<b>54</b>
Instructional Videos.....	54
Application Videos.....	54
<b>Warranty Statement .....</b>	<b>55</b>
<b>Customer Support.....</b>	<b>57</b>

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

# We Help Companies Deliver Products to the World

Thank you for choosing the Eastey Easy Packer Side Belt Case Taper for your packaging needs. Eastey is part of Engage Technologies, an ISO 9001-2015 certified company that has steadily built a solid reputation for quality since 1979. Engage is known for providing rugged, durable, reliable packaging equipment to help companies deliver their products to the world.

Each Engage Technologies company – Squid Ink, Eastey, and American Film & Machinery (AFM), focuses on a different part of the packaging section of the production line.

ENGAGE *technologies corporation*



**Squid Ink** ([www.SquidInk.com](http://www.SquidInk.com))

Coding and marking equipment, inks, and fluids for product identification and traceability



**Eastey** ([www.Eastey.com](http://www.Eastey.com))

Automated shrink wrapping and bundling, automated case sealing, case erecting and product handling



**AFM** ([www.AFMSleeves.com](http://www.AFMSleeves.com))

Automated shrink sleeve labeling equipment, tamper-evident banding equipment, shrink tunnels and shrink sleeve consumables

When you purchase your packaging equipment from the Engage Technologies family of companies, you can feel confident that you have a machine that is first in quality and built to last. Thank you for choosing us for your packaging needs.

## This User Guide is available online

This User Guide is also available from the Eastey Support Website in electronic format for web browsers and e-readers. Go to [Eastey.com/Support/User-Guides-Drawings](http://Eastey.com/Support/User-Guides-Drawings) to see available User Guides, or scan the QR Code at right using the camera app on your mobile device to go directly to the online version of this User Guide.



# Safety

## Safety Precautions

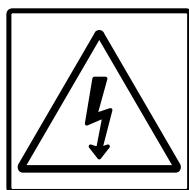
Before installing, operating or servicing this equipment, please read the following precautions carefully:

- This machine is equipped with moving belts. Do not place hands near the belts when they are moving as fingers may be pinched where belts enter the frame. We suggest the use of a roller-type exit conveyor or pack table for your cases. Always remove boxes after they clear the exit end of the machine.
- Observe caution when near the tape heads or when threading tape. The tape cutting knives are very sharp, automatically operated, and linked to tape wipe down rollers.
- Always disconnect electrical power before attempting maintenance for any electrical or moving parts. Do not attempt to open or work on the electrical box, junction boxes, or other electrical components of the unit without first disconnecting power to the machine. Electrical shock hazard exists if power is not disconnected.
- Use only the specified power-supply cable. Do not use the power cable to pull or position the machine, as this will damage or break the cable.
- Do not by-pass any factory-designed safety features such as guards, interlocks, switches, etc. Do not operate the machine if such modifications have been made.
- Do not attempt to operate the machine with loads that exceed the limits of use and operation in regards to weight and sizes, or with unstable loads that present a hazard of tipping or falling.
- This equipment is designed for indoor operation in a typical clean, dry factory environment. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.
- Do not place hands, head, or any part of the body inside the confines of the machine unless the tape head mechanisms are securely fastened, and the electrical supply is shut off.
- To minimize the potential for personal injury, always be sure that the machine operators and others working on the machinery are properly trained in the correct usage of the equipment and properly instructed regarding safe operation.
- Never provide service or clear a box jam when machine is running. Always stop the machine and shut off power before servicing.
- When feeding a box into the unit, always hold down the box top and present the box to unit. Release hands as soon as the belts begin to take the box.
- Do not wear loose clothing such as ties, scarves, jewelry etc. Long hair should be pulled back and/or covered while operating this machine.

## Explanation of Symbols



**Caution** sign or Safety Alert symbol. Indicates caution, be alert, Your safety is involved. Knowledge of safe operation is required. Caution indicates a hazardous situation which, if not avoided, could result in minor or moderate injury or damage to equipment or surroundings.

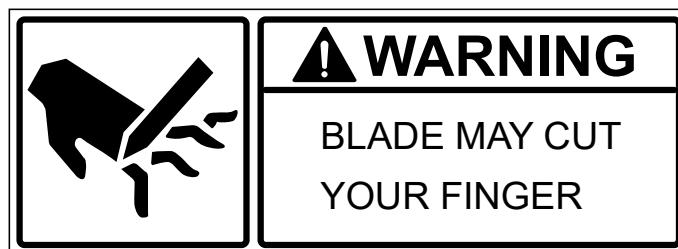


**Electrical hazard.** Indicates electrical danger. Allow only a trained electrician to open or perform work inside the electrical panel or enclosure.



**Warning** symbol. Indicates a hazardous situation which, if not avoided could result in death or serious injury. A warning indicates a situation or condition potentially more severe than indicated by a caution message but not imminent as a danger message.

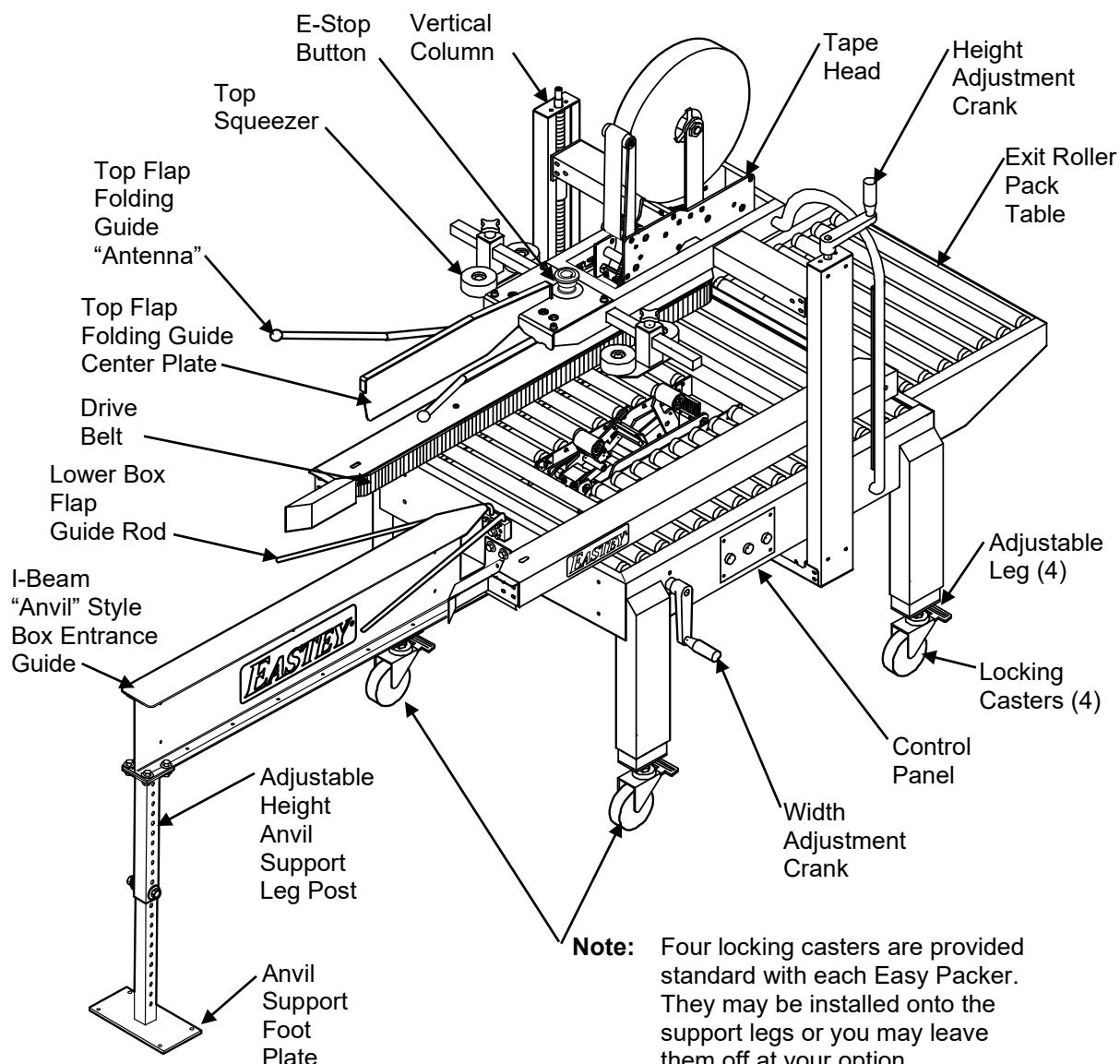
This symbol is associated with warnings for conditions as shown below.



# Introduction

The Easy Packer Industrial Case Taper features folding mechanisms for closing case top and bottom flaps before tape sealing: an I-beam anvil-style box entrance guide with guide rods for lower box flap closure, and a folding plate and guide rods for top flap closure.

## Easy Packer Industrial Case Taper Overview



1. Flap closing rods and center plough plate assist in flap closing prior to being sealed.
2. Industrial strength roller beds move boxes consistently through the taper.
3. Adjustable side rails and tape head offer fast and easy case changes.
4. Top and bottom tapeheads are identical and can be removed instantly without tools. Choose from two options.

## Easy Packer Case Taper Overview Online Video

To view an Overview Video of the Eastey Easy Packer Industrial Case Taper in operation, click the following link:

<https://www.youtube.com/watch?v=7v5eNws2XSY> or scan the QR code at right using the camera app on your mobile device.



## Instructional Videos Online

Instructional Videos for the Eastey Easy Packer Industrial Case Taper are available online and have been arranged in a playlist. To view the video playlist, click the following link: [https://www.youtube.com/playlist?list=PLw2fFM1Tj1XVwEOXq\\_cpbKbzF6trEd0W](https://www.youtube.com/playlist?list=PLw2fFM1Tj1XVwEOXq_cpbKbzF6trEd0W) or scan the QR code at right using the camera app on your mobile device.



## Specifications

### Easy Packer Taping Specifications

Sealer Type	Uniform side belt, top and bottom case sealer
Machinery Makeup	Industrial strength 12 gauge steel powder coated for durability
Belt Speed	20 cases per minute depending on box size and operator efficiency
Height Adjustment	Standard adjustable legs for 20" to 32.3" conveyor heights

Box Specifications	Length	Width	Height
Minimum Box Size	5"	4.0"	4.0"
Maximum Box Size	Infinite	19.5"	19.5"

Tape Size	2" wide pressure sensitive tape up to 15" diameter rolls, optional 3" wide tape
Tape Cartridge	Proven design requires no lubrication, designed for simple tape threading, removable for maintenance and interchangeable with top or bottom cartridges
Air Requirements	None
Electrical Requirements	110 VAC, 60Hz, 4.0A
Agency Approvals	CE Certification

## Easy Packer Features

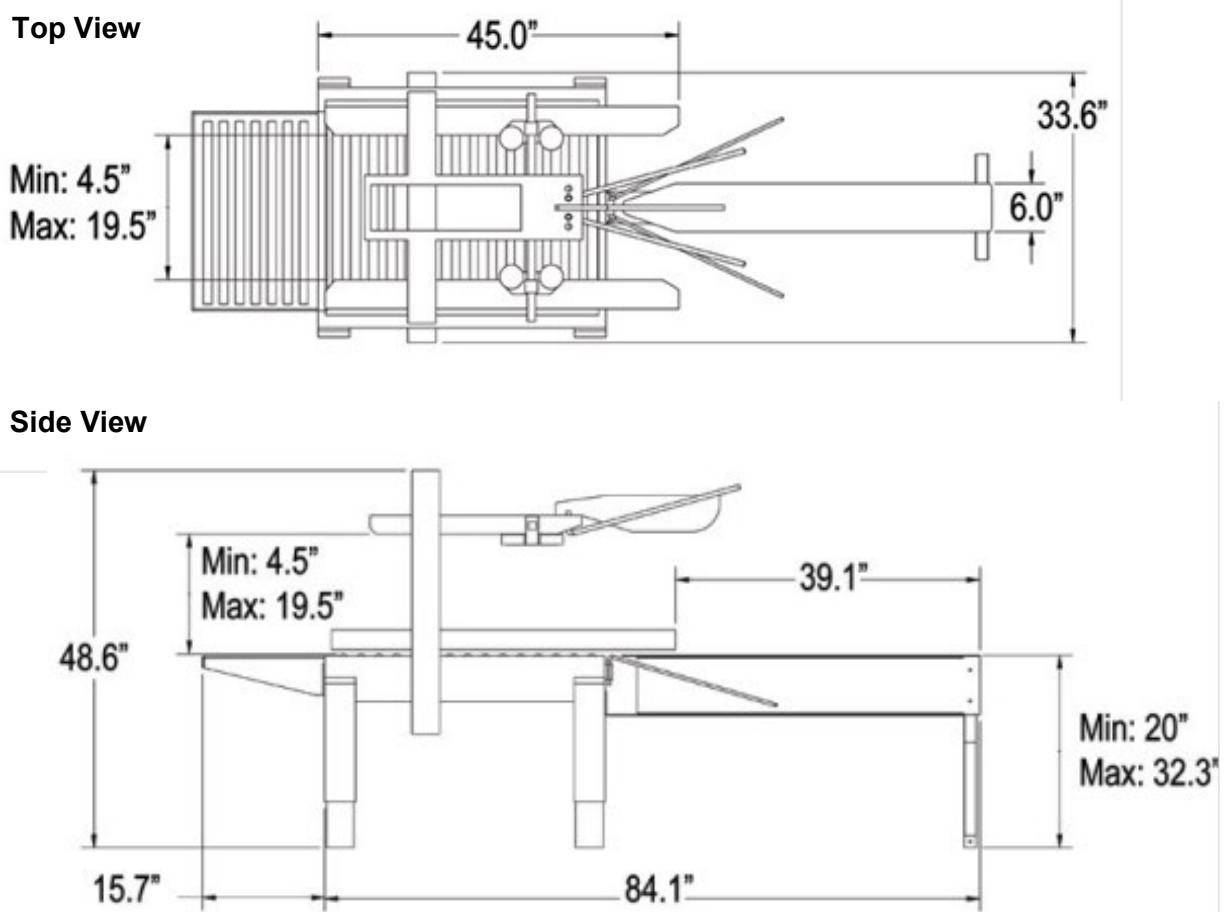
- Includes anvil packing station for easy case packing
- Utilizes Eastey's Easy-Taper tapehead

- Plug-in and go operation
- Powder coated 12 gauge steel
- Top and bottom tape cartridges
- Industrial strength side belts
- Adjustable leg extensions
- Fast and easy box size changes
- Low maintenance
- Accommodates wide case range
- Casters for transportation within plant

### Easy Packer Optional Accessories

- 3" Tape Head      Accepts 3" wide tape rolls
- Rear Packing Table      Roller table bolts after taping system to allow for case movement

### Dimensions



## Machine Serial Number

The Machine Serial Number can be found on the identification label on the side of the base frame near the case taper control panel.

The identification label displays the Model designator, Serial Number, and Electrical Power Rating requirements.

Record the Serial Number for future reference.

Note pertinent information for the case taper on this serial plate.

<b>EASY-PACKER SB-2/3EXN</b>	
MODEL:	<input type="text"/>
SERIAL NUMBER:	<input type="text"/>
PART NUMBER:	<input type="text"/>
SUPPLY VOLTAGE:	<input type="text"/>
FULL LOAD CURRENT:	<input type="text"/>
PHASE:	<input type="text"/>
REPLACEMENT BELT:	<input type="text"/>
CARTRIDGE REPLACEMENT:	<input type="text"/>

**EASTEY**  
Engage Technologies  
7041 Boone Ave. N.  
Brooklyn Park, MN 55428  
1-800-796-3279  
FAX: 1-763-795-8867

## Typical Applications

### Eastey Easy Packer Case Taping Machine

This case taping machine is intended for operation to assist with closing the case bottom and top flaps and seal top and bottom seams cases by applying OPP (oriented polypropylene) tape.

### Do NOT use the Easy Packer Case Taping Machine to seal the following product types:

- Explosive Products
- Flammable Products
- Hazardous Products
- Pharmaceuticals
- Agri-Foodstuffs
- Wet Products
- Products that are heavier or larger than allowed by the machine specifications.

**Do not** operate the machine in any extremely wet or oily environment that may exceed operating specifications. This equipment is designed for indoor operation in a typical clean, dry factory environment protected from rain and moisture.

# Installation

Carefully unpack the case taper from the shipping carton.

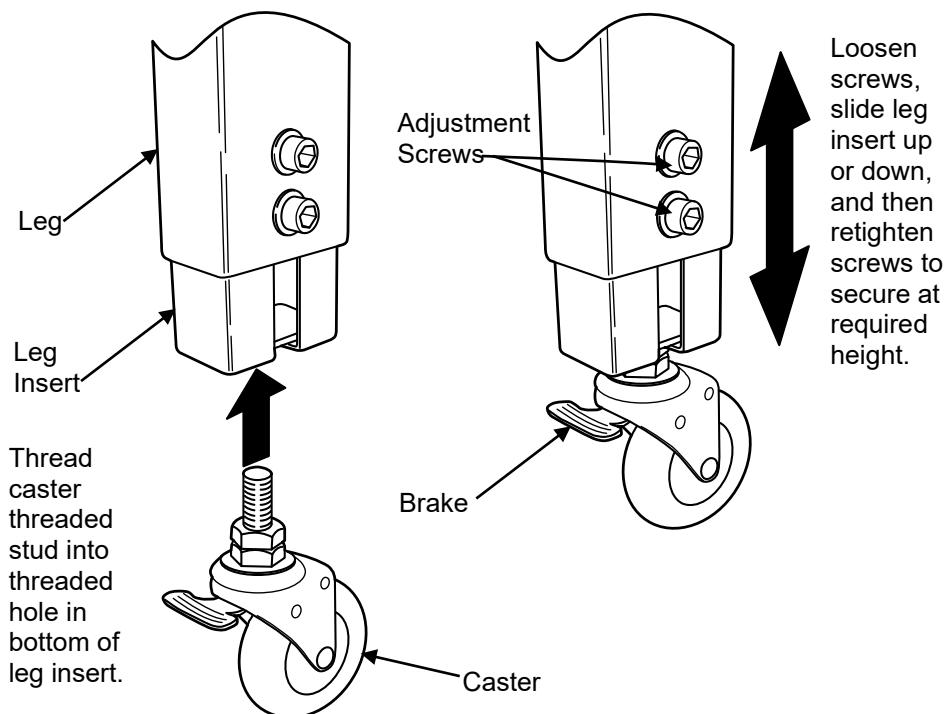
Remove the banding straps that secure the case taper to the shipping pallet. Lift the case taper off the pallet.

**CAUTION!** The case taper is a very heavy piece of equipment and will require a forklift, floor crane, or several people to move safely off the shipping pallet. Use proper equipment when lifting the case taper and ensure the case taper is secure and will not shift while removing shipping materials.

## Install Locking Casters and Adjust Height

Four locking casters are provided and optionally may be installed onto the four adjustable support legs. If the casters are to be installed, thread each caster into the threaded hole in the bottom of each leg while supporting the case taper.

**CAUTION!** Raise the case taper off the floor to install the casters. Use proper equipment when lifting the case taper. Ensure the case taper is secure and will not shift while the casters are being installed.



To adjust the leg height, loosen the adjustment screws on each leg and slide the insert up or down as required and then retighten the screws at the required height.

## Location Requirements

Move the case taper to the desired location. To lift or move the case taper without casters installed, you will need to use a pallet jack or forklift to lift and move it. If you have installed the casters, release the brake lever on each of the locking casters to move the taper easily over a smooth flat surface. Re-engage caster brake levers when the case taper has been moved to its location.

When installing the case taper please be aware of the following considerations:

1. The mounting surface is flat and level.
2. Conveyor or packing table height.
3. Alignment with packaging line.

When the case taper is positioned in the operating location you will need access to:

1. The control panel, with Start/Run and Stop switches, and E-Stop.
2. Height and width adjustments.
3. Both upper and lower tape cartridges for tape loading.

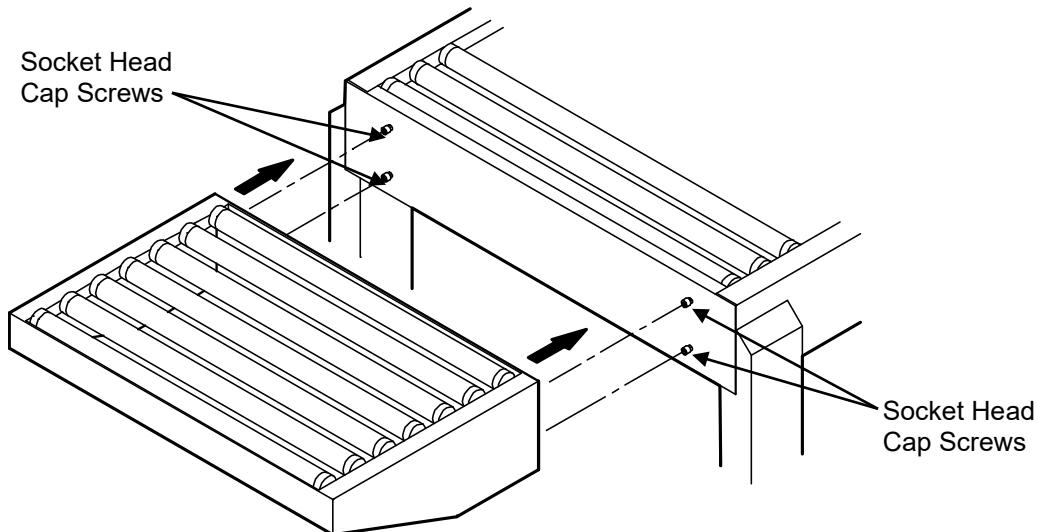
A packing table may be provided at the infeed end where the packer can fill boxes and position the flaps while feeding the boxes into the machine for closing and sealing. It is also convenient to have a pack table at the exit end of the taper.

It is essential that the table and conveyor be at the machine bed height and that the height of the I-beam anvil box entrance guide be adjusted so it is level.

The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

## Install the Exit Roller Pack Table

To attach the exit roller pack table, temporarily loosen socket head cap screws at the locations shown in the following illustration. Align the keyhole slots in the table flanges with the loosened cap screw heads and position the end table so rollers are level with the case taper rollers, then re-tighten cap screws to secure table.

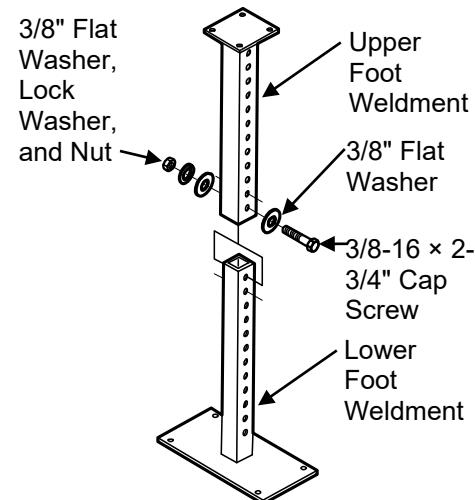


## Install the Box Entrance Guide

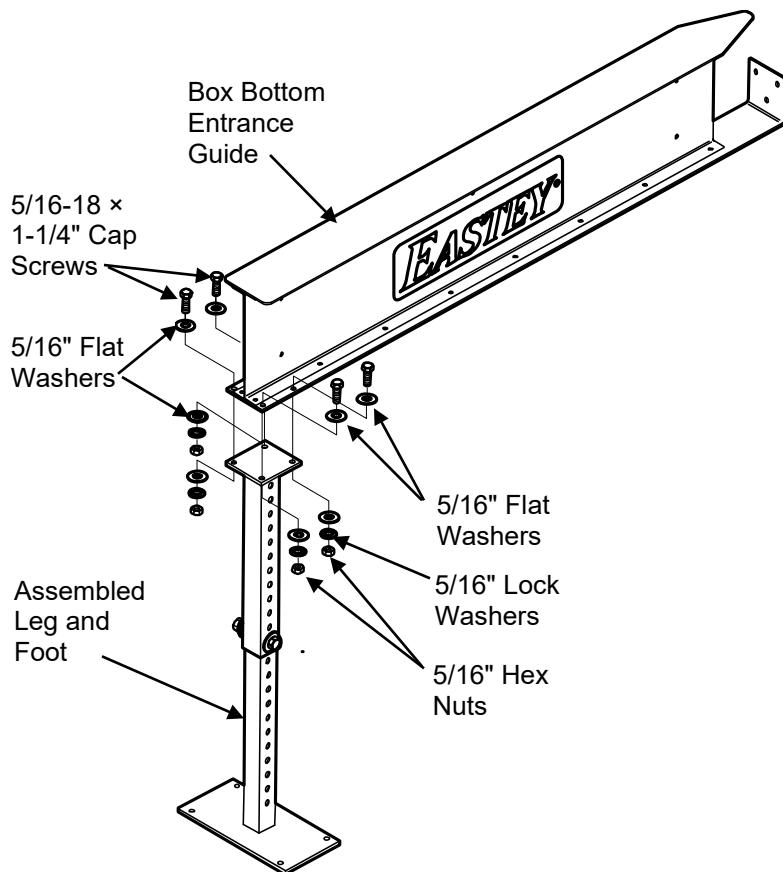
Follow these instructions to assemble and install the box entrance guide anvil and lower box flap guide rods.

**NOTE:** Do not tighten hardware to full torque during assembly; install hardware loosely to allow for adjustment, and then tighten when assembly is complete.

1. Assemble the support leg by sliding the square tube of the lower foot weldment into the slightly larger square tube of the upper leg weldment as shown. Fasten the two parts loosely together using the 3/8-16 x 2-3/4 cap screw, flat washers, lock washer, and hex nut as shown. (Height is determined by the sets of holes selected in the two tubes. At this time do not be overly concerned about the height of the assembled leg, as this can be adjusted to the proper height when connecting the I-beam to the case taper frame.)

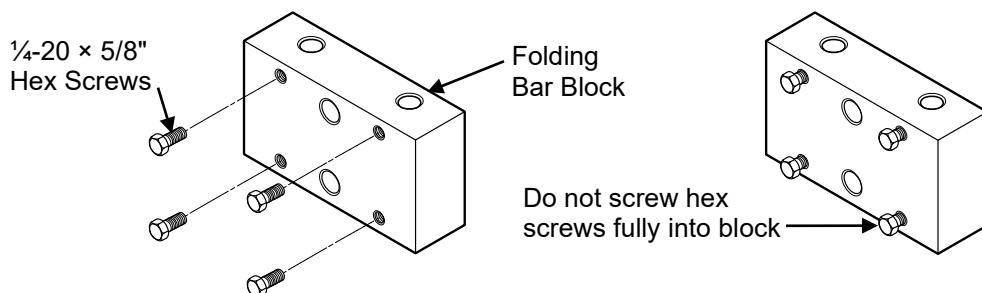


2. Align the holes in the top flange of the support leg with the holes in the bottom I-beam flange at the end of the box guide anvil base, and then fasten the support leg to the anvil using four 5/16-18 × 1-1/4 hex head cap screws, lock washers, flat washers, and hex nuts.

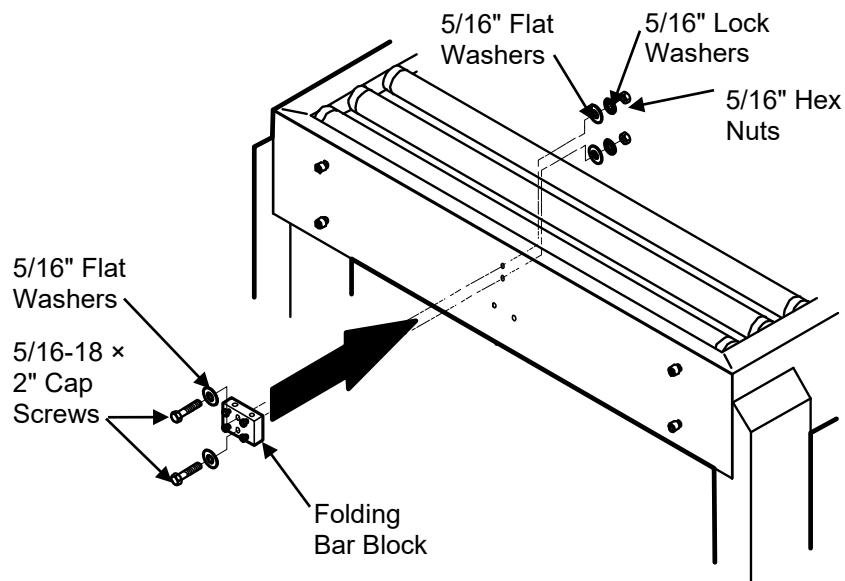


3. Partially assemble the folding bar block, inserting four 1/4-20 × 5/8-inch stainless steel cap screws into the four 1/4-20 threaded holes.

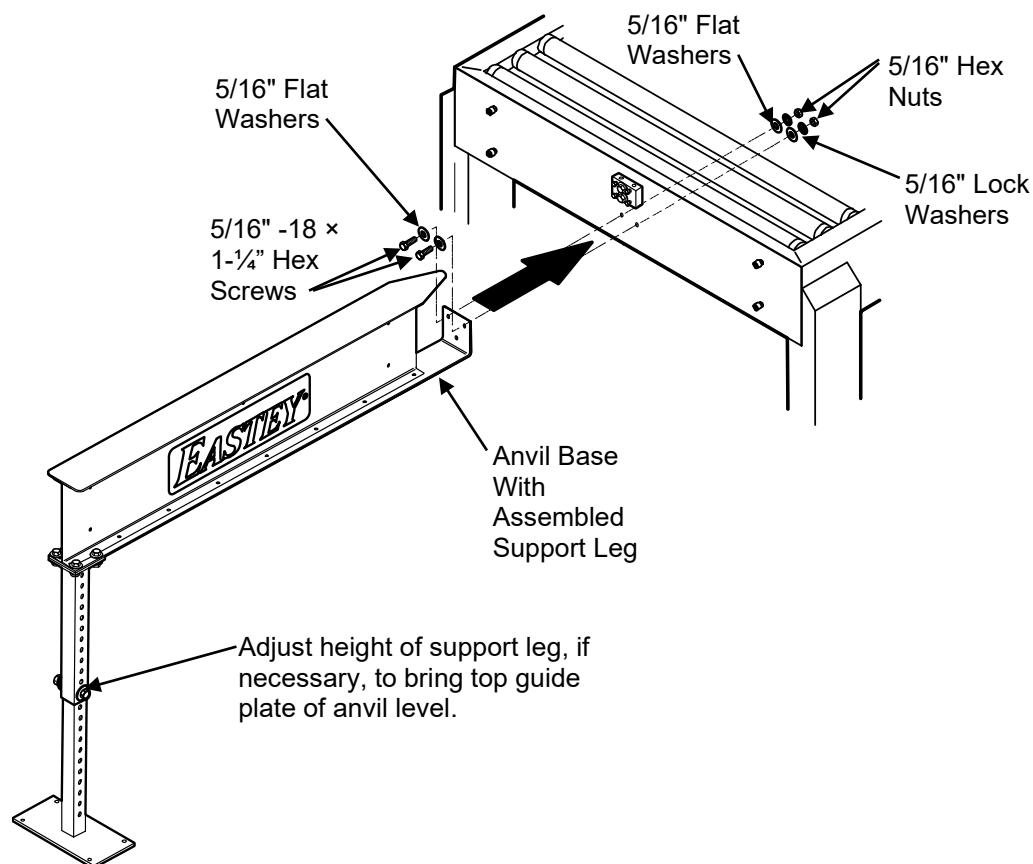
**NOTE:** **Do not tighten 1/4-20 × 5/8-inch hex screws fully into the block at this time. Install the cap screws to the depth just before they enter the vertical bore holes in the block.**



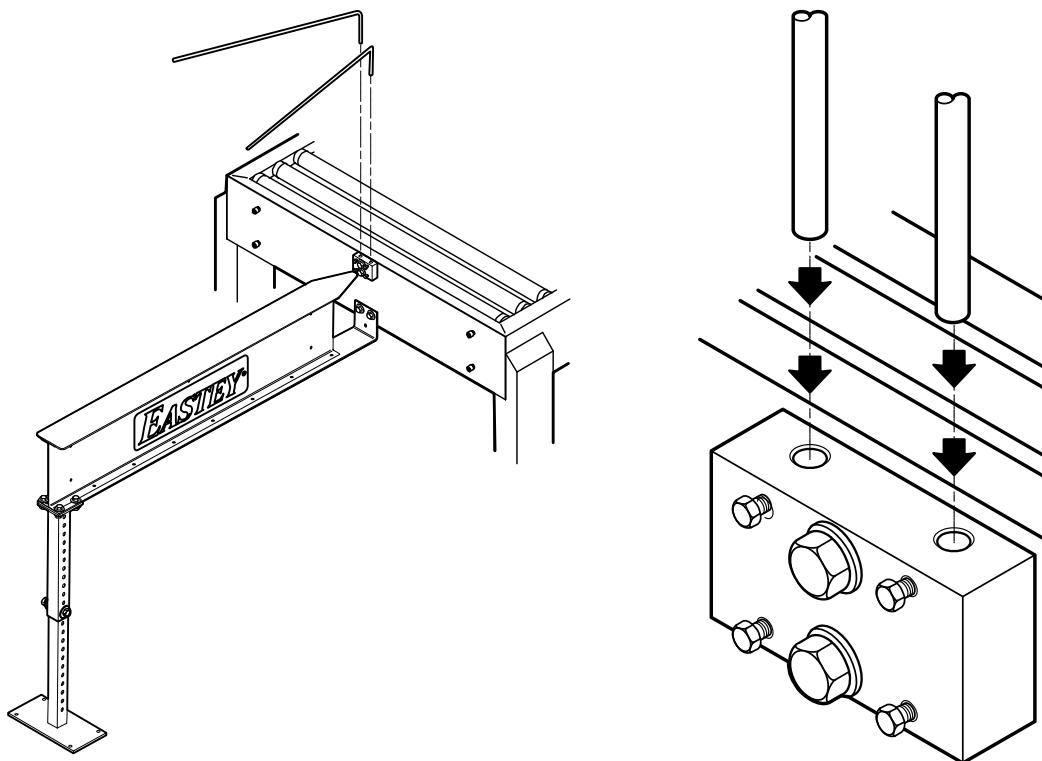
4. Fasten the folding bar block to the end of the case taper frame, centered near the top of the frame, as shown, using 5/16-18 × 2-inch cap screws, flat washers, lock washers, and hex nuts.



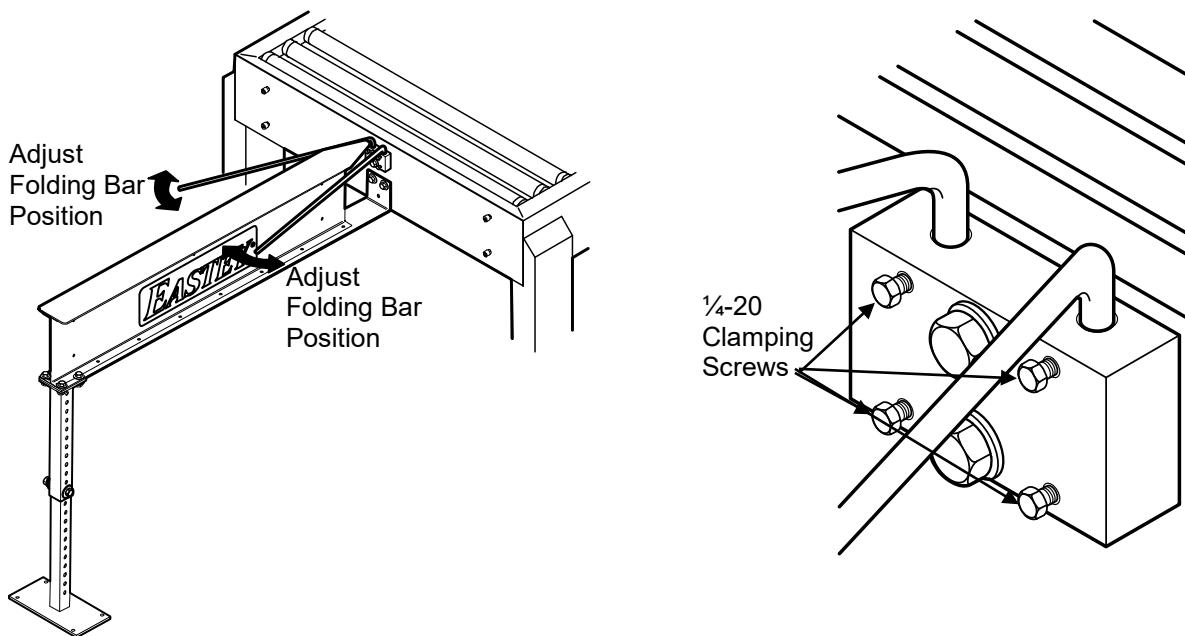
5. Fasten the anvil base with attached assembled support leg to the end of the case taper frame, centered and just below the folding bar block, using two 5/16-18 × 2 hex head cap screws, flat washers, lock washers, and hex nuts.



6. Insert the folding bars down into the through-holes from the top of the folding bar block.



7. Adjust the folding bars as required for the box flap configuration and the size of boxes to be sealed. Try several boxes to verify the bars are positioned correctly, and then tighten the four  $\frac{1}{4}$ -20  $\times$  5/8 hex screws to secure the folding bars in the correct position.



## **Next Steps**

Follow instructions in the Operation section for instructions to load the tape cartridges in the upper and lower tape heads.

If tape heads have not been loaded with tape, load the upper and lower tape heads with tape. (One roll each; follow instructions provided in the Tape Cartridge User Guide.)

Refer to the Adjustments section for instructions to make necessary height and width adjustments that must be made for operation of the box taper.

Refer to the Operation section for instructions to power up, operate, and shut down the machine.

# Operation

## Loading the Tape Cartridges

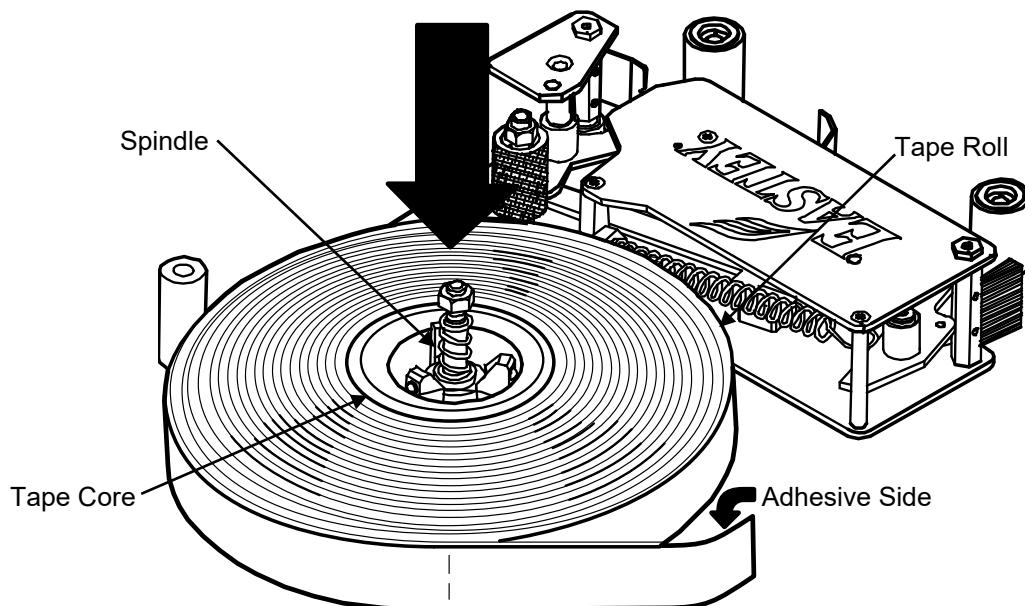
Turn the main power switch to "Off" and disconnect the power.

**CAUTION!** To avoid personal injury, remove the tape cartridge before loading tape.

**When handling the tape cartridge be careful to avoid contact with the tape cutting blade.**

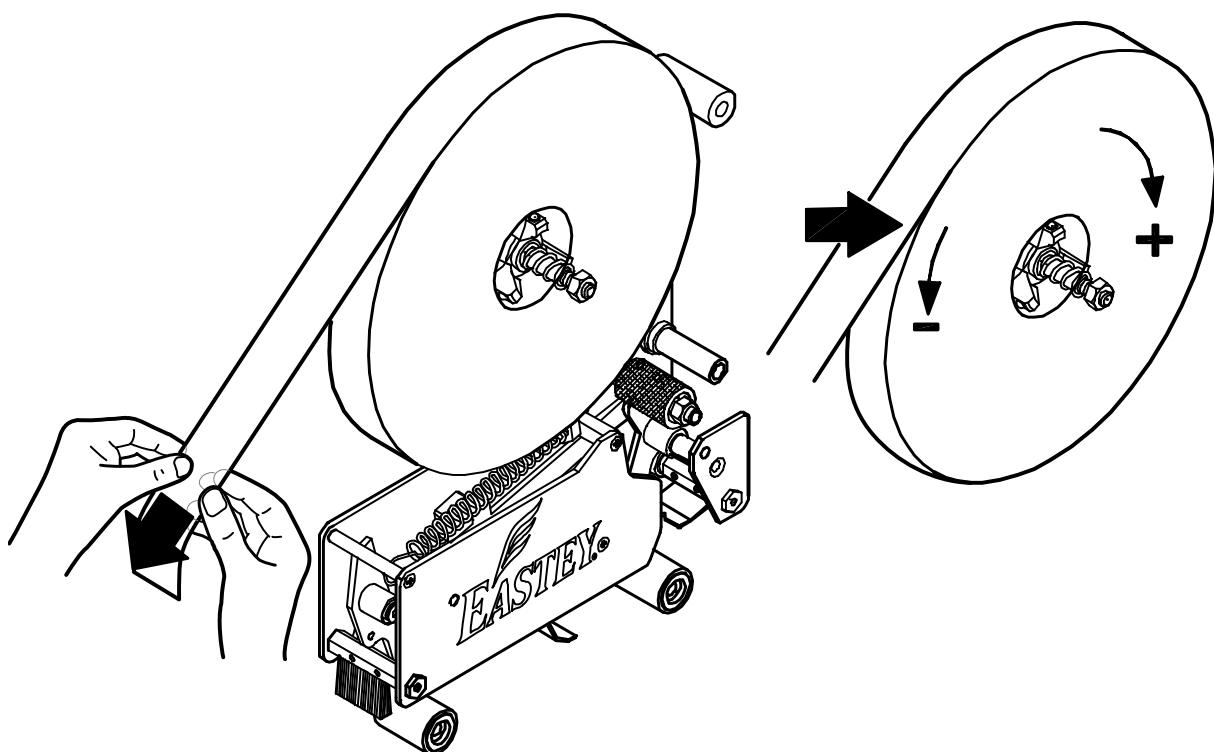
After the taping cartridge has been removed push the tape roll onto the tape core assembly.

**NOTE:** Make sure the tape roll is pushed all the way on the spindle assembly.



## Check Tension

Check the tape for correct tension.



Tighten or loosen the tape core holder to adjust tension.

## Thread Tape

Carefully thread the new tape through the rollers in the tape head as shown in the applicable diagram in the Tape Head User Guide provided with the tape head.

For convenience, diagrams for threading tape in the Eastey-EX Tape Head and EZ-EX Tape Head are provided on the following page. Follow the diagram that applies for your tape head, depending on the tape head model and position on the taper.

### VIDEO: Threading the Tape Cartridge — Eastey EX Tape Cartridge

To see a video to guide you through threading tape in the tape cartridge, click this link: <https://www.youtube.com/watch?v=TJRVNniJIXQ> or scan the QR code at right using the camera app on your mobile device.

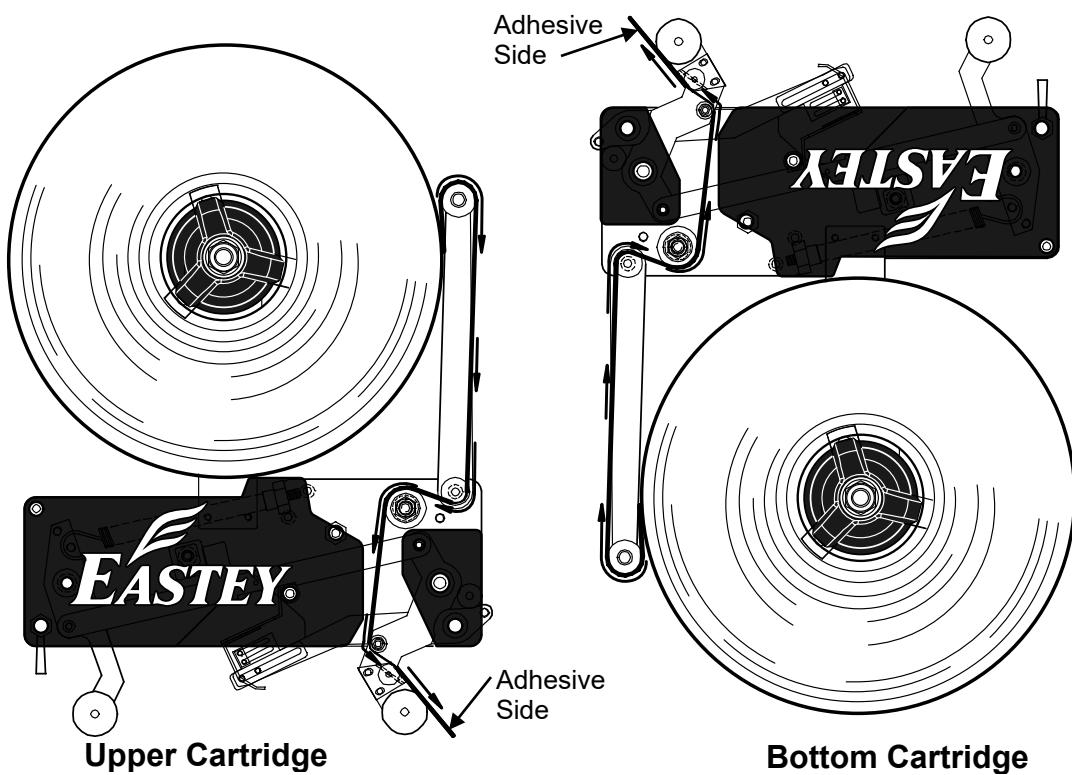


### VIDEO: Threading the Tape Cartridge — Eastey EZ-EX Cartridge

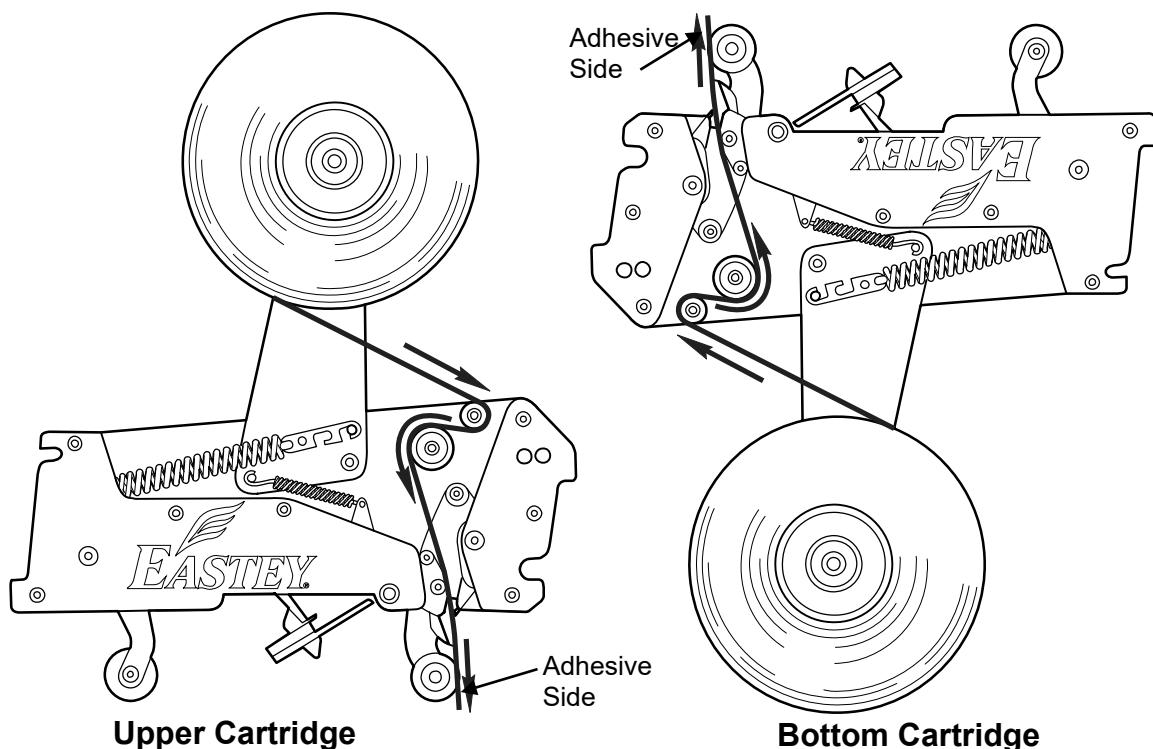
To see a video to guide you through threading tape in the tape cartridge, click this link: <https://www.youtube.com/watch?v=E5C8fH48IfY> or scan the QR code at right using the camera app on your mobile device.



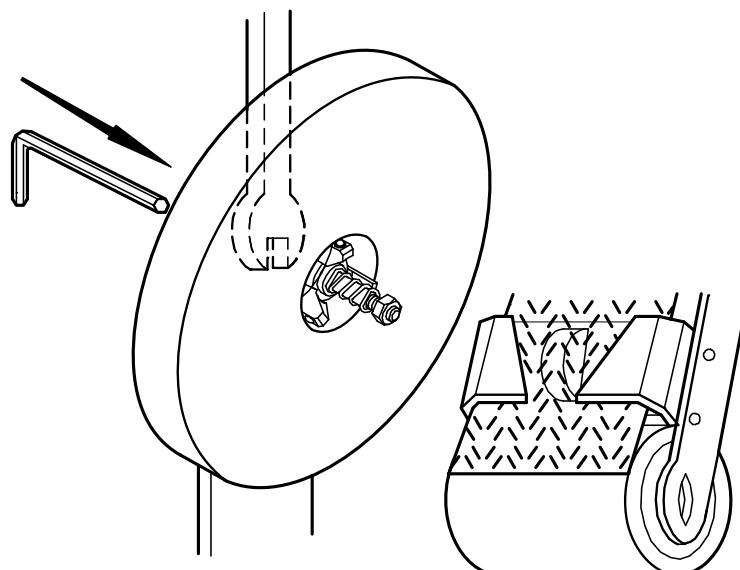
### Eastey-EX Tape Head



### EZ-EX Tape Head



## Center Tape — Eastey-EX Tape Head only



Make sure the tape is centered on all the rollers. There are several rollers in the tape cartridge where the tape alignment should be checked to verify the tape stays on center as it is being dispensed.

Be sure the tape is passed through the tape holder support bracket as it passes over the front wiper roller.

Return the tape cartridge to the operation position once the tape roll is loaded and tape has been threaded according to the applicable tape threading diagram.

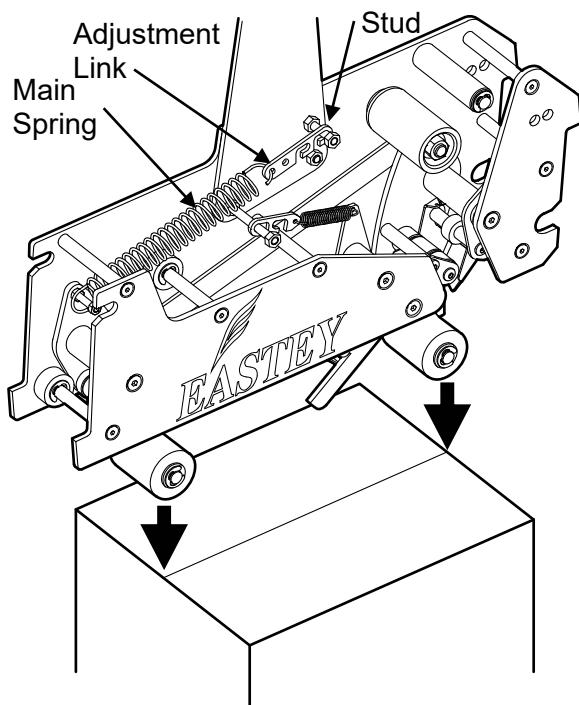
## Main Spring Adjustment

When setting tension for the rollers, consider the amount of pressure on the box flaps required to make the seal. Cartons completely filled to the top with product may require more pressure on top and bottom seams when applying tape than partially filled cartons, where excessive pressure could possibly crush the carton.

For sealing light weight boxes, decrease the main spring tension. For heavier boxes, increase the main spring tension.

Both Eastey-EX and EZ-EX tapeheads have a main spring, which may require tension adjustment for the particular application for which you will be using the case taper.

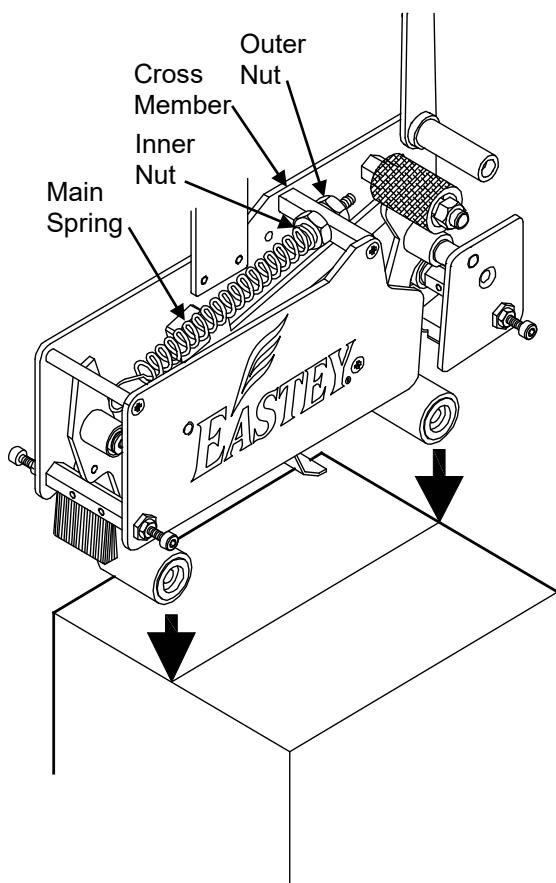
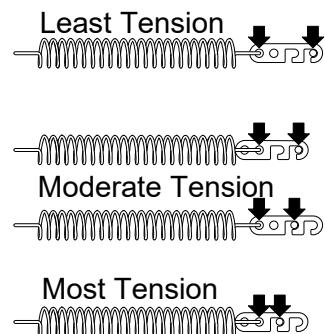
For quick reference and convenience, basic information for adjusting main spring tension for the Eastey-EX Tape Head and EZ-EX Tape Head is provided on the following page. For more information about setting the tape head tension, refer to the User Guide provided with the tape heads that are being used in the case taper.



### Eastey EZ-EX Main Spring Adjustment

For the Eastey-EZ tape head, there is an adjustment link at the end of the main spring that links the spring to the stud post.

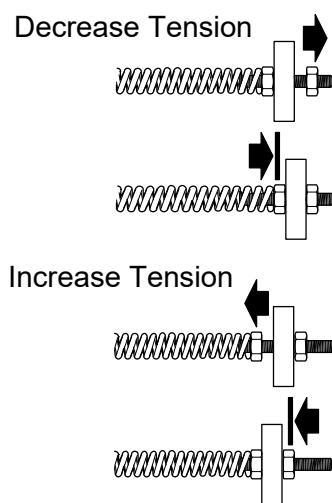
Spring tension is determined by which part of the adjustment link is hooked onto the stud post on the connecting arm, and by which hole in the adjustment link the main spring is hooked onto.



### Eastey-EX Main Spring Adjustment

For the EZ-EX tape head, there are two adjustment nuts, one to each side of the top crossmember where the threaded rod of the adjustable end of the main spring passes through the crossmember.

The adjustment nuts are used together to set the main spring to the required tension and to secure the spring at the set tension.



## Power

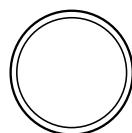
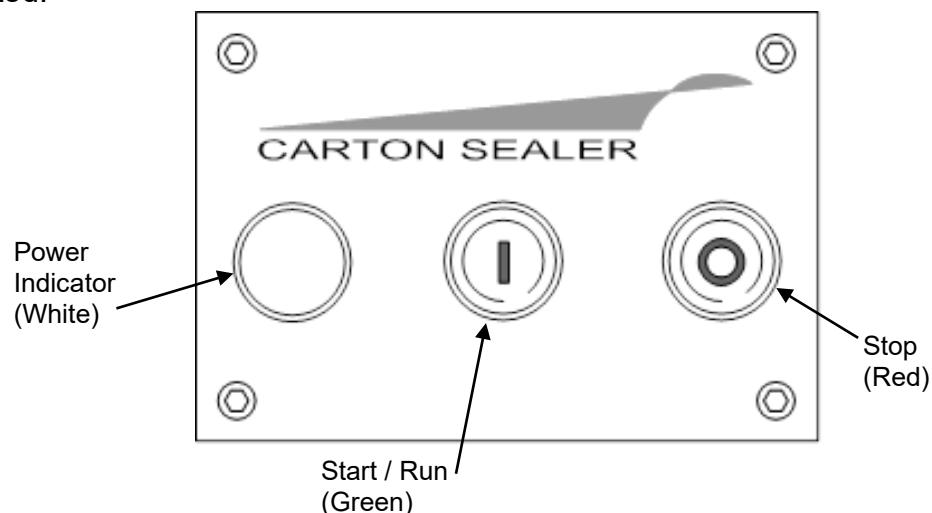
Plug the power supply cord into a properly wired and grounded outlet.

Press the start button.

**CAUTION! When the power is turned on be aware of moving parts and belts**

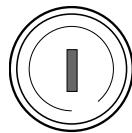
## Control Panel

When the main power switch is in the "ON" position the power lamp should be illuminated.



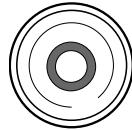
### Power Indicator Lamp (White)

- On when carton sealer is in operation.
- Off when carton sealer is not in operation.



### Start / Run Button (Green)

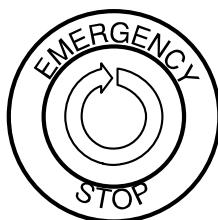
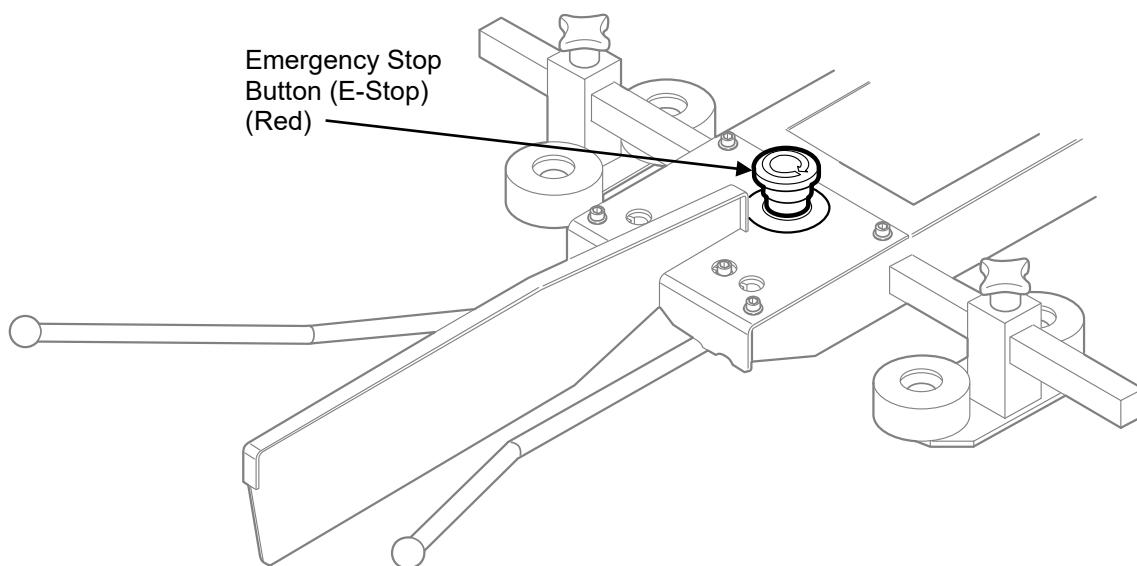
Press the Start button to start motors and belts.



### Stop Button (Red)

Press the Stop button to stop motors and belts.

## Emergency Stop



### Emergency Stop Button (Red with Yellow label)

- Press the red Emergency Stop button for emergency stop.
- To reset the Emergency Stop button once the emergency condition has been cleared and it is safe to operate the machine again, press the Emergency Stop button in while turning it approximately a quarter-turn in the direction of the arrow.

## VIDEO: Easy Packer Operation

To see a video demonstrating operation of the Eastey Easy Packer Industrial Case Taping System, click this link: <https://youtu.be/cyyCV6LuIk0> or scan the QR code at right using the camera app on your mobile device and follow the link.



# Adjustments



**WARNING:** Unless otherwise specifically stated, before performing any adjustments, maintenance, or repairs, power off the system, disable the power source, and do the same for all connected equipment consistent with logout/tagout best practices.

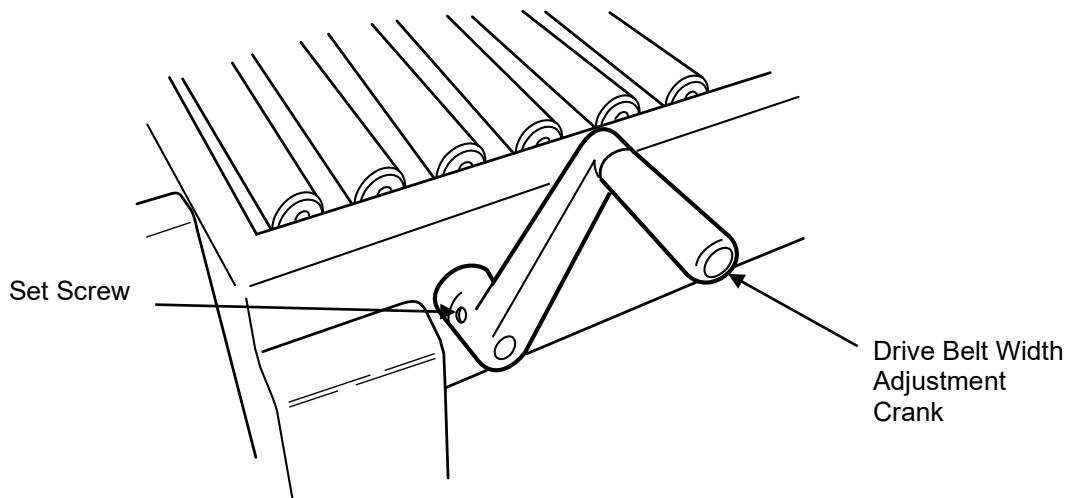
See <https://www.osha.gov/control-hazardous-energy> or scan the QR code at right using the camera app on your mobile device.



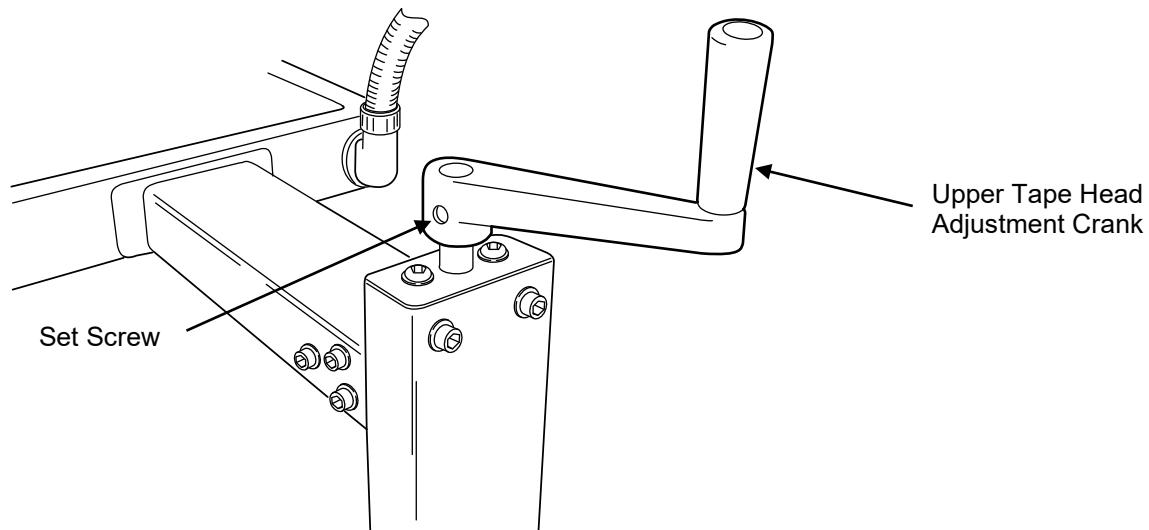
## Height and Width Adjustments

With the power off, place an appropriate size carton in the Case Sealer.

Use the drive belt width adjustment crank to set the drive belt width to the correct box width.



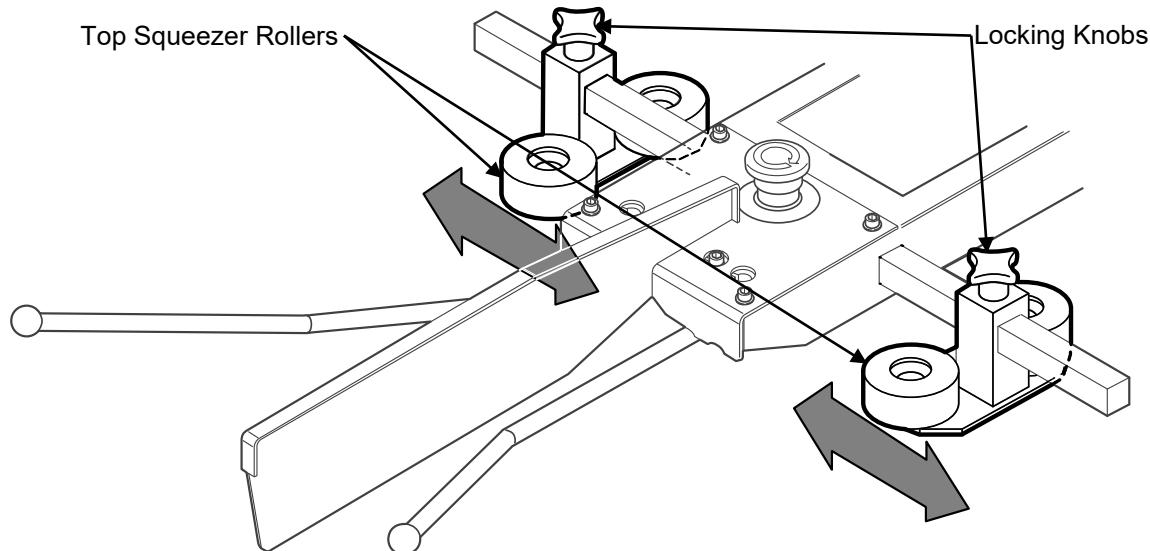
Use the height adjustment crank to set the upper tape head to the correct box height.



The height and width cranks can be mounted on either side of the machine by loosening the set screw and removing the crank. Mount the crank on the opposite side and re-tighten the set screw.

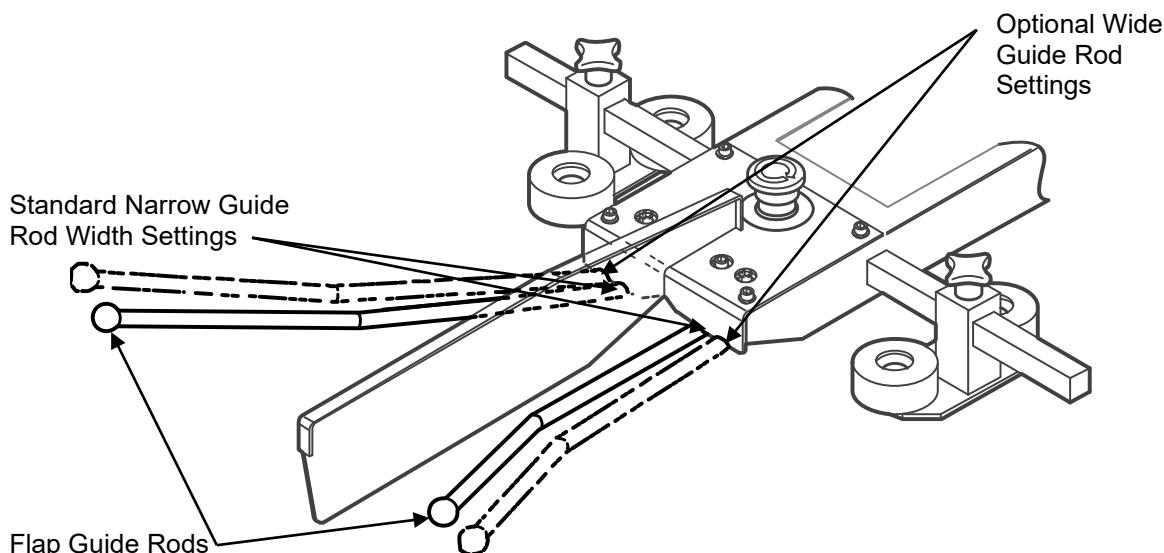
### Top Squeezer Roller Width Adjustment

Loosen the locking knobs on the top squeezer alignment rollers to set the top width to the correct box width and re-tighten the locking knobs. This will ensure the box stays centered.



## Upper Flap Guide Rod Position or Width Adjustment

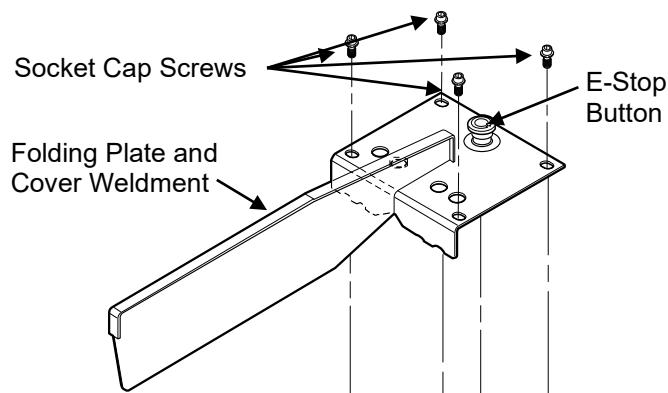
In normal operation the upper flap guide rods must be fastened rigidly in place for proper operation. The guide rods can be repositioned and then re-secured, however, to provide better positioning if required for carton-sealing applications, depending on the carton size and closing flap configuration.



## To Adjust Position of Flap Guide Rods Or Change Width Setting

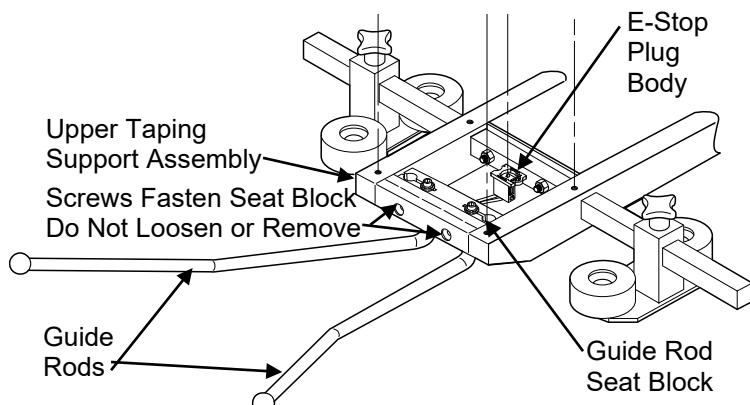
**NOTE:** For ease of disassembly remove the upper tape head temporarily so the folding plate and cover weldment can be placed in the tape head area. This way it will not be necessary to disconnect the electrical connections for the E-Stop or button from the body plug while adjusting or moving the guide rods. When removing cover or guide rods, retain all parts and hardware for reassembly.

1. Support the center flap folding plate and remove the four socket cap screws that secure the folding plate and cover weldment to the upper taping support assembly.



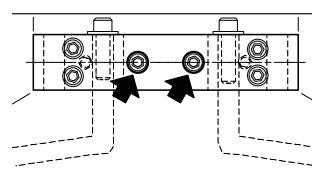
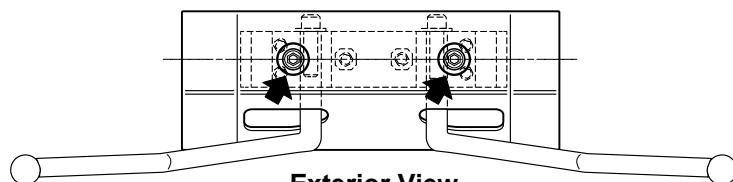
2. Temporally place the folding plate and cover weldment out of the way in the space where the upper tape head normally sits. This way it is not necessary to disconnect the E-Stop.

Guide rods are secured to the Seat Block, which is fastened to the upper taping support assembly.



**NOTE:** The seat block is fastened to the upper taping support assembly by four flange-head socket cap screws:

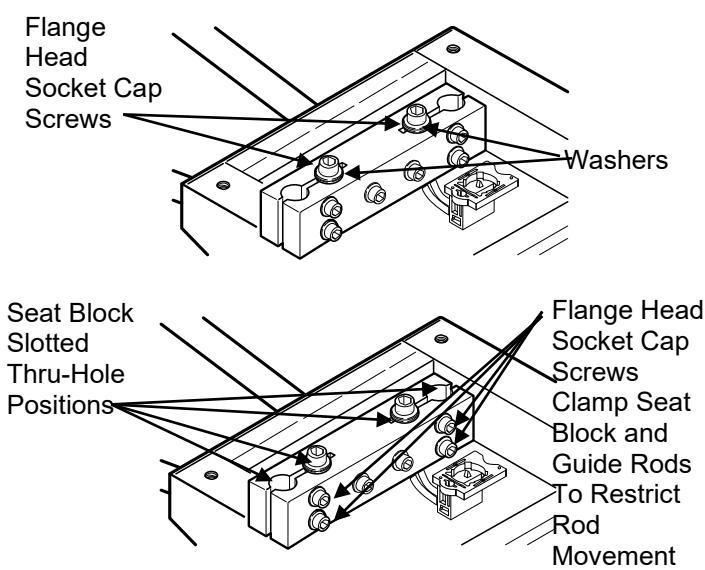
- Two cap screws that are visible through access holes in the front of the taping support assembly.
- Two cap screws that are aligned horizontally at the back of the block (closest to the center of the block) pass through the block, fastening it to the taping support assembly.



**It is not necessary to loosen or remove the cap screws in these locations to move or reposition the guide rods.**

Each guide rod enters the bottom of the seat block and passes up through it vertically (through either of a pair of thru-hole positions) and is fastened at the top of the seat block with a flange-head socket cap screw and washer.

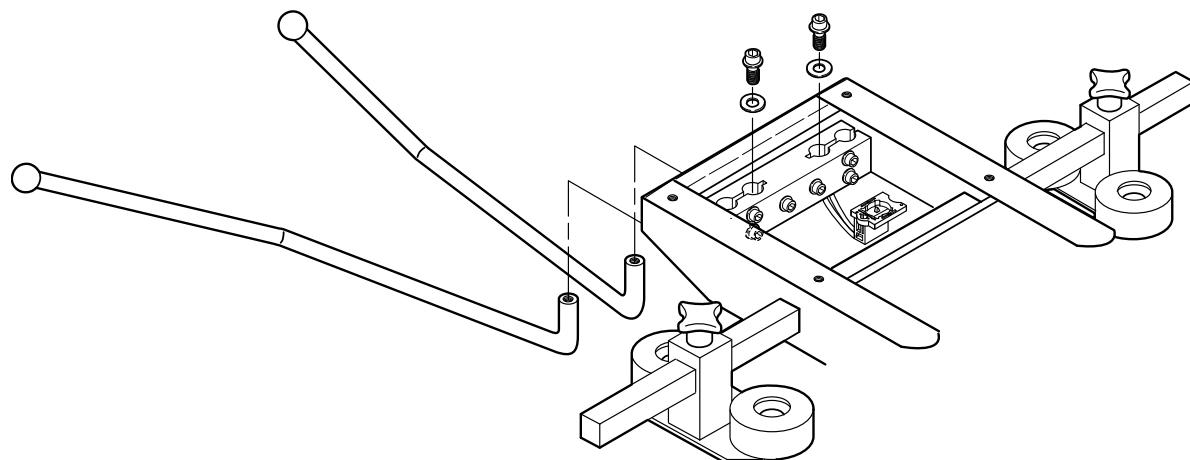
The seat block is slotted at each end, through the thru-hole positions, to allow the seat block to clamp each guide rod to secure it from pivoting as



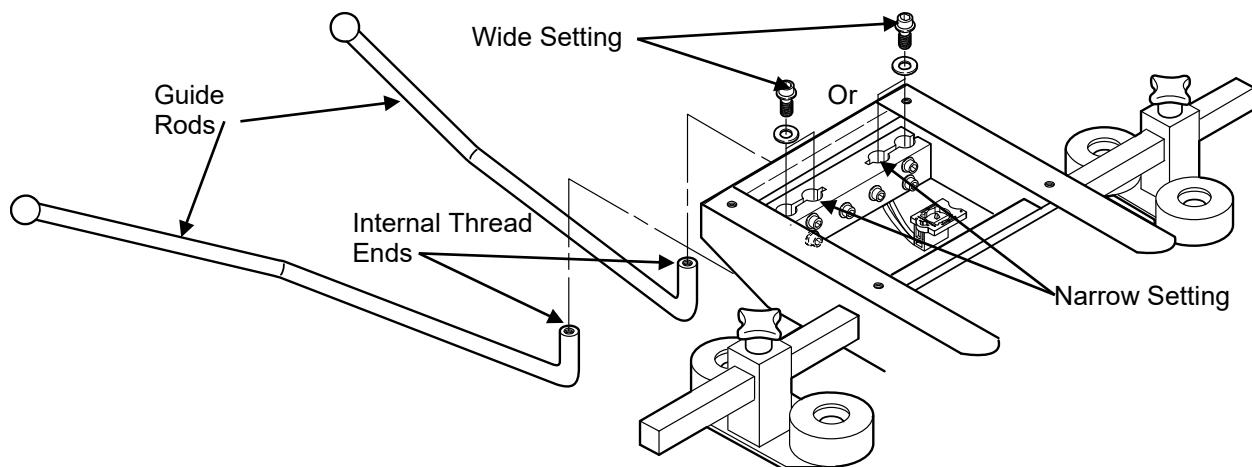
two flange-head socket cap screws (arranged vertically near each end) are tightened.

3. **To simply reposition or redirect the guide rods**, but not change the width settings, it is not necessary to remove the flange head socket cap screws and washers at the top of the block; just loosen the two flange head screws at the back of the block to relieve compression on the rod, then reposition the rod to the desired position and then retighten the clamping cap screws.

**To change the guide rods width setting**, remove the flange head socket cap screws and washers at the top of the block. Hold each rod as you loosen the two flange head cap screws at the back of the seat block that hold the guide rod in compression. As the screws are unscrewed, the detached guide rod will drop out through the bottom of the thru-hole.

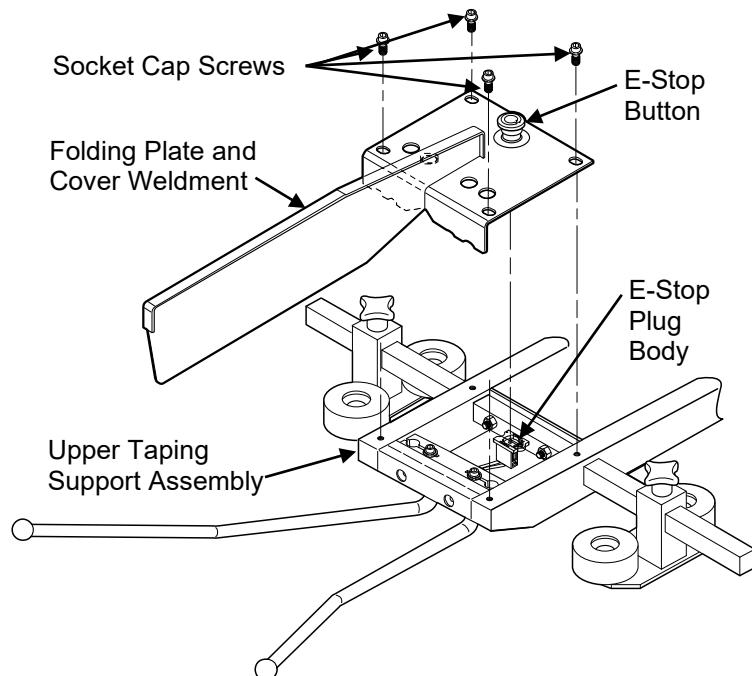


Place the guide rods through the thru-holes that provide the best width setting for the carton application. Insert the internal-threaded end of the guide rod up through the bottom of the block. Support the guide rod so the internal end is level with the top of the seat block and swiveled to the desired position, and tighten the cap screws just tight enough to clamp the guide rod and prevent movement, but take caution to not over-torque the cap screws or strip the threads in the seat block.



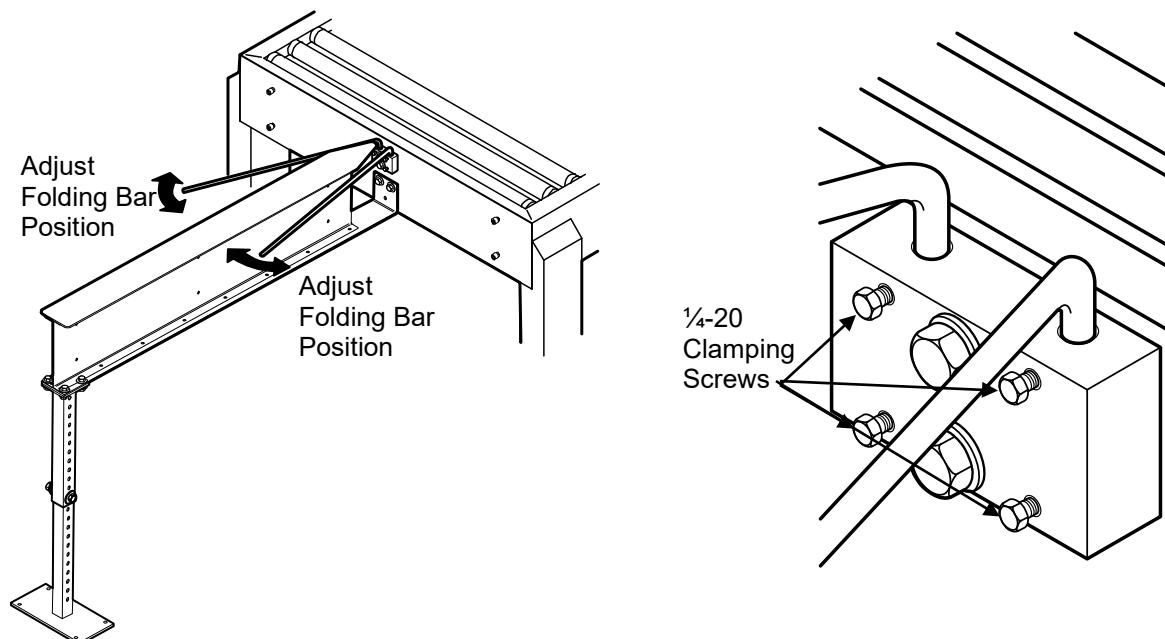
Insert the cap screws with washers, removed earlier, into the threaded holes in the tops of the guide rod ends and re-fasten.

4. Support the center flap folding plate and place the cover in the correct orientation on the upper taping support assembly. Check the E-Stop and reconnect the button assembly to the plug assembly if they became separated. Align and reattach the cover and center flap weldment to the upper taping support assembly using the same cap screws removed earlier, in the first step. Return the upper tape head into operational position.



### Lower Flap Folding Bar Position Adjustment

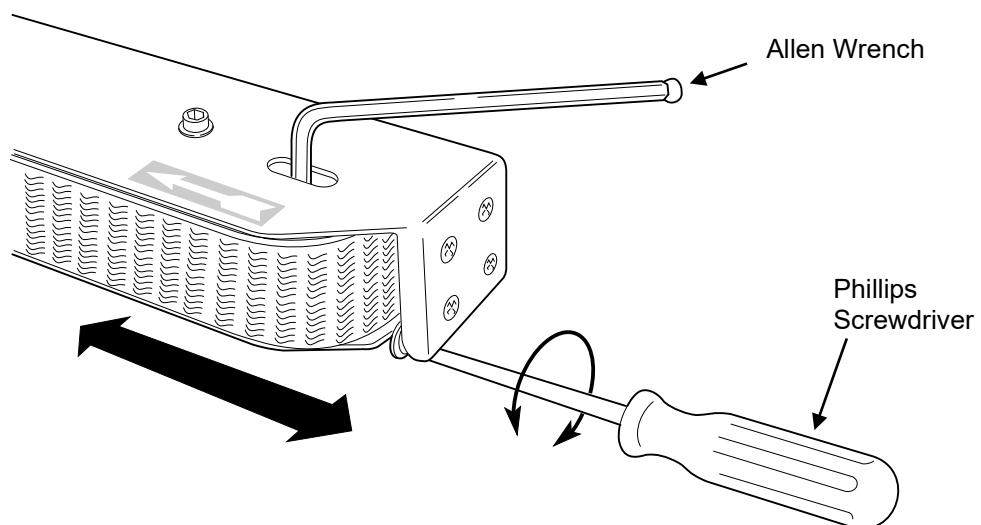
In normal operation the lower flap folding bars must be fastened rigidly in place for proper operation. The folding bars can be repositioned and then re-secured, however, to provide better positioning if required for carton-sealing applications, depending on the carton size and closing flap configuration.



To adjust the folding bars, loosen the four  $\frac{1}{4}$ -20 clamping screws (two per folding bar) to allow repositioning of the folding bars. Adjust the folding bars as required for the box flap configuration and the size of boxes to be sealed. Try several boxes to verify the folding bars are positioned correctly, and then tighten the four  $\frac{1}{4}$ -20 clamping cap screws to secure the folding bars in the correct position.

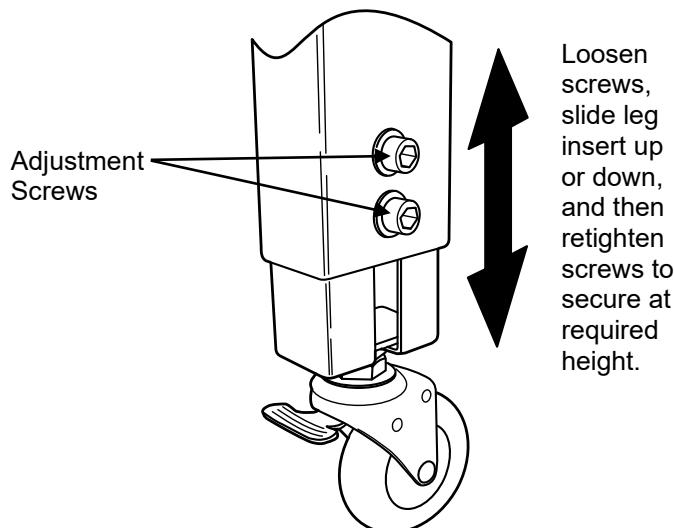
### **Belt Adjustment**

You do not have to remove the drive belt cover to adjust the drive belt. To adjust the belt, use an Allen wrench and loosen the belt nut. Adjust the belt to a suitable tension by turning the adjustment screw with a Philips screwdriver. Re-tighten the belt nut.



## Machine Body Height Adjustment

To adjust the leg height, loosen the screws on each leg and slide the insert up or down. When the leg is at the desired height, retighten the adjustment screws to secure the leg height.



**CAUTION!** Ensure the case taper is secure and will not shift while adjusting leg height.

## Tape Head Adjustment — Refer to Tape Head User Guide.

Refer to instructions in the Tape Head User Guide that is provided with the tape head for instructions regarding adjustment information for the tape head.

### VIDEO: Knife Blade Replacement

To see a video to guide you through replacing the knife blade of the tape cartridge, click this link: [https://youtu.be/b1PfCV-fts?list=PLw2fFM1Tj1XVwEOXq\\_cpbKlbzF6trEd0W&t=260](https://youtu.be/b1PfCV-fts?list=PLw2fFM1Tj1XVwEOXq_cpbKlbzF6trEd0W&t=260) or scan the QR code at right using the camera app on your mobile device.



# Maintenance

The Easy Packer Industrial Case Taping System will provide many hours of maintenance free operation. There are a few items that may require attention from time to time.



**WARNING:** Unless otherwise specifically stated, before performing any adjustments, maintenance, or repairs, power off the system, disable the power source, and do the same for all connected equipment consistent with logout/tagout best practices. See <https://www.osha.gov/control-hazardous-energy> or scan the QR code at right using the camera app on your mobile device.



## Rollers

Make sure rollers stay clean and grease free. If you should have to clean the rollers simply wipe them down with a clean lint free cloth. If a more thorough cleaning is necessary, wipe the rollers down with a mild detergent and water and let dry. **Never use harsh or abrasive cleaners or chemical agents when cleaning the rollers.**

## Cutting Knives

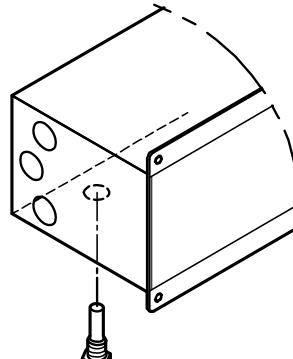
Occasionally inspect the cutting knives to ensure they are clean and free of adhesive residue. Make sure the cutting knife is sharp by inspecting cuts in the tape. Cuts should be straight and neat. If the quality of cuts is eroding, the knife blade is dull and should be replaced.

## Changing Knife Blades — Refer to Tape Head User Guide

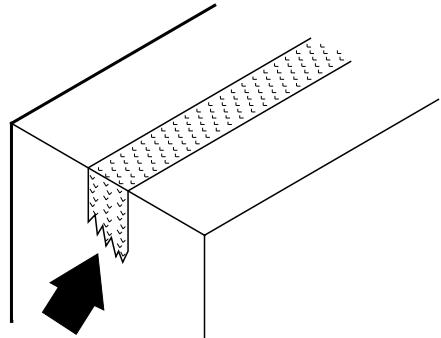
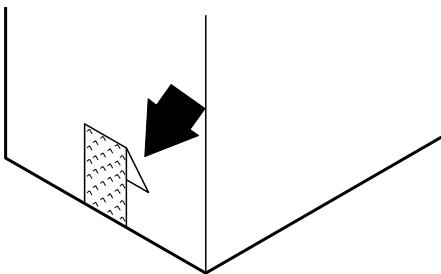
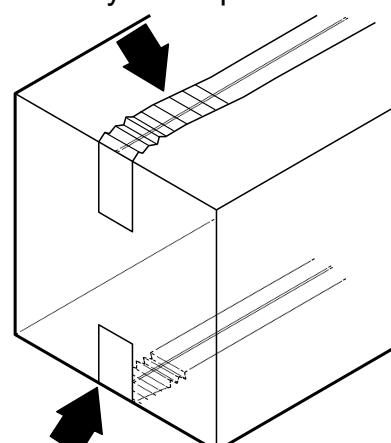
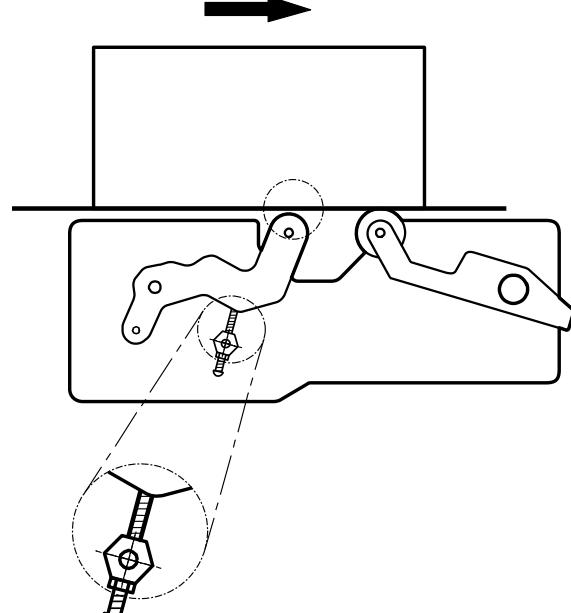
Turn off and unplug the taper. It is not necessary to remove either tape head to change the blade. Refer to the Tape Head User Guide provided with the tape head for instructions for changing the knife blades.

**CAUTION!** **Always be aware of the cutting edges while replacing the knife blades. Handle the knife blades carefully.**

# Troubleshooting

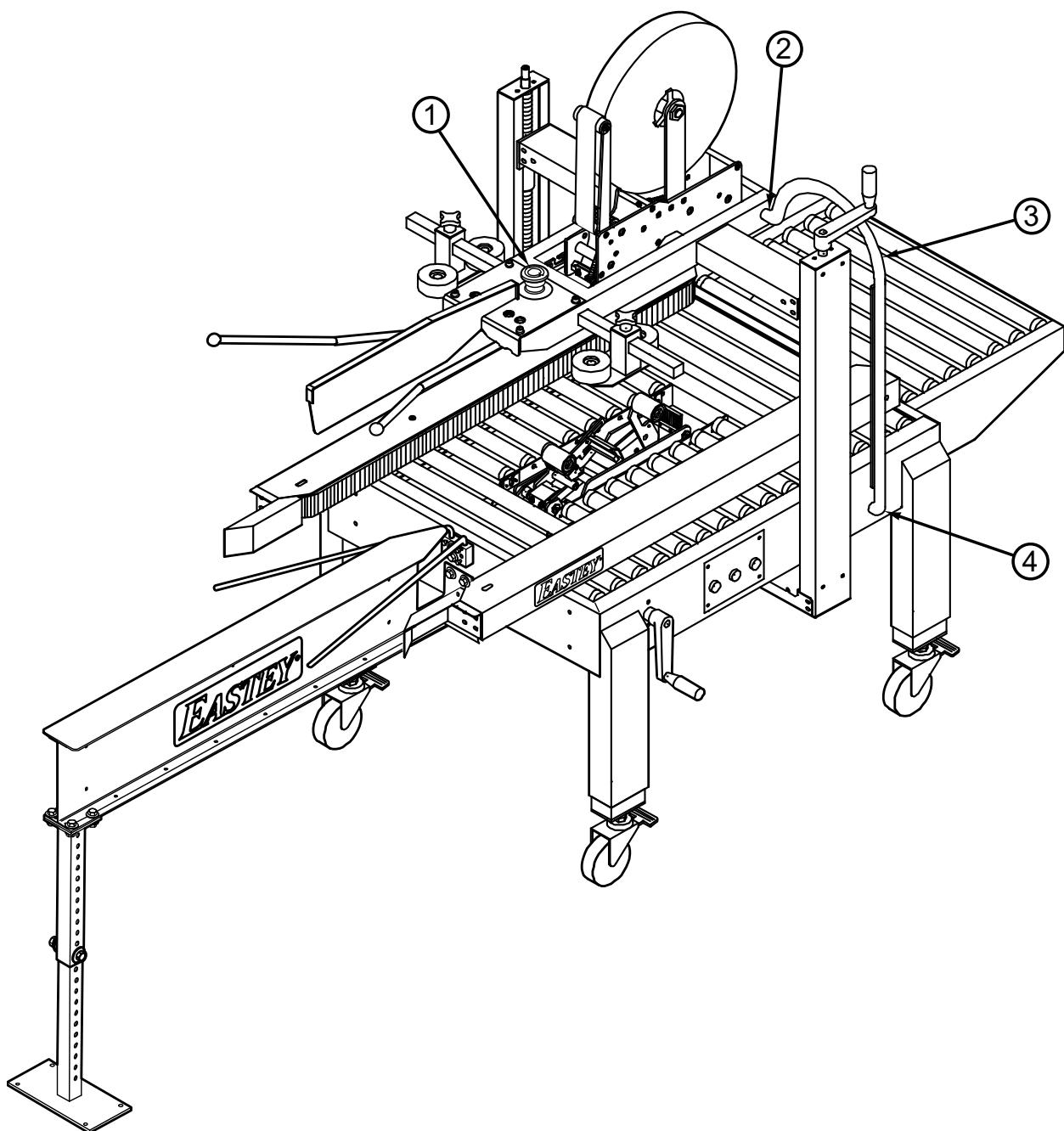
Problem / Possible Cause	Solution
<b>Taper will not start</b> <ul style="list-style-type: none"> <li>■ Machine is not connected to power.</li> <li>■ An emergency condition exists and the E-Stop has been activated.</li> <li>■ Start button has not been pressed.</li> <li>■ Fuse has blown.</li> </ul>	<ul style="list-style-type: none"> <li>▶ Check power input to be sure the machine has power.</li> <li>▶ Clear the Emergency condition and reset the E-Stop button.</li> <li>▶ Press the Start button to release overload.</li> <li>▶ Replace the Fuse. (Access fuse by removing plug from underside of control box as shown at right.)</li> </ul> 
<b>Machine is not operating</b> <ul style="list-style-type: none"> <li>■ Machine has inadequate electrical power or power is not connected.</li> </ul>	<ul style="list-style-type: none"> <li>▶ Verify system power meets specification requirements and verify power connection.</li> </ul>

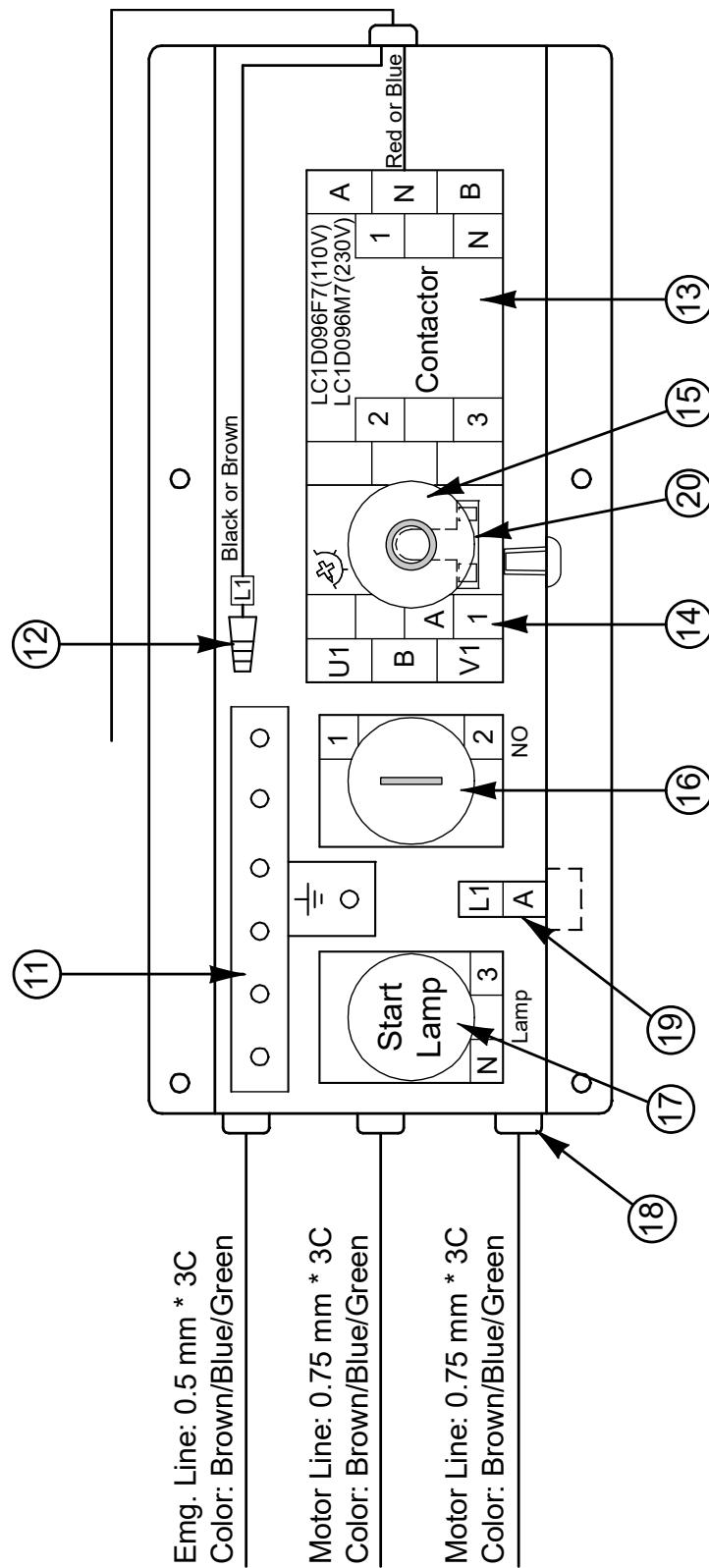
Problem / Possible Cause	Solution
<b>Stuck carton</b> <ul style="list-style-type: none"> <li>■ Drive belt or squeezer width set too narrow.</li> <li>■ Drive belt height set too low.</li> </ul>	<ul style="list-style-type: none"> <li>▶ Check drive belt width and squeezer width adjustments.</li> <li>▶ Check for proper height adjustment.</li> </ul>
<b>Uneven or poor tape cuts</b> <ul style="list-style-type: none"> <li>■ Knife arm spring tension is out of adjustment.</li> <li>■ Wiper roller spring tension is out of adjustment.</li> <li>■ Dull knife blade(s)</li> </ul>	<ul style="list-style-type: none"> <li>▶ Adjust knife arm spring tension.</li> <li>▶ Adjust wiper roller spring tension.</li> <li>▶ Replace cutting knife blades.</li> </ul>
<b>Uneven Tape Leg on Front</b>	<ul style="list-style-type: none"> <li>▶ Tape tension is too low. Tighten the one-way clutch roller and/or the tape core.</li> <li>▶ Adjust the one-way clutch roller in the slot so it is slightly beyond the front wiper roller.</li> <li>▶ Adjust the tape leg length. See Tape Leg Adjustment section.</li> </ul>

Problem	Solution
<b>Uneven or Torn Tape</b> 	<ul style="list-style-type: none"> <li>► Blade is dull. Replace blade.</li> <li>► Tape tension is incorrect. Increase tension.</li> <li>► Clean and adjust blade.</li> <li>► Blade mounted incorrectly or backwards.</li> <li>► Knife arm spring is worn. Replace knife arm spring.</li> <li>► Adjust cartridge height.</li> </ul>
<b>Tape Folding</b> 	<ul style="list-style-type: none"> <li>► Check that all rollers turn freely.</li> <li>► Check to be sure tape is threaded properly on front roller (page 24).</li> <li>► Check wipe down brush.</li> </ul>
<b>Tape Curling or Bunching Up</b> — Eastey EX Tape Head Only 	<p><b>Eastey-EX Tape Head Only</b></p> <ul style="list-style-type: none"> <li>► Adjust the tape cartridge height (approximately .06 inches from box)</li> </ul>  <ul style="list-style-type: none"> <li>► Check tape tension set by the spring tension at the tape core.</li> </ul>

# Parts

## Electrical

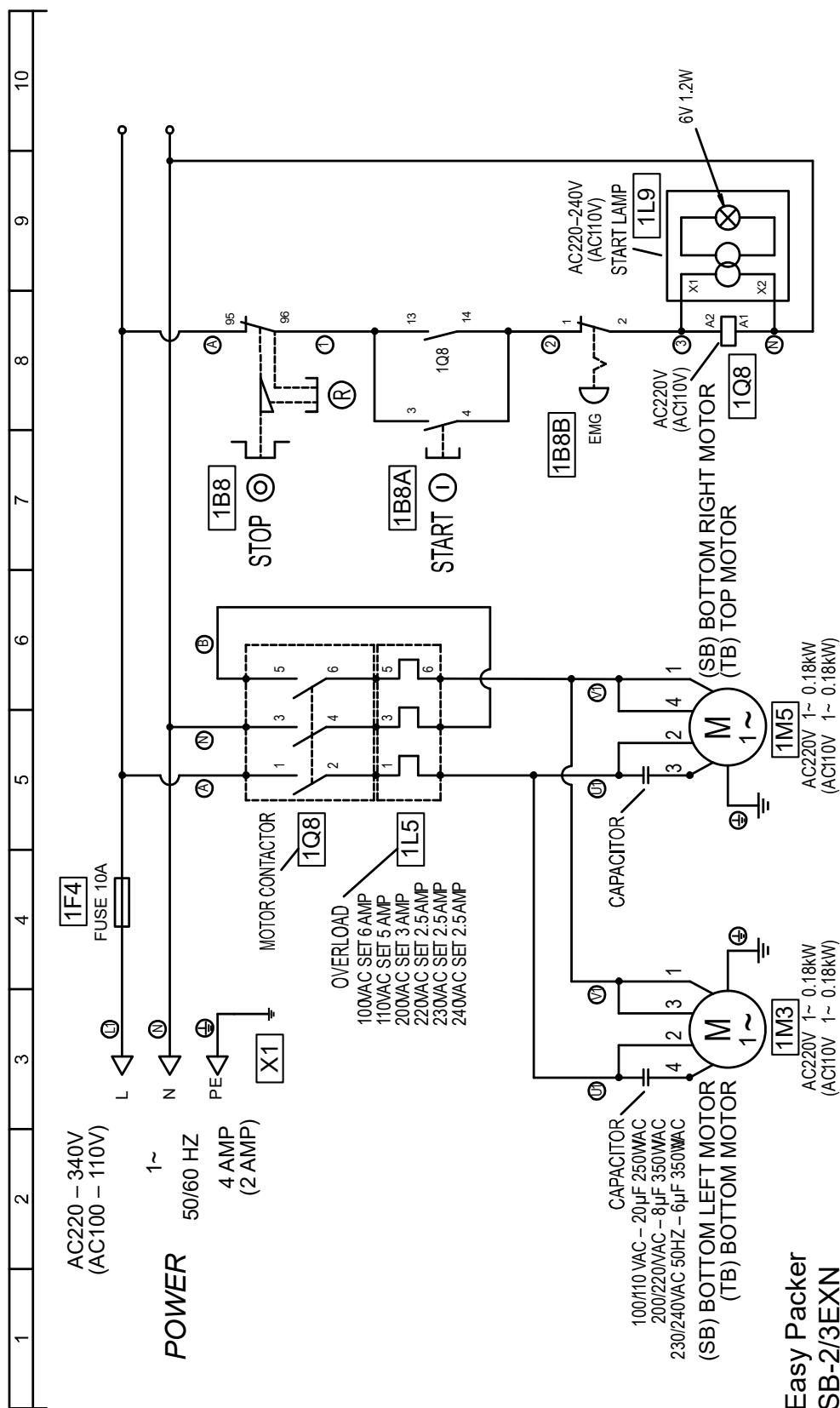




## Electrical Panel Layout

# Eastey Easy Packer And Model SB-2/3EXN

Electrical Panel Layout  
2012/11/30 Page 1 of 1

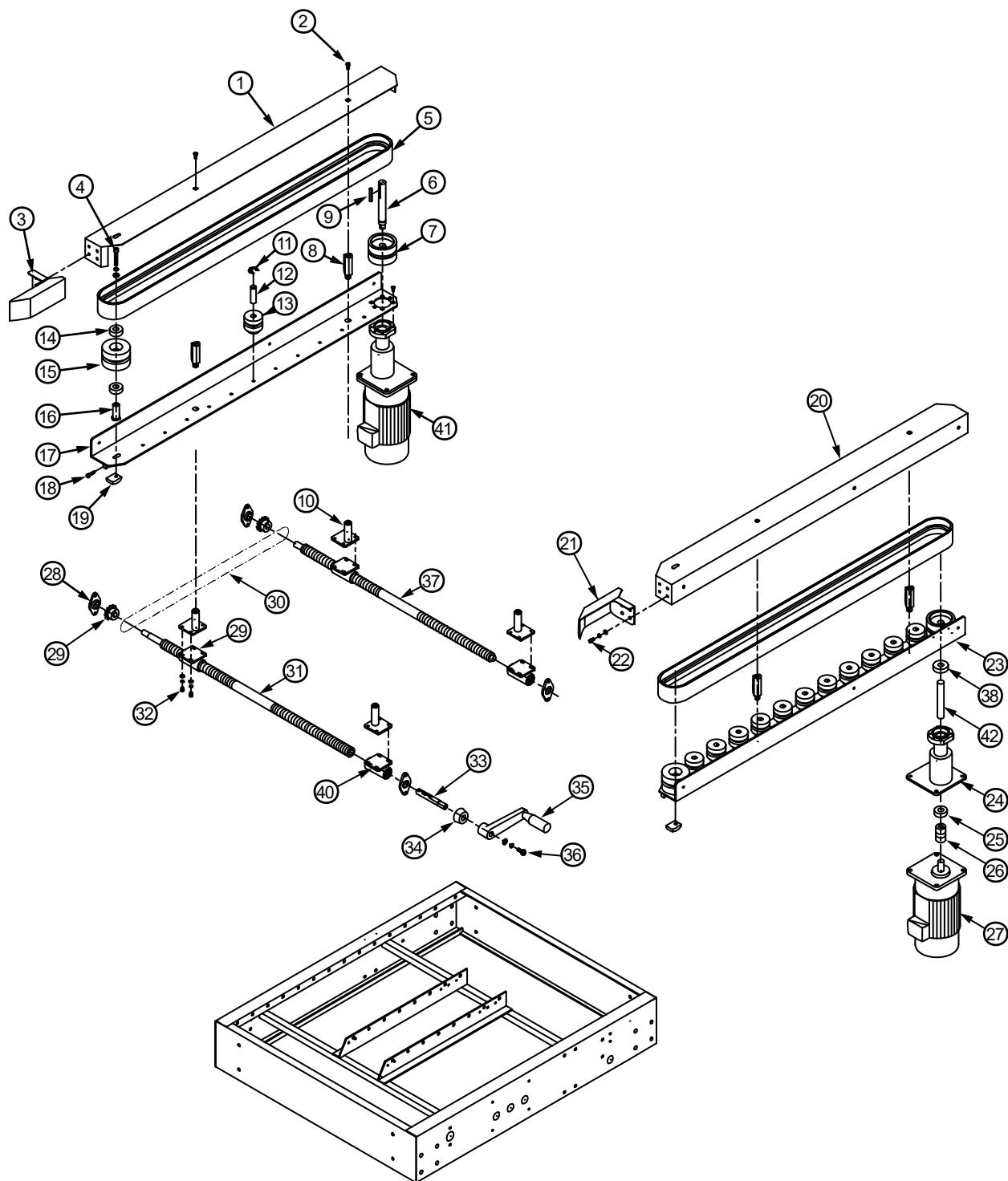


PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	5001937	EMG. SWITCH	1
	5001938	BUTTON SEAT CONTACTOR NCx1	1
2	5001755	1/2" CONNECTOR	1
3	5001830	1/2" PROTECT TUBE	1
4	5001756	1/2" 90° CONNECTOR	1
11	5001915	TERMINAL BLOCKS TB6P	1
12	5004092	CONNECTOR	1
13	5001759 5001759-V1	CONTACTOR LC1-D09F7 110V CONTACTOR LC1-D09M7 220V	1 1
14	5001760 5001760-V1	OVERLOAD PROTECTOR LR3-D106(4-6A, 110V) OVERLOAD PROTECTOR LR3-D086(2.5-4A, 220V)	1 1
15	5001978	BUTTON	1
16	5001903	BUTTON CONTACTOR NOX1	1 1
17	5001761-V1 5001762	POWER LAMP 220V BLANKIG PLUG	1 1
	5001761 5001762	POWER LAMP 110V BLANKIG PLUG	1 1
18	5004093	FIXED SEAT	4
19	5001730 5001730-1	FUSE FUSE SEAT	1 1
20	5004094	ENCLOSURE	1

	5001713-C 5001713-C2	MOTOR CAPACITOR (For 100-110V) 16µF MOTOR CAPACITOR (For 100V-110V) 20µF	2 2
--	-------------------------	---	--------

## Side Belt Assembly



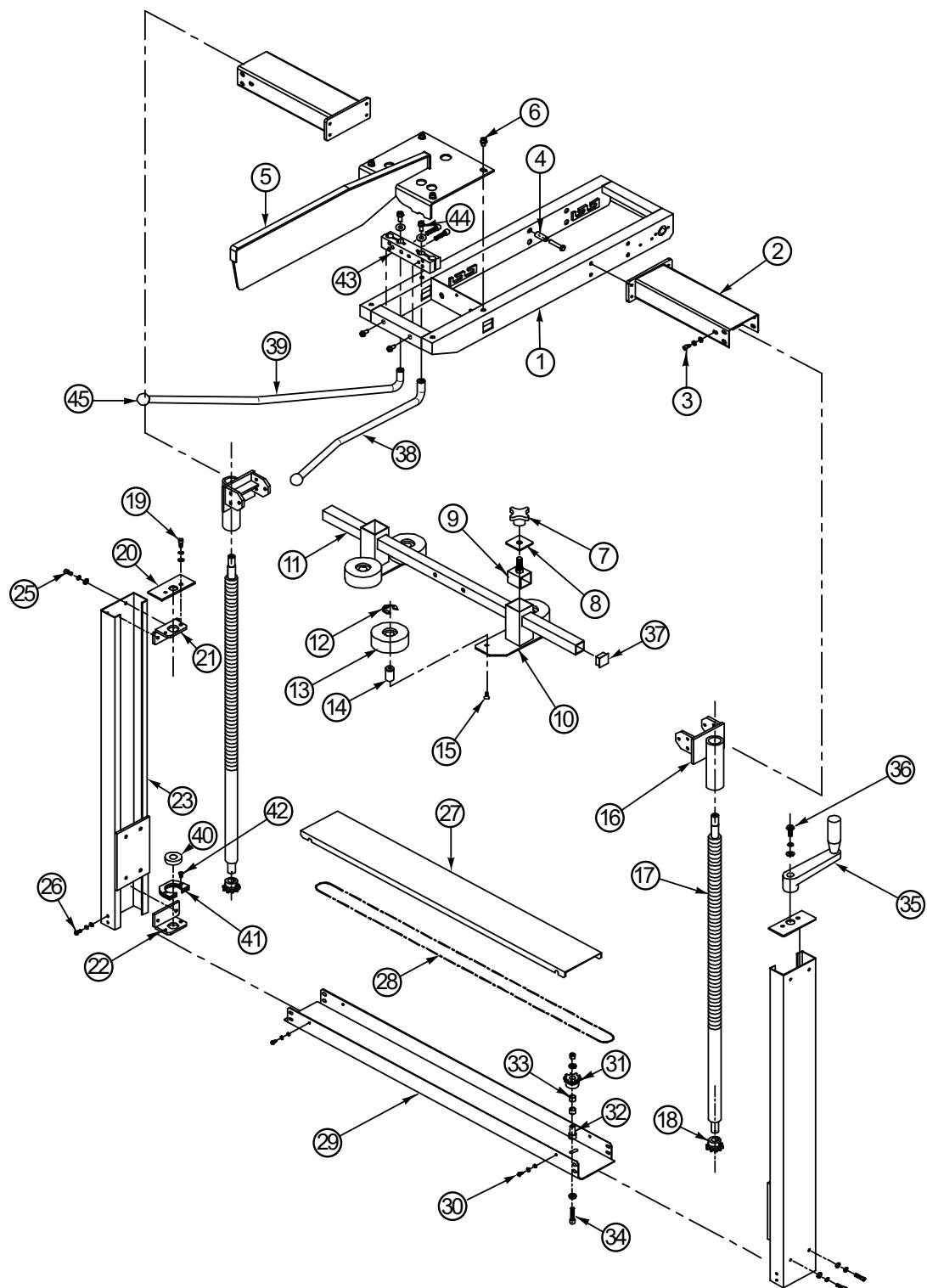
**PACKAGING PLUS**  
**317-841-1126 INFO@HOTMELTUNITS.COM**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>QUANTITY</b>
1	5004182	SIDE BELT COVER	1
2	5004096	SCREW M6×10L & S.W & W	4
3	5001752	GUIDE PLATE	1
4	5002196	SCREW M8×70L & W	2
5	5001033	BELT	1
6	5001711	MOTOR SHAFT	2
7	5001715	PULLEY DRIVER	2
8	5000965	SPEDIAL SCREW	4
9	5001859	KEY 5×5	2
10	5002197	SUPPORT SHAFT	4
11	5004097	RING STW-12	22
12	5001878	PULLEY SHAFT	22
13	5001877	PLASTIC PULLEY	22
14	5001700	BEARING 6003ZZ	4
15	5001703	PULLEY FOLLOWER	2
16	5001886	PULLEY SHAFT	2
17	5004183	SUPPORT COLUMN	1
18	5001879	SCREW M5×45L	2
19	5001880	ADJUSTMLNT BLOCK	2
20	5004100	SIDE BELT COVER	1
21	5001753	GUIDE PLATE	1
22	5002192	SCREW M6×12L & S.W & W	8
23	5004184	SUPPORT COLUMN	1
24	5001757	MOTOR SEAT	2
25	5001700	BEARING 6003ZZ	2
26	5001712	UNIVERSAL JOINT	2
27	5001713	MOTOR 110V/60HZ,T18:1	1
	5001956	MOTOR 110V/60HZ,T15:1	1
	5001713-V1-60	MOTOR 220V/60HZ,T18:1	1
	5001713-V1-50	MOTOR 220V/50HZ,T15:1	1
	5001713-V2-50	MOTOR 240V/50HZ,T15:1	1
	5001713-V3-50	MOTOR 380V/50HZ,T15:1	1
	5001713-V4-50	MOTOR 400V/50HZ,T15:	1

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
28	5001921	SHAFT SEAT	4
29	5001854	CHAIN SPOCKET	2
30	5001855	CHAIN	1
31	5002153	SPINDLE WIDTH ADJUSTMENT	1
32	5002192	SCREW M6×12L & S.W & W	8
33	5002156	SHAFT	1
34	5001977	HANDLE RING	2
35	5001710	HANDLE CRANKK ARM	1
36	5001827	SCREW M6×20L & S.W & W	1
37	5002154	SPINDLE WIDTH ADJUSTMENT	1
38	5001701	BEARING 6203ZZ	2
39	5002155	SPINDLE SUPPORT	2
40	5004101	SPINDLE SUPPORT	2
41	5001714	MOTOR 110V/60HZ,T18:1	1
	5001957	MOTOR 110V/60HZ,T15:1	1
	5001714-V1-60	MOTOR 220V/60HZ,T18:1	1
	5001714-V1-50	MOTOR 220V/50HZ,T15:1	1
	5001714-V2-50	MOTOR 240V/50HZ,T15:1	1
	5001714-V3-50	MOTOR 380V/50HZ,T15:1	1
	5001714-V4-50	MOTOR 400V/50HZ,T15:1	1
42	5004185	SPACER	2

## Vertical Column



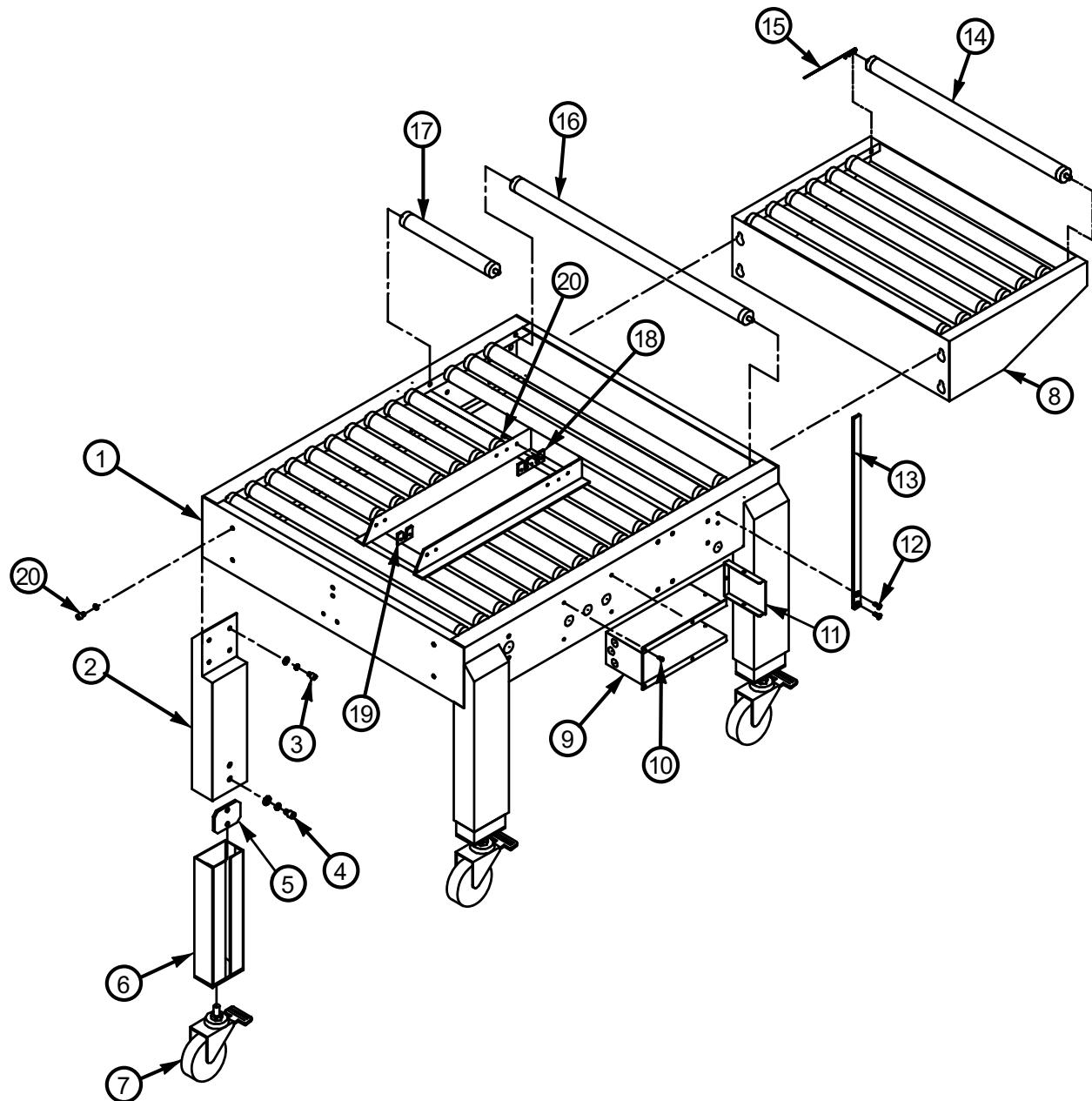
**PACKAGING PLUS**  
**317-841-1126 INFO@HOTMELTUNITS.COM**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>QUANTITY</b>
1	5001970	TAPING SET SUPPORT	1
2	5004102	SUPPORT SET	2
3	5002192	SCREW M6×12L & S.W & W	12
4	5004103	LINING	8
5	5001979	FOLDING DEVICE PLATE	1
6	5004104	SCREW M4×6L	4
7	5001709	HANDLE KNOB	2
8	5001811	LOCKING BRACKET	2
9	5001812	SCREW KNOB	2
10	5001813	COMPRESSION ROLLER SEAT	2
11	5004105	SUPPORT BAR	1
12	5001814	RING STW-17	4
13	5001708	COMPRESSION ROLLER	4
14	5001702	COMPRESSION ROLLER SHAFT	4
15	5002178	SCREW M6×10L	4
16	5001973	SPINDLE SUPPORT	2
17	5004106	HEIGHT ADJUSTMENT SPINDLE	2
18	5004107	CHAIN WHEEL	2
19	5002192	SCREW M6×12L & S.W & W	4
20	5004108	COVER PLATE	2
21	5004109	SET PLATE	2
22	5004110	SET PLATE	2
23	5004111	COLUMN	2
25	5002192	SCREW M6×12L & S.W & W	8
26	5002192	SCREW M6×12L & S.W & W	8

**PACKAGING PLUS**  
**317-841-1126 INFO@HOTMELTUNITS.COM**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>QUANTITY</b>
27	5004112	CHAIN PLATE	1
28	5001856	CHAIN	1
29	5004113	CHAIN COVER	1
30	5004114	SCREW M4×10L & S.W & W	4
31	5004115	CHAIN WHEEL	1
32	5004116	CHAIN WHEEL SHAFT	1
33	5001896	BUSH Ø10 x Ø12 x 10L	2
34	5004117	SCREW M6×35L & S.W & NUT	1
35	5001710	HANDLE CRANK ARM	1
36	5004118	SCREW M8×16L & S.W & W	1
37	5004119	RUBBER PLUG	2
38	5001981	FOLDING DEVICE	1
39	5001980	FOLDING DEVICE	1
40	5001852	BEARING 6202ZZ	2
41	5001754	BEARING SEAT	2
42	5001887	SCREW M6×16L	4
43	5001971	FOLDING DEVICE SEAT	1
44	2006035	SCREW M6×16L & S.W & W	2
45	5001982	HANDLE KNOB	2

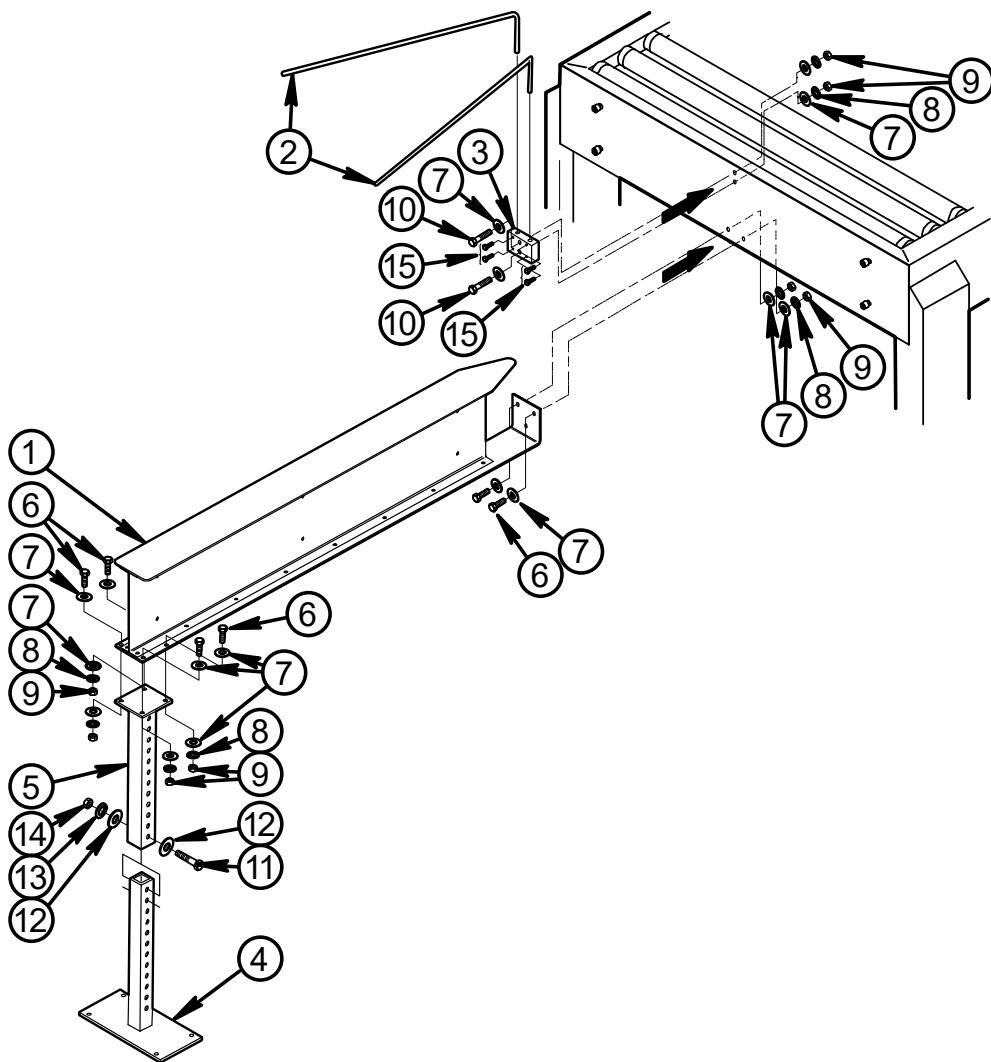
## Machine Body



**PACKAGING PLUS**  
**317-841-1126 INFO@HOTMELTUNITS.COM**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>QUANTITY</b>
1	5004120	MACHINE FRAME	1
2	5004121	MACHINE LEG	4
3	5004122	SCREW M8×16L & S.W & W	16
4	5004123	SCREW M10×16L & S.W & W	8
5	5004124	CLAMP	4
6	5002127	ADJUSTABLE LEG	4
7	5001892	CASTER	4
8*	5001738	TABLE ROLLER PACK COMPLETE: 8, 14 & 15	1
8	5004125	ROLLER SEAT	1
9	5004126	ELECTRICAL BOX	1
10	5004127	SCREW M5×10L	4
11	5004128	ELECTRICAL COVER	1
12	5002163	SCREW M6×12L	2
13	5004129	FIXED SEAT	1
14	5001720	ROLLER	7
15	5004130	PIN	13
16	5001716	ROLLER(LONG)	7
17	5001718	ROLLER(SHORT)	16
18	5004131	B-PLATE	2
19	5004132	A-PLATE	2
20	5004133	SCREW M8×12L & S.W & W	8
21	5004186	WASHER, SPACER, FOR ADJUSTABLE LEG	4

## Easy Packer Anvil Box Guide



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	5000757	FAB/WELD ANVIL BASE	1
2	5000761	FAB-FOLDING BARS	2
3	5000760	MACH-FOLDER BAR BLOCK	1
4	5001444	MACH/WELD BOTTOM FOOT, ANVIL	1
5	5001443	MACH/WELD-TOP FOOT, ANVIL	1
6	5000803	SCRW-HHC 5/16-18 x 1-1/4 SS	6
7	5000333	WASHER-FLAT 5/16 ZINC	16
8	5000339	WASHER-5/16 SPLIT, ZINC	8

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
9	055307-055	NUT-HEX 5/16-18 ZINC	8
10	5000668	SCREW-HH 5/16-18×2 SS	2
11	055293-072	SCREW, HHC 3/8-16×2 3/4" ZINC	1
12	055029-022	WASHER-FLAT 3/8 ZINC	2
13	055310-042	WASHER-SPLIT 3/8, NI	1
14	055307-062	NUT-HEX 3/8-16 NI	1
15	055293-038	SCREW HHC 1/4-20 × 5/8 SS	4

**Tape Head** — Refer to Tape Head User Guide.

Refer to the parts illustrations and listings in the Tape Head User Guide provided with the tape head for identification and part numbers of tape head parts.

# Video Library

The videos below cover topics discussed in this user guide. To view them, click the link or input the link text into a browser, or scan the QR code at right with the camera app on your mobile device.

## Instructional Videos

### VIDEO: Threading the Tape Cartridge — Eastey EX Cartridge

<https://www.youtube.com/watch?v=TJRVNniJIXQ>



### VIDEO: Threading the Tape Cartridge — Eastey EZ-EX Cartridge

<https://www.youtube.com/watch?v=E5C8fH48IfY>



## Application Videos

### VIDEO: Easy Packer Case Taper Product Overview

<https://www.youtube.com/watch?v=7v5eNws2XSY>



### VIDEO: Easy Packer Operation

<https://youtu.be/cyyCV6Lulk0>



# **Warranty Statement**

## **Easy Packer Carton Sealing Machine**

### **Warranty Statement**

Eastey warrants that all of the products it ships will be in good working order and free from defects in material and workmanship and will conform to the published specifications for that product.

### **Warranty Period**

Drive motor(s): 1 year

Tapehead: 1 year (Except for moving parts which are subject to normal wear, tear and replacement which are warranted to be free from defects in material and workmanship.)

All other parts: 1 year (Except for moving parts which are subject to normal wear, tear and replacement which are warranted to be free from defects in material and workmanship.)

### **Taping Quality**

Taping quality achieved in a given application is dependent on the installation, the material handling, and the maintenance provided. Eastey makes no warranty that the taping quality achieved in an application will be the same as that achieved on a test piece in our demo facility.

### **Shipping Policy**

Customer pays all incoming shipping. If the item is defective and under warranty, Eastey pays return shipping charges for least costly method. If expedited shipping is desired, customer must furnish his shipping account and shipping fees will be charged to that account.

### **Warranty Verification**

If you conclude that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax 763-795-8867 or e-mail: [info@eastey.com](mailto:info@eastey.com)). Once an RMA number has been obtained, return the defective item to Eastey. Eastey will analyze the product and, if found to be defective, we will, at our option, replace or repair the item. If the item is found to not be eligible for warranty, you will be notified and may decide on disposition. Defective products will be replaced or repaired as promptly as possible.

### **Warranty Eligibility**

The warranty provided by Eastey is only to the original buyer.

**Limited Warranty**

THE ABOVE WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE AND NONINFRINGEMENT.

**Disclaimer of Damages**

REGARDLESS OF WHETHER ANY REMEDY SET FORTH HEREIN FAILS OF ITS ESSENTIAL PURPOSE, IN NO EVENT WILL EASTEY BE LIABLE FOR ANY SPECIAL, CONSEQUENTIAL, INDIRECT OR SIMILAR DAMAGES, INCLUDING LOST PROFIT OR LOST OPPORTUNITIES OF ANY TYPE ARISING OUT OF THE USE OR INABILITY TO USE THESE PRODUCTS EVEN IF EASTEY HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

## Customer Support

### Eastey Technical Service

For help setting up or operating the Easy Packer Case Taper, please contact Eastey Technical Service at one of the numbers listed below.

Toll-Free Phone	800-835-9344
Phone	763-428-4846
Fax	763-795-8867
E-mail	info@eastey.com
Web	www.eastey.com



Thanks again for your purchase of Eastey products. We are pleased to be a part of your packaging needs.

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

PACKAGING PLUS  
317-841-1126 INFO@HOTMELTUNITS.COM

PACKAGING PLUS  
317-841-1126 [INFO@HOTMELTUNITS.COM](mailto:INFO@HOTMELTUNITS.COM)



PACKAGING PLUS  
317-841-1126 [INFO@HOTMELTUNITS.COM](mailto:INFO@HOTMELTUNITS.COM)