



Operations Manual

Eagle T550RL Carton Sealer



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

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1. Safety and Warnings



WHILE OPERATING THE EAGLE 550RL, OPERATORS MUST REFRAIN FROM WEARING CLOTHING OR ACCESSORIES THAT MAY GET CAUGHT IN THE MOVING PARTS OF THE MACHINE (WATCHES, RINGS, BRACELETS, TIES, LOOSE CLOTHING, ETC...)

The Eagle 550RL was designed for the purpose of sealing the top and bottom flaps of a carton. While operating the machine, the operator should ensure the machine is clear of any previously sealed cartons prior to continued use of the machine. Additionally, the operator must ensure that cartons are within acceptable weight limits to ensure proper feed through the machine.

Prior to setting up the machine

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

Prior to operating the Eagle 550RL, verify

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

The Eagle 550RL is designed to automatically shut down if the control panel is opened while the machine is in operation.



DO NOT USE EAGLE 550RL TO SEAL CARTONS CONTAINING HAZARDOUS SUBSTANCES OR EXPLOSIVE MATERIALS

2. Specifications

Power Requirement	110/220VAC, 50/60Hz (Single Phase)
Sealing Force	5kg/cm ²
Sealing Speed	21m/min
Max. Carton Weight	88lbs (40kg)
Tape Width	2-3in (48-72mm)
Carton Length	5.9in to infinite (150mm to infinite)
Carton Width	8.66-18.90in (220-480mm)
Carton Height	5.90-17.72in (150-450mm)
Machine Length	62.91in (1,598mm)
Machine Width	35.83in (910mm)
Machine Height	34.65in (880mm) [adjustable]
Weight	331lbs (150kg)
Operational Environment	32-104°F (0-40°C) @ ≤ 98% Humidity
Machine Noise Levels	≤ 75db

3. Machine Setup and Installation



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

3.1 Transportation

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

3.2 Working Height Adjustment

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

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

3.3 Tape Head Installation

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

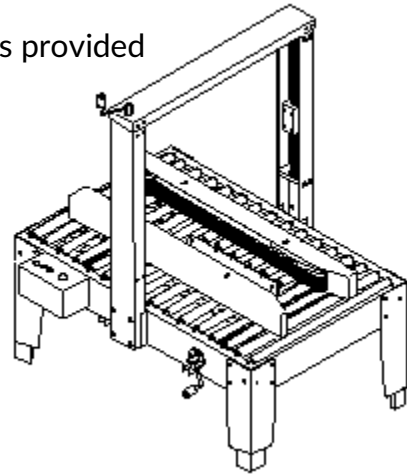
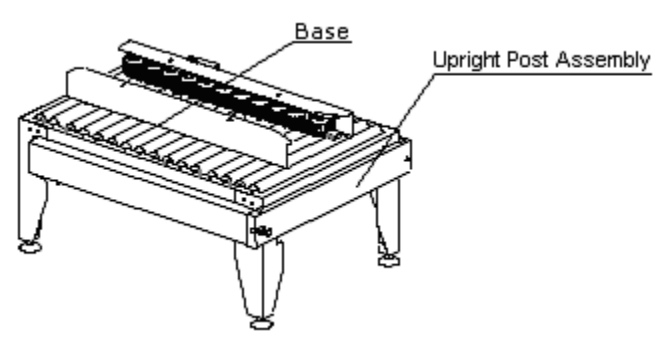


Check tape cutter position and adjust as needed.

3. Machine Setup and Installation

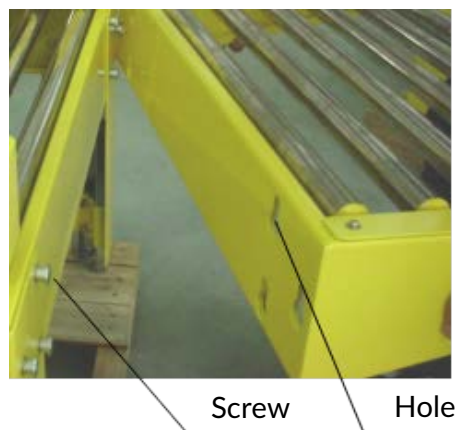
3.4 Upright Post Assembly

Attach upright post assembly to the base frame with the screws provided



3.5 Extension Table Installation

Align the holes in the extension with the posts in the frame and carefully lower the table extension.



3.6 Connect Power Supply

Connect the machine to the power supply.

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

4. Operation

4.1 Standard Operation

Prior to operating the machine, please confirm that

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

Machine Operation

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

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

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



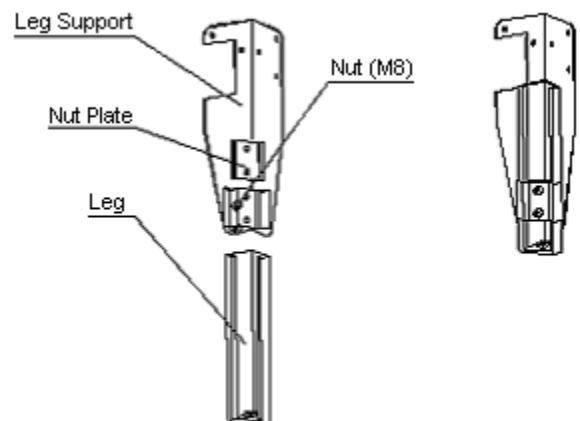
TURN OFF MACHINE AND DISCONNECT IT FROM THE POWER SOURCE PRIOR TO PERFORMING ANY MAINTENANCE OR SERVICE

4.2 Adjustable Work Height

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

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

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

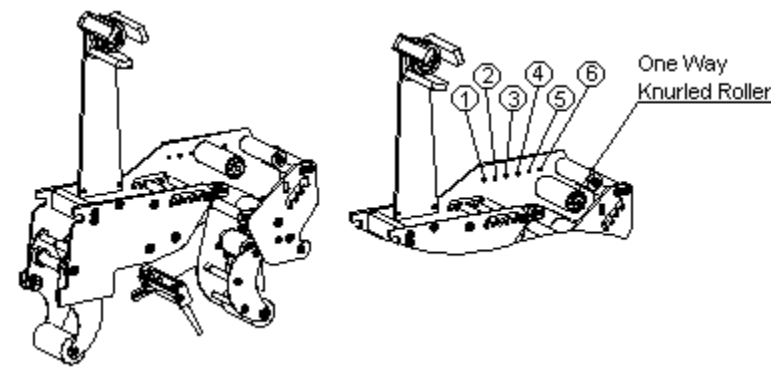


4. Operation

4.3 Feeding Adhesive Tape



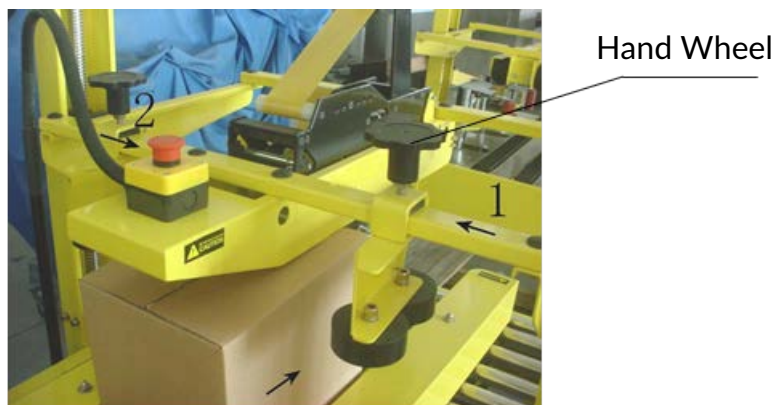
4.4 Adjusting Tape Length



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

4.5 Top Box Squeezer Adjustment

Loosen the knobs and move each top box squeezer in the direction of the arrows 1 and 2, keeping the rollers close to the case tighten the knobs.



5. Maintenance and Troubleshooting



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

5.1 Regular Maintenance & Cleaning

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

5.2 Lubrication

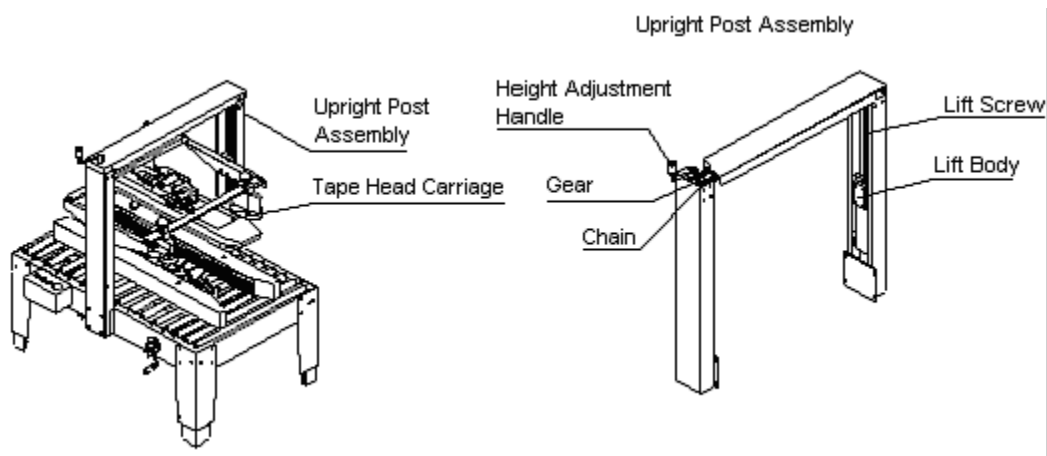
1. The driving chain should be lubricated once a month.
2. The bearings should be lubricated once a month.
3. The transmission axle, driving chain and bearing should be lubricated once a week.
4. All other moving parts should be lubricated on a regular basis.

5. Maintenance & Troubleshooting

5.3 Carriage Height Adjustment

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

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



5.4 Typical Faults & Solutions

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

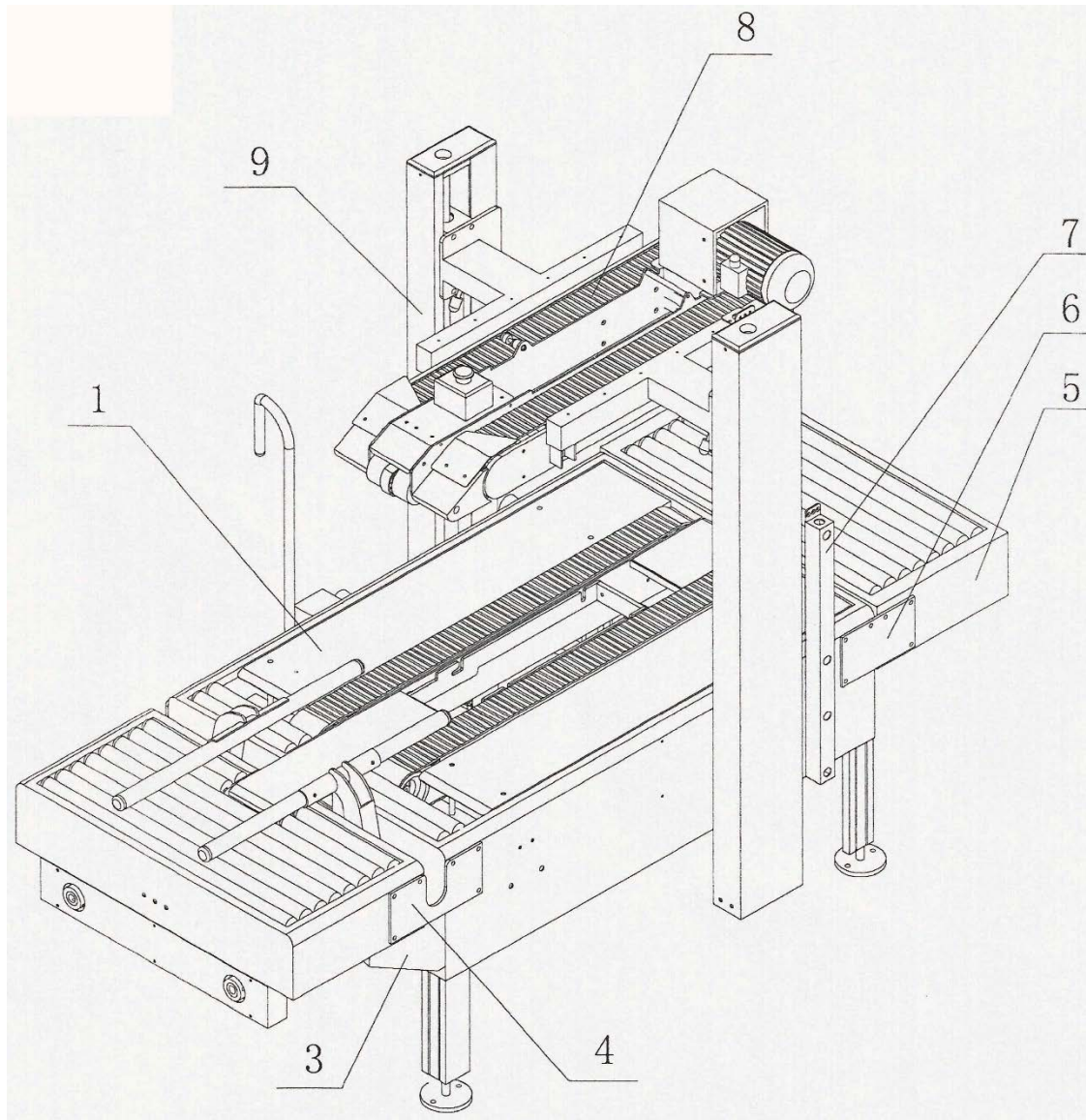
6. Illustrations & Parts List

6.1 Replacement Parts

	Description	Part Number	Qty
	Belt (Lower)	2070mm	-
	Belt (Upper)	1520mm	
	Chain	06B	
	Wheel	FJ-3A-118	
	Transmission Shaft	FJ-3A-90	
	Drive Wheel	FJ-3A-117	

6. Illustrations & Parts List

6.2 Main Parts



	Description	Part Number	Qty
1	Rack Parts	-	-
2	Guide Member	-	-
3	Support Plate	FJ-2D-30	2
4	Ingress Roller Table Bracket	FJ-2D-29	2
5	Roller Table Extension	FJ-2D-131	1
6	Egress Roller Table Bracket	FJ-2D-130	2
7	Bracket	YS-501-39	1
8	Upper Roller Belt	-	-
9	Vertical Mast	-	-

6.3 Roller / Horizontal Guide



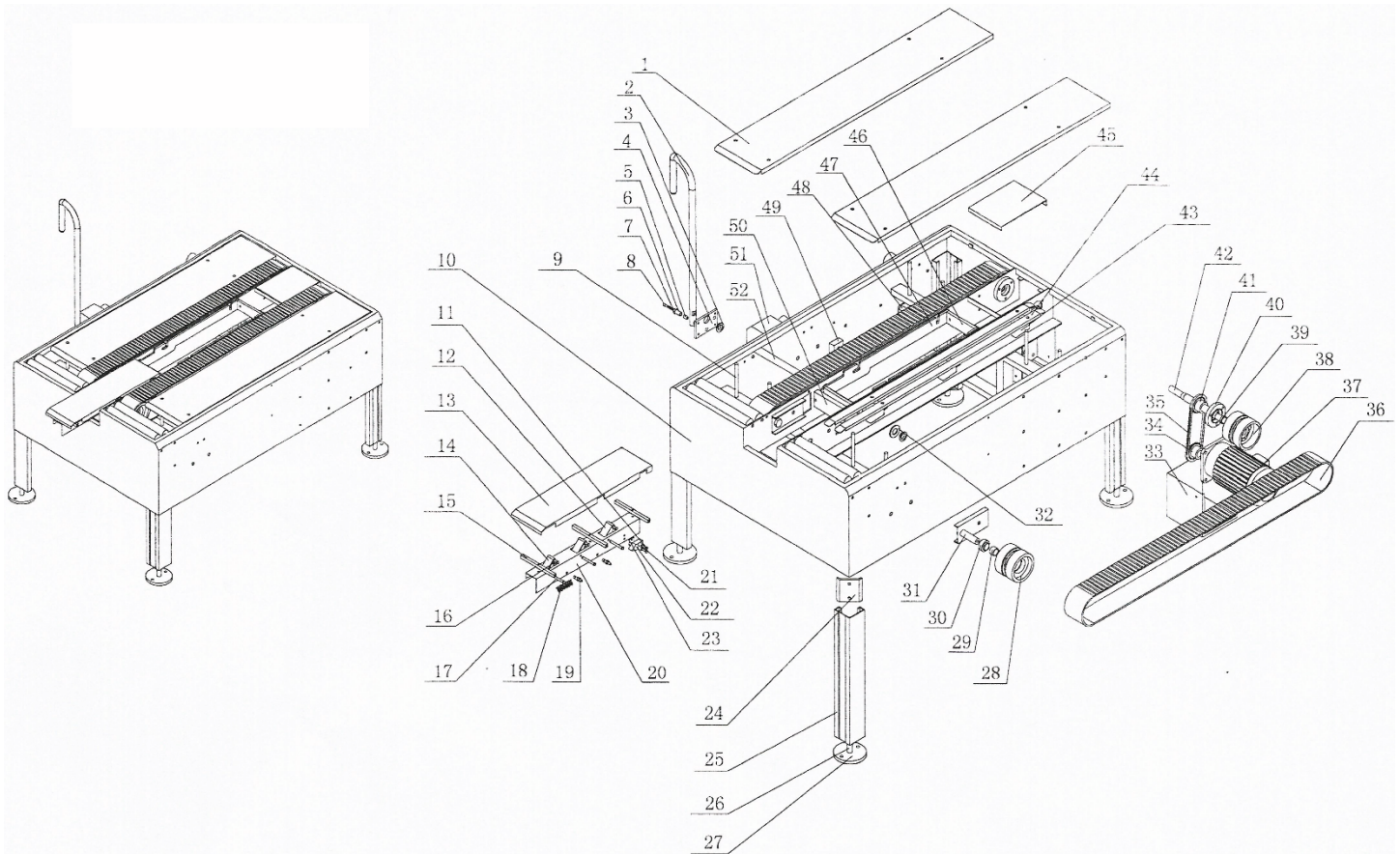
6. Illustrations & Parts List

6.3 Roller / Horizontal Guide (Continued)

12	Shaft	FJ-2D-16	2
13	Linear Bearing	FJ-2D-11	4
14	Collar	FJ-2D-12	2
15	Cover	FJ-2D-10	1
16		FJ-2D-33	1
17		FJ-2D-34	1
18		FJ-2D-35	2
19	Lower Cover	FJ-2D-15	1
20	Valve	-	2
21	Actuator	SC40X160	1
22		FJ-2D-17	1
23	Linear Bearing	FJ-2D-13	2
24	Cover	FJ-2D-10	1
25	Horizontal Guide Bracket	FJ-2D-24	2
26	Horizontal Guide	FJ-2D-31	2
27	Cap	FJ-2D-32	4
28	Bearing	FJ-2D-49	8
29	Bearing	FJ-1A-134	14
30	Roller Guide	FJ-2D-50	8
31	Roller Guide	FJ-2D-59	14
32	Bearing	?	44

6. Illustrations & Parts List

6.4 Frame



	Description	Part Number	Qty
1	Work Table	FJ-2D-59	2
2	Guide	FJ-2D-54	1
3	Washer	FJ-2D-57	3
4	Plate	FJ-2D-52	1
5	Spacer	FJ-1A-90	2
6	Sleeve	FJ-1A-92	2
7	Sleeve	FJ-1A-93	2
8	Bolt	FJ-1A-91	1
9	Pin	FJ-2D-58	8
10	Frame	FJ-2D-36	1
11	Bolt	FJ-2D-64	2
12	Bracket	FJ-2D-68	1
13	Cover	FJ-2D-60	1
14	Sensor	FJ-2D-67	2
15	Bracket	FJ-2D-30	3
16	Sensor Bracket	FJ-2D-71	3
17	Bracket	FJ-2D-72	3

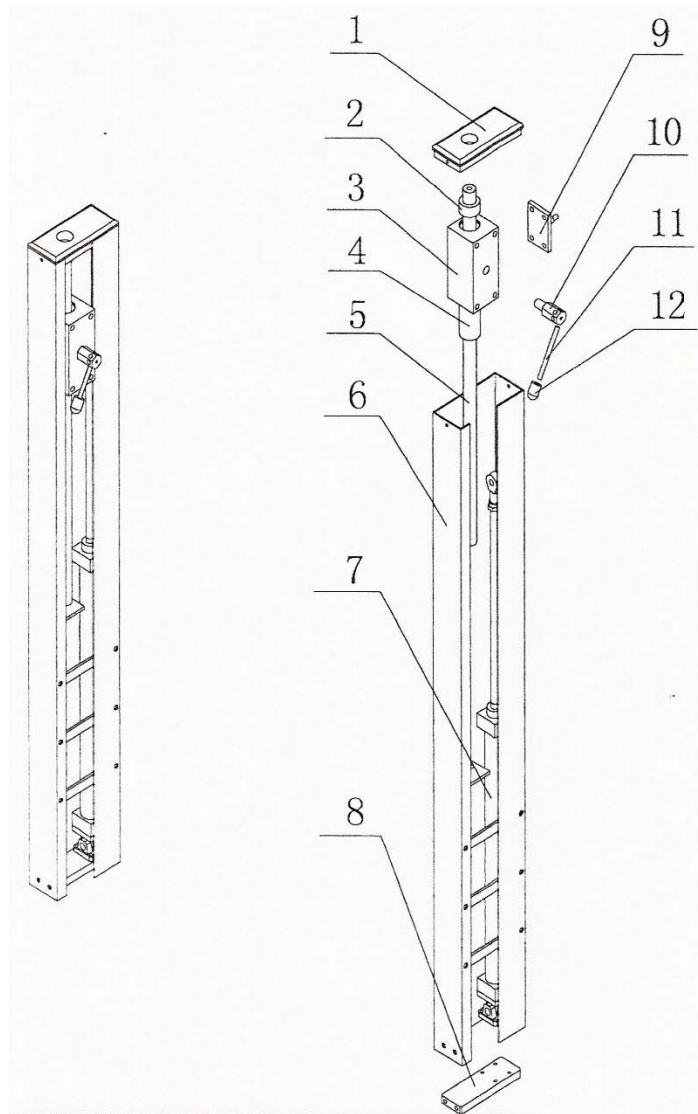
6. Illustrations & Parts List

6.4 Frame (Continued)

18	Spring		2
19	Bolt	FJ-2D-63	2
20	Bracket	FJ-2D-62	1
21	Sensor	FJ-2D-65	2
22	Guide		2
23	Sensor	FJ-2D-66	1
24	Bracket	FJ-1A-119	4
25	Leg	YS-501-12	4
26	Height Adjustment Screw	FJ-1A-115	4
27	Foot	FJ-1A-116	4
28	Drum	25-636-1	4
29	Inner Bearing	FJ-2D-135	4
30	Outer Bearing	FJ-2D-73	4
31	Shaft	FJ-2D-83	4
32	Washer	FJ-2D-53	2
33	Housing	FJ-1A-36	2
34	Sprocket	FJ-1A-128	2
35	Chain		2
36	Lower Belt	2195X73X5	2
37	Motor	CV100-20ZG3	2
38	Drum	25-002-1	4
39	Bearing	FJ-2D-78	4
40	Bearing	FJ-2D-77	4
41	Sprocket	FJ-2D-76	2
42	Shaft	FJ-2D-75	1
43	Bolt	FJ-2D-79	10
44	Rail	FJ-2D-82	4
45	Cover	FJ-2D-85	1
46	Cross Member	FJ-2D-56	2
47	Brace	FJ-2D-51	2
48			1
49	Sensor		1
50	Cross Member	FJ-2D-84	1
51	Control Housing		1
52	Brace	FJ-2D-54	1

6. Illustrations & Parts List

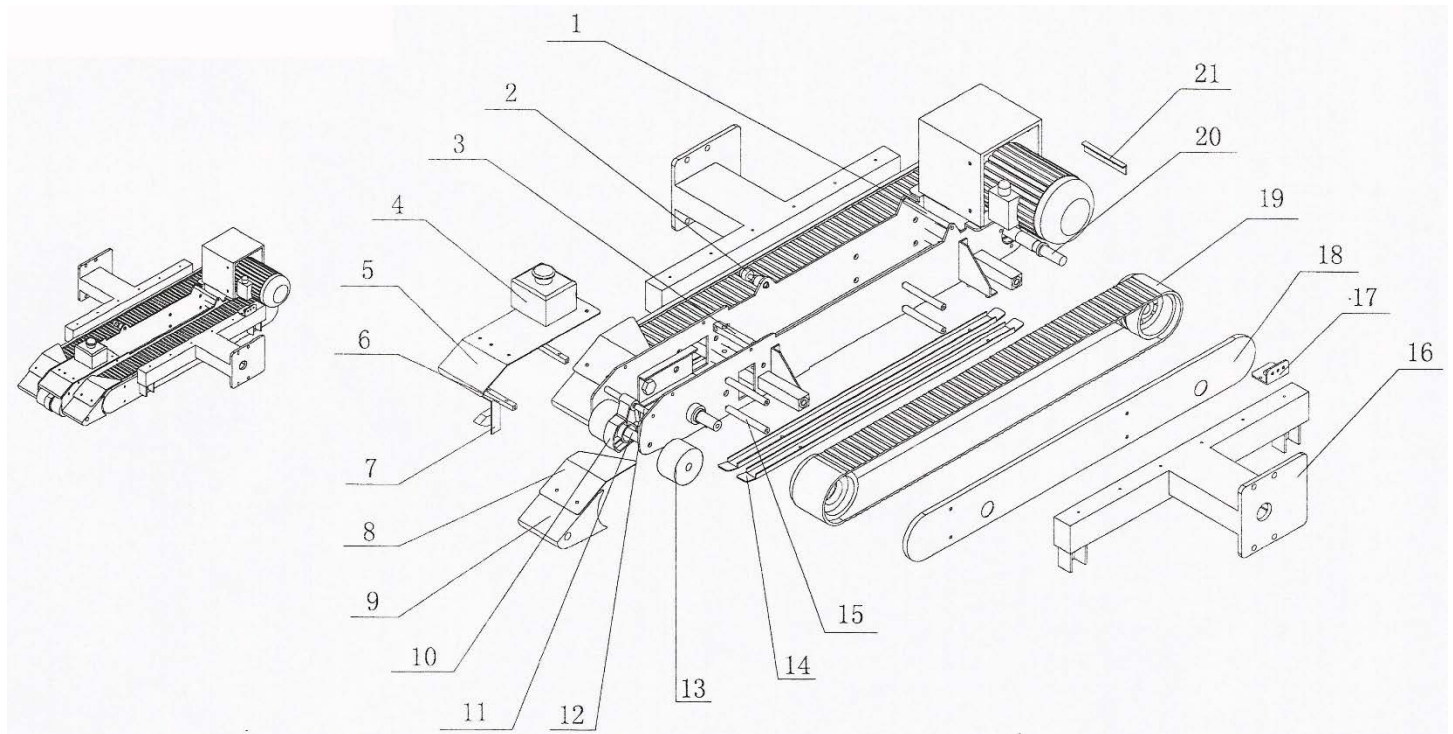
6.5 Vertical Mast



	Description	Part Number	Qty
1	Cap	YS-501X-94	2
2	Bearing	FJ-2D-93	2
3	Lift Body	FJ-2D-92	2
4	Coupler	LM25UU	4
5	Lift Screw	FJ-2D-91	2
6	Body	FJ-2D-86	2
7	Vertical Mast	SC40X500	2
8	Base	FJ-2D-90	2
9	Plate	FJ-2D-95	2
10	Crank	FJ-2D-103	2
11	Crank Handle	FJ-2D-104	2
12	Crank Handle Cap	FJ-2D-105	2

6. Illustrations & Parts List

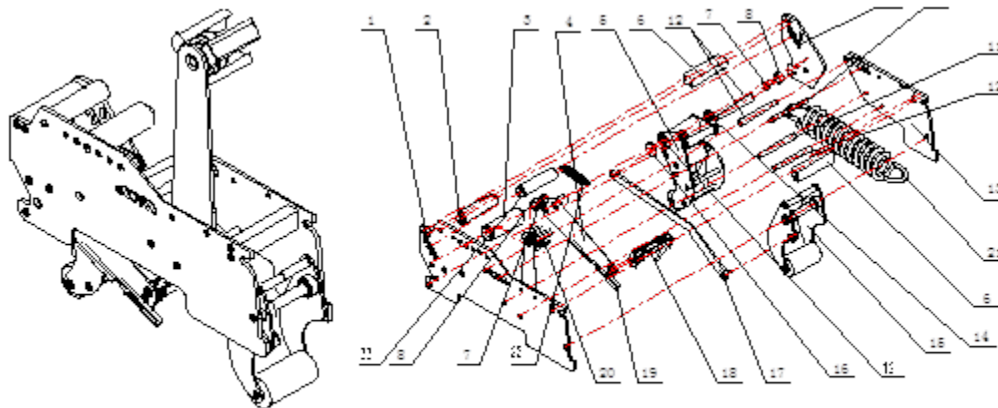
6.6 Upper Belt Assembly



	Description	Part Number	Qty
1	Shaft	FJ-1A-67	1
2	Bolt	FJ-2D-23	1
3	Cross Member	FJ-2D-115	1
4	E-Stop Button Housing		1
5	Cover	FJ-2D-125	1
6		FJ-2D-120	2
7		FJ-2D-124	1
8	Belt Cover	FJ-2D-126	2
9	Belt Cover	FJ-2D-70	2
10		FJ-2D-69	1
11		FJ-2D-122	1
12	Shaft	FJ-2D-121	1
13	Roller	FJ-2D-123	2
14	Lower Guide	FJ-2D-116	4
15	Belt Guide	FJ-2D-114	8
16	Mounting Bracket	FJ-2D-98	2
17	Bracket	YS-501-41	1
18	Side Plate	FJ-2D-113	2
19	Belt	1825X73X5	2
20	Shaft	FJ-2D-112	1
21	Cover	FJ-2D-129	1

6. Illustrations & Parts List

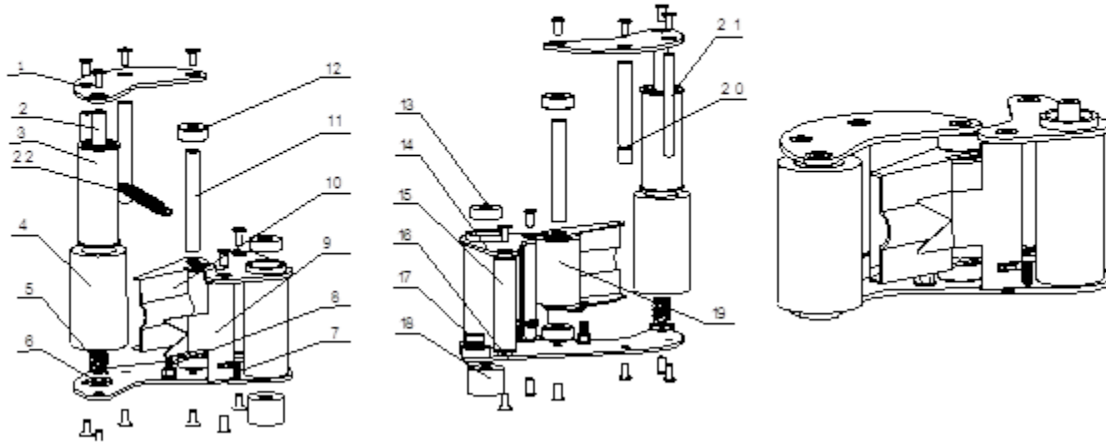
6.7 Tape Head Assembly



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

6. Illustrations & Parts List

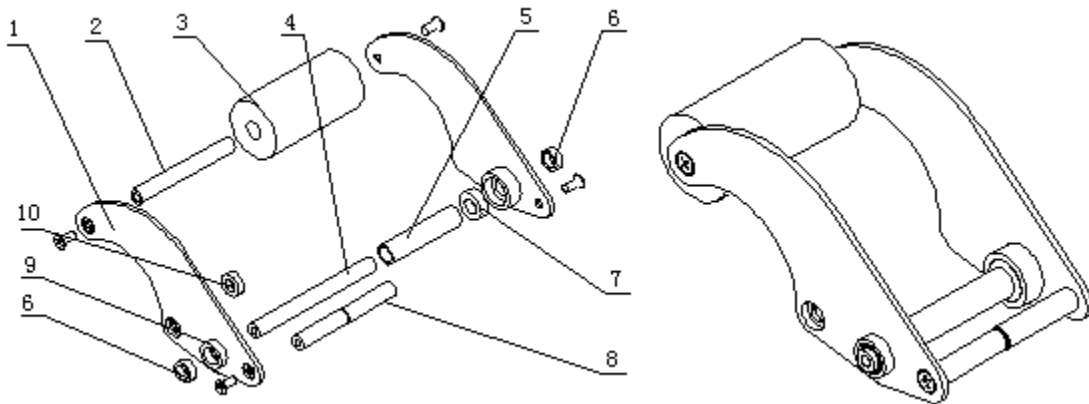
6.8 Front Tape Roller Assembly



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

6. Illustrations & Parts List

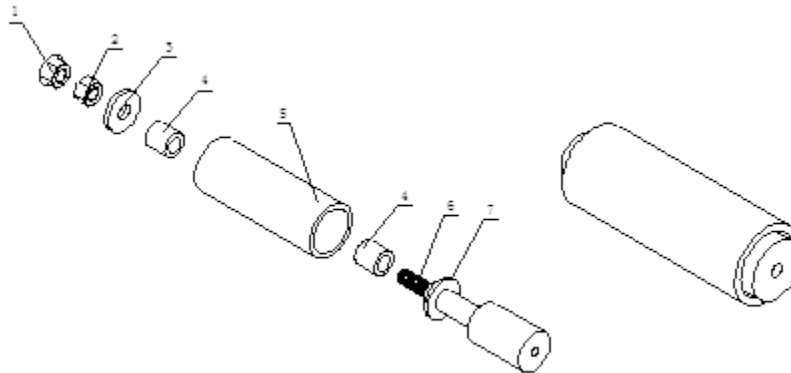
6.9 Back Roller Side Plate Assembly



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

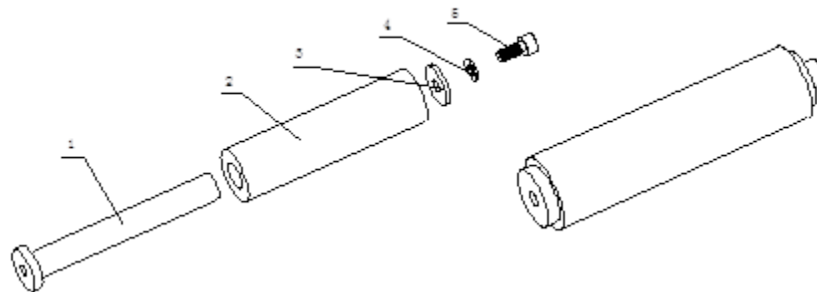
6. Illustrations & Parts List

6.10 Knurled Roller Assembly



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

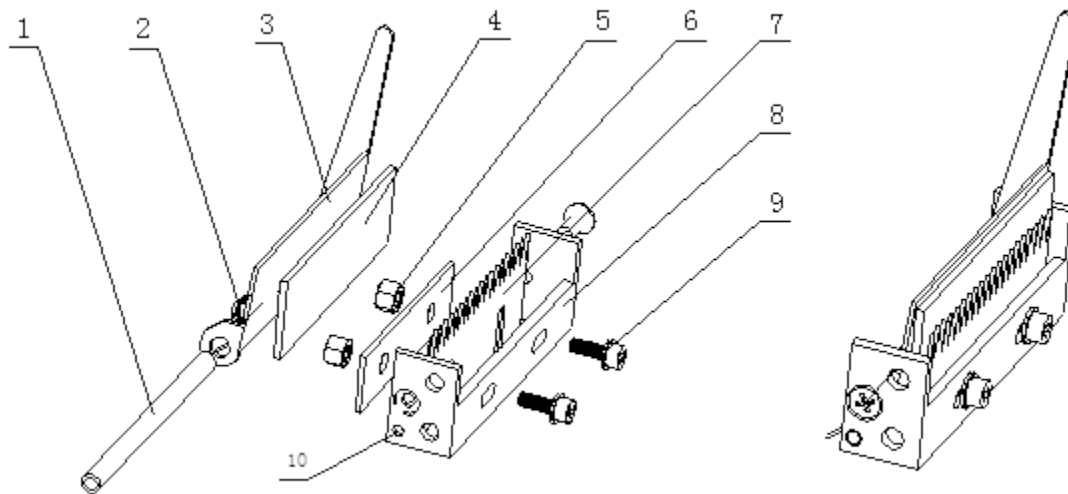
6.12 Guide Pulley Assembly



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

6. Illustrations & Parts List

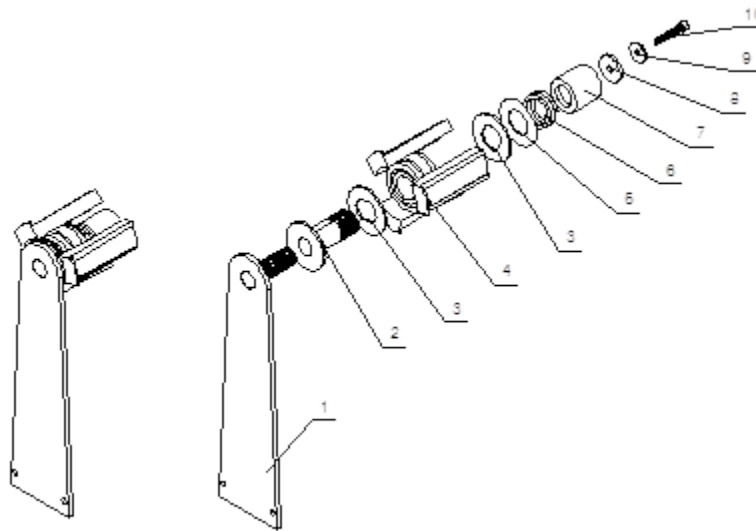
6.12 Knife Back Plate Assembly



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

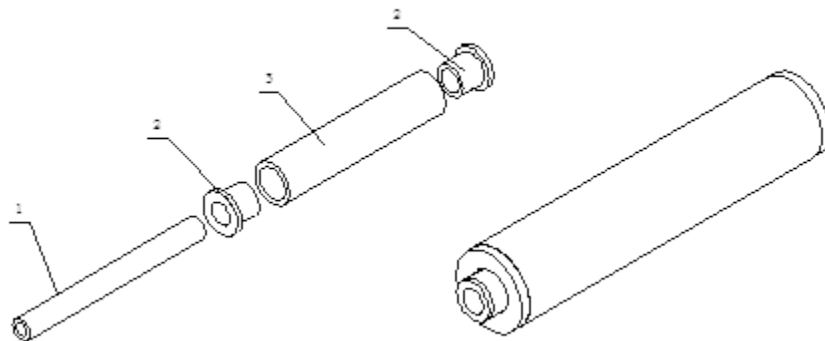
6. Illustrations & Parts List

6.13 Tape Hub Assembly



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

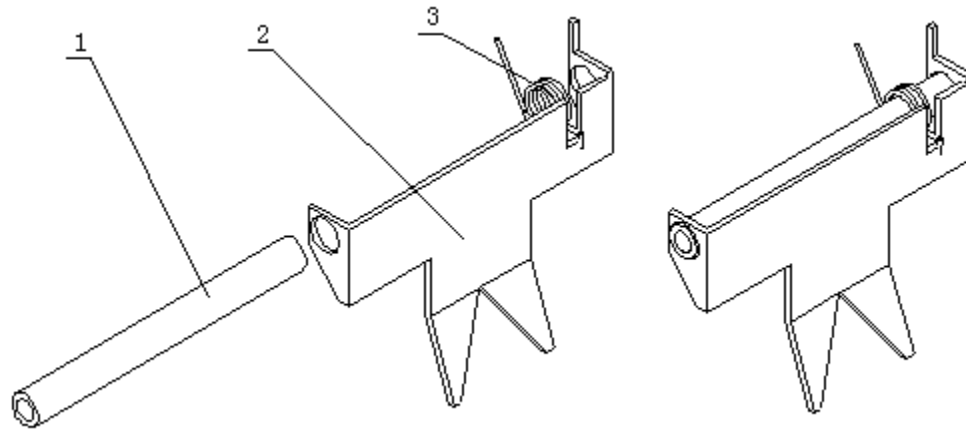
6.14 Guide Tape Wheel Assembly



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

6. Illustrations & Parts List

6.15 Tape Holder Assembly



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