



# Operations Manual

Eagle T200 & T200L Carton Sealer



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

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## 1. Safety and Warnings



**WHILE OPERATING THE MACHINE, 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 T200 & T200L are a uniform automatic case sealing machine using pressure-sensitive tape such as PVC or BOPP.

This machine has a wide range of applications including the following industries: pharmaceutical, publication, refrigeration and air-conditioning, household appliances, ceramics, produce, meats, poultry.

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 T200 & T200L, verify

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



**DO NOT USE TO SEAL CARTONS CONTAINING HAZARDOUS SUBSTANCES OR EXPLOSIVE MATERIALS**

## 2. Specifications

	<b>T200</b>	<b>T200L</b>
Power Requirement	110VAC, 50/60Hz (Single Phase)	110VAC, 50/60Hz (Single Phase)
Sealing Speed	~30 cartons per minute	30 cartons per minute
Max. Carton Weight	88lbs (40kg)	100lbs (45kg)
Tape Width	2-3in (48-72mm)	2-3in (48-72mm)
Carton Length	6in to infinite	6in to infinite
Carton Width	6.75-19.75in	6.75-30in
Carton Height	4.75-19.75in	4.75-30in
Machine Length	43in	43in
Machine Width	35in	
Machine Height	50.3in (adjustable)	
Shipping Weight	558lbs	708lbs
Operational Environment	32-104°F (0-40°C) @ ≤ 98% Humidity	32-104°F (0-40°C) @ ≤ 98% Humidity
Machine Noise Levels	≤ 75db	≤ 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 4 casters on the legs. 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 pin 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.

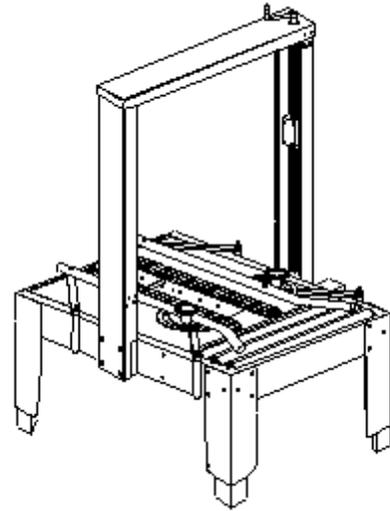
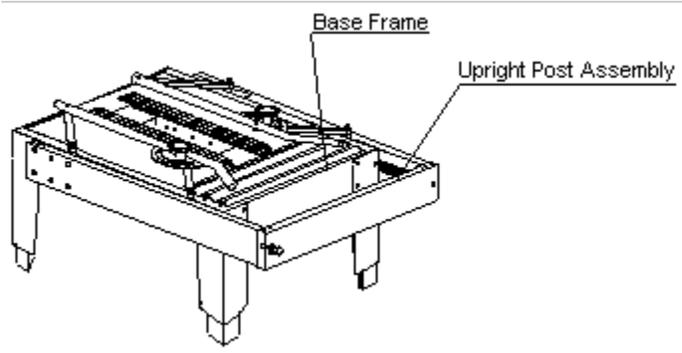


Check tape cutter position and adjust as needed.

### 3. Machine Setup and Installation

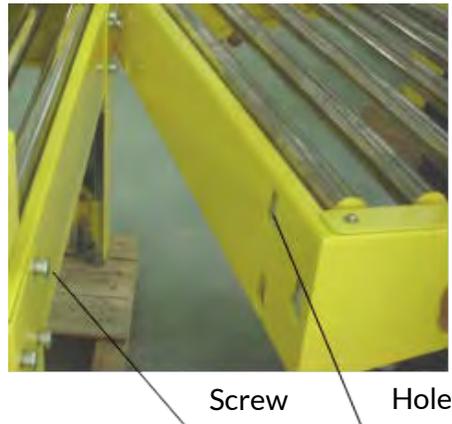
#### 3.4 Upright Post Assembly

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 power is being supplied to the machine (110V)
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 and belts do not have excess slack
  - a. Belt deviation (slack) should be checked once every ten days
  - b. Adjust belt tension as needed
3. Verify that tape is being dispensed in a consistent manner that ensures a smooth application onto the carton being fed through the machine.



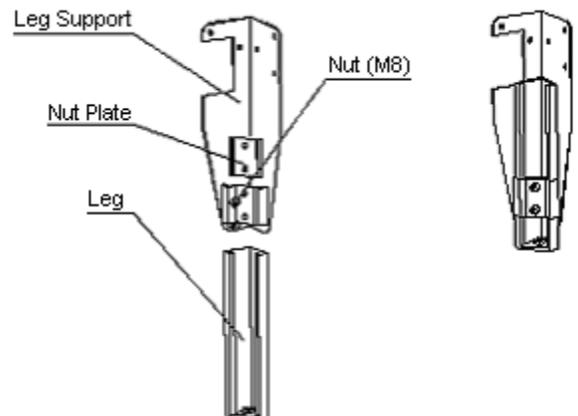
**TURN OFF MACHINE AND DISCONNECT IT FROM THE POWER SOURCE  
PRIOR TO PERFORMING ANY MAINTENANCE OR SERVICE**

### 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.

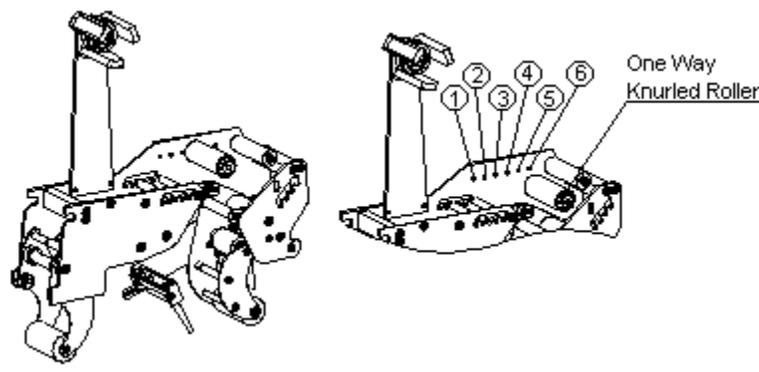


## 4. Operation

### 4.3 Feeding the Adhesive Tape



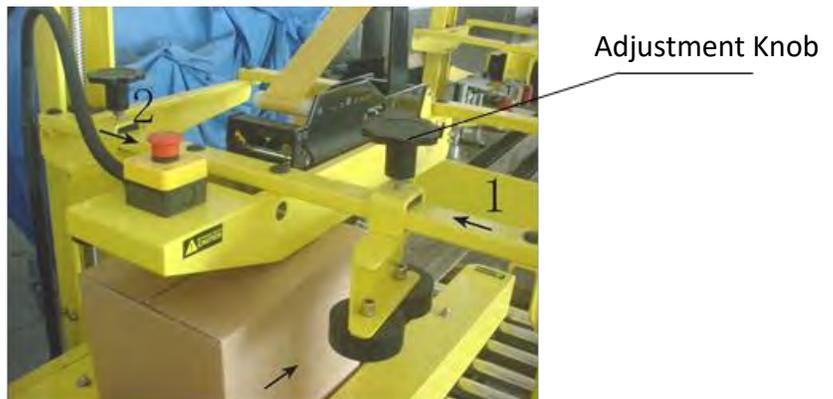
### 4.4 Adjusting Tape Length



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.
- Rollers should touch (aka kiss) the edge of the carton with a little bit of pressure.
- This will help squeeze the gap in between the flaps.
- Top squeezers are mainly used for the over filled cartons.
- Remember to adjust top squeezers when changing carton sizes.



## 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

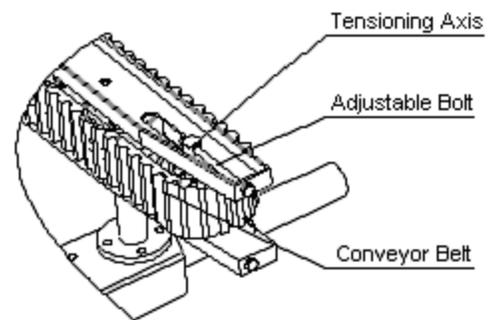
1. Check all bolts and screws regularly to ensure smooth, malfunction-free operation of the machine.
2. Lubricate moving parts of the machine on a regular basis.
3. Clean the machine surfaces.
4. Clean off any tape residue from the cutting blade daily.
5. If the machine is to be stored for an extended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

### 5.3 Conveyor Belt Replacement/Adjustment

1. Unscrew the screws, removing the protective cover of the belt.
2. Loosen the adjustable bolt until the belt becomes loose.
3. Loosen the set screws, removing the upper plate of the side power device.
4. Replace the belt.
5. Roll the belt manually and lead it into a suitable position at the same time.
6. Cover the side power device with the upper plate, tighten set screws and adjustable belts.
7. Determine proper tension of the belt by slightly pulling the middle of the belt and adjust the adjustable bolt



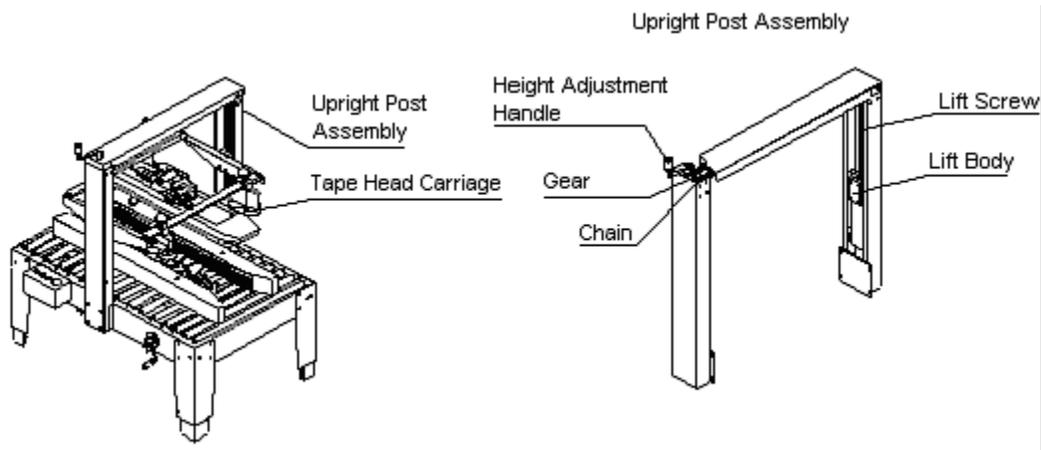
Adjustments are made using the adjustable bolt located at the end of the side conveyor system.

## 5. Maintenance & Troubleshooting

### 5.4 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.



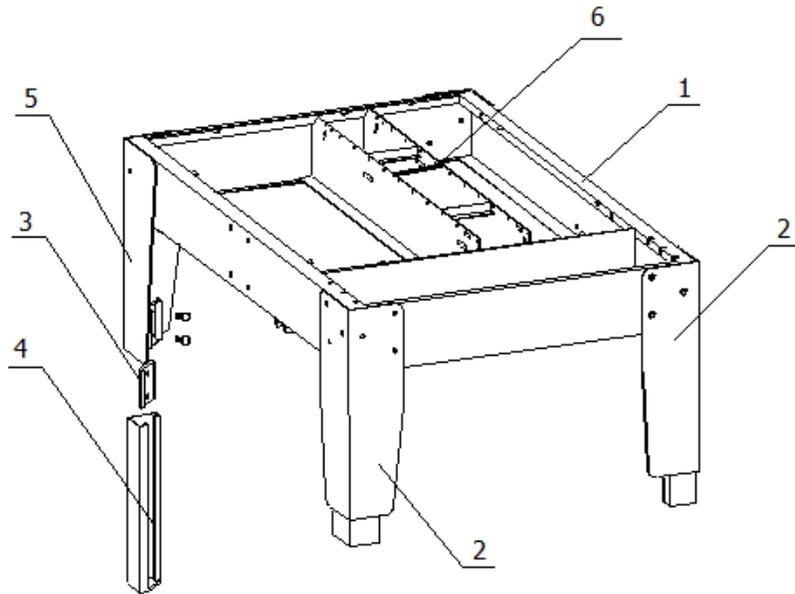
### 5.5 Typical Faults & Solutions

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. Check for proper tape threading.

## 6.1 Main Frame Components

If you have a T200L, please be sure to add a -2L to the end of the part number for any part marked with an \*

If you have a stainless steel model, please add -SS to any metal part when ordering.



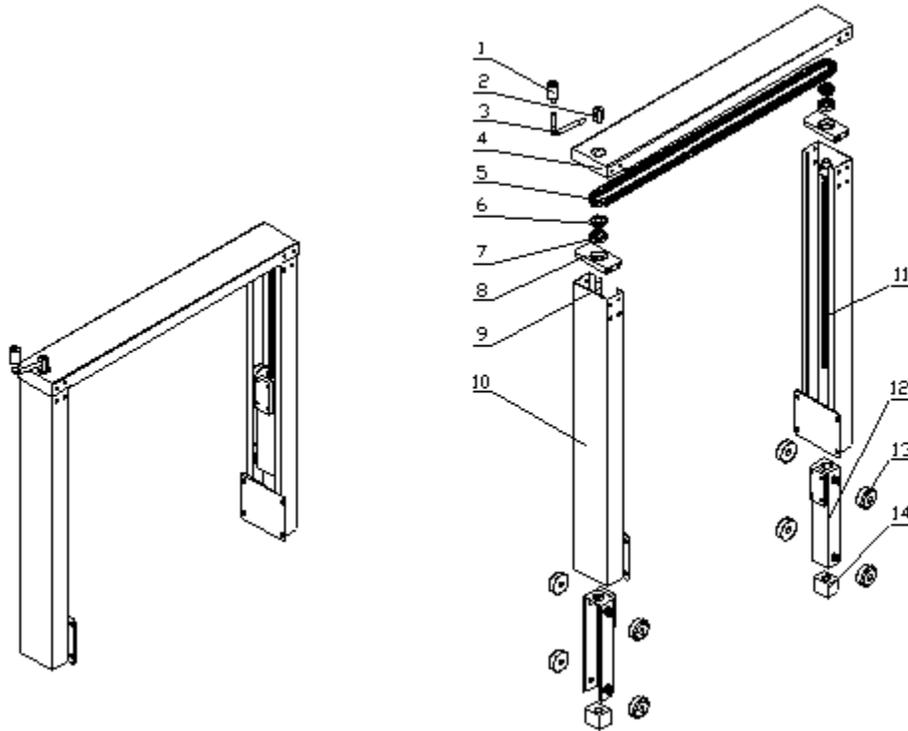
	Description	Part Number	Qty
1	Machine Frame*	FJG-1A-100	1
2	Front Leg Support - Must specify Left or Right	FJG-1A-110L or FJG-1A-110R	2
3	Nut Plate	FJG-1A-112	4
4	Leg	FJG-1A-113	4
5	Rear Leg Support - Must specify Left or Right	FJG-1A-111L or FJG-1A-111R	1/ea
6	Support Shaft	FJ-1A-68	1

## 6. Illustrations & Parts List

### 6.2 Upright Post Assembly

If you have a T200L, please be sure to add a -2L to the end of the part number for any part marked with an \*

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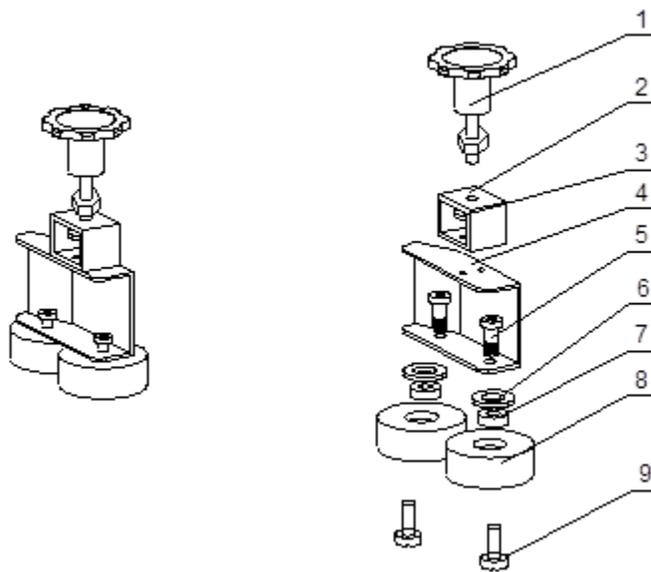
	Description	Part Number	Qty
1	Handle	FJG-1A-193	1
2	Hub	FJG-1A-944	1
3	Handle Mount	FJG-1A-917	1
4	Beam*	FJG-1A-176	1
5	Chain*	06B2	1
6	Height Adjustment Gear	FJG-1A-179	2
7	Lift Screw Bearing	6905-ZZ	2
8	Upper Supporting Board	FJ-3AS-21	2
9	Lift Screw (Left)	FJ-3AS-26	1
10	Upright Post Body*	FJ-3AS-24	2
11	Lift Screw (Right)*	FJ-3AS-25	1
12	Lift Body*	FJ-3AS-19	2
13	Idler Wheel	FJ-1B-11	8
14	Nut	FJ-3AS-20	2

## 6. Illustrations & Parts List

### 6.4 Top Box Squeezer

If you have a stainless steel model, please add -SS to any metal part when ordering.

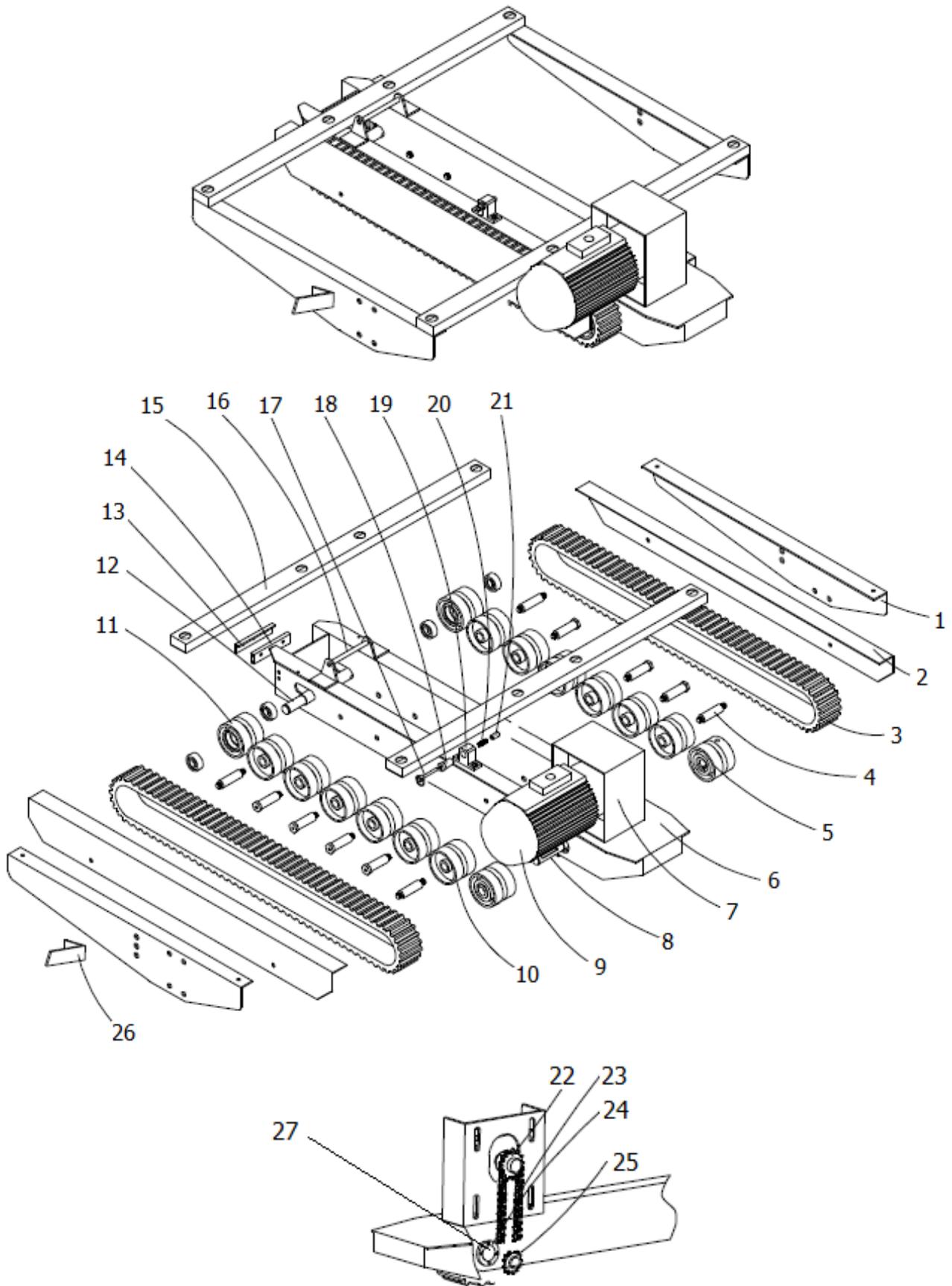
Description	Part Number	Qty
Complete Left Top Squeezer Assembly	TM-TBSA-LA	1
Complete Right Top Squeezer Assembly	TM-TBSA-RA	1



	Description	Part Number	Qty
1	Knob	FJG-1A-197T	1
2	Locking Frame	FJG-1A-194	1
3	Backing Guard	FJG-1A-943	1
4	Frame - Must specify Left or Right	FJG-1A-116L or FJG-1A-116R	1
5	Bolt	FJG-3A-143B	2
6	Spacer/Washer	FJG-3A-143W	2
7	Squeezer Bearing	6203Z	2
8	Contact Roller	FJG-1A-142	2
9	Spindle	FJG-3A-143	2
10	Round Nut	FJG-3A-143RN	2

## 6. Illustrations & Parts List

### 6.4 Tape Head Carriage (Upper Belt Drive)



## 6. Illustrations & Parts List

### 6.4 Tape Head Carriage (Upper Belt Drive)

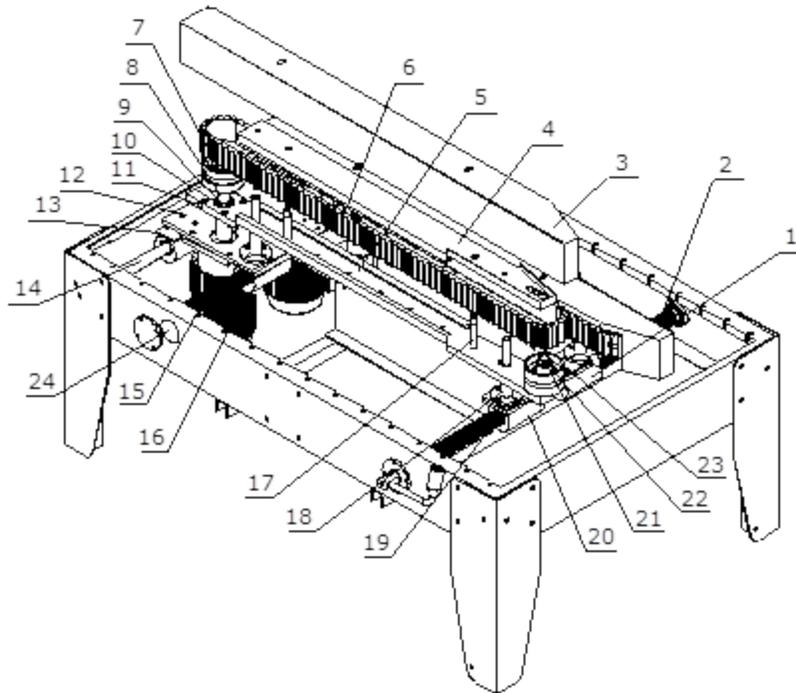
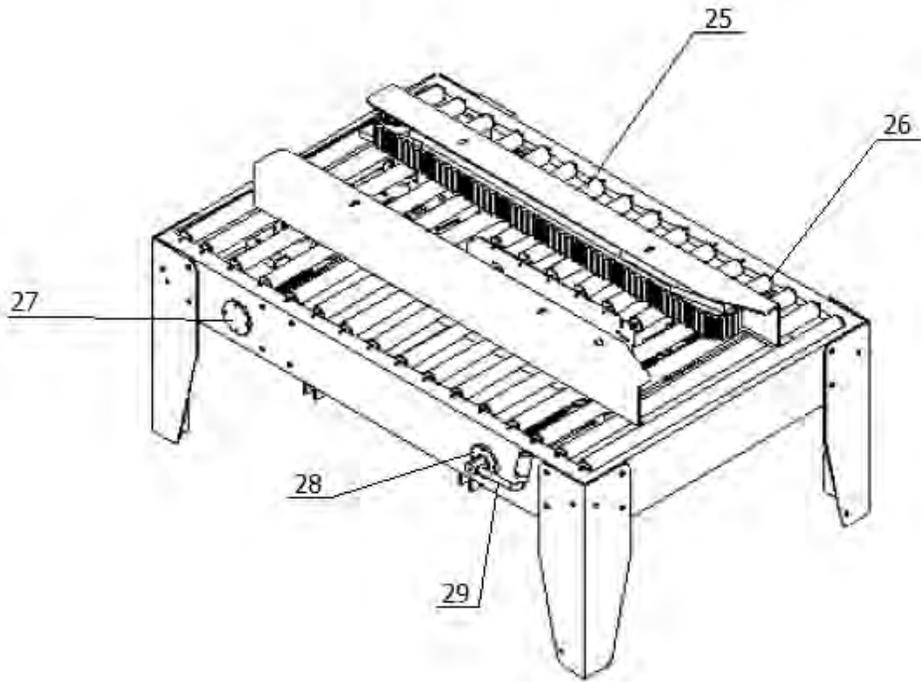
If you have a T200L, please be sure to add a -2L to the end of the part number for any part marked with an \*

If you have a stainless steel model, please add -SS to any metal part when ordering.

	Description	Part Number	Qty
1	Bracket - Must specify Left or Right	FJG-1A-130L or FJG-1A-130R	2
2	Belt Guard - Must specify Left or Right	FJ-2A-135L or FJ-2A-135R	2
3	Conveyor Belt	1520X50X5MM	2
4	Shaft	FJ-3A-415	12
5	Drive Wheel	FJ-3A-419M	2
6	Motor Support	FJ-2A-126	1
7	Motor Cover	FJ-3A-437	1
8	Upper Transmission (Drive) Axle	FJ-1D-120	1
9	Motor	CV200-20ZG3	1
10	Wheel	FJ-3A-416	12
11	Wheel	FJ-3A-413	2
12	Upper Tension Axle	FJ-2A-123	1
13	Retaining Plate	FJ-1A-703	1
14	Brush Support	FJ-1A-701	1
15	Support Bars*	FJG-1A-131.2	2
16	Supporting Shaft	FJ-1-440	1
17	Shaft	FJ-3A-807	1
18	Spring Holder	FJ-3A-808	1
19	Fixed Block	FJG-1A-127	1
20	Compression Spring	FJ-1A-930	1
21	Sliding Block	FJ-3A-806	1
22	Motor Sprocket (16 teeth)	FJ-2A-132.1	1
23	Chain	06B200	1
24	Bearing Bracket	FJ-1D-304	2
25	Lower Sprocket (13 teeth)	FJ-2A-132	1
26	Switch Stop/Pointer	FJ-3A-450	1
27	Bearing	6003Z	1

## 6. Illustrations & Parts List

### 6.5 Side Conveyor System (Continued)



## 6. Illustrations & Parts List

### 6.5 Side Conveyor System (Continued)

If you have a T200L, please be sure to add a -2L to the end of the part number for any part marked with an \*

If you have a stainless steel model, please add -SS to any metal part when ordering.

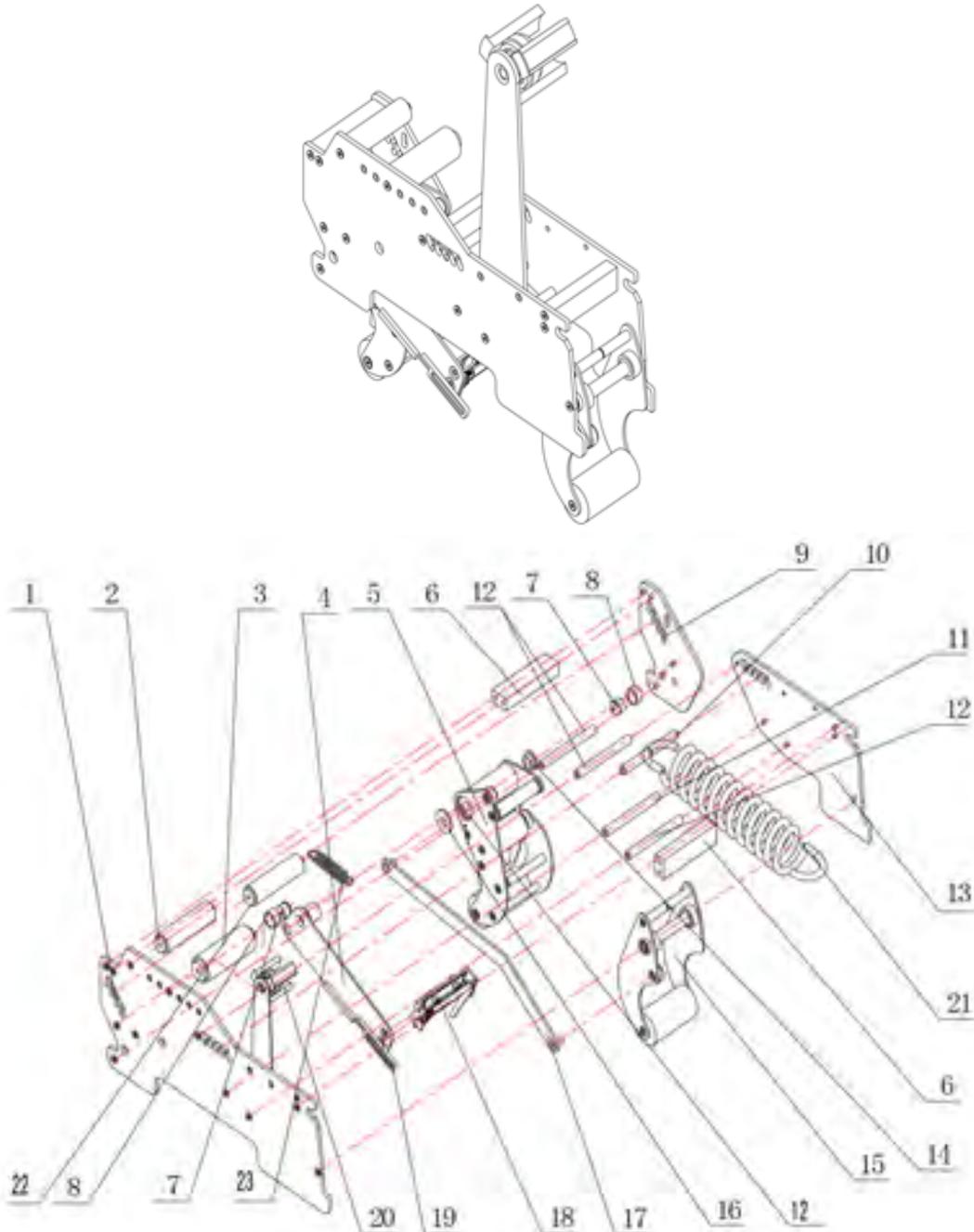
	Description	Part Number	Qty
1	Right Lead Nut	FJG-1A-927	2
2	Lead Screw (Left/Right)*	FJG-1A-155	1
3	Cover Plate - Must specify Left or Right	FJG-1A-169L or FJG-1A-169R	1/ea
4	Side Belt Cover - Must specify Left or Right	FJG-1A-152L or FJG-1A-152R	1/ea
5	Conveyor Support Base - Must specify Left or Right	FJG-1A-151L or FJG-1A-151R	1/ea
6	Belt	1867X50X5mm	2
7	Metal Drive Wheel	FJG-1A-148	2
8	Transmission Shaft	FJ-1A-200	2
9	Driver Wheel Sleeve	FJG-1A-208	2
10	Conveyor Bearing	6005	2
11	Bearing Base	FJ-3A-116	2
12	Motor Mount Panel	FJ-1A-302	2
13	Sliding Sleeve	FJ-1A-920	2
14	Guide Shaft*	FJ-1A-201	1
15	Lead Screw (Left/Right)*	FJG-1A-154	1
16	Motor - Standard RPM 1670	CV200-20ZG1/G2	2
17	Locating Pins	FJG-1A-160	4
18	Connection Pole	FJG-1A-162	4
19	Orientation Plate	FJG-1A-158	2
20	Left Lead Nut	FJG-1A-156	2
21	Tensioning Shaft	FJG-1A-141	2
22	Tension Wheel Sleeve	FJG-1A-207	4
23	Wheel	FJG-1A-149	2
24	Width Adjustment Gear	FJ-1A-129	2
25	Short Roller Assembly*	FJG-1A-182/183S	12
26	Long Roller Assembly*	FJG-1A-182/183L	10
27	Screw Retainer Closed Assembly	FJ-SR-C-ASSY	3
28	Screw Retainer Open Assembly	FJ-SR-O-ASSY	1
29	Handle Mount Assembly	FJG-1A-196A	1
Parts in 29	Handle	FJG-1A-193	3
	Hub	FJG-1A-944	1
	Handle Mount	FJG-1A-917	1

## 6. Illustrations & Parts List

### 6.6 Tape Head

If you have a stainless steel model, please add -SS to any metal part when ordering.

Description	Part Number	Qty
Complete Top Tape Head	TAPE HEAD-T	1
Complete Bottom Tape Head	TAPE HEAD-B	1



## 6. Illustrations & Parts List

### 6.6 Tape Head (Continued)

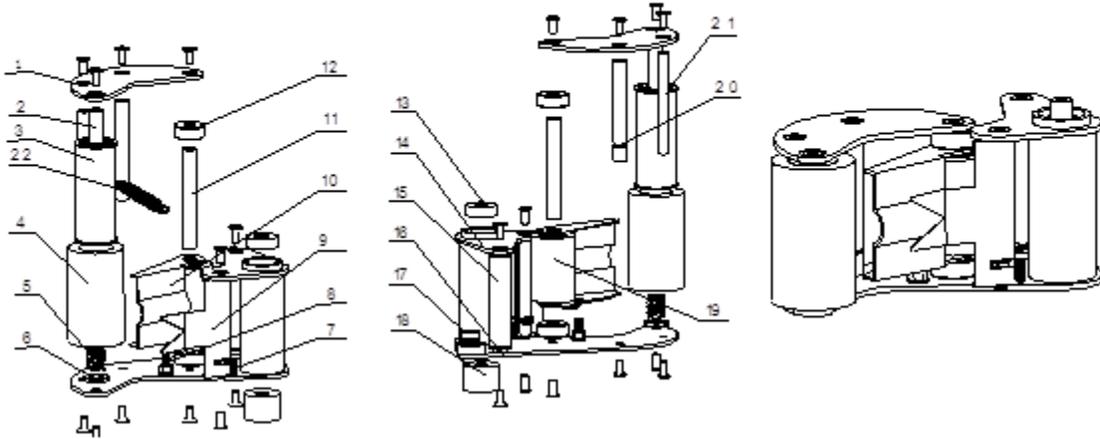
If you have a stainless steel model, please add -SS to any metal part when ordering.

	Description	Part Number	Qty
1	Side Plate	FJ-01-17	1
2	Guide Pulley Assembly - see pg 22 for breakdown	FG-GUIDEPA	1
3	One-Way Knurled Roller Assembly - see pg 22 for breakdown	FJ-E-34	1
4	Blade Carrier	FJ-01-04	1
5	Front Roller Assembly - see pg 20 for breakdown	FG-FRROLLERA	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 - see pg 21 for breakdown	FG-BKROLLERA	1
16	Brass Washer	FJ-02-04	1
17	Connecting Lever	FJ-01-14	1
18	Knife Blade Assembly - see pg 23 for breakdown	KNIFE BLADE ASSY	1
19	Knife Leveling Piece	FJ-01-01	1
20	Tape Hub Assembly - see pg 24 for breakdown	FG-TAPEHUBASSY	1
21	Tension Spring - Must Specify Upper or Lower	FJ-H-07-U or FJ-H-07-L	1
22	Extension Spring Axis	FJ-00-01	1
23	Extension Spring	FJ-H-04	1

## 6. Illustrations & Parts List

### 6.7 Front Tape Roller Assembly - FG-FRROLLERA (can be order as set)

If you have a stainless steel model, please add -SS to any metal part when ordering.

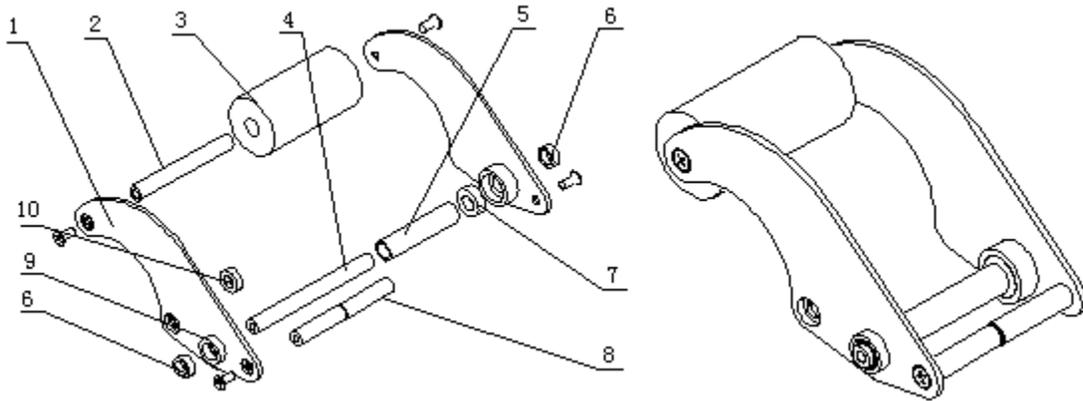


	Description	Part Number	Qty
1	Front Plate - Must specify Left or Right	FJ-01-09L or FJ-01-09R	1
2	Shaft	FJ-00-08	1
3	Roller Shaft	FJ-E-38-01	1
4	Front Rubber Roller	FJ-E-41-01	1
5	Press Spring	FJ-11-00	1
6	Gasket	FJ-50-100	1
7	Phillips Flat Head Screw	M4x12	1
8	Phillips Flat Head Screw	M5x15	1
9	Press Tape Board	FJ-01-05	1
10	Press Board	FJ-01-08	1
11	Shaft	FJ-00-10	1
12	Axle Sleeve	FJ-02-02	2
13	Bearing	6900Z	1
14	Front Claw	FJ-50-00	1
15	Guide Tape Wheel Assembly	FJ-02-13A	1
16	Axle Sleeve	FJ-02-14	1
17	Bearing	688Z	1
18	Bearing	HK2020	1
19	Axle Sleeve	FJ-02-10	1
20	Shaft	FJ-00-11	1
21	Shaft	FJ-00-09	1
22	Pulling Spring	FJ-H-00	1

## 6. Illustrations & Parts List

### 6.8 Back Roller Side Plate Assembly - FG-BKROLLERA (can be order as set)

If you have a stainless steel model, please add -SS to any metal part when ordering.

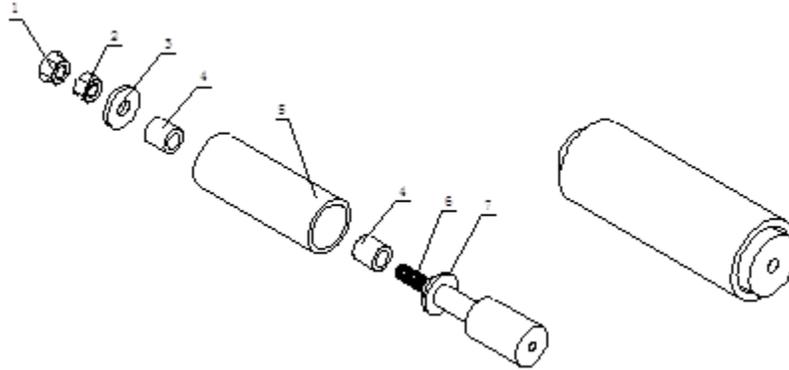


	Description	Part Number	Qty
1	Back Plate - Must specify Left or Right	FJ-01-13L or FJ-01-13R	1
2	Shaft	FJ-00-10	1
3	Back Rubber Roller	FJ-40-03	1
4	Shaft	FJ-00-06	1
5	Axle Sleeve	FJ-02-05	1
6	Axle Sleeve	FJ-02-06	2
7	Bearing	6800Z	2
8	Shaft	FJ-00-05	1
9	Axle Sleeve	FJ-02-00	1
10	Bearing	688Z	1

## 6. Illustrations & Parts List

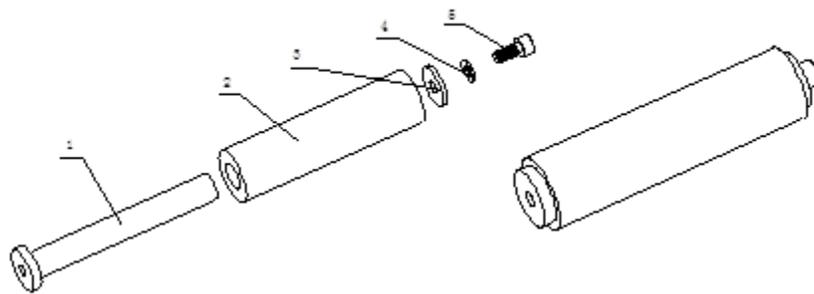
If you have a stainless steel model, please add -SS to any metal part when ordering.

### 6.9 One Way Knurled Roller Assembly - FJ-E-34 (can be order as set)



	Description	Part Number	Qty
1	Locknut	M8	1
2	Nut	M8	1
3	Washer	FJ-02-03	1
4	Bearing	HF-1216	1
5	One Way Roller	FJ-E-34-01	1
6	Shaft	FJ-00-04	1
7	Axle Sleeve	FJ-02-01	1

### 6.10 Guide Pulley Assembly - FG-GUIDEPA (can be order as set)

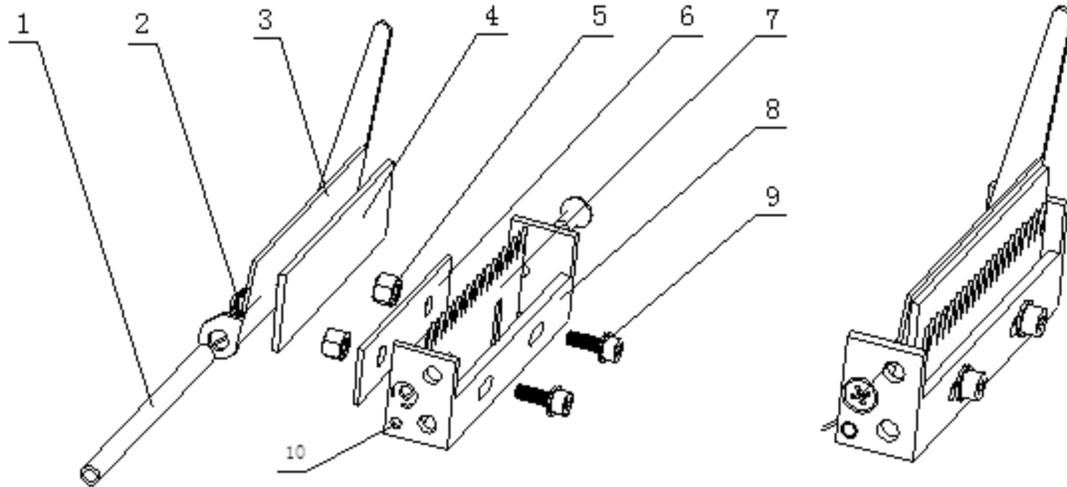


	Description	Part Number	Qty
1	Shaft	FJ-00-03	1
2	Axle Sleeve	FJ-02-07	1
3	Bearing Bushing	FJ-02-08	1
4	M5 Lock Washer	M5LOCKWASHER	1
5	Socket Head Cap Screw	M5X12SHCS	1

## 6. Illustrations & Parts List

### 6.11 Knife Blade Assembly - KNIFE BLADE ASSY (can be order as set)

If you have a stainless steel model, please add -SS to any metal part when ordering.

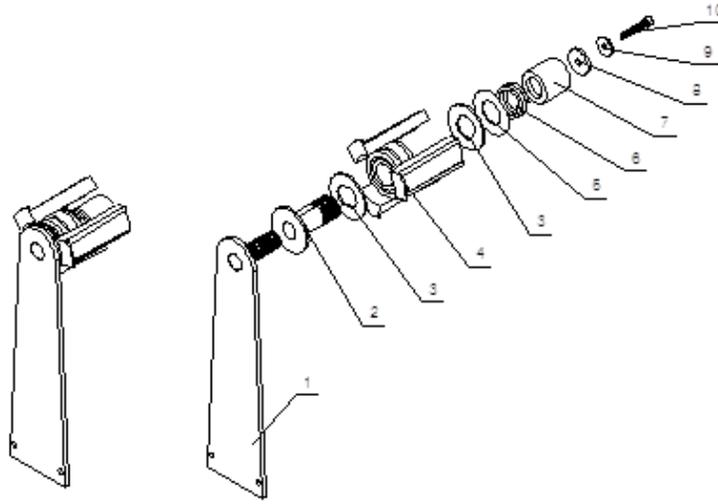


	Description	Part Number	Qty
1	Shaft	FJ-00-00	1
2	Torsion Spring	FJ-H-01	1
3	Protecting Blade Guard	FJ-01-06	1
4	Sponges	Included on FJ-01-06	1
5	Nut	M4	2
6	Knife Support	FJ-40-04	1
7	Blade - standard 2"	W65MM	1
8	Blade Carrier Block	FJ-01-07	1
9	Socket Head Cap Screw	M4x16SHCS	2
10	Phillips Flat Head Screw	M4x12	1

## 6. Illustrations & Parts List

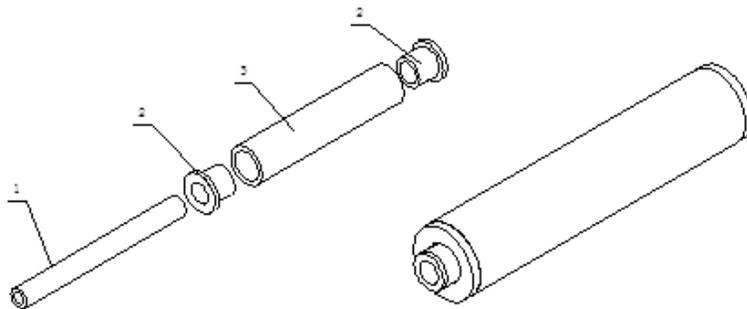
If you have a stainless steel model, please add -SS to any metal part when ordering.

### 6.12 Tape Hub Assembly - FG-TAPEHUBASSY (can be order as set, does not include arm)



	Description	Part Number	Qty
1	Tape Frame	FJ-05-00	1
2	Axle Sleeve	FJ-02-12	1
3	Anti Skid Washer	FJ-05-01	2
4	Tape Wheel	FJ-02-05-03	1
5	Gasket	FJ-05-02	1
6	Press Spring	FJ-H-08	1
7	Adjuster Shaft	FJ-00-14	1
8	Bearing Bush	FJ-02-08	1
9	M5 Lock Washer	M5LOCKWASHER	1
10	Socket Head Cap Screw	M5x40SHCS	1

### 6.13 Guide Tape Wheel Assembly - FG-02-13A (can be order as set)

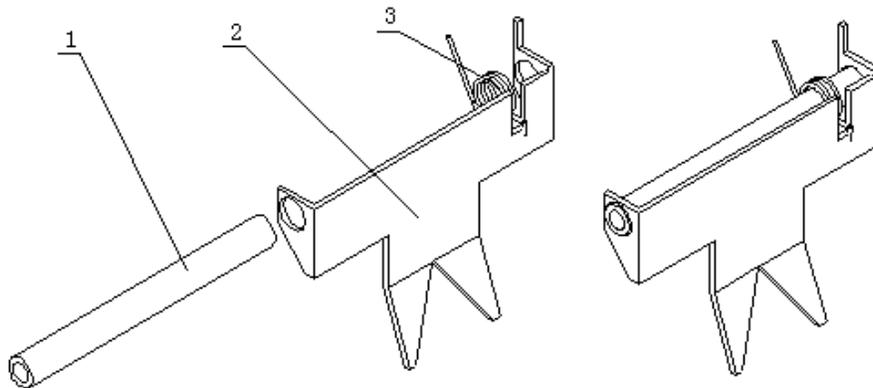


	Description	Part Number	Qty
1	Shaft	FJ-00-09	1
2	Axle Sleeve	FJ-02-14	2
3	Guide Tape Wheel	FJ-02-13	1

## 6. Illustrations & Parts List

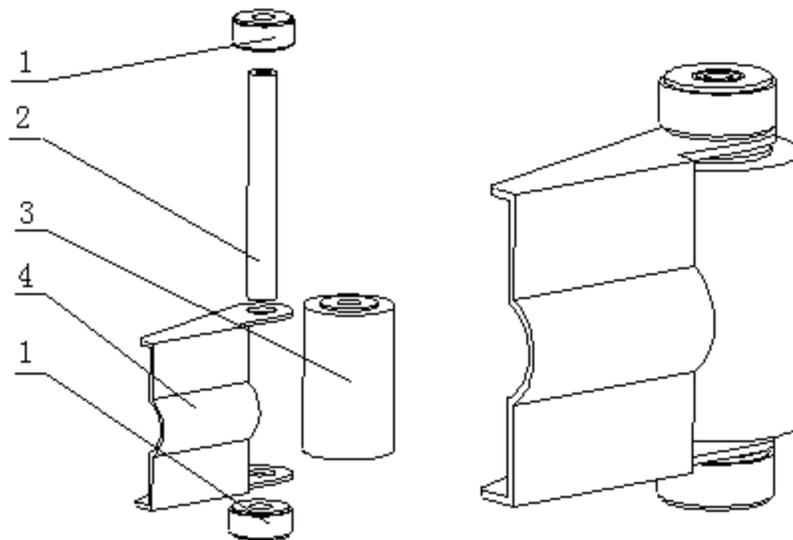
If you have a stainless steel model, please add -SS to any metal part when ordering.

### 6.14 Tape Holder Assembly



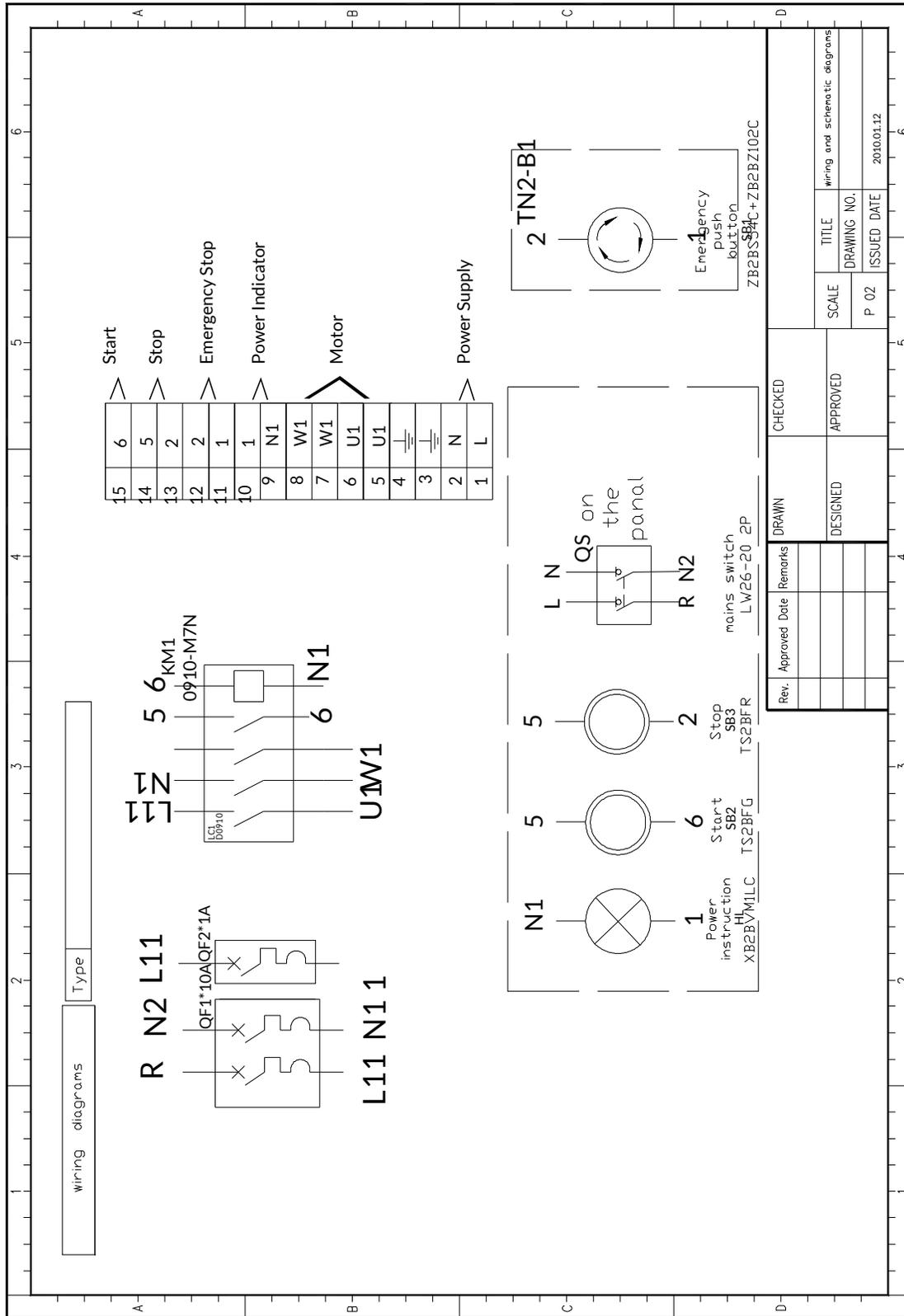
	Description	Part Number	Qty
1	Shaft	FJ-00-09	1
2	Press Tape Board	FJ-01-05	1
3	Torsion Spring	FJ-H-03	1

### 6.15 Tape Guide Assembly

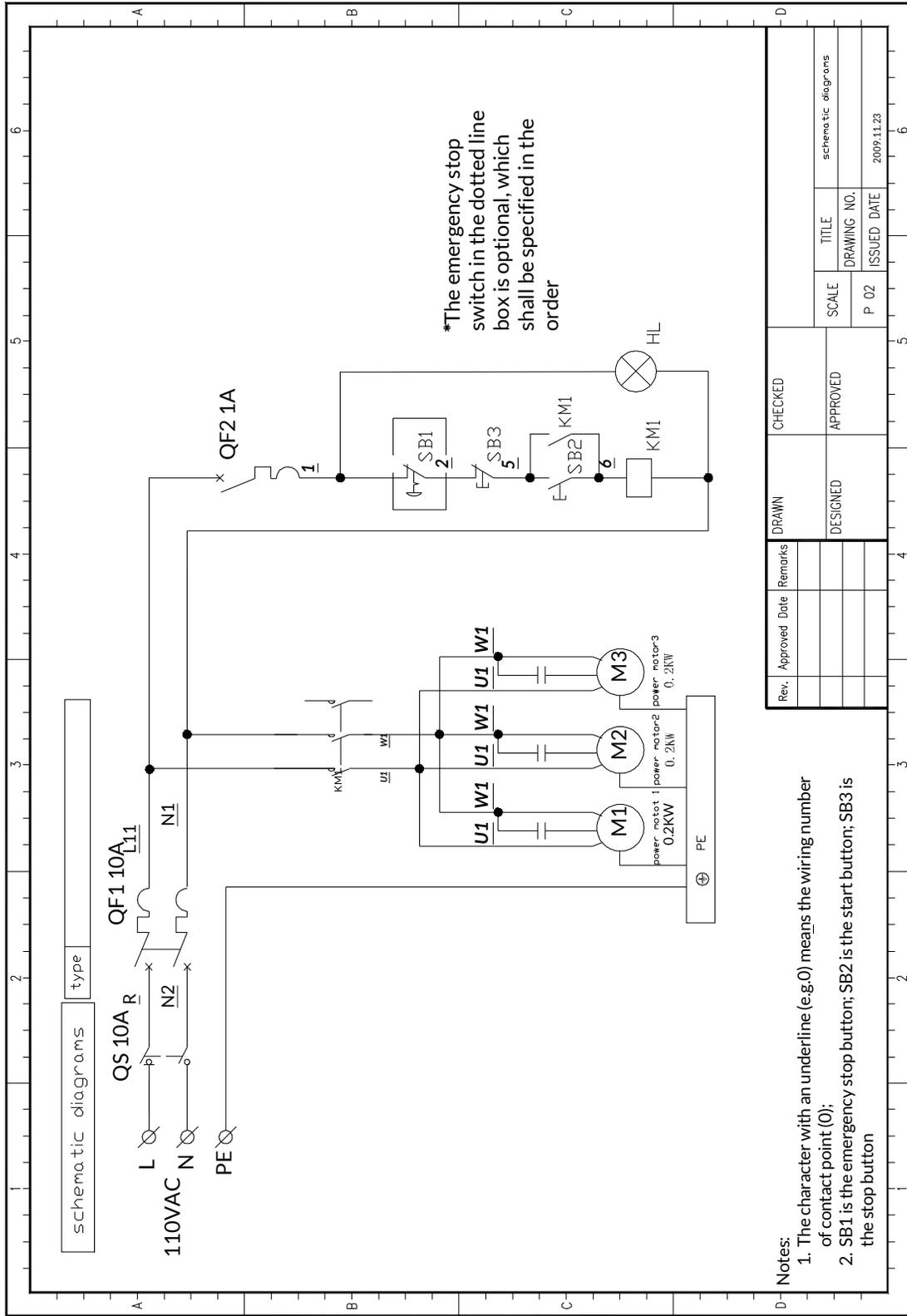


	Description	Part Number	Qty
1	Axle Sleeve	FJ-02-02	2
2	Shaft	FJ-00-10	1
3	Axle Sleeve	FJ-02-10	1
4	Press Board	FJ-01-08	1

# 7. Electrical Schematics



# 7. Electrical Schematics



Rev.	Approved Date	Remarks	DRAWN	CHECKED	SCALE	TITLE
			DESIGNED	APPROVED	P 02 <td>SCHEMATIC DIAGRAMS</td>	SCHEMATIC DIAGRAMS
						DRAWING NO.
						ISSUED DATE
						2009.11.23

- Notes:
1. The character with an underline (e.g.0) means the wiring number of contact point (0);
  2. SB1 is the emergency stop button; SB2 is the start button; SB3 is the stop button