



USER MANUAL USA 20-B



For Serial Numbers:
TM062 or TM562 XX X XXX



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SERVICE INSTRUCTIONS

Technical Support

This is the Interpack Model USA 20-B Uniform Semi-Automatic Bottom Only Case Sealer you ordered. It has been set up and tested in our factory with Intertape manufactured pressure sensitive tapes. If any problems occur when setting up or operating this equipment, please contact the authorized distributor from where you purchased this item.

Should you need to contact **Interpack Technical Support**, please have the Case Sealer **model number and serial number** available. This information can be found on the nameplate of the side panel of the machine. Interpack Technical Support is available during normal business hours (Eastern Time).

PHONE 813-621-8410 x101

If you have a technical question that does not require an immediate response, you may contact Interpack by fax.

FAX 813-621-8449

Replacement Parts

Order parts by item number, part name and quantity required. Replacement parts are available from your Authorized Interpack Distributor exclusively.

Should you require assistance selecting the correct part, you may call:

Intertape Polymer Group
Interpack Machinery
9940 Currie Davis Drive, Suite B23
Tampa, FL, 33619

Tel: 1-800-474-8273 Option 3
Fax: 1-800-462-1293

MODEL: _____

SERIAL NUMBER: _____

DISTRIBUTOR PURCHASED FROM: _____

DATE OF PURCHASE: _____

WARRANTY

EQUIPMENT WARRANTY AND LIMITED REMEDY: The following warranty is made in lieu of all other warranties, express or implied, including, but not limited to, the implied warranty of merchantability, the implied warranty of fitness for a particular purpose, and any implied warranty arising out of a course of dealing, a custom or usage of trade:

Intertape sells its Interpack Tape Heads, Case Tapers and Case Erectors with the following warranties:

1. The HSD[®] 2000 Tape Heads' knife blades, springs and wipe down rollers will be free from all defects for a period of ninety (90) days.
2. All other HSD[®] 2000 Tape Head parts will be free from all defects for one (1) year after delivery.
3. Water Activated Tapers' blades and brushes will be free from defects for ninety (90) days after delivery
4. Drive Belts will be free from defects for ninety (90) days after delivery
5. The Gear Motors will be free from defects for one (1) year after delivery.
6. All other components for Case Tapers and Case Erectors will be free from defects for one (1) year after delivery.

If any part is proven defective within its warranty period, then the exclusive remedy and Intertape's and the seller's sole obligation shall be, at Intertape's option, to repair or replace the part, provided the defective part is returned immediately to Intertape's factory or an authorized service station designated by Intertape.

A part will be presumed to have become defective after its warranty period unless the part is received or Intertape is notified of the problem no later than five (5) calendar days after the warranty period.

If Intertape is unable to repair or replace the part within a reasonable time, then Intertape, at its option, will replace the equipment or refund the purchase price. Intertape shall have no obligation to install the repaired or replacement part.

Intertape shall have no obligation to provide or pay for the labor required to install the repaired or replacement part. Intertape shall have no obligation to repair or replace (1) those parts failing due to: operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts

1. Failure or damage is due to misapplication, lack of proper maintenance, abuse, improper installation or abnormal conditions such as temperature, moisture, dirt or corrosive matter, etc.
2. Failure due to inadequate cleaning, improper operating environment, improper utilities or operator error.
3. Failure due to operations above the rated capacities, or in any other improper manner, either intentional or otherwise.
4. Failure is due to equipment, which has been altered by anyone other than an authorized representative of Intertape Polymer Group.
5. Failure is due to an attempt by the purchaser to correct alleged defective equipment. In this event the purchaser is responsible for all expenses incurred.

LIMITATION OF LIABILITY: Intertape and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by written agreement signed by authorized officers of Intertape and seller.

DESCRIPTION OF USA 20-SB

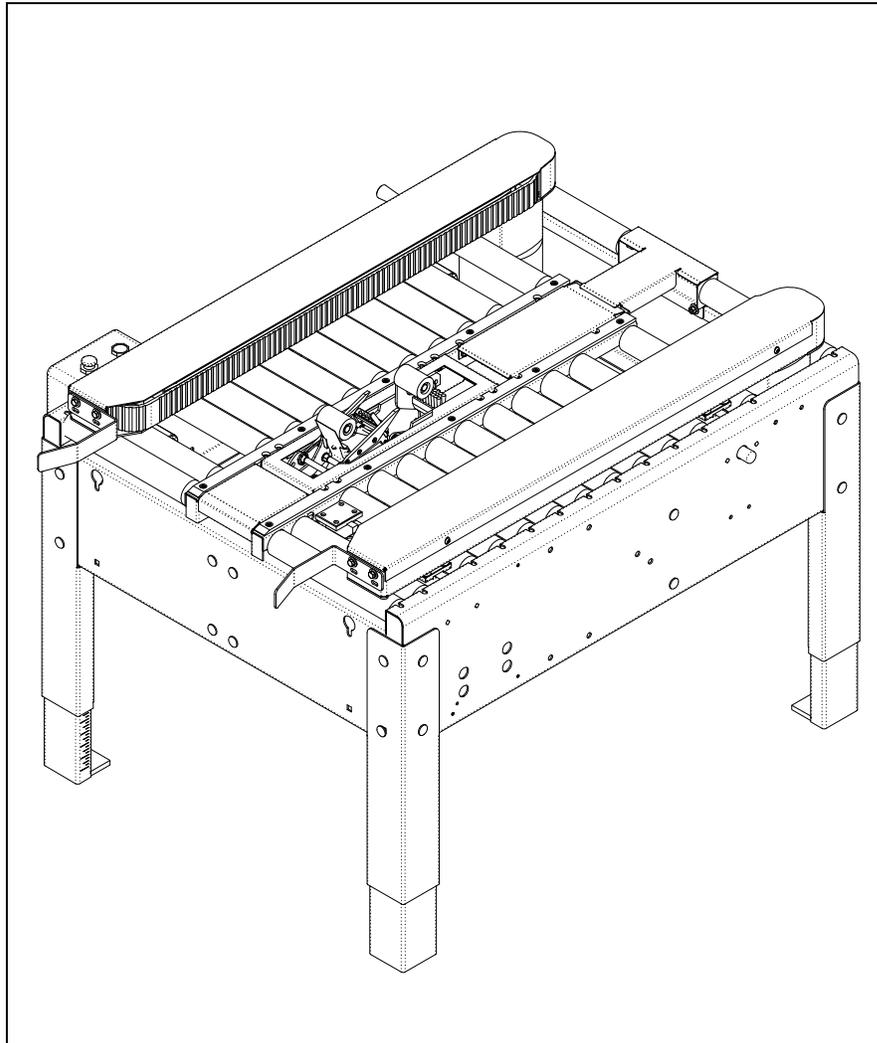


Figure 1

The Interpack USA 20-SB Carton Sealing Machine with HSD® 2000-ET II Tape Head is designed to apply Intertape brand pressure sensitive carton sealing tape to the bottom center seam of regular slotted corrugated cartons. The USA 20-SB is manually adjustable to a wide range of carton sizes (see Carton Size Capacity, page 12). The self-centering Side Belt Drive system makes carton width adjustment effortless. The USA 20-SB Carton Sealer features mirror image controls to facilitate its adaption into an existing conveyor line.

SAFETY ISSUES

There are a number of safety labels used on Interpack Carton Sealers. These labels are placed at different locations (refer to figure 2) on the machine to warn operators and service personnel of possible dangers. Please read the labels on the machine and the following safety precautions before using the machine.

- ✓ **Read this manual for other important safety operating and service information.**
- ✓ **Only trained personnel are to operate and service machine.**
- ✓ **Wear safety glasses.**
- ✓ **Shut off power to machine before adjusting.**
- ✓ **Unplug electrical power before servicing.**
- ✓ **All covers and guards must be in place before operating.**
- ✓ **Stay clear of moving parts which can shear and cut.**
- ✓ **Never operate the Tape Heads with the Knife Guard removed.**
- ✓ **Turn electrical supply off before servicing the Tape Heads, including tape loading and threading.**

SAFETY ISSUES

PLACEMENT OF WARNING LABELS

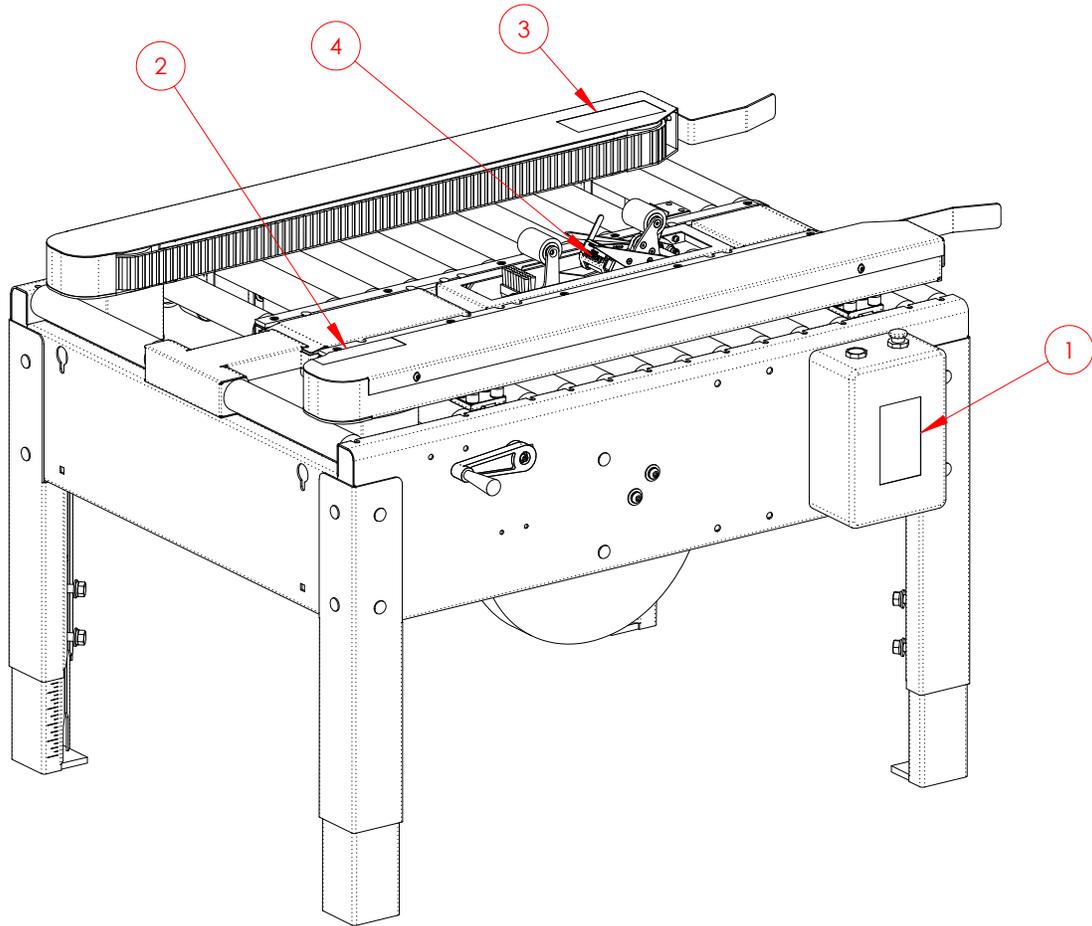


Figure 2

4)

⚠ WARNING

Sharp
Cutting
Blade

(The same label can be found on the top tape head as well)

1)



⚠ DANGER
HAZARDOUS VOLTAGE
Follow lockout procedures before servicing machine or electrical enclosures.
Contact with live electrical parts will result in

1)

⚠ WARNING

OPERATION / SERVICE

- Only trained people are to operate and service machine.
- Shut off power to machine before adjusting.
- Unplug electrical power before servicing.

MACHINE MANUAL

For other important safety, operating and service information read this machine's manual.

EYE HAZARD
Wear Safety Glasses which conform to ANSI Std. Z87.1 or EN 166



COVERS AND GUARDS

All covers and guards must be in place before operating machine.

ELECTRICAL SHOCK
Hazardous voltages may cause personal injury.

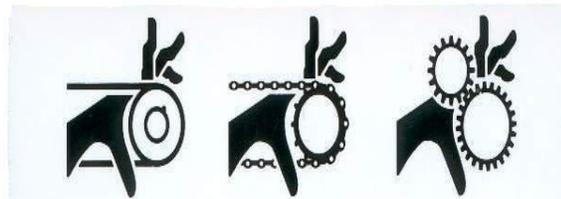


Only authorized and qualified personnel are to service electrical enclosures.

FAILURE TO FOLLOW THE ABOVE COULD RESULT IN SEVERE INJURY.

3)

⚠ WARNING



Moving machine parts can crush, cut and shear.
Disconnect and lockout all power before servicing machine.
Failure to follow the above can result in severe personal injury.

2)



Note: Should any of the safety labels shown in Figure 2 be damaged or destroyed, replacements are available.

SPECIFICATIONS

Machine Dimensions

Overall outside dimensions:

- Height: 33 ½ inches maximum
- Length: 51 inches
- Width: 41 ¼ inches

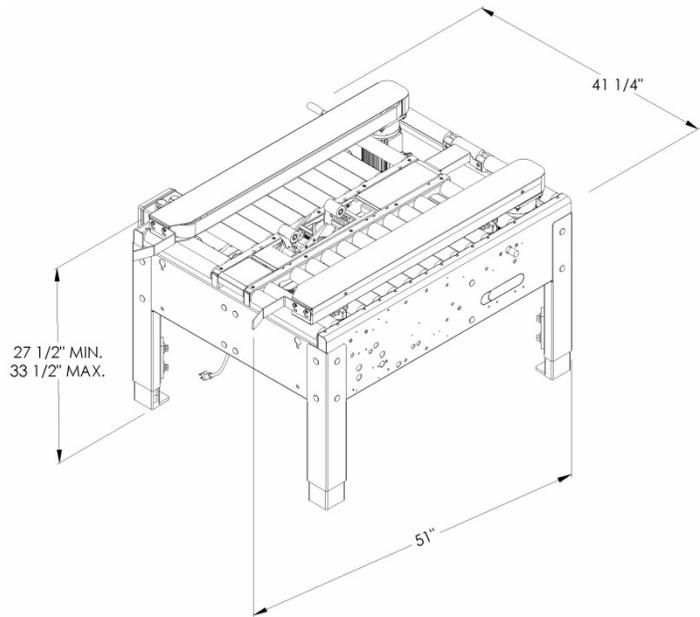


Figure 3

Machine Weight

The machine weighs 384 lbs.

Power Requirements

Electrical - 115 V, 60 HZ, 6 A.

Standard electrical equipment:

- Two (2) 1/3 H.P. gear motors,
- A neoprene power cord, and
- A grounded plug.

Contact your Intertape representative for power requirements not listed above.

Operating Speed

Belt speed is 82 feet per minute. Actual production rate is dependent on operator's dexterity and the case size mix.

SPECIFICATIONS

Operating Conditions

Use in a dry, relatively clean environment at 40° to 105° F (5° to 40° C) with clean dry cartons.

Tape

1) General

Use Intertape brand Pressure Sensitive Carton Sealing Tape.

2) Tape Width

1.5 to 2 inch wide tape (36 to 48 mm) maximum.

3) Tape Roll Diameter

Maximum of 16 inches (405 mm) on a 3-inch (76.2 mm) diameter core. (Accommodates all Intertape brand film tape machine roll lengths).

4) Tape Application Leg Length – Standard

2.5 inches (+0.25", -0") (63.5 mm, +6.3 mm, - 0 mm).

5) Tape Application Leg Length – Optional

2 inches (+0.25", -0.5") (50.8 mm, +6.3 mm, -12 mm). Refer to HSD® 2000 Tape Head manual for adjustment of tape application leg length.

Box Board

Style: regular slotted containers (RSC)
125 to 275 psi bursting test, single or double wall B or C flute.

Carton Weight Capacity: Up to 85 lbs.

SPECIFICATIONS

Carton Size Capacity

	Height (inches)	Width (inches)	Length (inches)
Standard (2") <i>minimum</i>	2	3 ½	6
<i>maximum</i>	Infinite	20	Infinite

	Height (inches)	Width (inches)	Length (inches)
Standard (3") <i>minimum</i>	2	4 ½	6
<i>maximum</i>	Infinite	20	Infinite

SET-UP PROCEDURES

Receiving and Handling

The machine is shipped to the customer in a box and fixed to a pallet.

- Remove the strapping and the staples at the bottom of the box.
- Lift off the box cover and sleeve.
- Remove the mounting bolts and nuts, which secure the USA 20-SB to the shipping pallet.
- Lift the machine off the pallet and install it on your packaging line.
- Remove all tie wraps and other shipping materials.

Note: *After unpacking the machine, look for any damage that may have occurred during shipping. Should the machine be damaged, file a claim with the transport company and notify your Intertape representative.*

Setting-up

1) General

The Carton Sealer must be installed on a near level ground.

Ensure that the machine is level and firmly on the ground (no rocking). Adjust the rollers' height with the four (4) telescopic adjustment legs to accommodate conveyor heights from 24 to 30 inches.

To adjust the Carton Sealer height, jack up the machine to give ample room to extend the legs. Using a 9/16" box end wrench, loosen the eight (8) 1/2" hex head bolts. Adjust the legs to the desired conveyor height and tighten the bolts. Etched scales on the legs facilitate proportionate leveling.

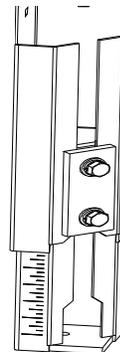


Figure 4

SET-UP PROCEDURES

Customer supplied feed and exit conveyors (or rollers) must be level with the machine, otherwise, the performance of the machine may be affected. The customer-supplied feed conveyor (if used) should provide straight and level entry. The customer-supplied exit conveyor (if used) should be straight and declined no more than 1/4 inch per foot away from the machine.

2) Electrical Connection

The electrical control can be located on either side of the Carton Sealer for customer convenience. It contains the green "on" push button and the red "E-Stop" mushroom push button, which is to be used both for emergency stops as well as regular halting of the machine.

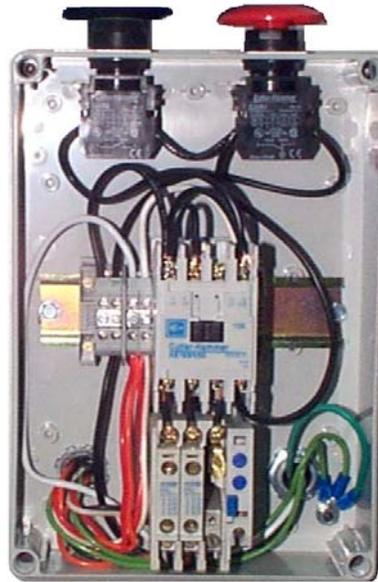


Figure 5

An eight (8) foot strand three phase power cord with plug is provided for 115 V, 60 Hz, 15 Ampere electrical current. The servicing receptacle must be properly grounded. Before the machine is plugged into the receptacle, ensure that all materials are removed from the machine. The electrical control is protected with an automatic circuit breaker with resettable overload.

SET-UP PROCEDURES

3) Width Adjustment Handle

The foldable handle that is used to adjust the width of the self-centering side rails is located on the left hand side of the machine. Unscrew and change sides.

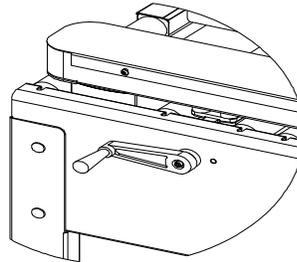


Figure 6

4) **Tape Loading and Threading**

A) Tape Loading

WARNING! *TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT THE POWER CORD FROM THE ELECTRICAL SUPPLY BEFORE BEGINNING TO WORK ON THE TAPE HEADS OR TO LOAD TAPE. IF POWER CORDS ARE NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.*

The HSD®2000-ETII - 48 tape heads accommodate 2-inch wide tape rolls, while the optional HSD®2000-ETII - 75 tape heads accommodate 3-inch wide rolls. See the label on the side of the HSD®2000-ETII tape head for the loadable tape sizes.

Push the roll of tape onto the mandrel with the adhesive side up (refer to threading diagram on the HSD®2000-ETII tape head) until the core is set against the mandrel flange. This ensures the tape will be aligned when feeding into the tape head.

SET-UP PROCEDURES

B) Tape Threading

WARNING! *THE KNIFE CONTAINED IN THE TAPE HEAD IS EXTREMELY SHARP. USE CAUTION WHEN REMOVING THE BLADE GUARD AND THREADING THE TAPE TO AVOID PERSONNEL INJURY.*

To thread the Tape Head, no special tools are required.

-
- Remove the Tape Head by grasping the tape application rollers and lifting straight up.
- Pull approximately twelve (12) inches from the roll and fold in half lengthwise. This allows you to thread the tape without it adhering to the guide and clutch rollers inside the Tape Head.
- Follow the tape-threading diagram on the side plate of the HSD® 2000-ETII Tape Head. Refer to your Tape Head manual for further information if required.
- Turn the blade guard away from the knife in the Tape Head.
- Cut off the folded tape.
- Replace the lower Tape Head to its initial position.

OPERATING INSTRUCTIONS

Once the HSD® 2000-ETII Tape Heads (both bottom and top) have been loaded with tape and threaded, the machine is ready to process regular slotted cartons. The following instructions are presented in the order recommended for processing cartons successfully through the USA 20-SB Carton Sealing machine.

1. Turn the Width Adjustment Handle to open the drive base in order to allow an empty test carton to slide on the machine
2. Place an empty test carton with the flaps held in closed position onto the conveyor rollers.
3. Adjust the self-centering drive belts by turning the Width Adjustment Handle.
4. Remove the test carton from the machine.
5. Ensure that the electrical power is on.
6. Switch the machine "on" with the start push button.
7. Process the first carton with the flaps in the closed position.
8. When the carton exits the Carton Sealer, process the next carton.

WARNING! **ENSURE THAT THE OPERATOR'S HANDS ARE AWAY FROM THE MOVING BELTS OF THE SIDE DRIVE BASE ASSEMBLY.**

Note: *Should any problem occur during processing that requires halting the machine, press the red "E-Stop" mushroom button.*

Note: *The machine should never be washed down or subjected to conditions causing condensation on components.*

MAINTENANCE

Depending on usage, grease acme shaft about in three months intervals.

Open up drive base by winding handle, apply grease to the acme shaft between the cast iron drive base supports, then close the drive base and repeat application to the outside of cast iron drive base supports. Recommended lubricants are: 1st Beacon 325 (ESSO brand), 2nd graphite base greases, 3rd standard ball-bearing grease.

Spray column shaft once a month with silicon based dry film lubricant. This won't attract dust and lint from the surroundings.

No other lubrication is necessary to operate the machine.

TROUBLESHOOTING

Interpack Carton Sealers are fabricated with high quality components that provide trouble-free operation for a long period. However, should a problem occur, we recommend that you consult the following table. If the problem you encounter is not discussed in this table, call Intertape Customer Service Department (see page 2 of this document).

TROUBLE	POSSIBLE CAUSES	SOLUTIONS
Main power is turned "on" and nothing happens.	Overload protection by circuit breaker.	Check that all circuits are "on".
Cartons are not taped properly.	Tape Head is not adjusted correctly.	Refer to Tape Head manual.

RECOMMENDED SPARE PARTS LIST

We recommend that you stock the following spare parts.

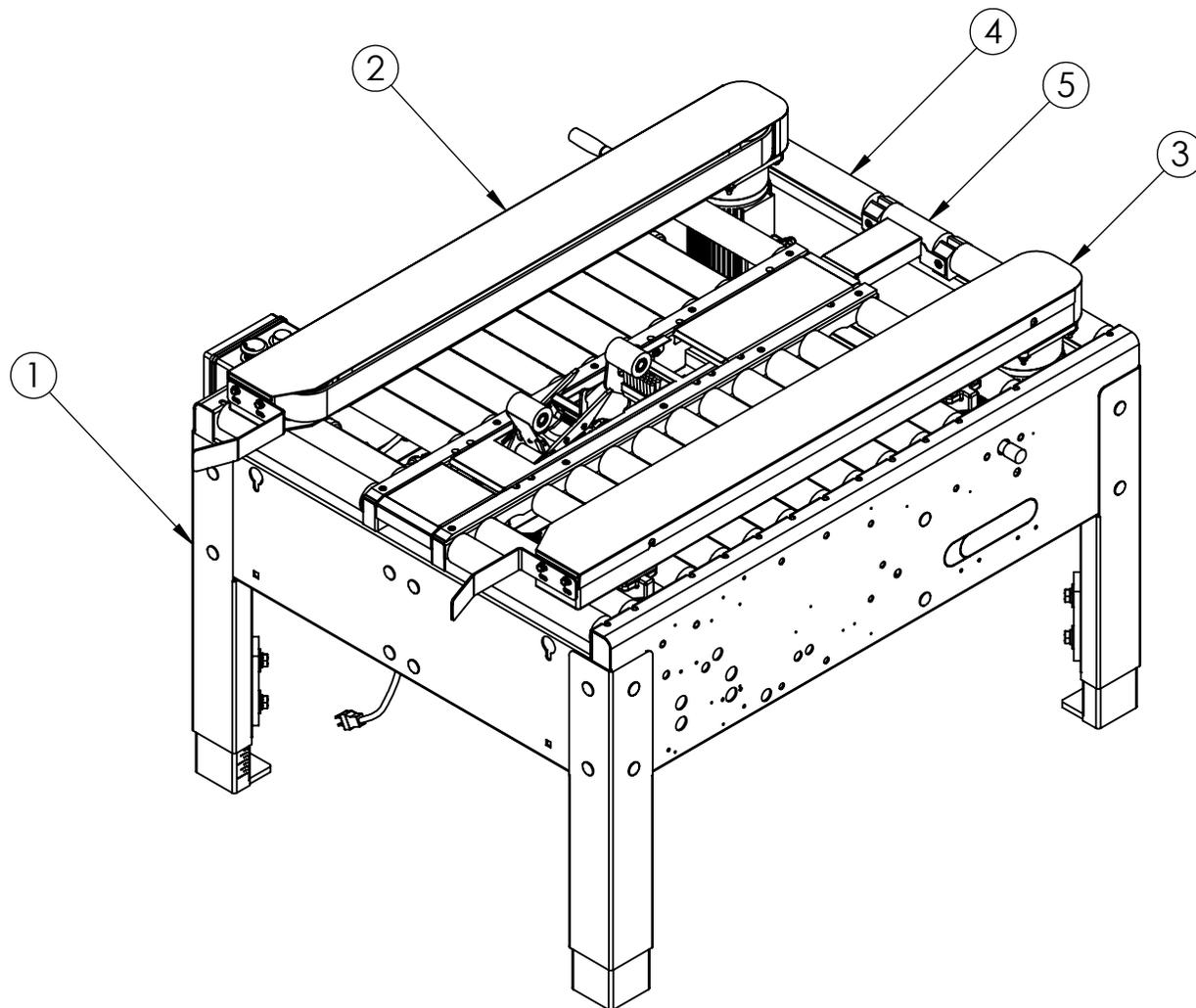
DESCRIPTION	ITEM NUMBER	RECOMMENDED QUANTITY
Bearing Pulley	UPM0324	2
Bumper	UPM0576	8
Belt Endl.Sag 12E, 2" X 83"	UPM0663	2

APPENDIX A – ILLUSTRATIONS AND PARTS LISTS

APPENDIX CONTENTS

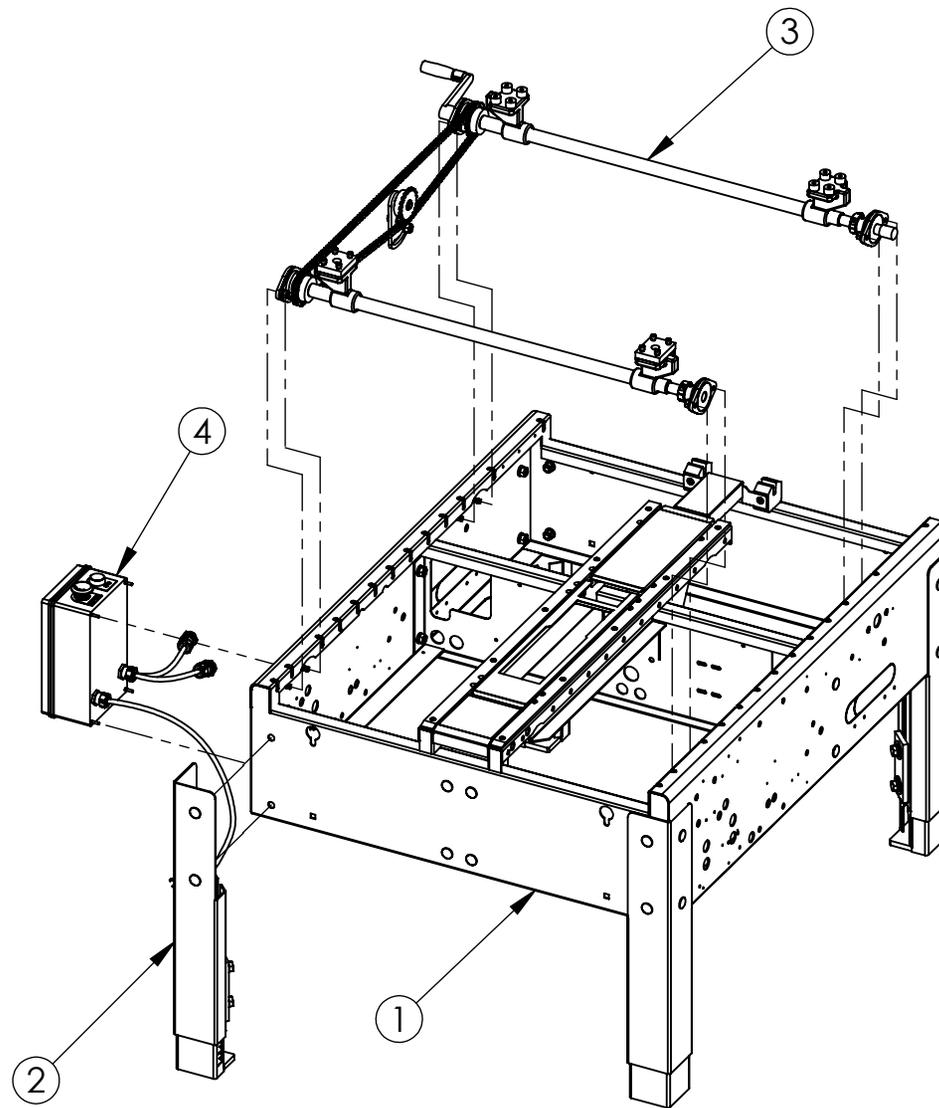
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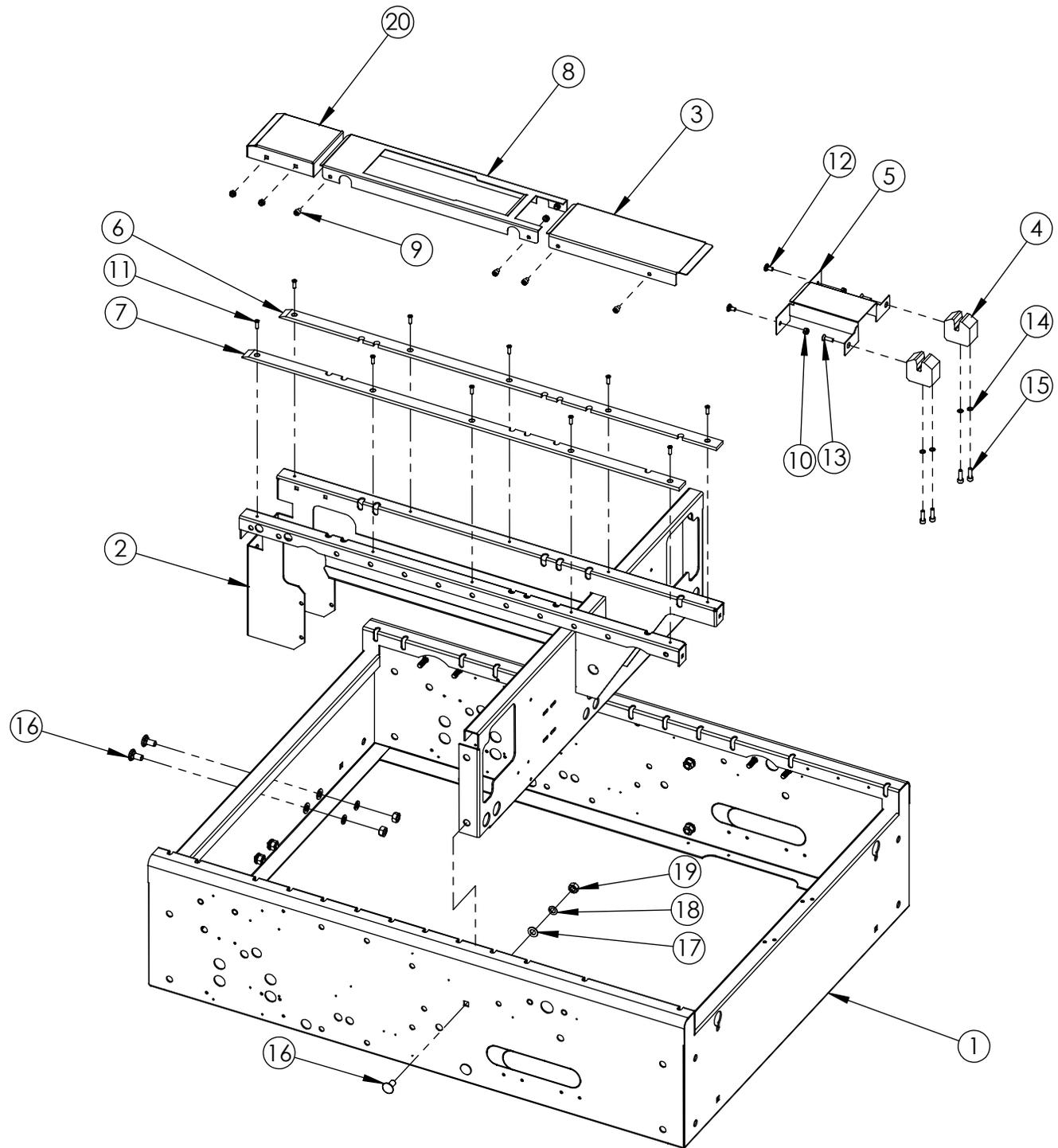


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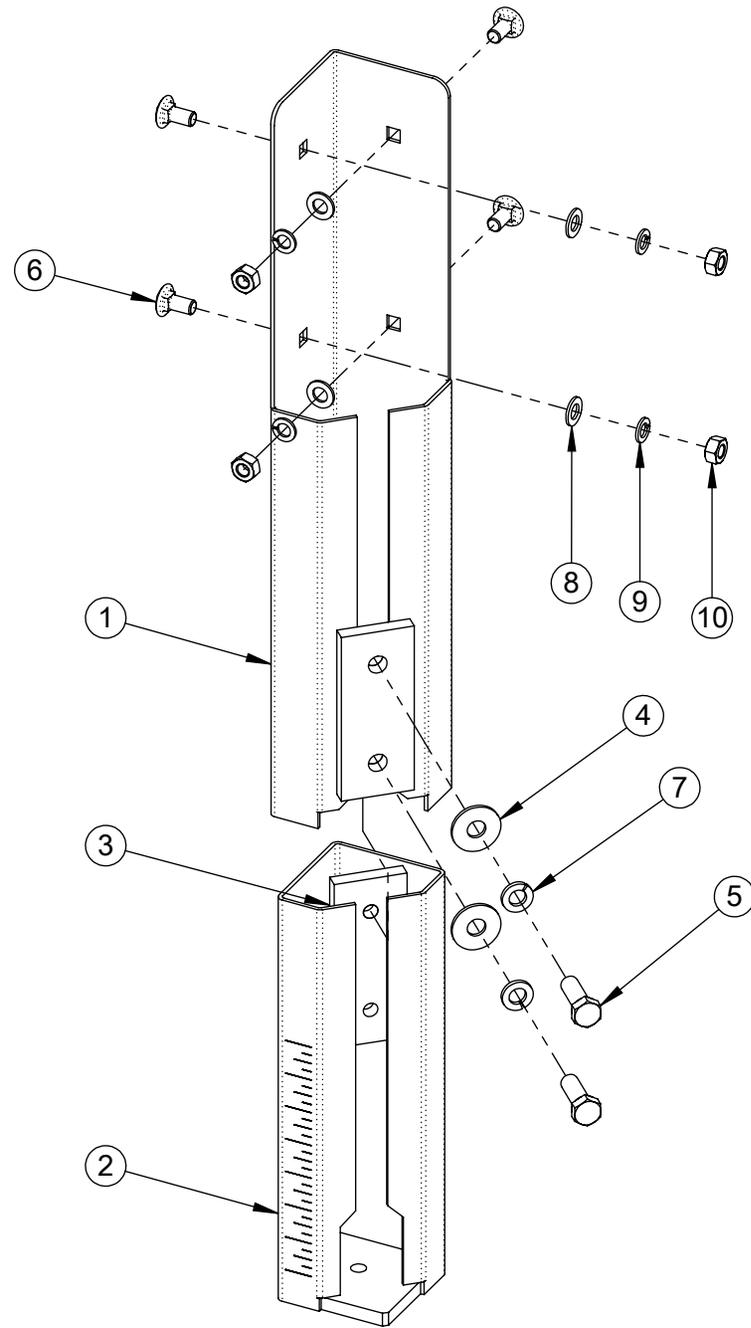
ITEM	PART #	DESCRIPTION	QTY.
1	USM6115	BASE ASSEMBLY	1
2	USM0812	DRIVE BASE ASS'Y LH	1
3	USM0811	DRIVE BASE ASS'Y RH	1
4	UPM3227	PVC ROL CHARCOAL DIA 1.9 X 4.50	1
5	UPM3226	PVC ROL CHARCOAL DIA 1.9 X 12.00	26



ITEM	PART #	DESCRIPTION	QTY.
1	UAM0328	BASE SUB-ASS'Y	1
2	UAM0275	LEG ASSEMBLY METRIC	4
3	USM6111	DRIVE CENTRING ASS'Y	1
4	USM0817	ELECTRICAL ASSEMBLY	1

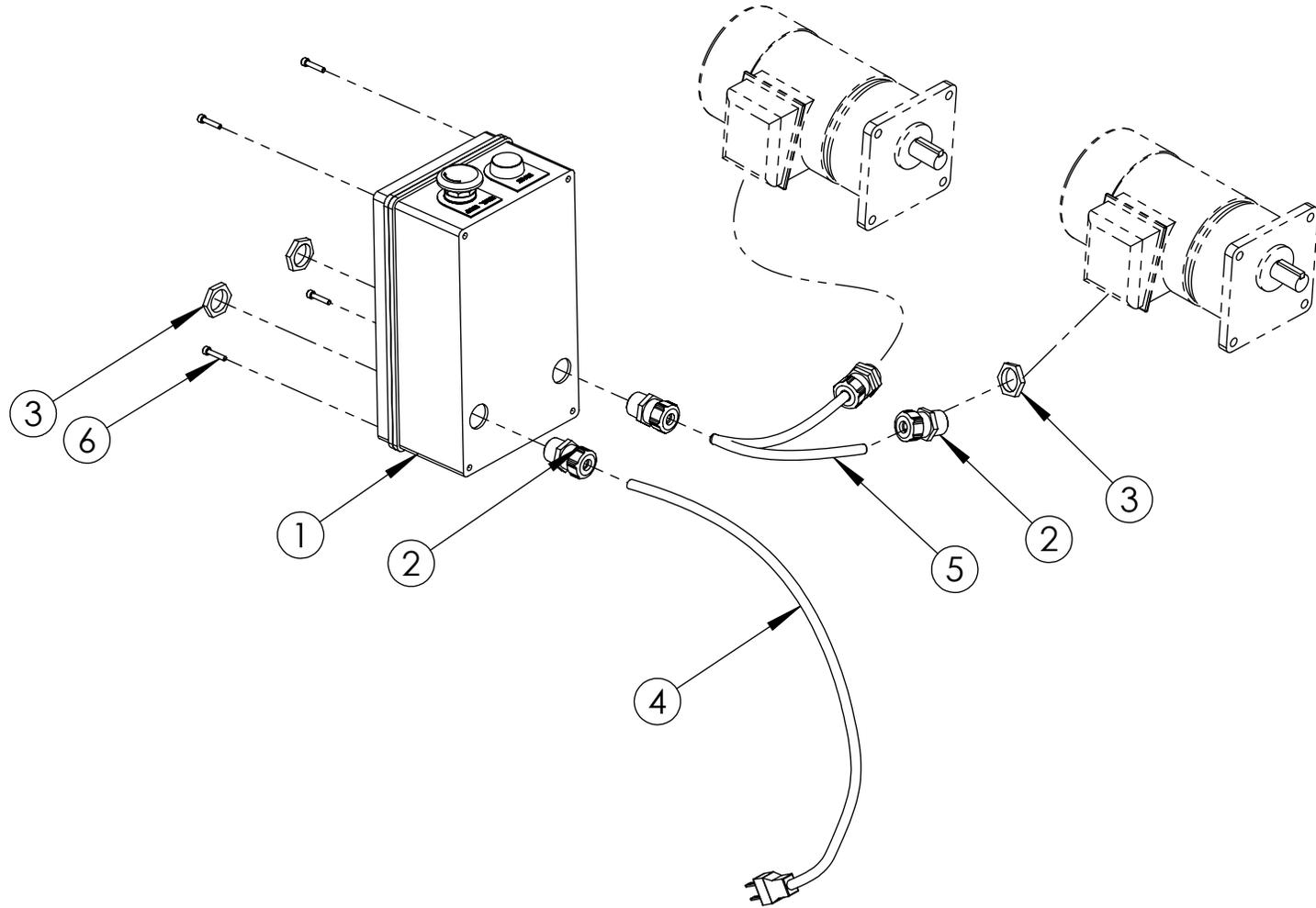


ITEM	PART #	DESCRIPTION	QTY.
1	UPM3287EV	OUTSIDE FRAME	1
2	UPM2522EV	TRANSVERSE BRACING	1
3	UPM4193	REAR GAP FILLER	1
4	UPM3234EV	OUTLET ROLLER BLOCK	2
5	UPM3288EV	OUTLET COVER USA SB	1
6	UPM0609EV	SLIDING PAD L.H.	1
7	UPM0606EV	SLIDING PAD R.H.	1
8	UPM3815	T.H. INSERT 2"	1
9	UF3170	SS SHCS M6-1 x 8mm	8
10	UF3391	SS NYLON LOCK NUT M6-1.0	14
11	UF4114	SELF TAPPING SCREW M5 x 16mm	10
12	UF3745	SS CARRIAGE BOLT M6-1 x 12mm	6
13	UF5402	FHCS M6 - 1 x 20	2
14	UF6411	SS LW M6	4
15	UF0835	SHCS M6-1 X 20mm	4
16	UF4229	CARRIAGE BOLT M10-1.5 x 20	8
17	UF3680	FW M10	8
18	UF6371	LW M10	8
19	UF6314	HNR M10 x 1.5	8
20	UPM3229	INLET COVER	1

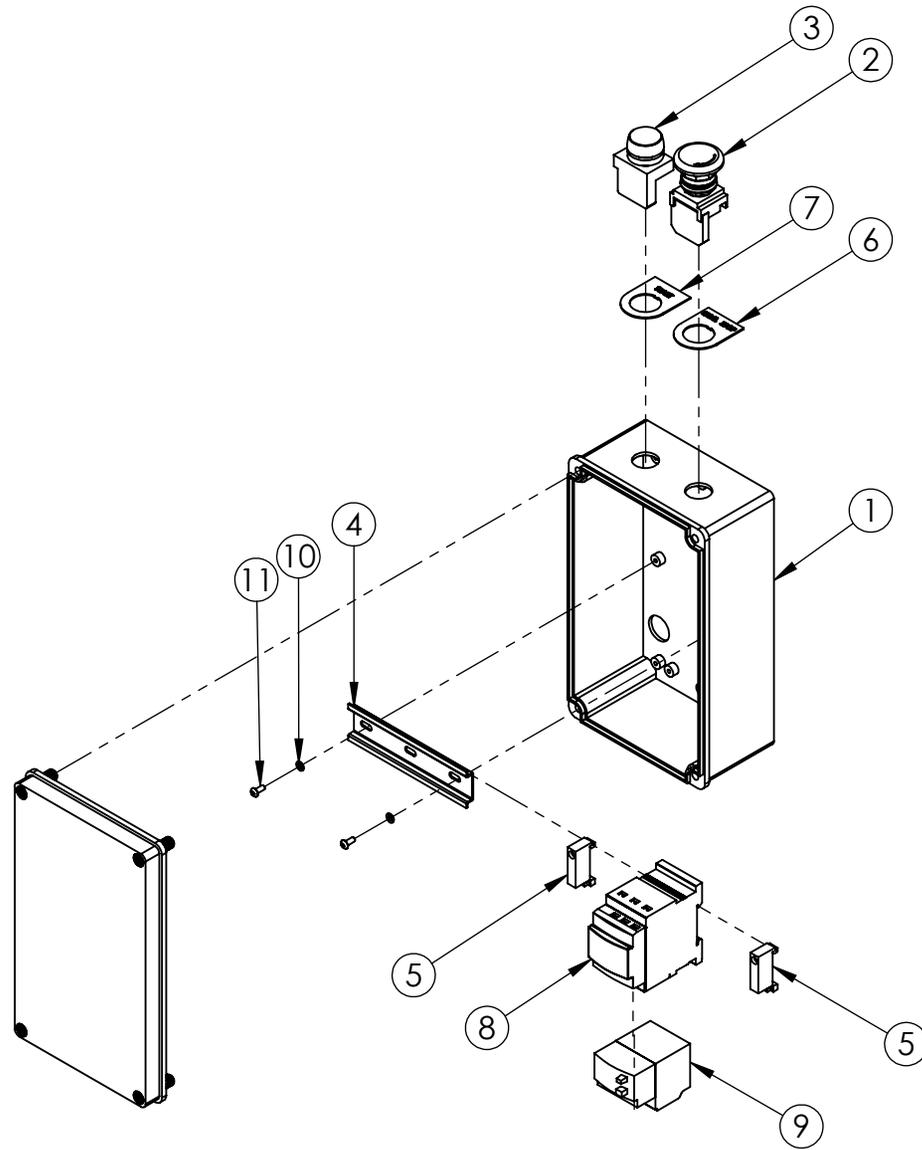


ITEM	PART #	DESCRIPTION	QTY.
1	UPM7640	LEG WELDMENT	1
2	UPM7641	LEG ADJUSTMENT	1
3	UPM7642	LEG FRICTION PLATE	1
4	UF4231	FW M12	2
5	UF6393	HHCS M12-1.75 x 35mm	2
6	UF4229	CARRIAGE BOLT M10-1.5 x 20	4
7	UF4230	L.W. ZINC M12	2
8	UF3680	FW M10	4
9	UF6371	LW M10	4
10	UF6314	HNR M10 x 1.5	4

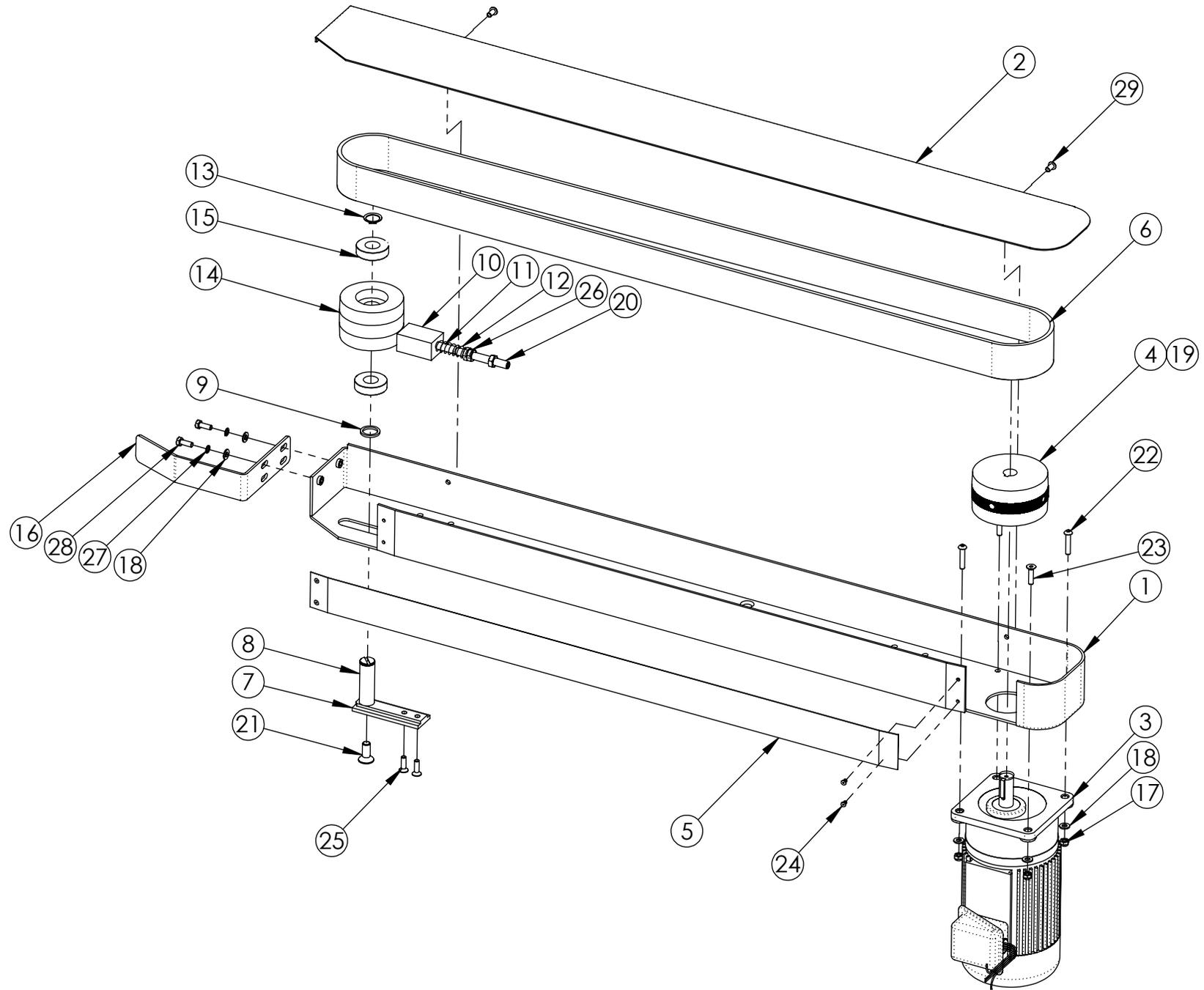
ITEM	PART #	DESCRIPTION	QTY.
1	UPM0618	CHAIN #35-165 PITCH	1
2	UPM7583	SHAFT COLLAR	2
3	UF6371	LW M10	2
4	UF6382	HHCS M10-1.5 x 25 mm	2
5	UF6314	HNR M10 x 1.5	2
6	UF3680	FW M10	4
7	UPM3242	DRIVE SUPPORT SPACER	2
8	UPM0576	BUMPER	8
9	UF0840	SHCS M6-1 X 25mm	1
10	UF1828	FW M6	1
11	UF2210EV	SQUARE KEY ROUND ENDS 5 X 5 X 20	1
12	UPE0001EV	CRANK HANDLE, FOLDABLE	1
13	UPM0620	SPROCKET 35B20.75ID C/W 3/16 KW	3
14	UPM0575EV	CASTING LH	2
15	UPM0574EV	CASTING RH	2
16	UPM0573EV	Acme Shaft, No Handle TW	1
17	UPM0566EV	Acme Shaft For Handle TW	1
18	UPM2207	CAP VINYL BLACK	1
19	UF2210	SQUARE KEY, ZINC .188 x .188 x .75	2
20	UF0640	SHCSHK 1/4-20 X 1-1/4"	8
21	UPM2198	BEARING SPACER	4
22	UPM0523EV	FLANGE BEARING	4
23	UF0866	HNR M8 - 1.25	8
24	UF0867	LW M8	8
25	UPM0631EV	TENSIONNER BRACKET	1
26	UPM0640EV	TENSIONNER PIN	1
27	UPM0641	CHAIN TENSIONNER SPACER	1
28	UF5402	FHCS M6 - 1 x 20	1
29	UPM0639EV	SLEEVE BEARING 12 mmID 3/4OD 3/4LG	1
30	UF2170	1/2" RETAINING RING	1



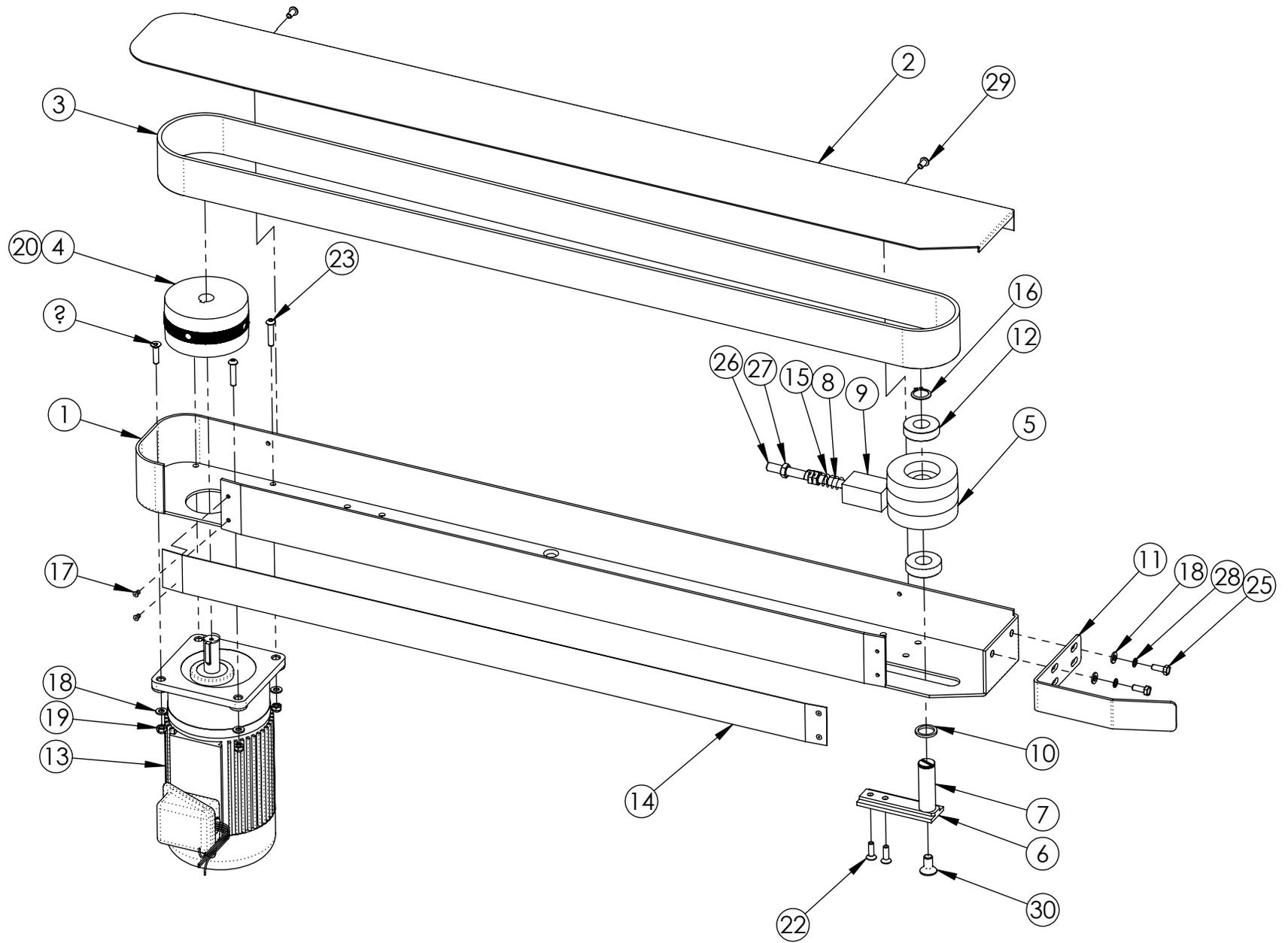
ITEM	PART #	DESCRIPTION	QTY.
1	UAM0264	ELECTRIC CONTROL BOX	1
2	UPM0197EV	STR.RELF METL.LIQDTGHT M20X1.5 (8-10mm)	4
7	UPM5031	LOCKNUT M20 X 1.5(FOR STRAIN RELF)	4
4	UPM0209	POWER CORD, 14/3	1
5	UPM0225	CABLE 18/3 TYPE SJ	2
6	UF3646	SHCS M4-0.7 x 20	4



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM7527	ENCLOSURE DEMEX HIBOX 132 X 232	1
2	UPM2211	BUTTON MUSHROOM 22mm 1 N.C.	1
3	UPM2212	BUTTON GREEN 22mm 1 N.O.	1
4	UPM0407EV	DIN RAIL USA 2324	1
5	UPM7440EV	TB END ANCHOR FOR DN SER	2
6	UPM2209EV	LEGEND PLATE "E-STOP"	1
7	UPM2210EV	LEGEND PLATE "START"	1
8	UPM7524	MOTOR STARTER TELEMEC 110VAC	1
9	UPM2213EV	MOTOR O/L TELEMEC 2.5-4.0A	1
10	UF3710	FW M4	2
11	UF6365	BHCS M4 x 0.7 x 10mm	2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM3283EV	DRIVE BASE LEFT SIDE	1
2	UPM3281EV	DRIVE BASE COVER LH	1
3	UPM7116	MOTOR 1/3HP 21.4 : 1	1
4	UPM0129EV	DRIVE PULLEY 50mm	1
5	UPM0029	STRIP UHMW 2" X .03"THK	1
6	UPM0663	BELT ENDLESS 50mm x 2108 mm	1
7	UPM1879EV	TENSIONNER SLIDE	1
8	UPM1233EV	IDLER PULLEY SHAFT 50mm	1
9	UPM0109	IDLER PULLEY SPACER	1
10	UPM0101EV	TENSIONNER SPRING HOLDER	1
11	UPM0112	SPRING LOCATOR PIN	1
12	UPM0038	DIE SPRING (DRIVE BASE)	1
13	UF2220	EXT RET'G RING 3/4" SHAFT	1
14	UPM0259	IDLER PULLEY	1
15	UPM0324	BEARING, PULLEY	2
16	UPM0647	CARTON RETAINER	1
17	UF5900	NYLON LOCK NUT M6-1.0	4
18	UF1828	FW M6	6
19	UF3683	SSS M6 X 10mm	2
20	UF1400	SSS HK 3/8-16 X 3	1
21	UF1191	FHCS M10-1.5 x 25	1
22	UF3711	BHCS M6-1 x 30mm	3
23	UF1194	FHCS M6 - 1 x 25 mm	1
24	UF2080	POP RIVET S-44	4
25	UF5402	FHCS M6 - 1 x 20	2
26	UF1610	HNJ 3/8-16	3
27	UF6363	LW M6	2
28	UF0454	HHCS M6-1.0 X 16mm	2
29	UF1195	BHCS M6-1 x 12 mm	2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM3282EV	DRIVE SECTION, RIGHT SIDE	1
2	UPM3280EV	DRIVE BASE COVER RIGHT SIDE	1
3	UPM0663	BELT ENDLESS 50mm x 2108 mm	1
4	UPM0129EV	DRIVE PULLEY 50mm	1
5	UPM0259	IDLER PULLEY	1
6	UPM1879EV	TENSIONNER SLIDE	1
7	UPM1233EV	IDLER PULLEY SHAFT 50mm	1
8	UPM0112	SPRING LOCATOR PIN	1
9	UPM0101EV	TENSIONNER SPRING HOLDER	1
10	UPM0109	IDLER PULLEY SPACER	1
11	UPM0647	CARTON RETAINER	1
12	UPM0324	BEARING, PULLEY	2
13	UPM7116	MOTOR 1/3HP 21.4 : 1	1
14	UPM0029	STRIP UHMW 2" X .03"THK	1
15	UPM0038	DIE SPRING (DRIVE BASE)	1
16	UF2220	EXT RET'G RING 3/4" SHAFT	1
17	UF2080	POP RIVET S-44	4
18	UF1828	FW M6	6
19	UF5900	NYLON LOCK NUT M6-1.0	4
20	UF3683	SSS M6 X 10mm	2
30	UF6397	FHCS M10-1.5 x 20mm	1
22	UF5402	FHCS M6 - 1 x 20	2
23	UF3711	BHCS M6-1 x 30mm	3
24	UF1194	FHCS M6 - 1 x 25 mm	1
25	UF0454	HHCS M6-1.0 X 16mm	2
26	UF1400	SSS HK 3/8-16 X 3	1
27	UF1610	HNJ 3/8-16	3
28	UF6363	LW M6	2
29	UF1195	BHCS M6-1 x 12 mm	2