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OPERATION, SAFETY and SERVICE MANUAL

MODEL : OB-260N,360N,560N

MACHINE No.:



IMPORTANT DO NOT DESTROY

***Read carefully and understand SAFETY INSTRUCTIONS
before operating your Strapack machine.**

Keep this booklet in a convenient location for use at any time.

This machine is conformity with the requirement of the following EC Directive ,

◇ 2006/42/EC

Machinery Directive

◇ 2014/30/EU

EMC Directive



360N-1A-02001-01 2017-12)

ORIGINAL INSTRUCTION

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Application Principles

- Automatic banding machine. For bundle size please see next page.
- Best suited for all types of packages (e.g. printed material, cartons, etc.)

Machine Features

- DC Direct Drive
- Programmable IC Box
- Automatic Re-Feed in case of feeding error
- Internal Coil Holder, Reel Movement controlled electronically
- This series adopts a new tensioning method and tightens a package in a stable manner while giving less damage to the tape.
- Max tension is higher than conventional OB series.
Tension – Up to 60N (13.5lbf or 6.1kgf) ※OB-360N case of film tape 110 μ m
- Tension adjustment volume placed inside the conventional type is placed on the operation panel , which allows its adjustment during operation.
- Start Switch, placed on the front side of the conventional type, is placed on the table of this machine, further enhancing operation.
- No Tools Required to access the strap path.
- Eco friendly
- Quiet – 71.9 dB(A)
- Other Advanced Features
 - ✧ Easy Strap Loading
 - ✧ Quick Warm-up Heater
 - ✧ Variable Electric Tension

Standard Specification

	OB-260N	OB-360N	OB-560N
Joint (Strap Weld)	Heat Seal		
Arch Size	W425 x H216 mm (W16-3/4 x 8-1/2 in.)		
Dimensions : Width	570mm (22-1/2 in.)		
: Height	489mm (19-1/4 in.)		490mm (19.3in.)
: Depth	282mm (11-1/8 in.)		342mm (13-7/16 in.)
: Table Height	238mm (9-3/8 in.)		239mm (9.4 in.)
Machine Weight	Approx. 26 kg (57.3 lb.)		Approx. 28 kg (61.7 lb.)
Electric Power	Single Phase 100V / 110~240V		
Full Load Current	4.7A		
SCCR	1kA		
Power Consumption	250W		
Tension : 60 μm film tape	—	5~30N (1.1~6.7lbf)	
: 80 μm film tape	5~30N (1.1~6.7lbf)	—	
:110 μm film tape		5~60N (1.1~13.5lbf)	
: 80g paper tape		5~45N (1.1~10.1lbf)	
Noise Emissions	71.9dB(A)		
Speed	30 bundles/ min : depending on individual conditions		
Package : Min. Size	W 30 x H10 mm (W1-3/16 x 0.4 in.)		
: Max. Size	W420 x H210 mm (W16-1/2 x 8-1/4 in.)		
Tape : Width	20mm	30mm	50mm
: 60 μm film tape	—	W30mm x 370m	—
: 80 μm film tape	W20mm x 200m	—	W50mm x 200m
:110 μm film tape	W20mm x 200m	W30mm x 200m	W50mm x 200m
: 80g paper tape	W20mm x 190m	W30mm x 190m	W50mm x 190m

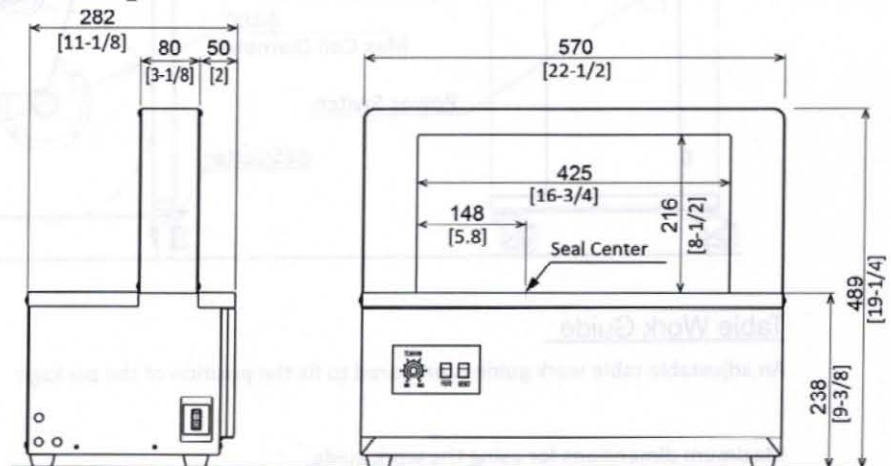
Operating Environment

Use this machine where the following environmental conditions are met.

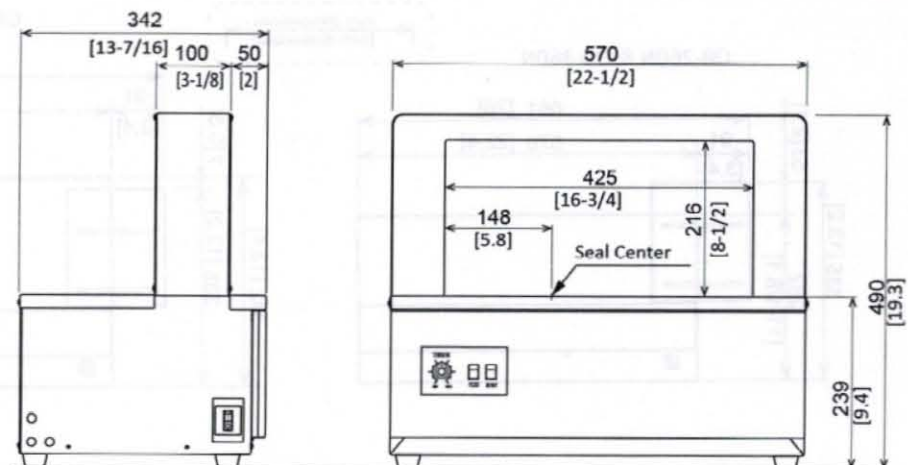
- This machine is for indoor use only.
- Temperature: Between 0 degrees Celsius and 40 degrees Celsius (do not freeze)
- The humidity: Relative humidity being 0-85% (without condense dew)
- Atmosphere : Free from excessive dust, acid fume, corrosive gases and salt.
- The place where water and oil do not congregate or drip.
- A place without the danger of explosion
- This machine is not explosion-proof type.
- Place with no direct exposure to sunlight (Avoid places such as by the window.)

Dimensional Outline Drawing

【OB-260N & OB-360N】



【OB-560N】



Main Options

A special base for long tapes and a table work guide are available as options.

Please use them according to the situation of use

Base for Long Tape.

Below is a special stand when using a long tape with its coil outer diameter 400 mm at maximum.

(Weight: approx. 27 kg / 29.5lb). Four casters all have a stopper.

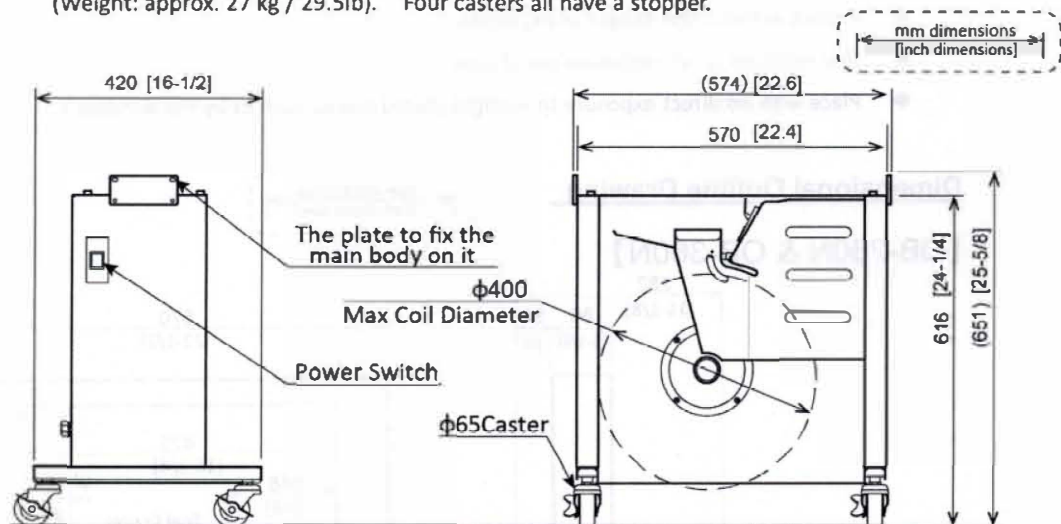
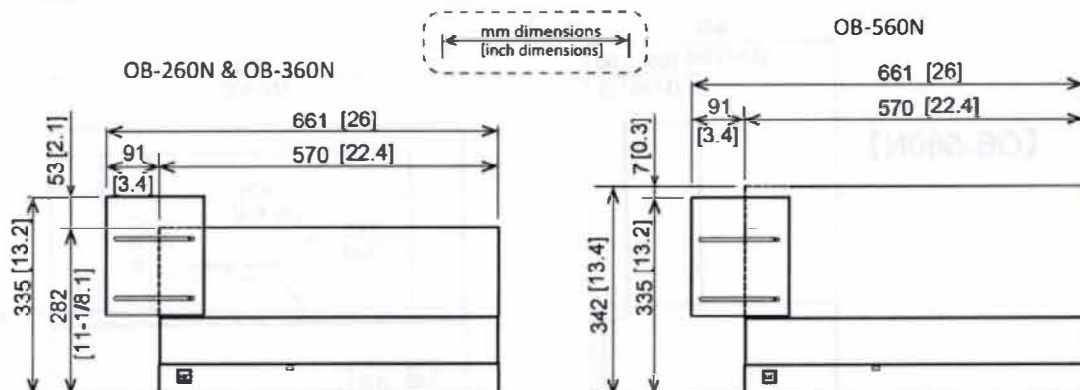


Table Work Guide

An adjustable table work guide is prepared to fix the position of the package

Maximum dimensions for using the work guide.



Chapter 2 SAFETY INSTRUCTION

This important manual has been prepared to provide you with instructions for safe operation, easy maintenance and safety information relating to your machine. It is essential that you carefully read the "SAFETY INSTRUCTION" and understand it before you attempt to operate your machine.

Please keep this manual by the machine to refer to it immediately as needed.

Only trained technicians should be allowed to repair and adjust the machine.

Definition of risk level

This machine is designed prioritizing the safety of the operator. However, due to the nature of the system, some unremovable risks exist.

This manual indicates three levels of the risks according to the gravity of the risk: "Danger", "Warning" and "Caution". Please carefully read each category and make sure you understand well before operating or maintaining the machine.

The level of risk in the order of the gravity: DANGER > WARNING > CAUTION.

 DANGER	Imminent danger that can cause death or severe injury if not avoided
 WARNING	Potential danger that can cause death or severe injury if not avoided.
 CAUTION	Potential danger that can cause injury of lesser degree if not avoided.

Safety instructions for each process

This machine consists of Parts for Transportation, Parts of Operation, Parts of Electrical Danger, Parts of High Temperature. Mishandling of the machine can cause injury to the operating personnel.

Every personnel including those who may move or install the machine, who may adjust, repair or clean the machine, or who may work with or around the machine, should read and understand the safety instruction of this manual and safely and appropriately handle the machine.

•Move

- Follow the instructions according to this manual when moving the machine.
- Make sure that the machine is carried by two persons, not by just one person.



- Do not hold the arch when moving the machine.

•Installation

- Install the machine on a stable, flat floor.
- Install the machine where there is appropriate ventilation of air.
- Install the machine where there is no splashing of water or oil.
- Place it properly in case the operator or anybody around fall with their foot caught by the power cord.
- Use with the correct voltage.
- Power Plug should be connected to the power outlet of at least 10A.
- Be sure that the Power Cord is plugged all the way into the power outlet.
- Do not plug in and out with wet hands.
- Use caution not to drop the tape coil when loading the strap.
- Use appropriate type of tape.

●Operation

 DANGER	● Do not strap the following types of package. ✧ Explosives ✧ Exposed food items (for sanitary reasons) ✧ Breakables such as glass ✧ Harmful chemicals ✧ Live animals
 WARINIG	● Remove jammed strap appropriately; do not put your fingers. ● To remove the tape in the gap around the Slide Table, use a tool; do not insert fingers.
 CAUTION	● Read the Instructions carefully. ● Use this machine to band appropriate packages. ● Dress appropriately to operate the machine. ● Do not touch the machine when your body has collected static. ● Watch your steps around the power cords. ● Never operate the machine when the table or operation panel is removed. ● Do not touch the banding tape during the machine operation. ● Never put your hand, head or any part of the body inside the arch during the operation. ● Use caution to keep your body parts from getting caught between package and strap. ● Use caution to keep your body parts from getting caught in the door when the door opens or closes. ● Never operate the machine when the door switch is inactive. ● Do not cover the photoeyes on the machine when inappropriate. ● Remove jammed strap appropriately; do not pull by force. ● Do not turn power on and off repeatedly in a short time. ● Do not damage the Power Cord. ● Do not use deformed or damaged Power Cord. ● Do not place liquid on the machine. ● Do not stand or sit on the machine. ● Do not use banding tape as handles. ● Do not drop the package/bundle on the table and floor. ● Do not leave the coil or piece of tape on the floor. (e.g. Do not bend by force, do not place something on top of it, do not tangle)

●Maintenance, Adjustment, Cleaning

WARNING

- Maintenance can only be done by a trained personnel.
- At the time of maintenance, the machine power should be turned off and the power plug should be unplugged.
- Remove jammed strap appropriately; do not put your fingers.
- To remove the tape in the gap around the Slide Table, use a tool; do not insert fingers.

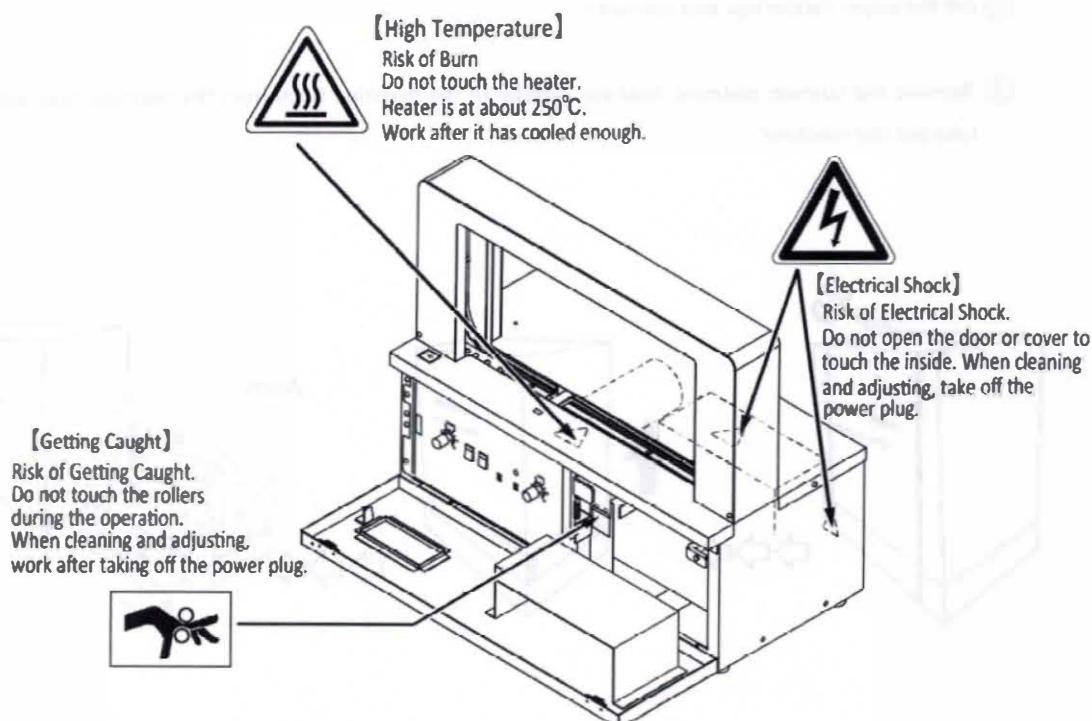
CAUTION

- After the power is turned off, wait until the following parts cools off.
 - ◇ Heater
- When you need to work on the IC Board, make sure that the remaining electricity has been discharged.
 - **Right after the power switch is turned off, there is still some electric charge on the condenser of the IC board. Therefore, handle it very carefully.
- When handling springs, be careful not to hurt yourself with the spring pressure.
- Handle the troubling tape according to the specified steps and avoid pulling it too hard.
- Before operation, be sure to check that the table and external panel are set in place.
- Before operation, be sure to check that the door switch is valid.
- When the maintenance is complete, replace the tables and outer panels and turn the power back on. Confirm the safety switches work normally.
- Use only parts provided or approved by Strapack.
- Dispose of the replaced parts appropriately, according to local trash regulations.
- Keep the Power Plug free of debris and dusts.
- Keep the Power Plug free of debris and dusts.
- Do not damage the Power Cord.
 - (e.g. Do not bend by force, do not place something on top of it, do not tangle)
- Do not use deformed or damaged Power Cord.
- Remove dust and dirt on power plugs and outlets on a regular basis.

Alert Labels

- Warning labels are seen where there is a potential risk of danger.
 - ✧ Carefully read the instructions on the Safety Alert Labels and follow them.
 - ✧ Replace missing or damaged safety labels with new safety labels immediately.
 - ✧ If safety labels are replaced with new labels, make sure new safety labels are attached in the same location as the replaced labels.
- The alert labels shown below are attached to machine:

	WARNING : Electric Shock Hazardous voltage cause electric shock.
	WARNING : Getting Caught Entangling of hands may result in severe injury.
	CAUTION : High Temperature Hazardous temperature (over 65°C/ 149°F) can burn.



Chapter 3 INSTALLATION



Do not hold the arch unit

The arch may warp or the connection part may be deformed. As the result, the tape may not feed correctly.



Do not hold the machine from the front side.

During the move of the machine, if the arch hits your body, the arch may warp or the connection part may be deformed.

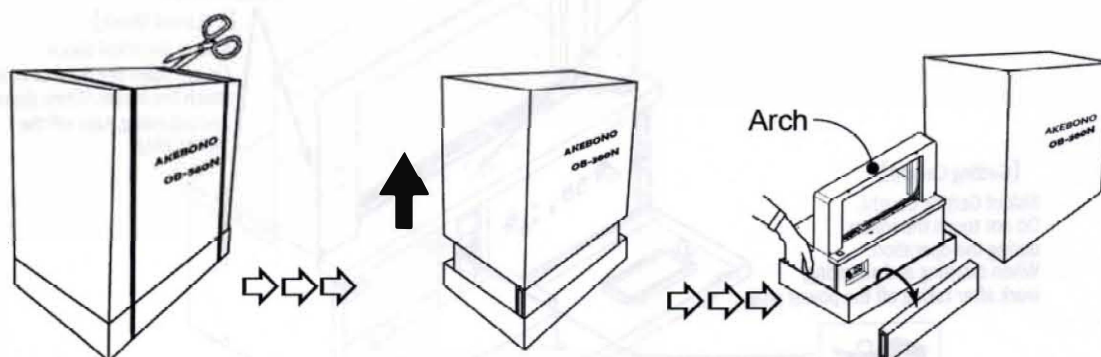
As the result, the tape may not feed correctly.



As the machine weight is over 25kg, do the work very carefully.

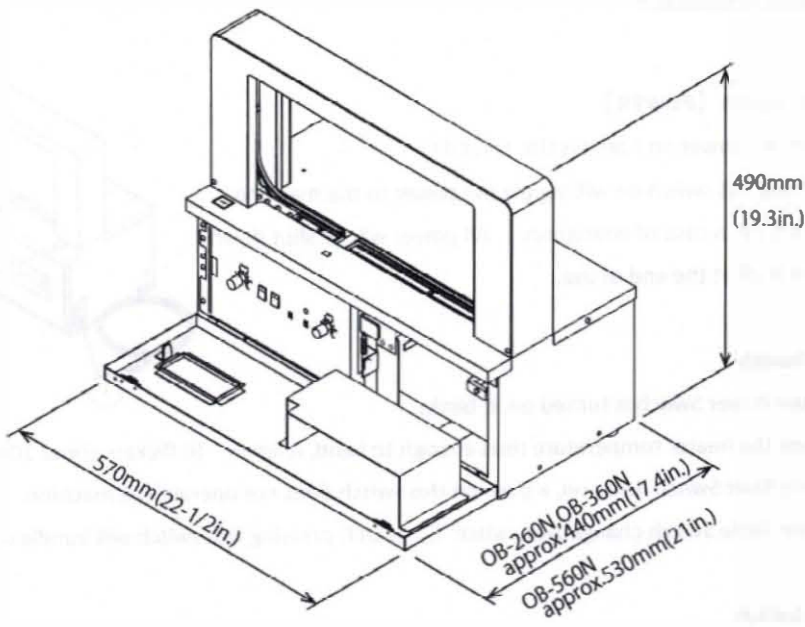
To remove the machine from the carton box and pallet

- ① Cut and remove the PP strapping from the carton box.
- ② Lift the upper carton box and remove it.
- ③ Remove the cushion material, hold the bottom of the machine body from the machine rear side, and take out the machine.



Moving the machine to an appropriate area

This machine requires the space indicated below.



Connect Power Cable (for outside North America & Republic of Korea)

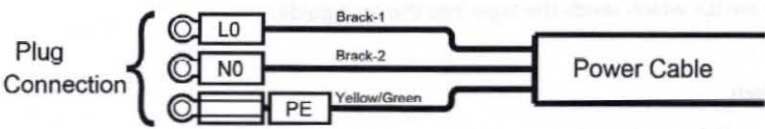
1. Connect to appropriate Power Supply

Current 10A

Voltage Single Phase 230V, 50Hz

Allowance of Fluctuation..... Voltage 198V ~ 264V Frequency 50±3Hz

2. Use the appropriate plug according to the outlet.

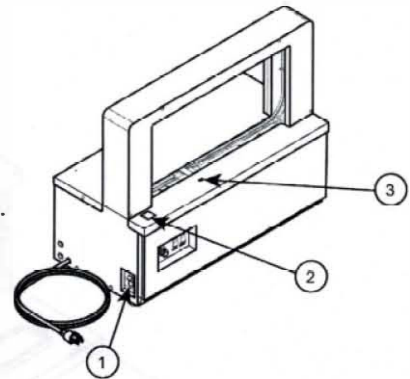


Chapter 4 MACHINE INFORMATION

Operation Switches

① Power Switch **【POWER】**

- Turn the power on / off. I is ON, O is OFF.
- Turning this switch on will supply the power to the machine.
- Turn it off in case of emergency. All power will be shut down.
- Turn it off at the end of use.



② Start Switch

- When Power Switch is turned on, it blinks.
When the heater temperature rises enough to band, it lights (it flickers about 10seconds).
While Start Switch lights on, a push on this switch does not operate the machine.
- When Table Switch changeover switch ⑦ is OFF, pressing this switch will bundle once.

③ Table Switch

- When Table Switch changeover switch ⑦ is ON, putting a package on Table Switch will carry out a banding automatically.
- When Table Switch changeover switch ⑦ is OFF, because it still detects a package, even pressing Start Switch will not start the machine unless it is on Table Switch window.

④ Tension Adjustment Dial

- It is a dial that regulates tensioning power.

⑤ FEED Switch

- It is the switch which sends the tape into the arch guide.

⑥ RESET Switch

- It is a switch to rotate the camshaft.
Press it once to stop it at the retraction limit of the Slide Table. Press it again to return it to the home position.
- When the tape is clogged, push this switch once to open the band guide and remove the tape, then press it again to return to the home position.

⑦ Table Switch Changeover Switch

- Turn ON/OFF Table Switch ③.

⑧ Mode Switch

- According to the package, change the way of banding in following two ways
 - MONO (single acting): Banding and feeding tape.
 - TEMPORARY STOP: Banding and pausing with the guide open.

⑨ Heater Adjustment Dial

- Adjust the heater temperature.
- It gets lower counter-clockwise and higher clockwise.

⑩ Cooling Time Adjustment Dial

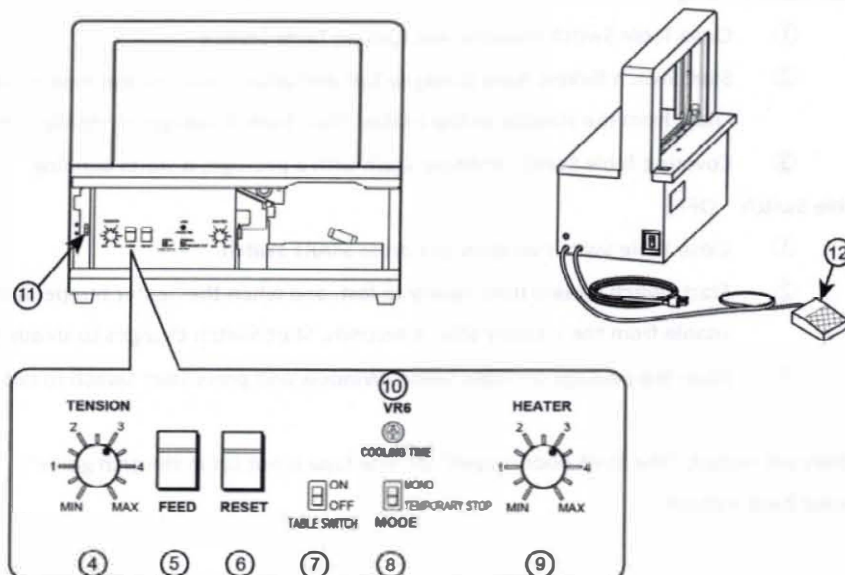
- For using paper tape, when the tape is broken as welded with too strong repulsion of the package, this changes the time cooling process stops (adjusts a span of time during which the weld cools to ensure its firmer joint).

⑪ Door Switch

- As Front Door opens, it stops banding operation, camShaft rotation and Tape Feeding. At this time START switch ② blinks.

⑫ Foot Switch

- Instead of pushing Start Switch by hand, stepping on it will start it.



Useful Functions

Prevention of Banding without a Package

To prevent banding without a package, when a package is not on the table, the machine does not complete banding. When the package comes off or floats from the window of Table Switch in the middle of tensioning, the machine stops. Recover it according to the following procedures.

- ① Remove the package if any.
- ② Remove the tape.
- ③ Press RESET Switch once. (The camshaft rotates and returns to the original.)
- ④ Press FEED Switch to send the tape.



Below the Slide Table there is a heater (about 250 ° C) for welding the tape. Touching it will cause burns.

If the tape is at the Slide Table and the gaps around it in the shape of a small loop, do not insert your fingers directly and remove it with a tool (such as a radio pliers or tweezers).

Energy Saving

In order to save power consumption during standby and reduce damage to the tape by the heat from the heater, it stands by with the heater down to the standby temperature if the operation stops for 10 minutes. At this time, Start Switch will blink (slowly).

To restart, the procedure differs depending on whether Table Switch selector switch is ON or OFF.

【Table Switch ON】

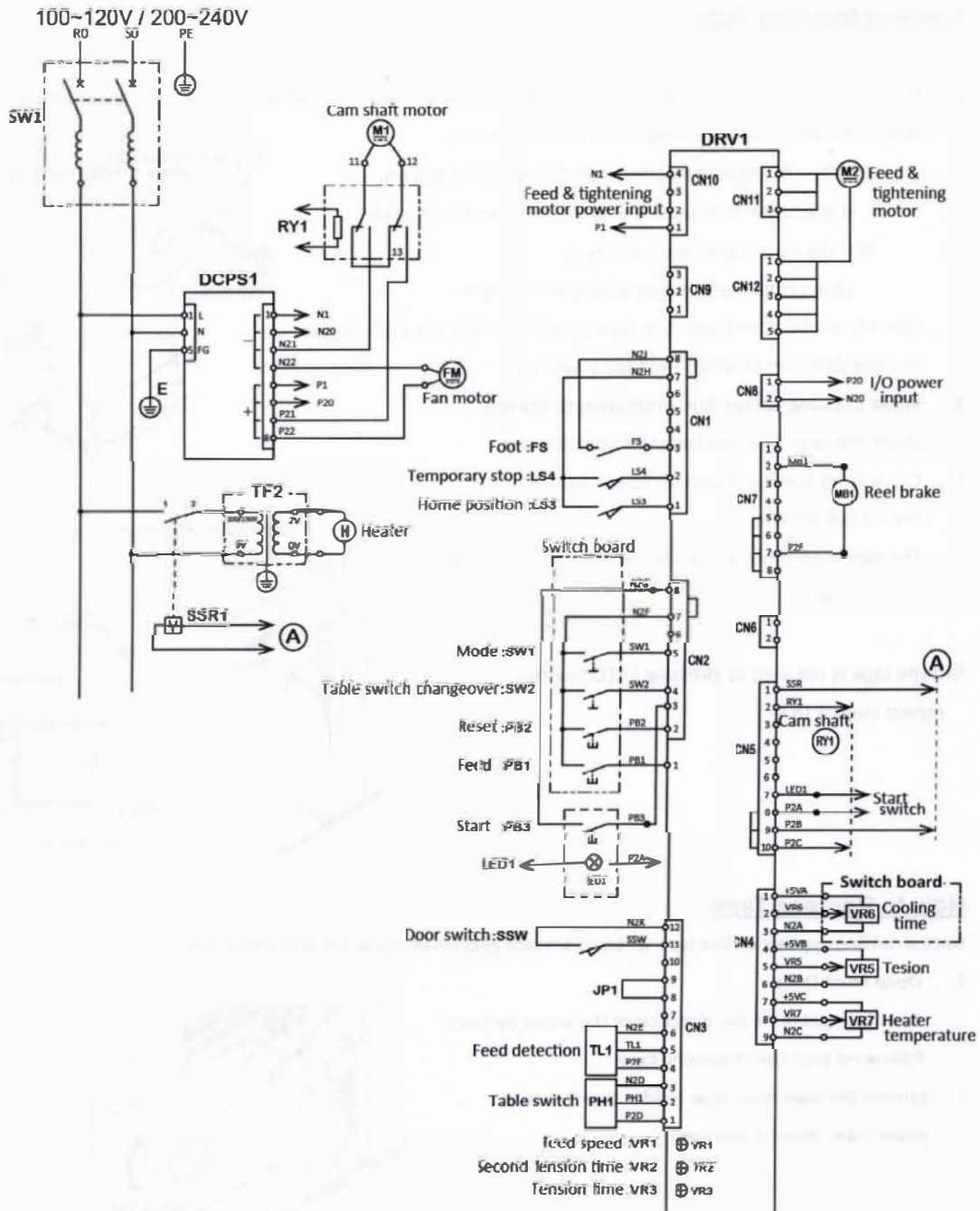
- ① Close Table Switch Window and turn on Table Switch.
- ② Start Switch flickers from slowly to fast and after 4 seconds the heater temperature rises from the standby to the usable. Start Switch changes to steady light.
- ③ Covering Table Switch Window again with a package, it starts banding.

【Table Switch OFF】

- ① Close Table Switch window and press START switch.
- ② Start Switch flickers from slowly to fast, and when the heater temperature reaches the usable from the standby after 4 seconds, Start Switch changes to steady light.
- ③ Place the package on Table Switch Window and press Start Switch to band it.

※ If it does not restart, "the front door is open" or "the tape is not set in the arch guide".
So please have a check.

Wiring Diagram [Index # SEOB-1033E]



Chapter 5 OPERATION

Loading banding Tape

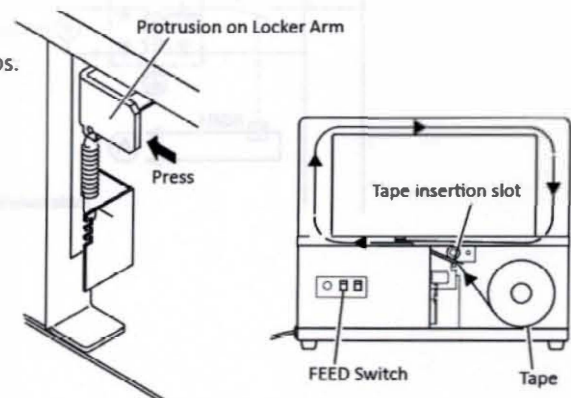
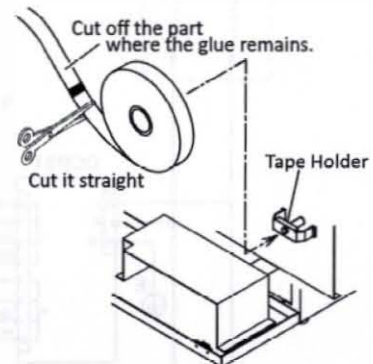
1. Peel off the adhesive tape at the end of the new tape roll and trim off with scissors the part around back to where the adhesive tape was (so one round of tape).

※When the tape is inserted with the adhesive still on, it will cause tape jamming at the roller and tape guide.

※If the tip of tape bends or tears, tape cannot be inserted well. Cut it straight.

2. Open Front Door and push the tape paper tube into the tape holder. See the direction in which the tape is wound.
 3. While pressing Locker Arm protrusion to the left, insert the tape end into the tape insertion slot.
 4. Close Front Door and turn on Power Switch.
 5. Press Feed Switch.
- The tape is sent out and passes around the arch and stops. Tape is all set.

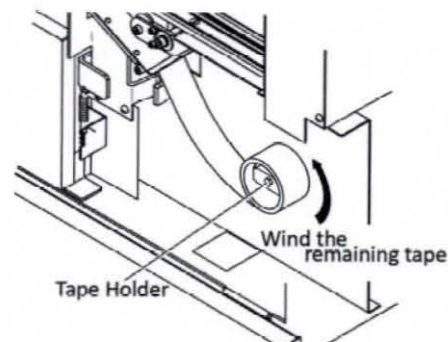
※If the tape is not sent by pressing FEED Switch, repeat steps 1 to 5.



How to Replace Tape

Since a red line appears on the tape when its amount gets small, replace it with a new one.

1. Open Front Door,
Turn Tape Holder in the direction of the arrow by hand,
Fully wind back the remaining tape.
2. Remove the tape from Tape Holder together with paper tube, Insert a new tape



How to Operate

1. Turn on Power Switch.

When operation turns possible after about 10 seconds, Start Switch changes from blinking to steady light.

2. Banding Operation

① When Table Switch is ON: When a package is placed on the table, it is automatically banded.

※It will not start unless a package is on Table Switch Window.

※When the package comes off or up from Table Switch during tensioning, "Prevention of banding without a package" turns on, making the machine stop.

(P.4-3 See "Prevention of Banding without a Package")

When Table Switch is OFF: Place the package on the table and press Start Switch to band.

※If the package is not on Table Switch Window, banding does not start even if you press Start Switch.

② When a banding is completed, the tape will be sent enabling next banding.

※Until tape is sent and banding becomes possible, Start Switch flickers fast.

When ready, it changes to steady light.

※If the next package is placed before Start Switch turns into steady light, the next banding does not start.

In that case, lift the package once.

③ Banding behavior differs on MODE. Use MODE suitable for packing work.

● MONO (single acting):

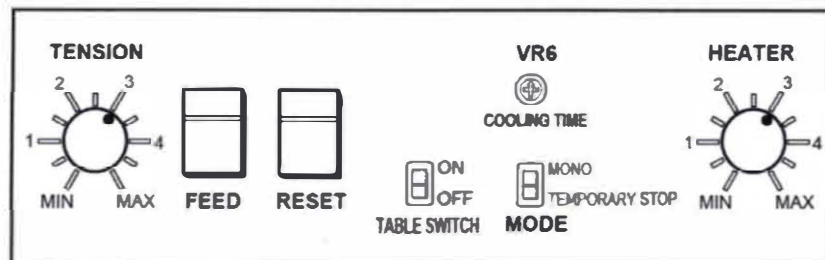
The machine does not band next unless the package is removed off the window of Table Switch after banding.

● TEMPORARY STOP (pause):

The machine stops temporarily with Band Guide and Slide Table open after banding.

Removal of the package off Table Switch will send out tape automatically.

Use this when Slide Table is caught on tape after banding due to soft tension or etc.



※Cautions for removing the tape remaining inside Band Guide

When tape remains in Band Guide due to banding errors or etc.,
do not open Band Guide by hand nor pull the tape forcefully.

This might deform Band Guide and cause malfunctions.

Press RESET Switch once.

Then it stops with the band guide open.

Press RESET Switch after removing the tape, and it returns to the original position.

After that, push FEED Switch to send the tape to the required point.



Chapter 6 ADJUSTMENT & PREVENTIVE MAINTENANCE



Warning

When cleaning, turn off the power switch and unplug the power plug.
Heaters is hot. After confirming that Power Switch has cooled enough
after being turned "OFF", remove top table and clean the heater.

Routine Maintenance

Please contact Technical Support when there is an error or problem that needs to be checked or repaired.

[Daily]

●Before work

- Adhesive State..... Check the adhesion is good.
- Abnormal Noise Check there is no abnormal noise during machine operation
- Vibration Check there is no abnormal vibration during machine operation.
- Power Check there is no abnormality such as deformation / breakage in the power plug / power cord.

●After Work (or Before operation)

- Cleaning the inside of the machine Remove tape powder, dust, paper powder, foreign matters etc. left in the machine with air blow or brush etc.

[Monthly]

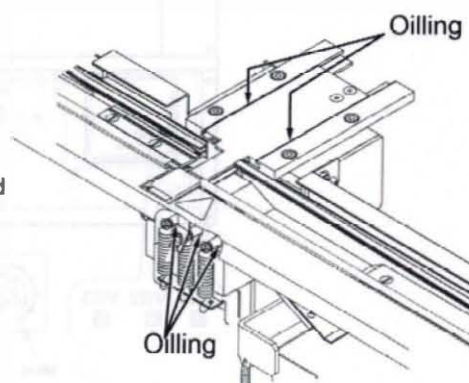
●Oiling (Recommended Lubricant: Hydraulic Oil # 32)

Lubricate the sliding part on both sides of
Slide Table and Three Blocks shown on the right.

《Caution》

Carefully lubricate it so that oil does not drip and
stick to other places.

Also, if foreign matters such as dust get into
lubricant, it will affect the performance of the
machine so start lubricating it after cleaning.



●Checking Devices

- Door Switch The machine does not operate when front door is open.

<When this device is out of order>

If you can carry out banding even while Front Door is open with power switch ON, door switch is broken.
Stop using it until safety is confirmed by replacing the part.

Adjustments

[Factory-set] in below passages means the factory-set values which are not designated at the time of order.

<Control Board>

Since Control Board is on the rear side inside the machine, so remove Rear Panel and make adjustments.

- **VR1** : Dial to adjust the speed to feed tape [factory-set: maximum]

If you want to raise the binding speed, turn it clockwise.

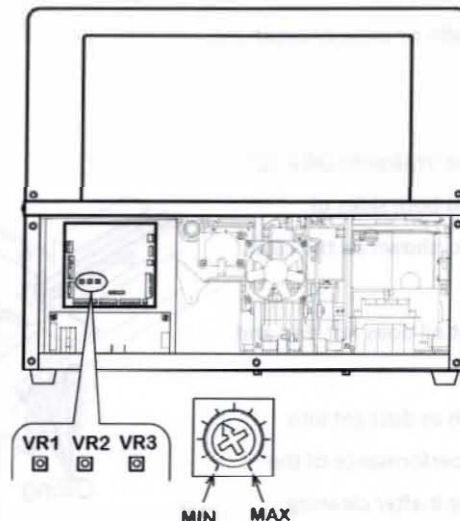
However, increasing the tape feed speed increases the sound of feeding the tape.

- **VR2** : Dial to adjust second tension time [Factory-set: 0]

When you want to tighten a soft package firmly holding them down with your hands, we extend this time.

- **VR3** : Dial to adjust time to tension tape [Factory-set: 4]

Adjust the time according to the package size.



Chapter 6 ADJUSTMENT & PREVENTIVE MAINTENANCE

《Front Panel》 · · · Other than VR 5, open Front Door and Make adjustments.

●VR5 : Slide Table

Adjustment Dial [factory-set: 0]

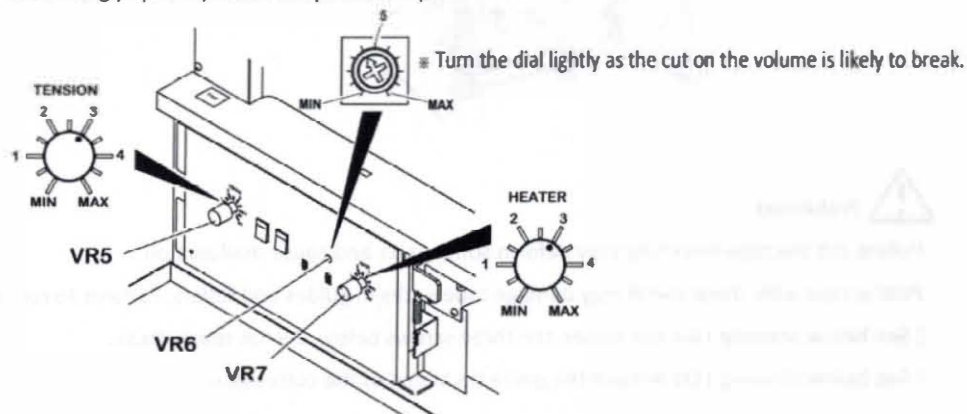
Adjusts tensioning force. With 60 μ m film tape, setting it as over [3] will make adhesion and tape feeding failures likely to occur.

●VR6 : Cooling Time Adjustment Dial [Factory-set: 0]

Using paper tape, the tape may break when welded due to the repulsive force of the package. In such a case, increase the cooling time. Usually set it to MIN when using film tape and to 2 to 5 when using paper tape.

●VR7 : HEATER Temperature Adjustment Dial [factory-set :3.5]

Since the heater temperature varies depending on the input voltage and the outside air temperature, adjust it also checking how the tape is welded. If the tape breaks at the welded part when welded, the heater temperature is too high. Usually set it to 1.5 to 2.5 when using 60 μ m film tape, 3 to 4 when using paper tape and 110 μ m film tape.

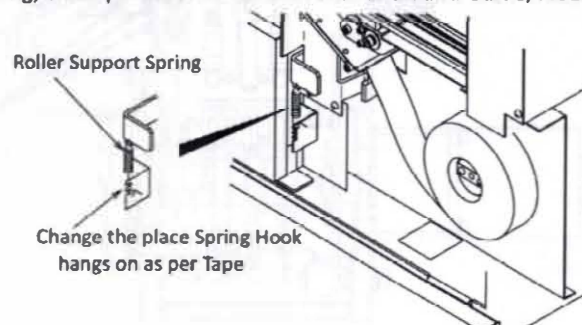


●Roller Retention Spring [factory-set: 2nd from the top]

Change the hanging position of Roller Pressing Spring according to the tape to be used.

If the roller pressing force is too strong, the tape will break at the roller and Band Guide, resulting in feeding failure.

60 μ m Film Tape	: 1st~2nd from top
110 μ m Film Tape	: 2nd~3rd from top
Paper Tape	

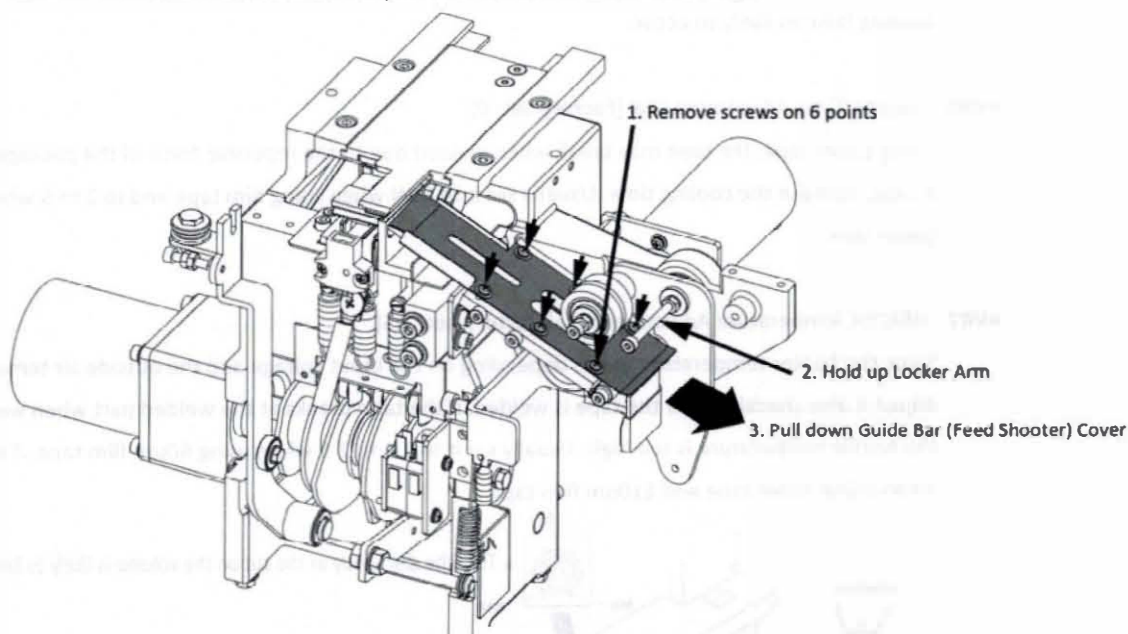


What to do when Tape is jammed



Caution: Touching the interior of the machine, turn off Power Switch and unplug the power cord before starting work.

Remove Guide Bar and follow the steps below to remove the jammed tape



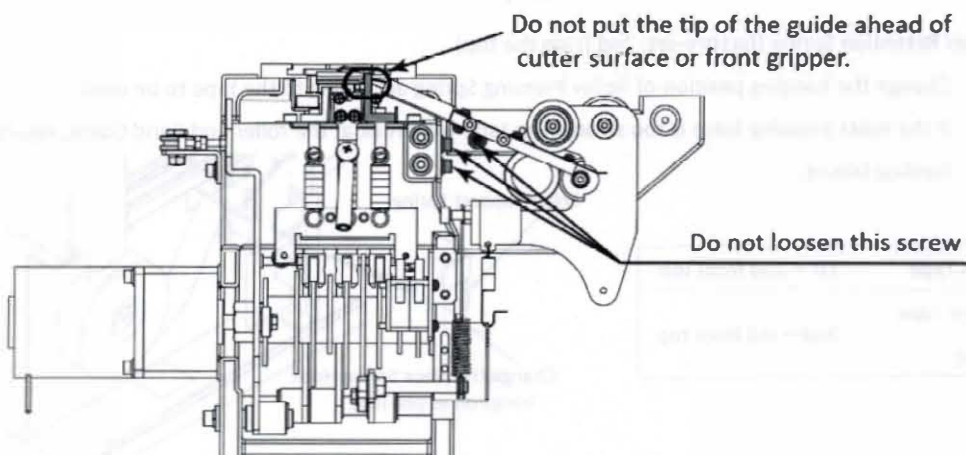
Prohibited

Pulling out the tape forcefully may deform some parts and cause malfunction.

Pulling tape with sharp metal may damage tape paths in guides and rollers, Failures to run tape may occur.

(See below drawing) Do not loosen the three screws below. Do not touch these.

(See below drawing) Do not put the guide tip ahead of the cutter face



Troubleshooting



DANGER : When touching the inside of the machine, turn off Power Switch and disconnect the power plug.

- Should you have any trouble, consider the following items. If the problem persists, contact your local Strapack distributor or our after-sales service representatives.
- As for "Condition" in Start Switch display, the display differs depending on other conditions such as the position where the tape stops.

Phenomenon.	Start Switch Display	Cause	Steps
The START switch does not blink (light) even when Power Switch is on.	Off Off	1. Power supply fault (power outage etc.) 2. Disconnect power cord, Failure to plug the Power Plug	1. Check Power Supply. 2. Check Power Cord and plug.
Banding does not start even if Start Switch is pushed. Or even with Table Switch on, it does not start even if you put a package on.	Blink (Slow) 《Condition》 《Condition》 Steady Light Blink (Slow) Blink (Fast)	1. Heater preheating 2. Doesn't turn Table Switch ON / OFF 3. The package is not on the Table Switch 4. Because the package is black, Table Switch does not work. 5. Heater is at standby temperature 6. The tape has not reached Edge Detector.	1. Wait for about 10 seconds after turning on the power. 2. To use Table Switch, turn it on. 3. Put the package on Table Switch window. 4. Consult a Strapack dealer. 5. Starts to band 4 seconds after cancelling energy saving mode (P.4-3) 6. Press FEED Switch

PHENOMENON	START	CAUSE	STEP
With Table Switch on, it starts without a package. Or, even if you put on a package, it cannot start next banding.	Steady Light	1. Machine is placed inappropriately	1. In places exposed to direct sunlight and in bright places by the window, Sensor of Table Switch might not work properly . Change its location or use it manually (Table Switch OFF).
	Steady Light	2. Dirt on Table Switch window. (Sensor Area).	2. Remove dust and dirt.
Does not feed tape.	Blink (Fast)	1. Disorders of Setting tape	1. Roll up and reset the tape
	Blink (Fast)	2. Out of tape	2. Replace it with a new tape.
		3. Tape Jamming	3. ① If the edge of the tape is defective, open Front Door, wind up the tape and cut its tip. ② P.6-4 "What to do when Tape is Jammed"
	Blink (Fast)	4. Cutting Tape	4. Depending on the shape of the package, tape may break at the time of tight tensioning. Cut its tip and set the tape again.
The machine stopped in the middle of banding.	Off	1. The power turns off on the way	1. Confirm that Start Switch lights and blinks. Press RESET Switch.
	Blink (Fast)	2. Out of oil at each oiling point of machine	2. Lubricate each part.
	Blink (Fast)	3. Tape cutting failure	3. It is necessary to adjust / exchange the cutter. Contact a Strapack dealer.
	Blink (Fast)	4. The package has come off Table Switch Window	4. Support the package so that it does not come off Table Switch during banding.
	Blink (Fast)	5. Front Door opens.	5. Close Front Door tightly and press RESET Switch.

PHENOMENON	START	CAUSE	STEP
Tape does not weld	Steady Light	1. Heater temperature too low	1. With VR 7 heater temperature adjustment volume. Raise the heater to the proper temperature.
	Steady Light	2. Heater Wire disconnected or Terminal Screw loosened.	2. Check Heater Wire and Terminal part. Replace Heater Wire or tighten Terminal Screw again
	Steady Light	3. Heater temperature is too high	3. VR 7: Heater Temperature Adjustment Dial. Lower the heater to proper temperature. Especially when using paper tape, if the temperature is too high, the tape is peeled off immediately after welding and the weld becomes defective.
	Steady Light	4. Shorter cooling stop time setting when using craft tape	4. VR 6 Cooling Time Adjustment Dial. Make the cooling time longer so that tape cannot come off immediately after welding.
	Steady Light	5. Foreign substances such as melting scrap of tape adhere to the top surface of the press head, heater, insulating plate.	5. Turn off power and rub the top of Press Head, Heater, Insulation Board with a flat screwdriver to remove dusts.



Although the environment where the machine should be used, conditional range becomes narrower depending on the type and thickness of the tape. Make use of this machine under a proper setting after confirming conditions of this product and the tape to be used

Please check the conditions of each product and tape to use under proper conditions

Eg. 60μm film tape, Temperature: 0-35°C Humidity: 30%-85%



A package which does not make Table Switch work cannot be banded in the standard condition, please consult the dealer from which you bought this product.

- ✧ When the package is black, Table Switch does not work
- ✧ When the package does not block the window of Table Switch because it is too small.
(Window size 11mmx6.5mm)
- ✧ When the package does not block the window of Table Switch because its bottom is raised or empty in some area

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