

best by: **SNEED**  
Coding Solutions, Inc.

# SNEED PACK

## CE-50 Case Erector



# Sneed Coding Help Desk:

<https://help.sneedcoding.com/>



Thank you for your purchase of the SNEED-PACK CE-50 Case Erector. In this manual you will find the basic operating and setup procedures to ensure your success with the CE-50. Please read the manual carefully before operating the equipment.

## Safety Precautions



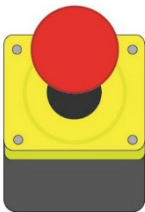
- Keep hands clear of any moving parts while the case sealer is in operation and always power down prior to inspection. Failure to do so may cause bodily harm.



- Risk of electric shock, make sure the machine is properly grounded before use.



- Do not alter the mechanical or electrical systems. Any changes could result in malfunction or injury.

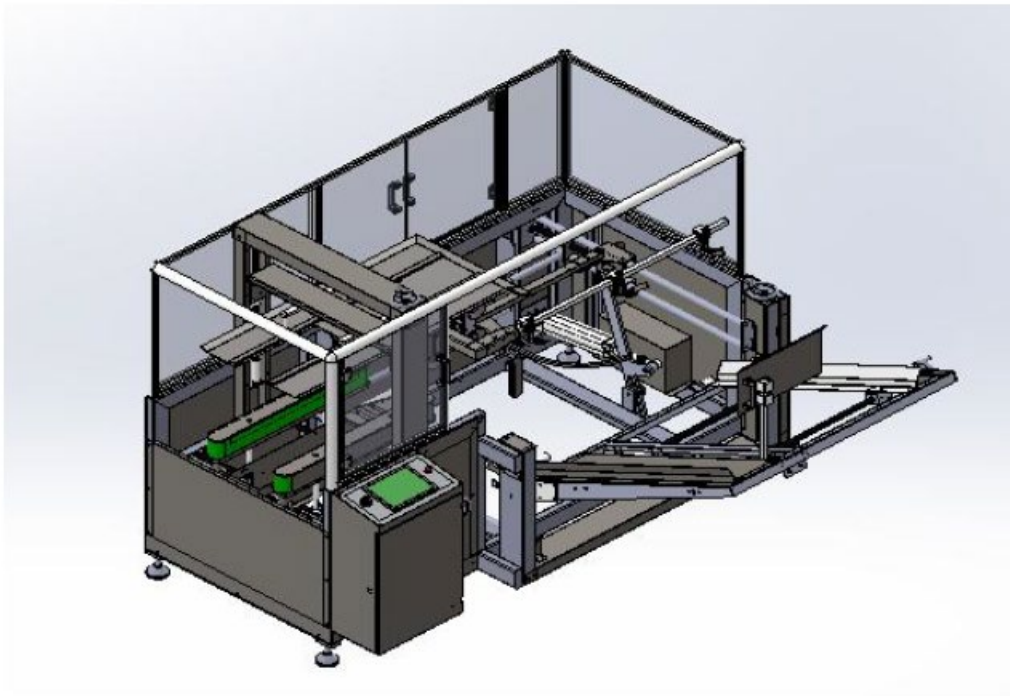


- Always turn off power to the case sealer when changing the tape roll or performing maintenance.

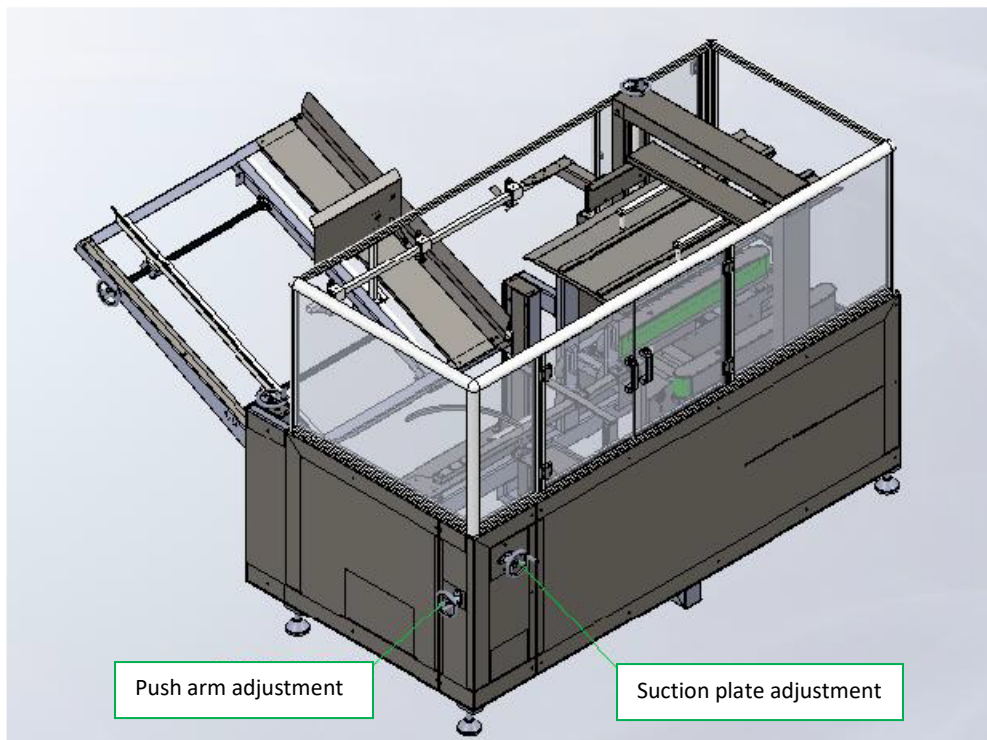
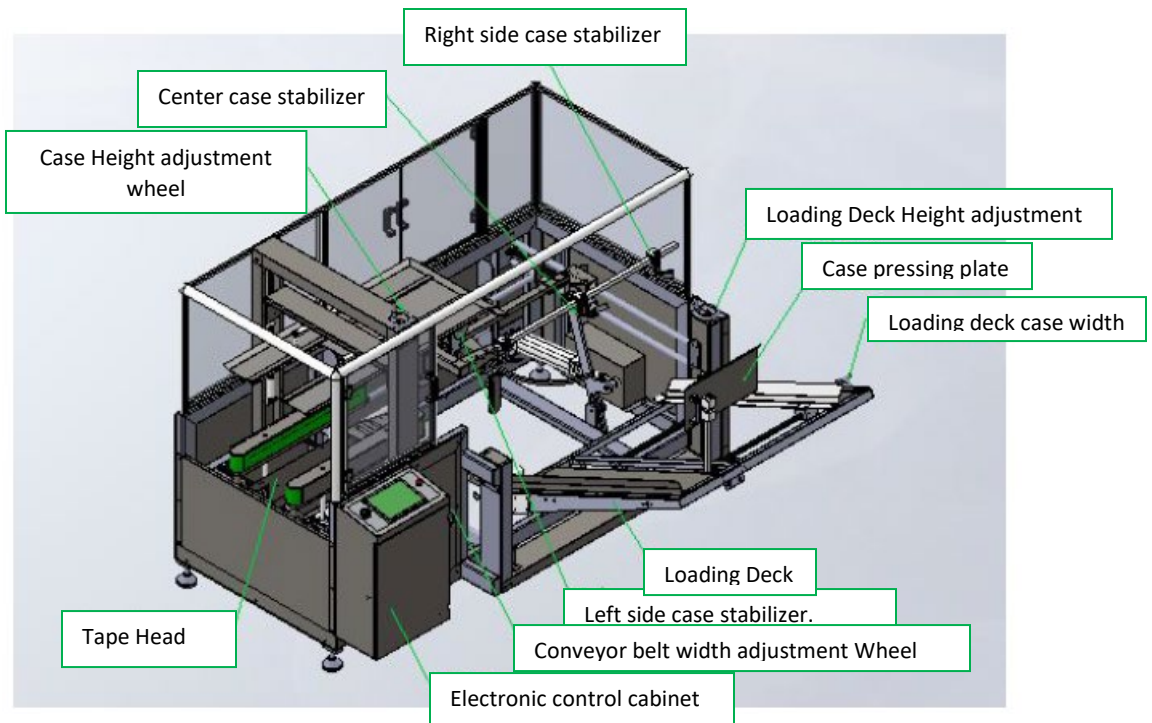
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## Specifications



- 📦 **Speed:** 8 - 10 cartons per/min
- 📦 **Minimum & maximum carton size:**
  - Width: 150mm – 500mm
  - Height: 100mm – 500mm
  - Length: 250mm – 650mm
- 📦 **Overall Machine size:**
  - Length: 250cm
  - Width: 190cm
  - Height: 165cm
  - Weight: 1058lbs
- 📦 **Power - 220V @ 50hz**



## Basic Setup and Operation

### Setting the Carton Dimensions

- 1) Fold a carton to size leaving the flaps on one end open (see fig.2)
- 2) Place the carton in the output side of the machine and use the width hand wheel seen in figure 1 to set the conveyance belts to the width of the case.
- 3) Repeat step two for the height using the height adjustment wheel on top of the machine, lowering, or raising the top deck to contact the box

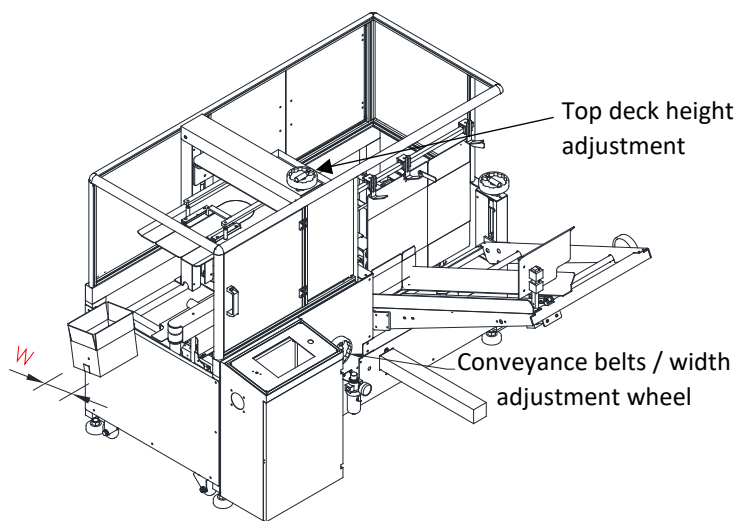
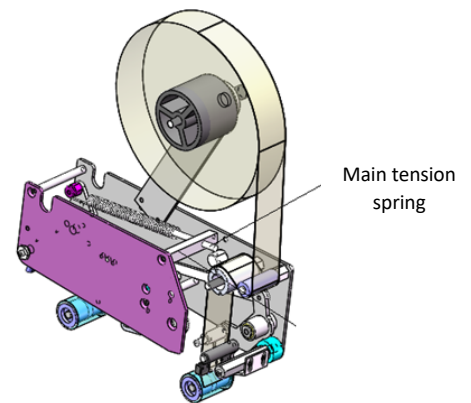


Fig.1

- 4) Next, use the hand wheel in figure 2 to adjust the suction cup plate, lining it up with the belt face as seen in Figure 3.  
**The carton push arm will fail to push the case through the machine if this isn't set properly and the case will jam.**

Fix: The most common issue is that the belts have been set too close together and need to be spaced apart.

Fix: If the case is stuck halfway through the tape head you will need to adjust the main tension spring on the tape head.



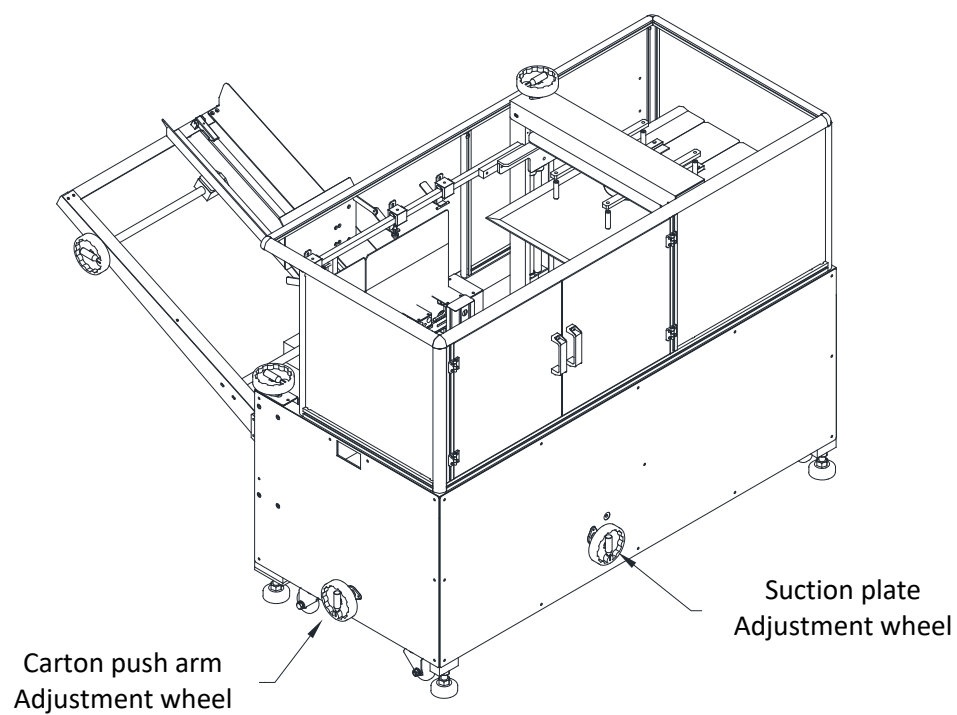


Fig. 2

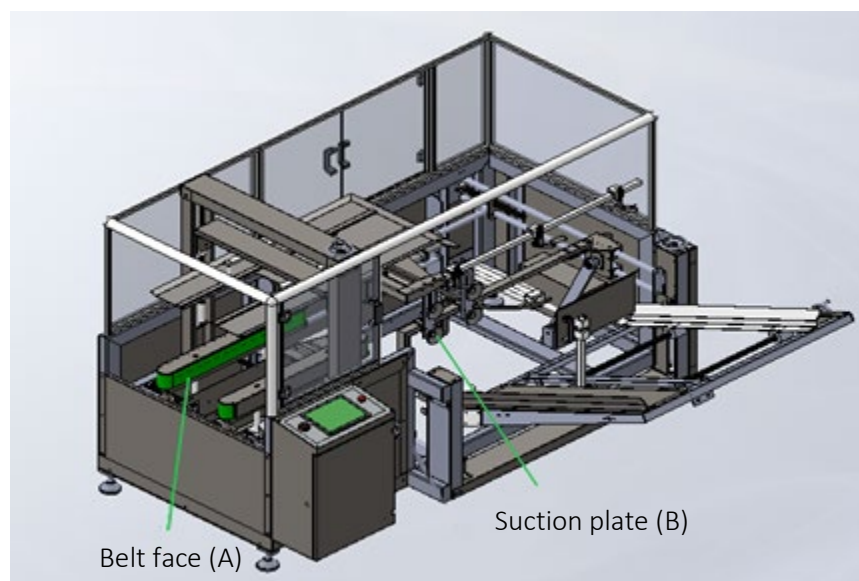


Figure 3.

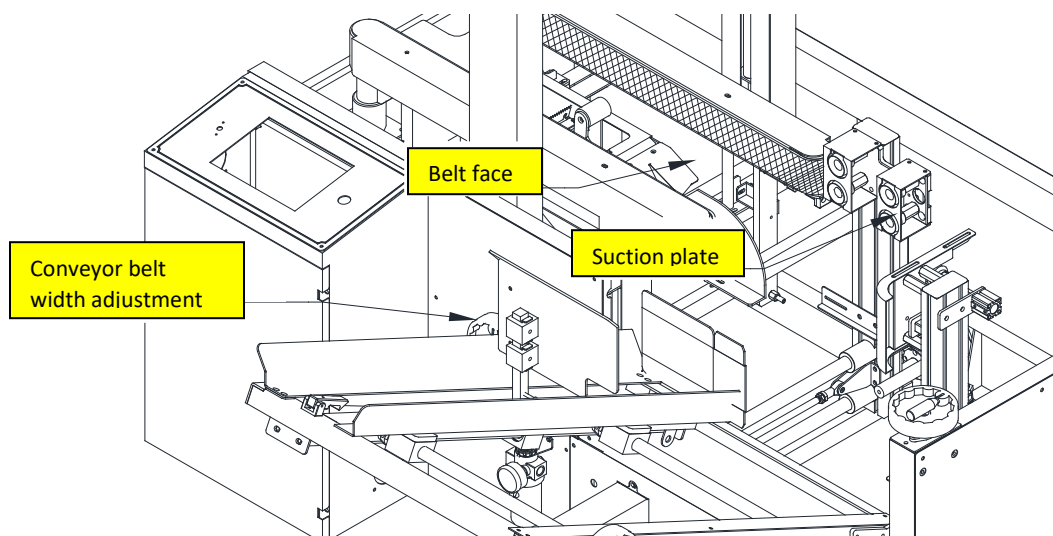


Fig. 4

✖ The suction cups (B) and the belt face (A) should be aligned on the same vertical plane.

## Loading the Cartons

- 1) Begin by placing a flat and unfolded box onto the loading deck and set the width using the hand wheel in figure 5.

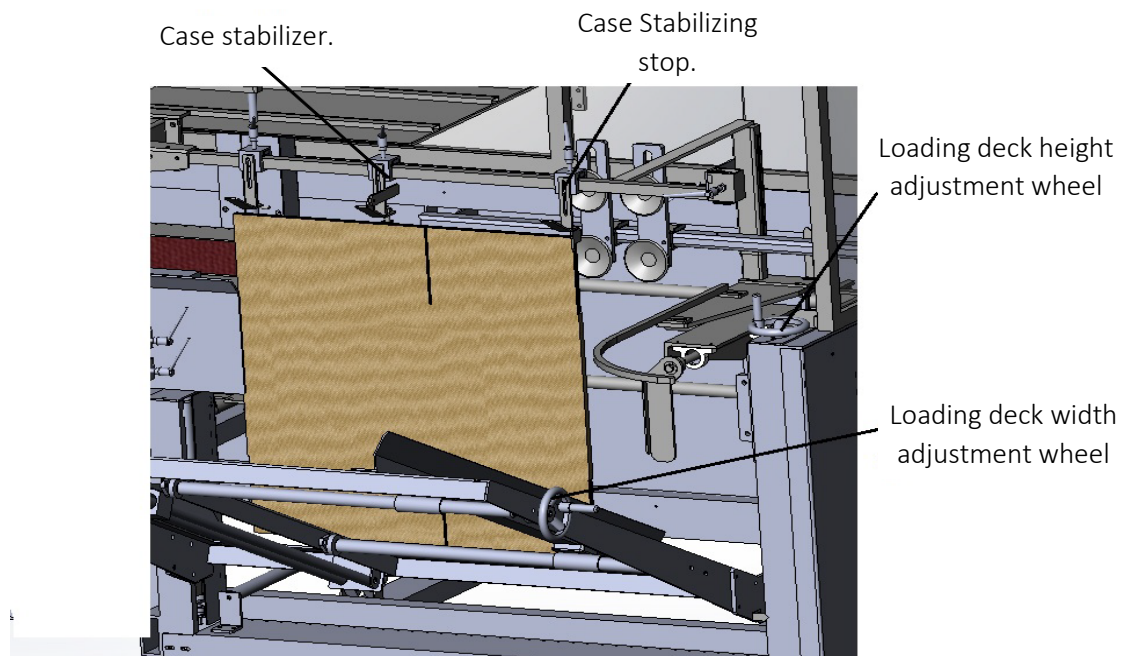


Figure 5.

- 2) Stand the flat case up and set the height until the top of the case contacts the case stoppers. **Be sure that you have positioned the stabilizing stops to each end so they are not in the way and can be set properly once you have adjusted the height. The center case stop should be set just to the left of the folding line.**

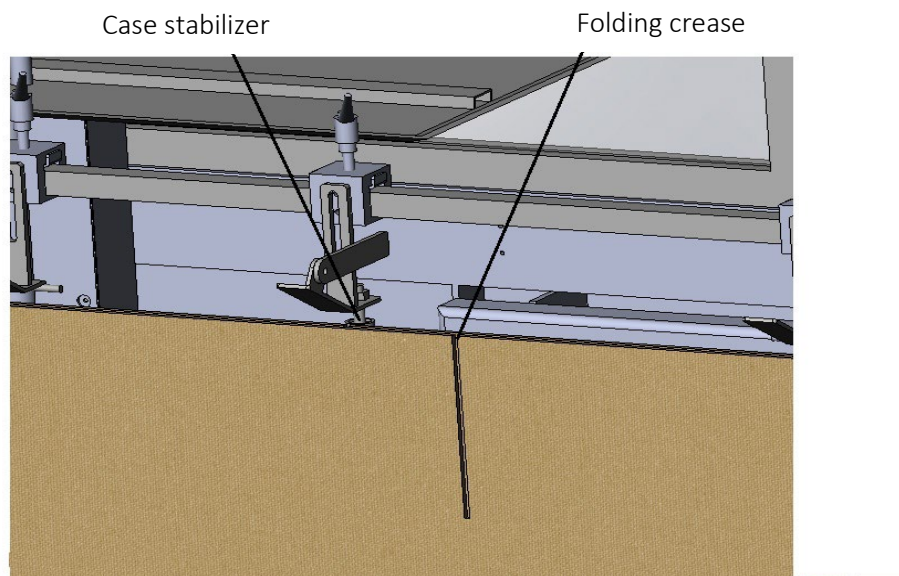
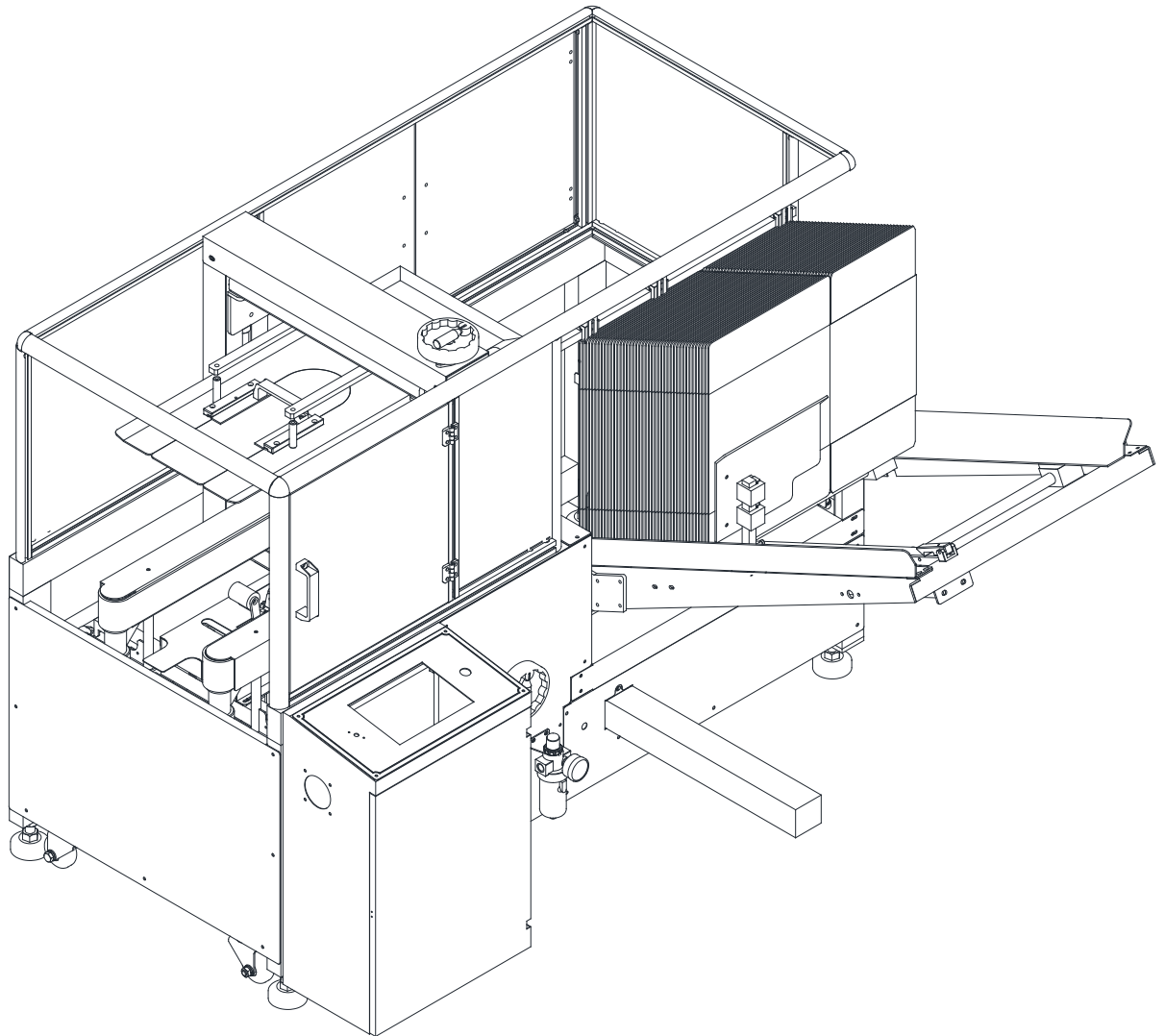


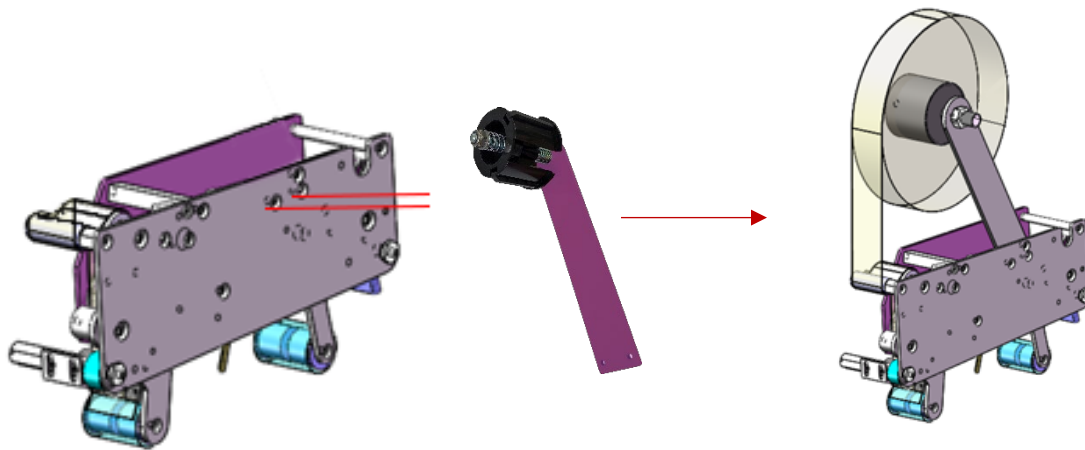
Figure 6.

- 3) Finally load your cartons onto the loading deck and release the pressure plate to hold them in place.

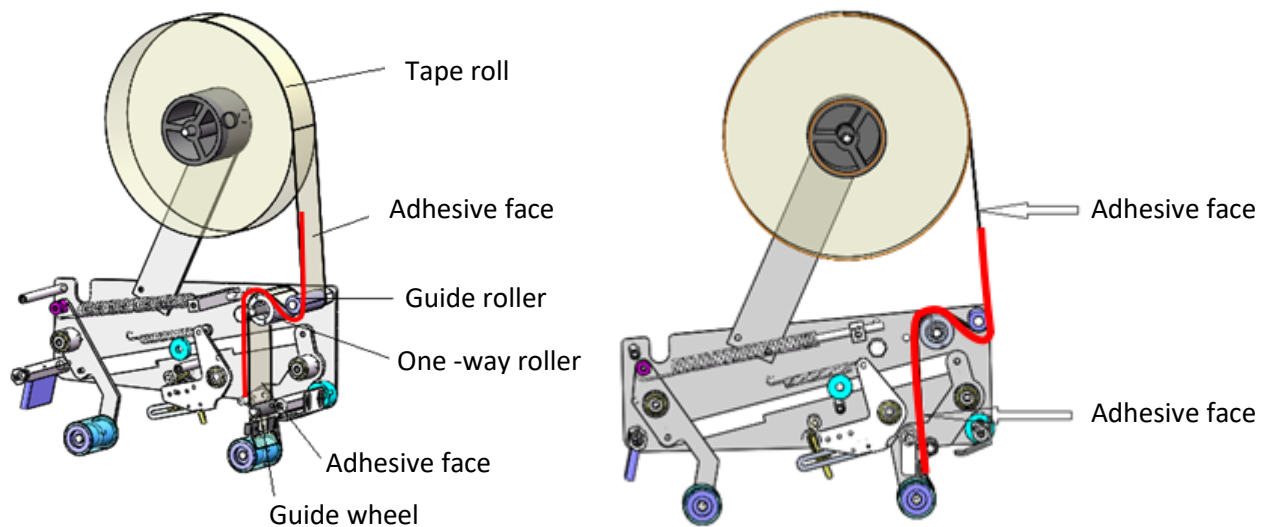


## Installing the Tape

1. Begin by attaching the tape arms to each tape head using the included screws. (top and bottom)



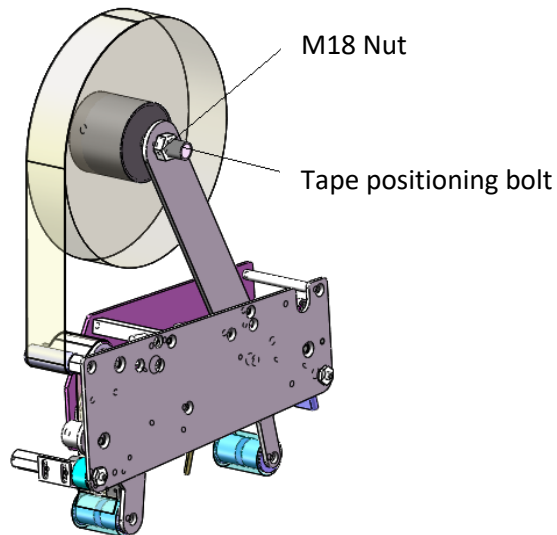
2. Next Install the tape onto the tape wheel so that when you pull the tape down the adhesive side is facing outward.
3. Now guide the tape under the first guide roller, over the one-way roller, and through the clip just above the last guide roller. **The red line shows the tape path**



## Adjusting the Tape Position

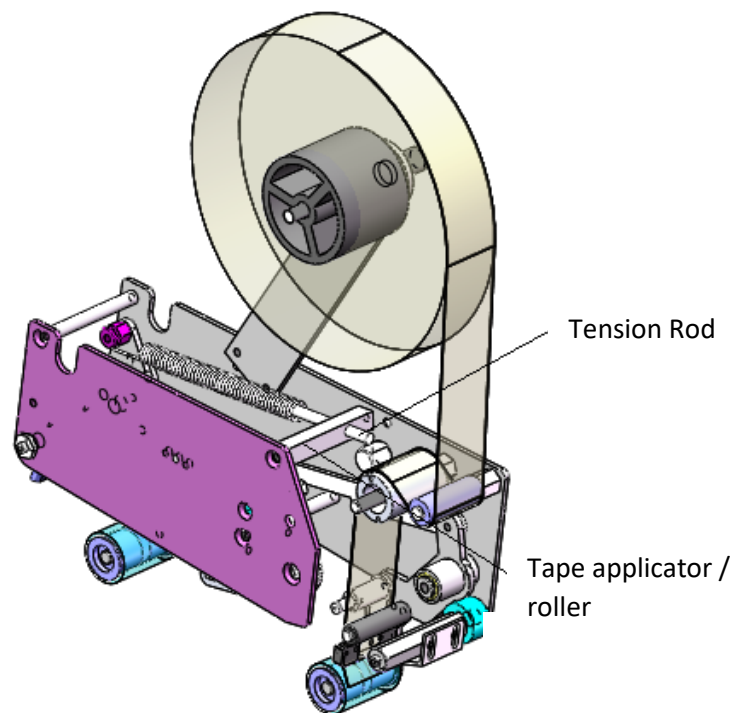
If you find that your tape is not lining up with the center of the box seams you can use the M18 nut shown in figure 6 to reposition the tape.

1. Remove the tape roll
2. Loosen the nut
3. Thread the tape spindle in or out to move the tape to the left or right on the arm.
4. Tighten the M18 nut into place when you have set the desired position.



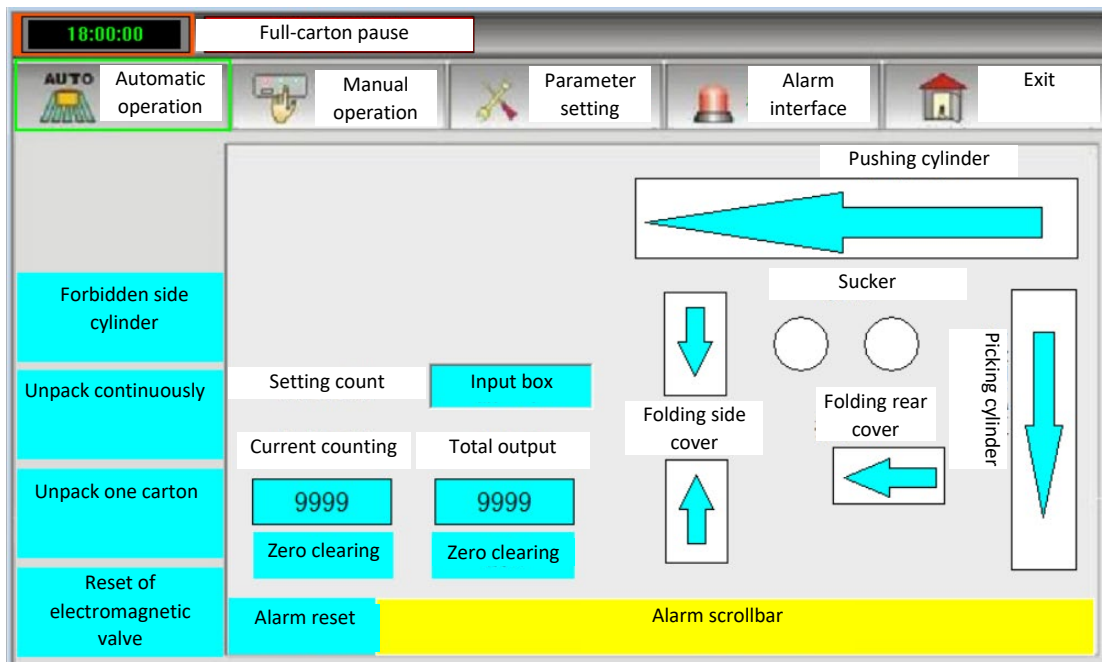
## Setting the Tape Tension

- ✿ The tape applicators will come to you already adjusted. You may find that over time the tension needs to be adjusted.
- ✿ To loosen or tighten the tension of the tape applicators use the nut on the end of the tension rod.
- ✿ Turn the nut right to tighten the spring and to the left to loosen.

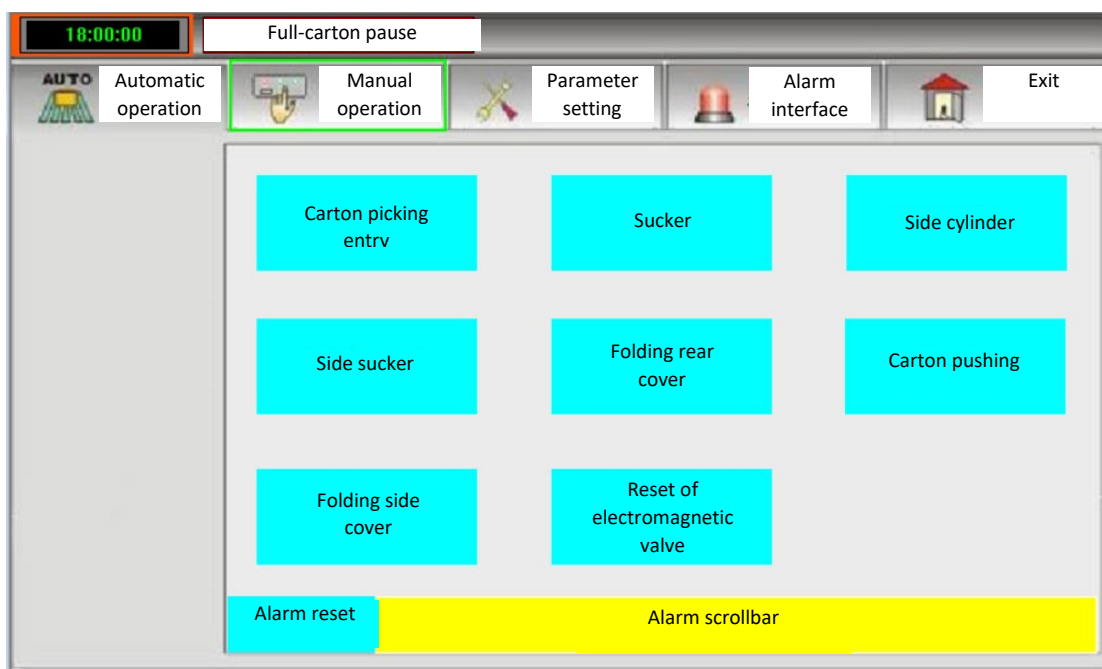


## Menu Navigation

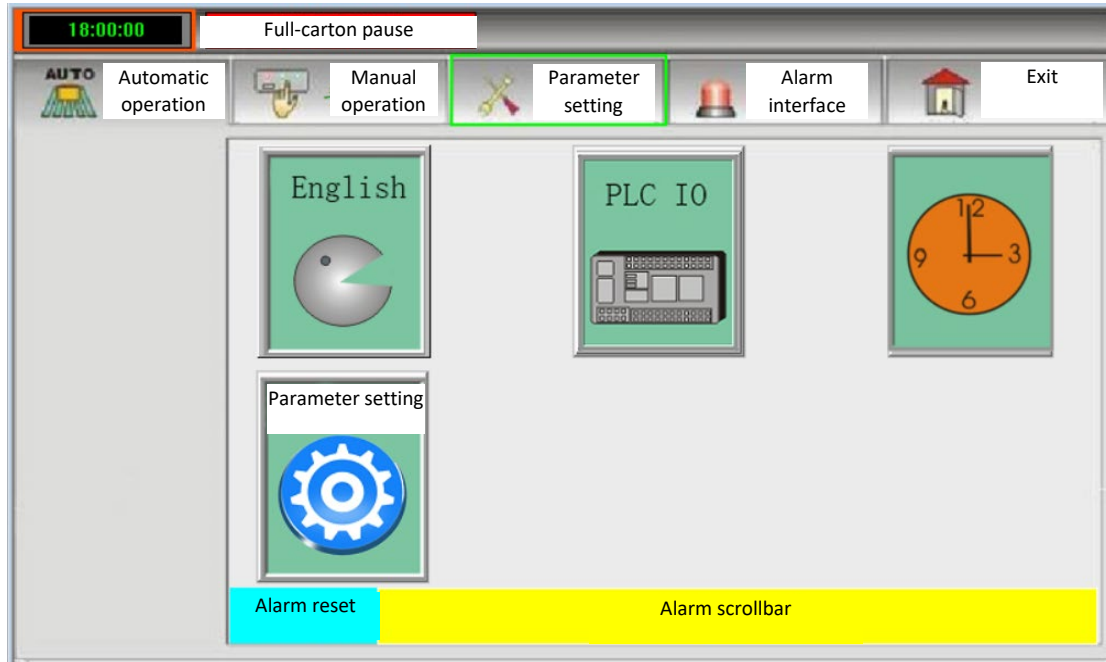
The main menu



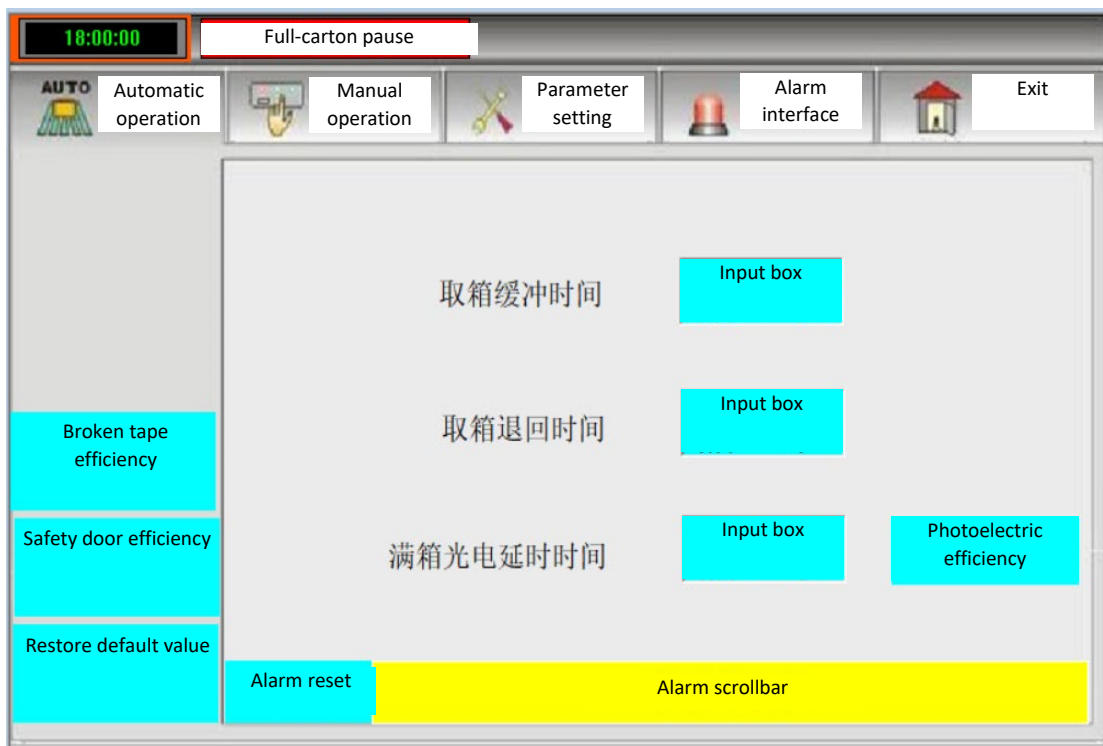
The “Manual Operation” menu allows for the individual operation of components.



## Settings



## Advanced settings



Alarms

18:00:00

Full-carton pause

AUTO

Automatic operation

Manual operation

Parameter setting

Alarm interface

Exit

日期	时间	报警描述

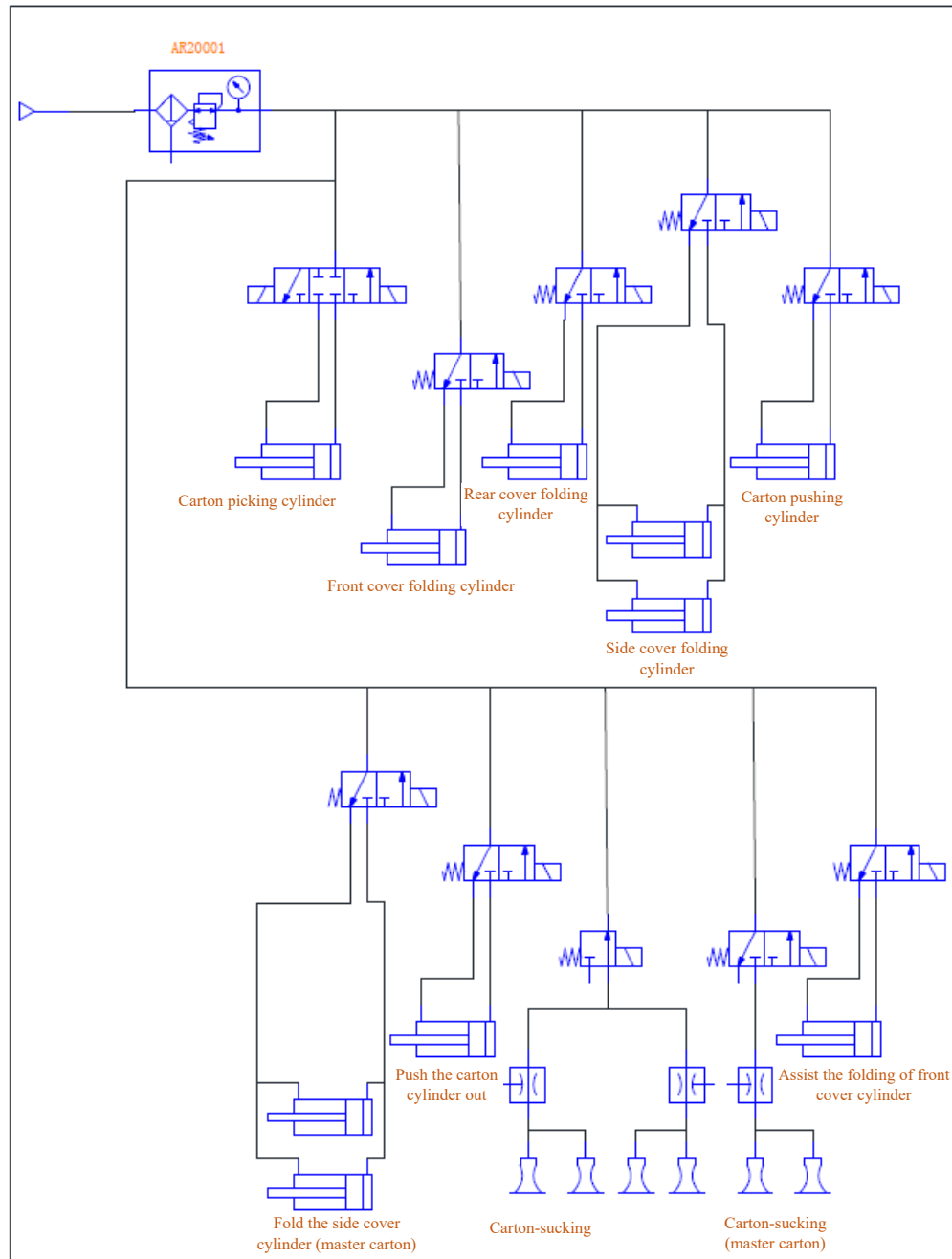
Alarm reset

Alarm scrollbar

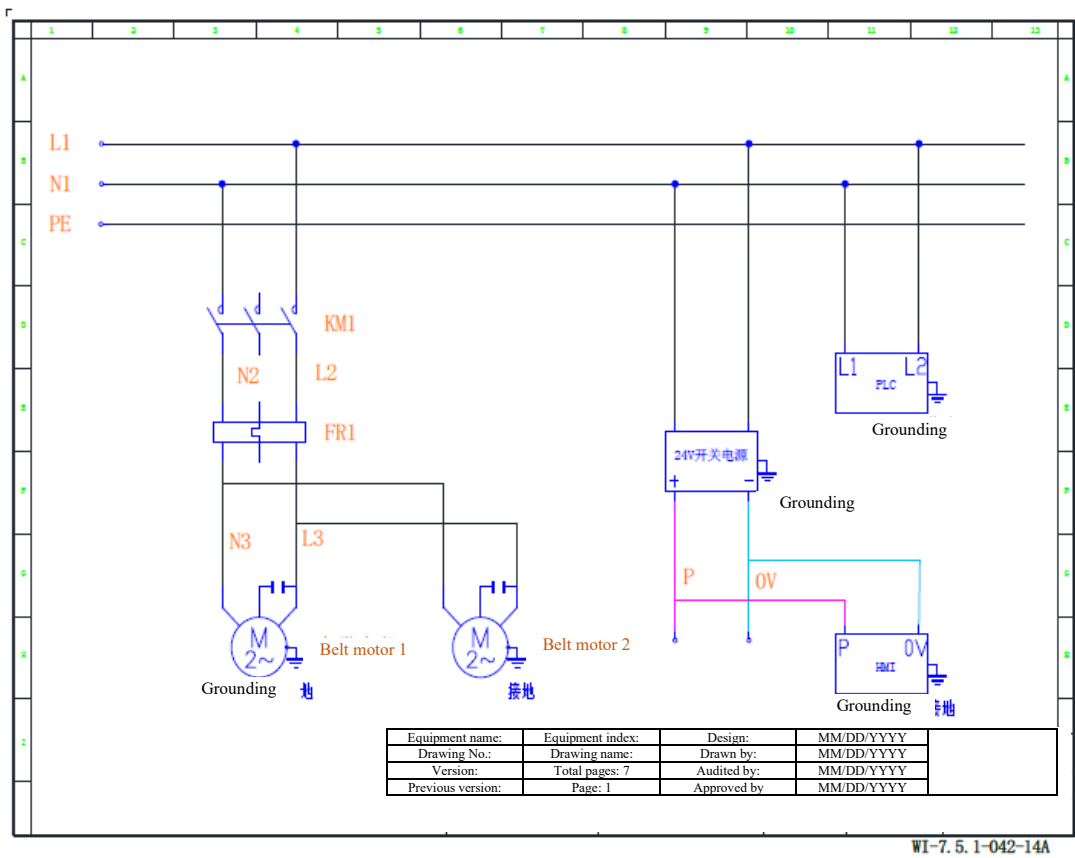
## Pneumatic & Electrical Schematics

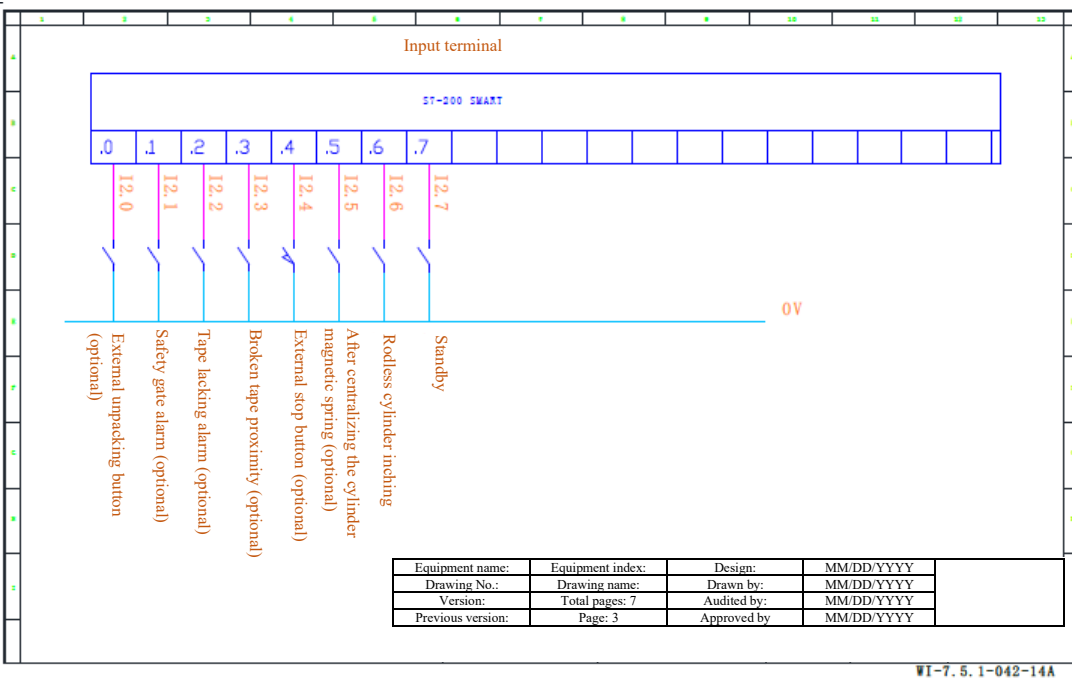
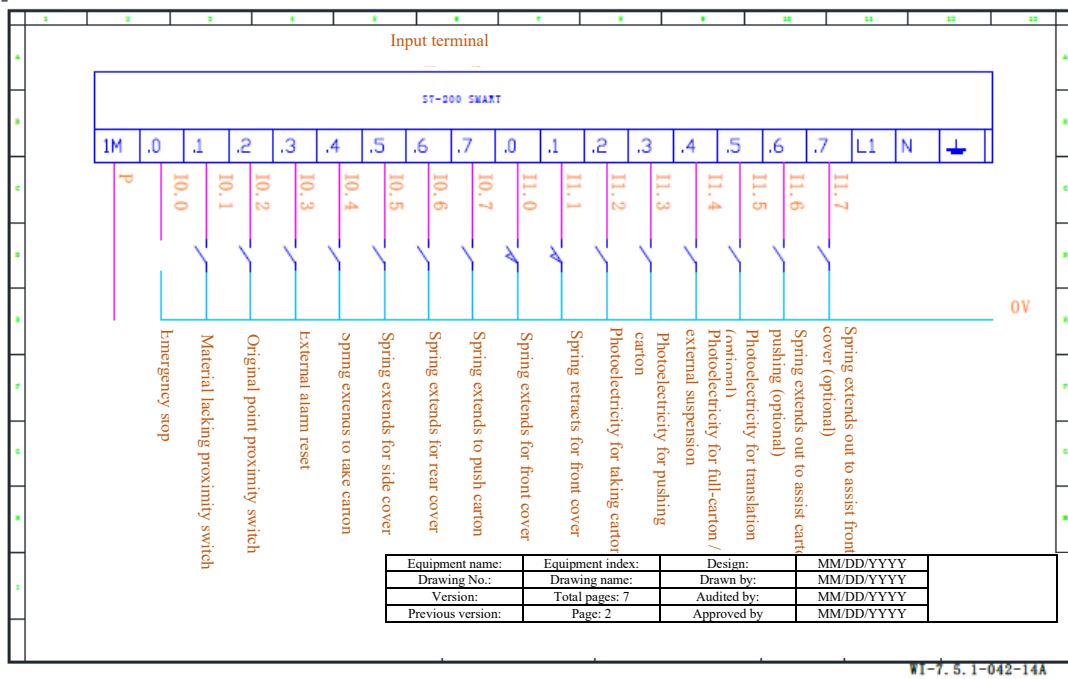
### Air Line Schematic

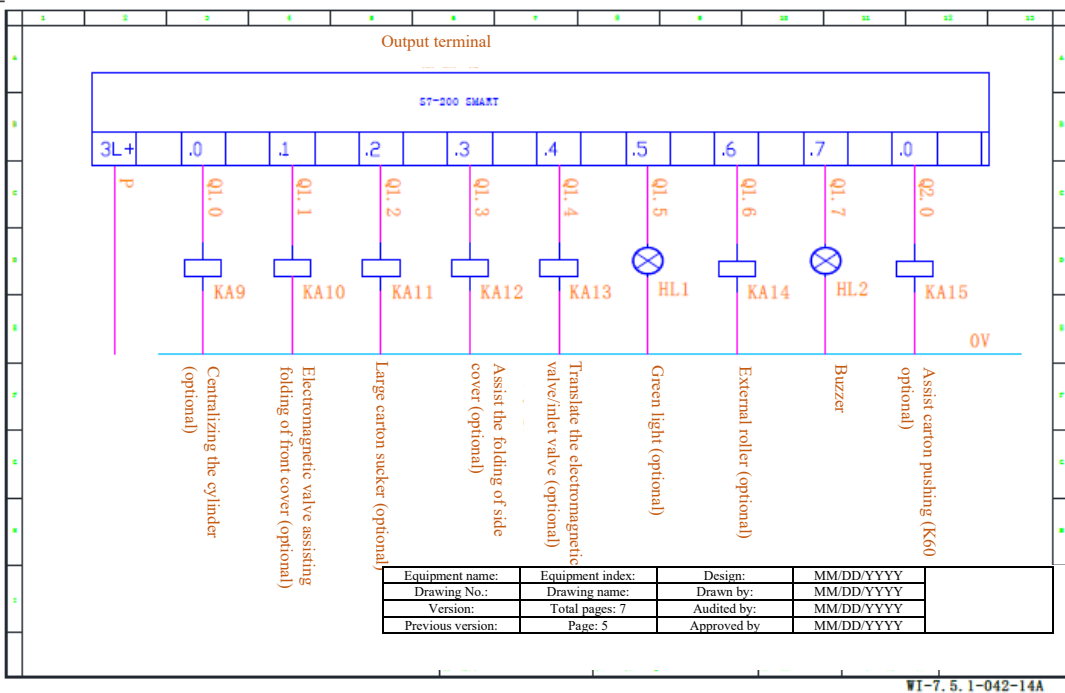
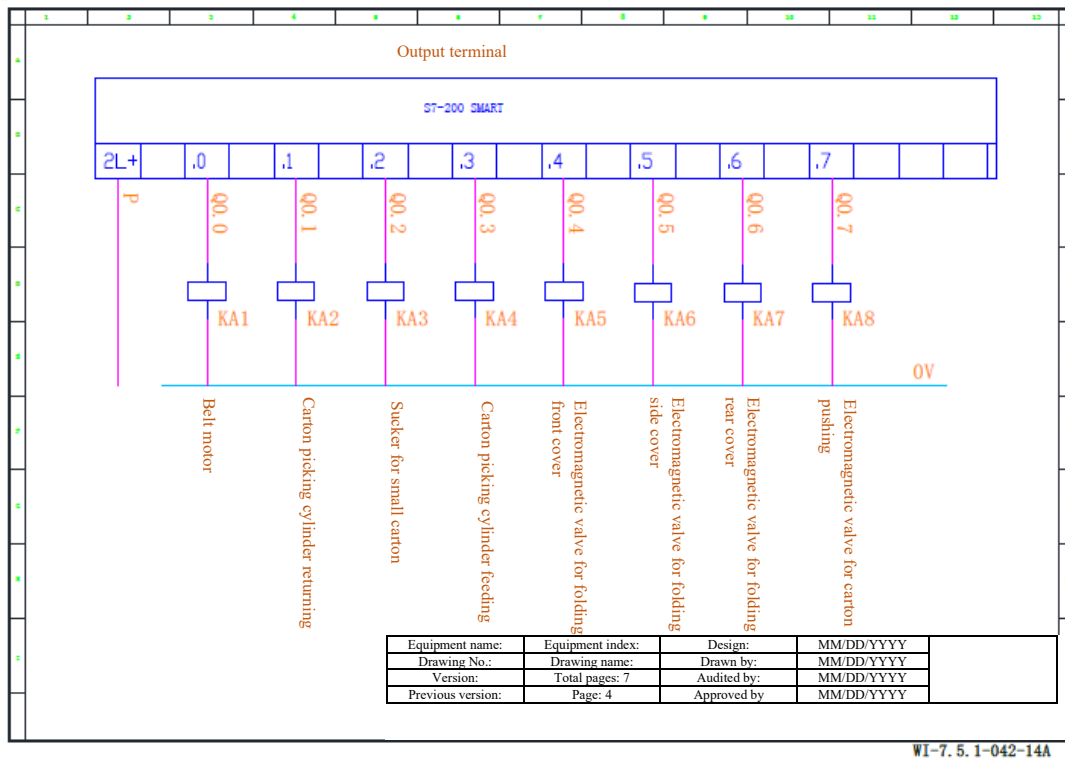
Air Pressure 5-6kg/cm<sup>2</sup>

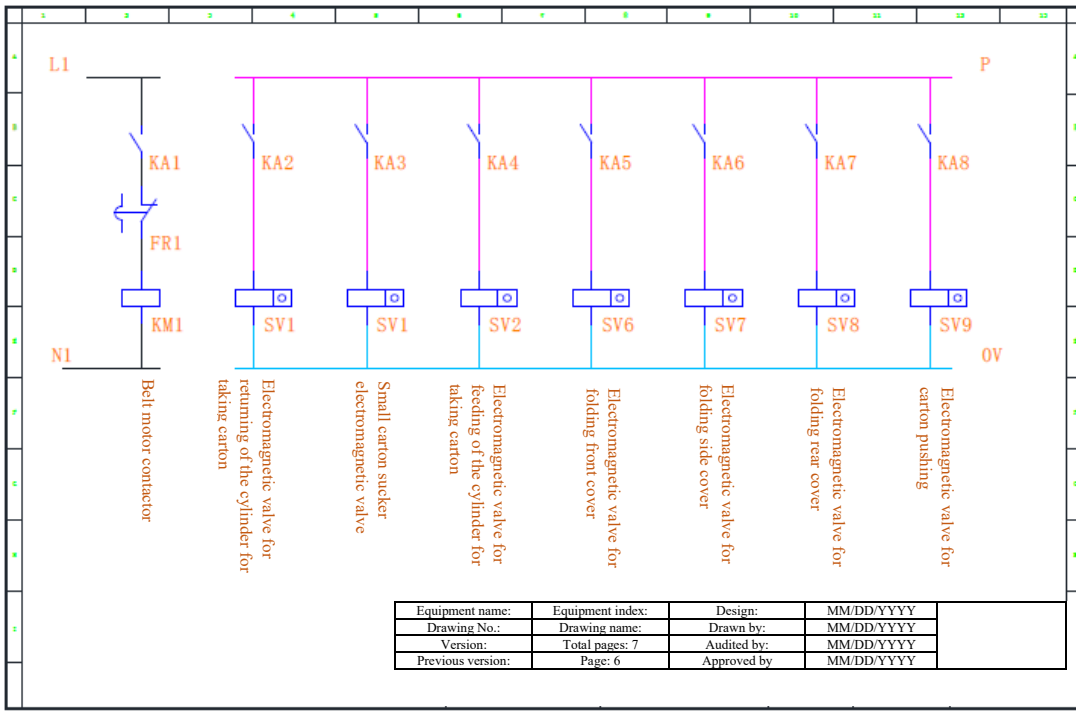


Electrical

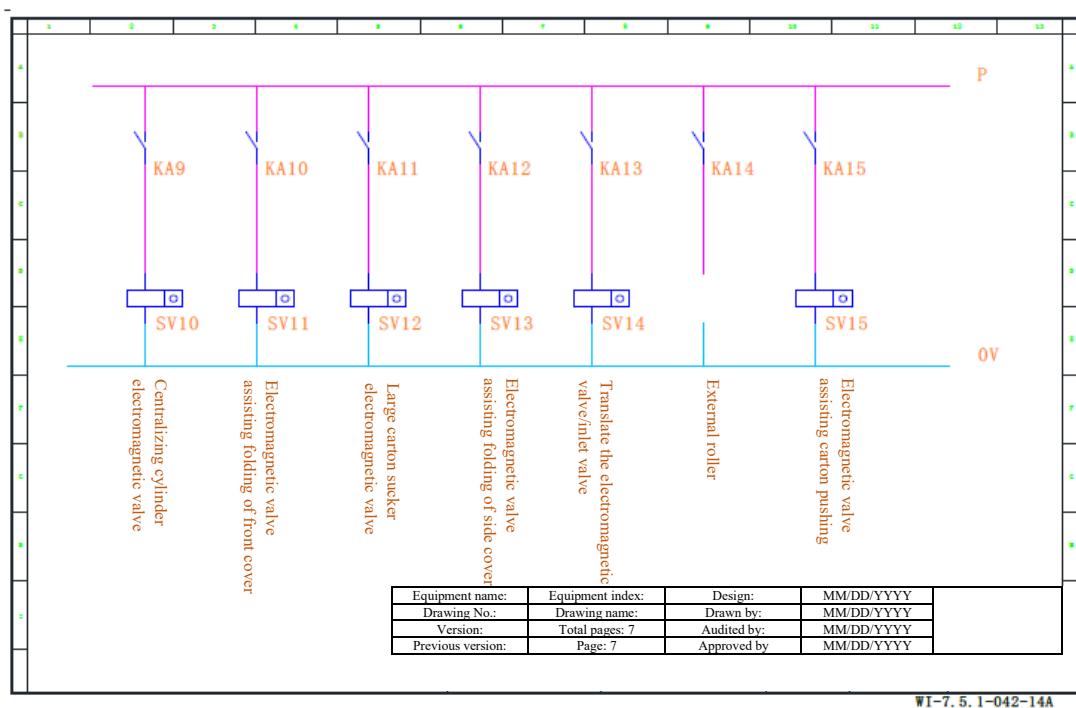








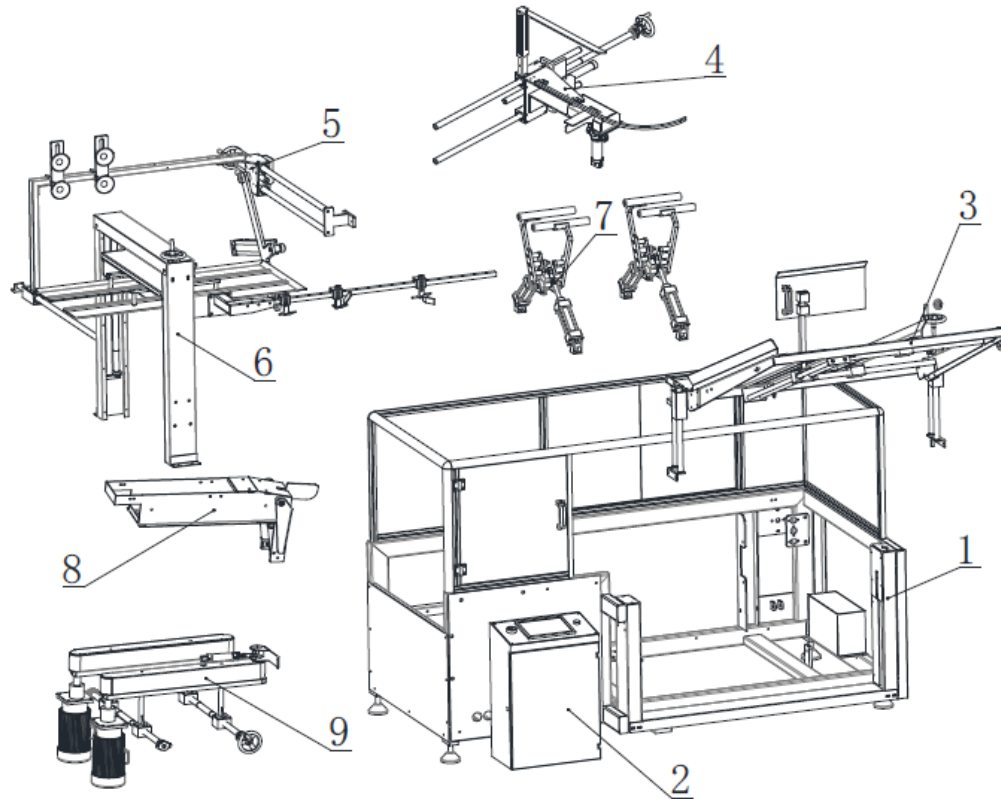
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WI-7.5.1-042-14A

## Exploded Views

### Main body

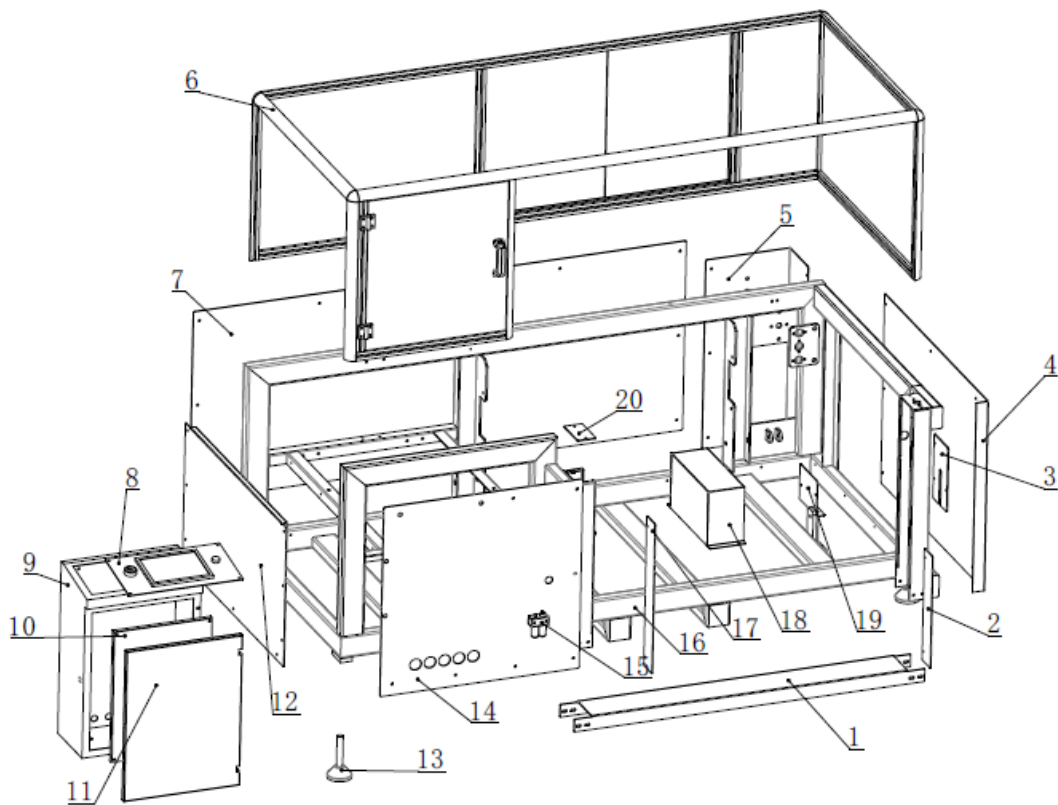


### Part List

S/N	Name	Quantity	Remarks
1	Main frame	1	
2	Distribution box	1	
3	Trough mechanism	1	
4	Rear cover folding and carton feeding mechanism	1	
5	Carton picking mechanism	1	
6	Regulating mechanism for carton pressing	1	

7	Sider cover folding mechanism	1	
8	Front cover folding mechanism	1	
9	Belt conveying mechanism	1	

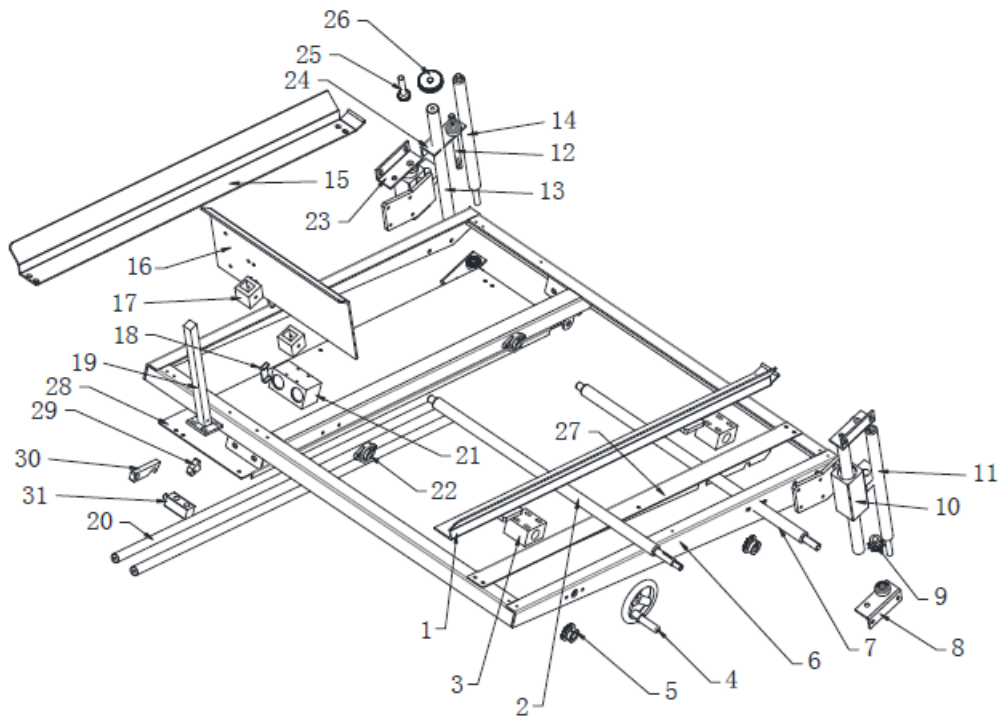
## Frame & Chassis



Part List

S/N	Name	Quantity	Remarks
1	Trough chain cover	1	
2	Lower side sealing plate of right upright column	1	
3	Upper side sealing plate of right upright column	1	
4	Right side sealing plate of main frame	1	
5	Corner sealing plate of main frame	1	
6	Shield	1	
7	Rear sealing plate of main frame	1	
8	Control panel	1	
9	Distribution box	1	
10	Switch panel	1	
11	Distribution box door	1	
12	Left side sealing plate of main frame	1	
13	M20 foot cup	4	
14	Front sealing plate of main frame	1	
15	Air filter	1	
16	Main frame	1	
17	Lower side sealing plate of left upright column	1	
18	Rolling plate cover	1	
19	Flowing fixed plate	1	
20	Upper cover of upright column	1	

## Loading Deck

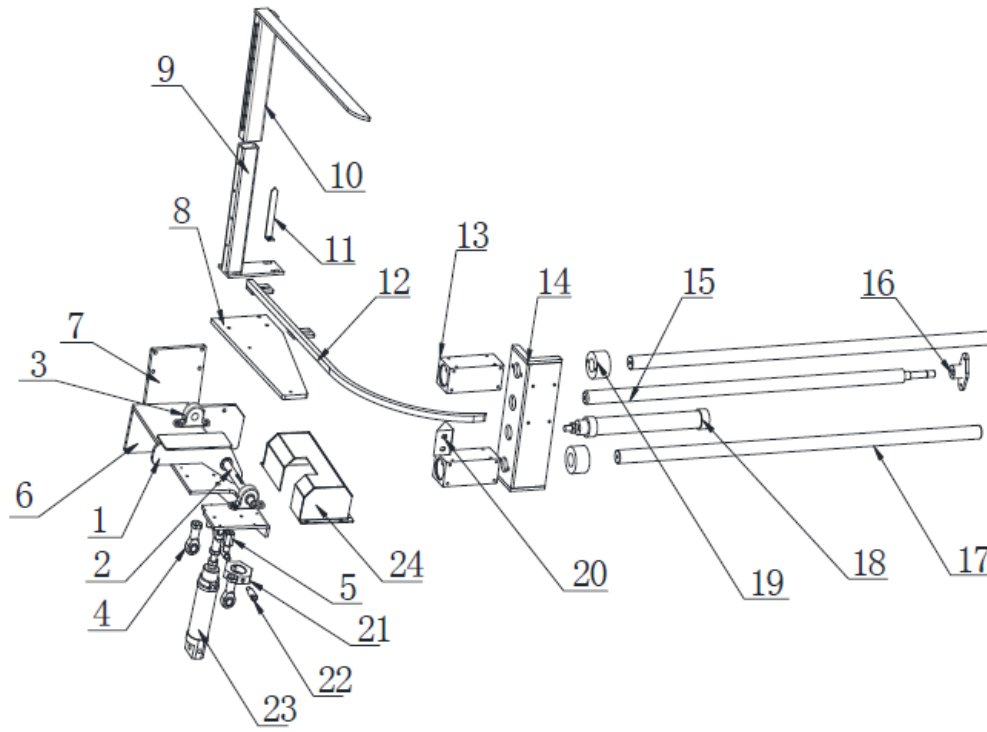


## Part List

S/N	Name	Quantity	Remarks
1	Movable stock guide of trough	1	
2	Driving threaded rod of trough	1	
3	Left threaded rod of trough	2	
4	Two pairs of hand wheels	2	$\phi$ 12*100
5	Chain Wheel	2	3分12T $\phi$ 15
6	Material rest	1	
7	Driven threaded rod of trough	1	
8	6001 Lower angle iron of upright column	2	
9	Chain Wheel	2	3分10T $\phi$ 12

10	Upright column sliding block of trough	2	
11	Driving threaded rod of upright column	1	
12	Spindle extension for threaded rod	1	
13	Upright column sliding axle of trough	2	
14	Driven threaded rod of upright column	1	
15	Fixed stock guide of trough	1	
16	Pressing plate of trough	1	
17	Square adjustable iron	2	
18	U-shaped gasket	1	
19	Carton pressing rod	1	
20	Carton pressing sliding axle	2	
21	Trough sliding block	1	
22	Horizontal bearing	4	KFL002
23	Angle iron of central upright column	2	
24	Angle iron of top upright column	1	
25	Pinion	1	1.0M18T 66L
26	Bull gear	1	1.0M50T 25L
27	Small cover plate of material rest	1	
28	Large cover plate of material rest	1	
29	Material rest buckle-hanger	1	
30	Material rest buckle-fabricated section	1	
31	Fixed seat of material rest buckle	1	

## Push Arm

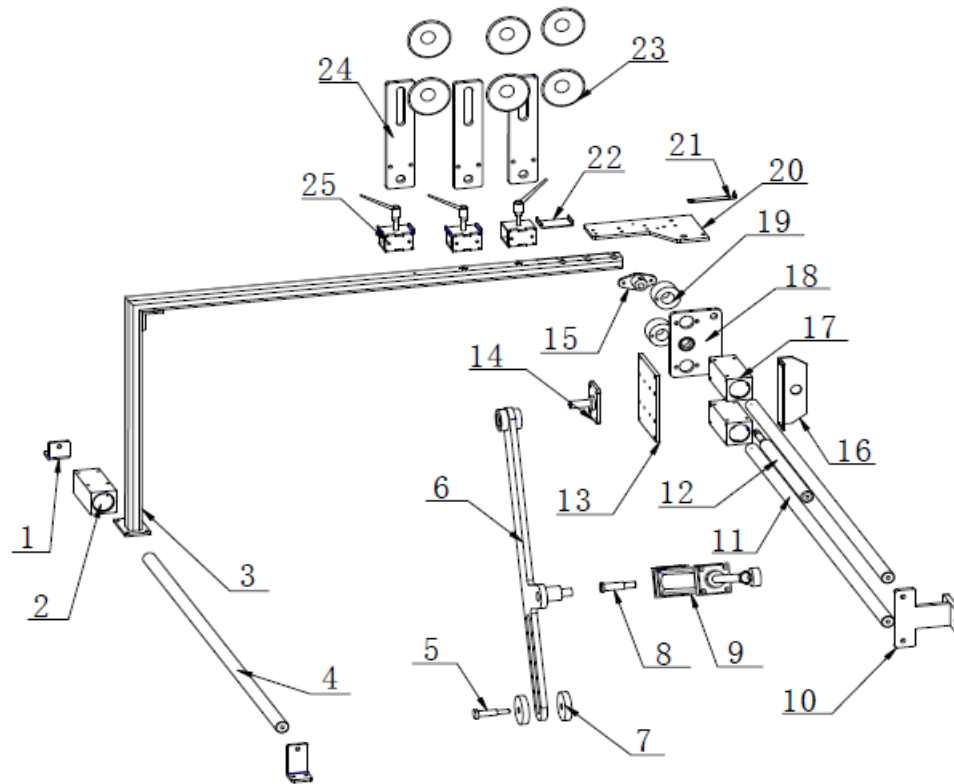


## Part List

S/N	Name	Quantity	Remarks
1	Fold the rear cover	1	
2	Folded rear cover axle	1	
3	Vertical bearing	2	KP002
4	Fisheye (right)	3	M12*1.25
5	Fisheye connection axle	2	
6	Fixed plate of rear cover folding	1	
7	Connecting plate for sliding block of carton feeding	1	
8	Carton pushing plate	1	
9	Support pipe of carton pushing auxiliary rod	1	

10	Carton pushing auxiliary rod	1	
11	Index	1	
12	Main carton-pushing rod	1	
13	Carton pushing sliding block	1	
14	Carton pushing set	1	
15	Carton pushing threaded rod	1	
16	Locking seat of threaded rod	1	
17	Carton pushing sliding axle	1	
18	Push the carton cylinder out	1	MAC32X250-S-CA
29	Bushing of sliding axle	2	
20	Fixed seat of carton pushing cylinder	1	
21	Side cover folding-cylinder locking seat	1	
22	Rear cover folding-cylinder locking axle	2	
23	Cylinder	1	MAC40X55-S-U
24	Shield of rear cover folding	1	

## Carton Suction Picker

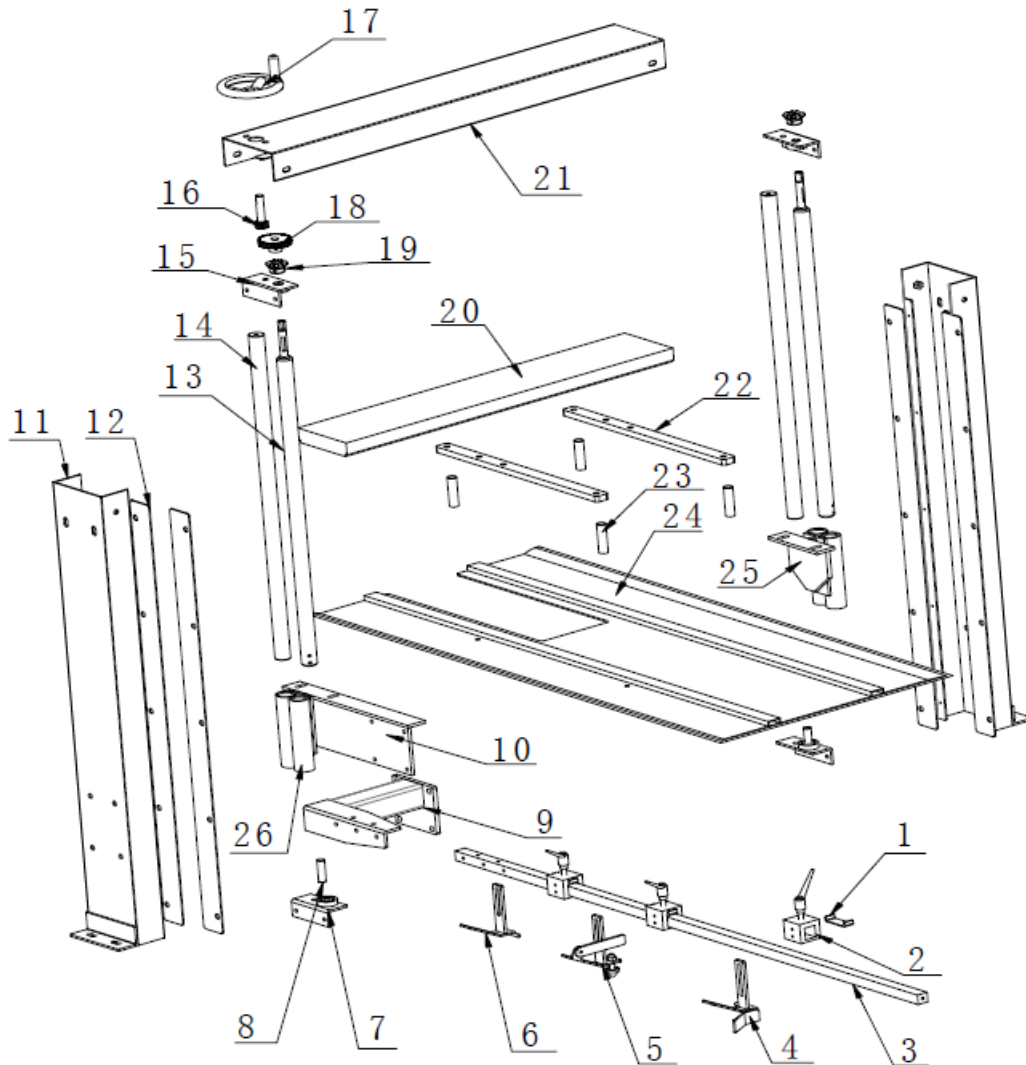


### Part List

S/N	Name	Quantity	Remarks
1	Fixed angle iron of auxiliary sliding axle	2	(1 for the long and 1 for the short)
2	Auxiliary sliding block of carton-sucking rod	1	
3	Carton-pushing auxiliary rod	1	
4	Auxiliary rod sliding axle	1	
5	Hexagonal screw M12*70	1	Dacromet
6	Carton picking rod pendulum	1	
7	Sliding sheet for carton picking swing rod	2	
8	Fixed axle of carton picking cylinder	1	
9	Carton picking cylinder	1	SC50X250-S-CA

10	Front fixed seat of carton-sucking sliding axle	1	
11	Carton picking sliding axle	2	
12	Carton picking threaded rod	1	
13	Connecting plate for sliding block of carton picking	1	
14	Upper fixed seat of carton picking cylinder	1	
15	Locking seat of threaded rod	1	
16	Fixed seat of buffer	1	
17	Carton picking sliding block	2	
18	Carton picking positioning plate	1	
19	Bushing of sliding axle	2	
20	Fixed seat of sucker rod	1	
21	Index	1	
22	U-shaped gasket	2	
23	Sucker	6	Single pole 60MM
24	Sucker fixed plate	3	
25	Fixed adjustment set of sucker	3	

## Adjusting Mechanism

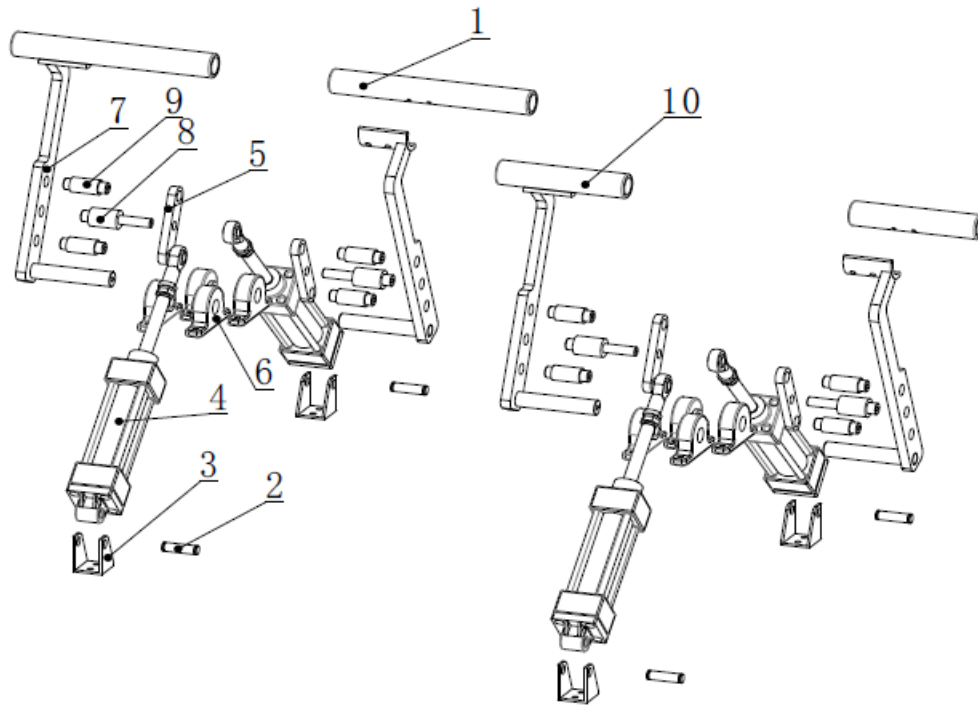


### Part List

S/N	Name	Quantity	Remarks
1	U-shaped gasket	3	
2	Square adjustable iron	3	
3	Carton blocking rod	1	
4	Right adjusting block	1	

5	Middle adjusting block	1	
6	Left adjusting block	1	
7	Lower angle iron of vertical material	2	
8	Threaded rod foot axle	2	
9	Fixed seat of carton blocking rod	1	
10	Fixed plate 2 of vertical material dual threaded rods	1	
11	Vertical material	2	
12	Side over of vertical material	4	
13	Threaded rod of vertical material	2	
14	Sliding axle of vertical material	2	
15	Upper angle iron of vertical material	2	
16	Pinion	1	1.0M18T 66L
17	Two pairs of hand wheels	1	φ 12*125
18	Bull gear	1	1.0M50T 18L
19	Chain Wheel	2	3-part 10T φ 12
20	Carton pressing fixed beam	1	
21	Vertical material chain cover	1	
22	Carton pressing fixed plate	2	
23	Carton pressing adjusting axle	4	
24	Carton pressing plate	1	
25	Fixed plate 1 of vertical material dual threaded rods	1	
26	Vertical material dual threaded rods	2	

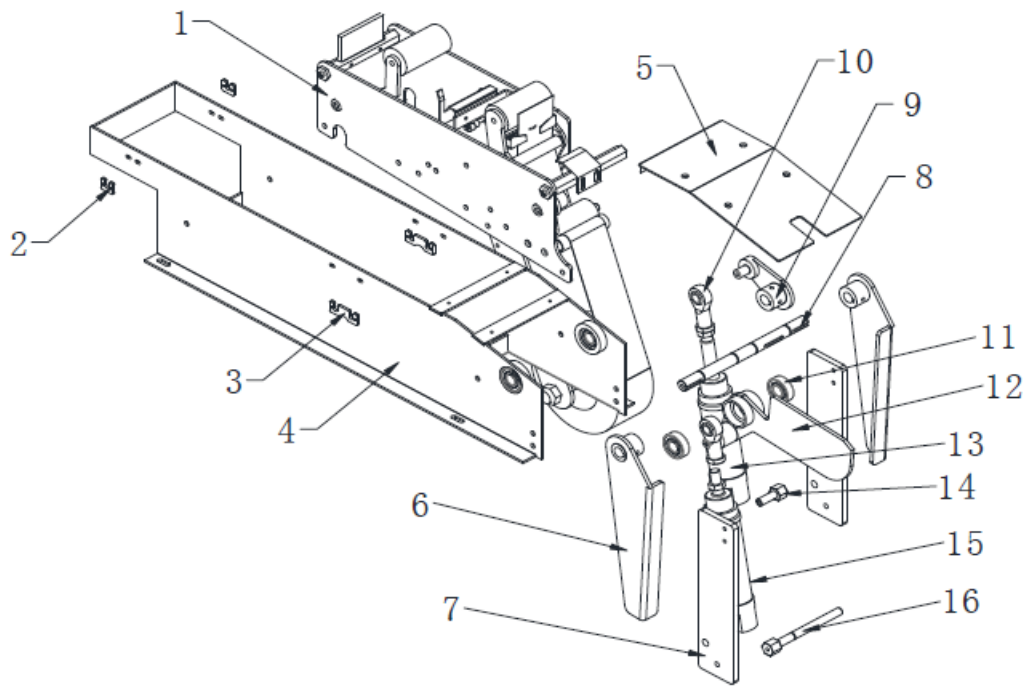
## Sider Flap Folding Mechanism



### Part List

S/N	Name	Quantity	Remarks
1	Side cover folding pipeline	2	
2	Cylinder locking axle	4	
3	Cylinder seat of side cover folding	4	
4	Side cover folding cylinder	4	SI40X100-S-CA
5	Locking piece of side cover folding	4	
6	Base bearing	8	KP004
7	Swing rod of side cover folding	4	
8	Fixed axle of side cover folding cylinder	4	
9	Reinforcing column of side cover folding cylinder	4	
10	Side cover folding pipeline (short)	2	

## Front Flap Closing Mechanism with Tape Head

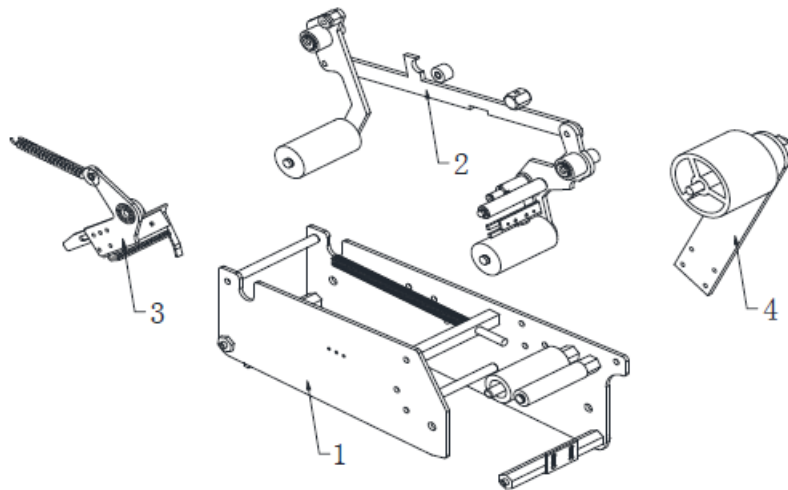


### Part List

S/N	Name	Quantity	Remarks
1	Tape sticker	1	
2	Single U cramp	2	
3	Dual U cramp	2	
4	Lower cutter holder	1	
5	Cutting cover plate	1	
6	Auxiliary plate of front cover folding	2	
7	Fixed plate of front cylinder folding	2	
8	Front cover folding axle	1	
9	Auxiliary swing rod of front cover folding	1	

10	Fisheye lens	2	M12*1. 25
11	Bearing	4	NSK6202
12	Fold the front cover	1	
13	Cylinder	1	MAC40X55-S-CA
14	Fixed axle of front cover folding auxiliary cylinder	1	
15	Cylinder	1	MAC40X70-S-CA
16	Fixed axle of front cover folding cylinder	1	
17			

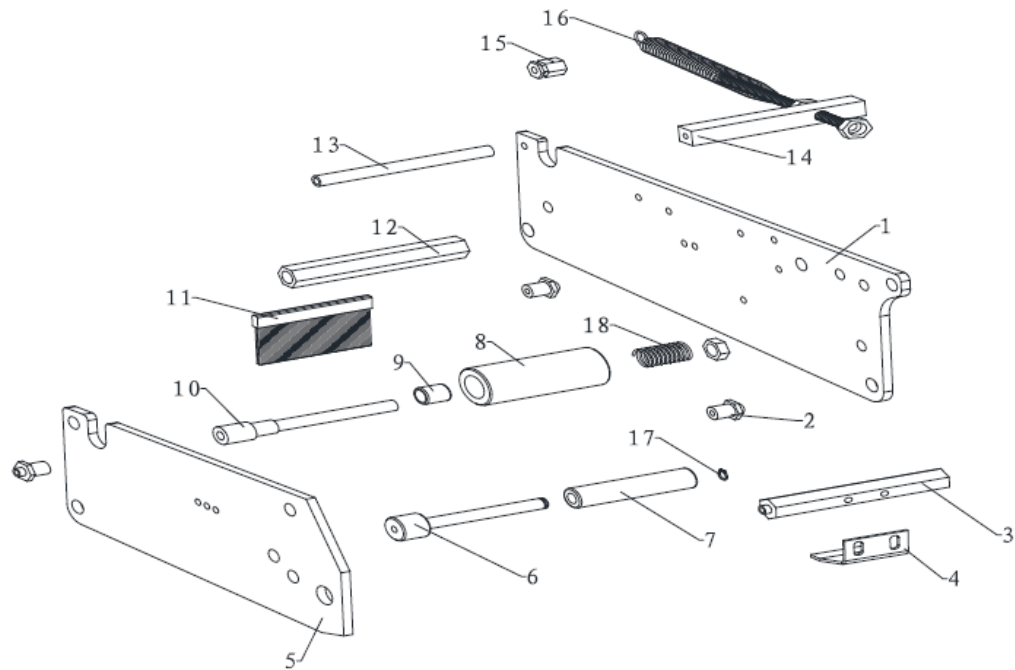
## Tape Head



## Part List

S/N	Name	Quantity	Remarks
1	Mandrel frame part	1	
2	Swing arm part	1	
3	Cutter part	1	
4	Tape holder part	1	

## Tape Head Frame

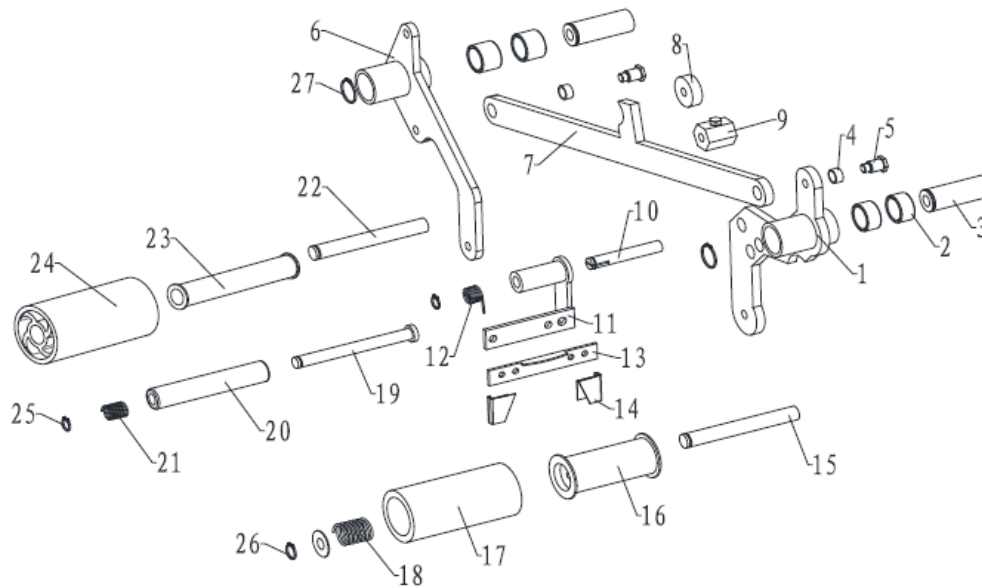


### Part List

S/N	Specification	Drawing No.	Name	Quantity
1	434*147*4	T3-001-1	Large left panel	1
2	17*20//45/Galvanized	T3-21	Hexagonal threaded axle	3
3	Subtense 17*128	T3-06	Front pivot axle	1
4		T3-050A	Front guide plate	1
5	310*135*4	T3-002-1	Small right panel	1
6	Subtense 17*101	T3-07	PE guide wheel axle	1

7	φ 20*80	T3-08	PE Tape guide roller	1
8	φ 35*80	T3-01	One-way knurl wheel	1
9			One-way bearing	1
10	Subtense 14*118	T3-03	One-way wheel axle	1
11	8*11*46*75MM/3 Cun		Brush	1
12	Subtense 17*116	T3-10	Brush locking axle	1
13	φ 10*116	T3-09	Panel locking axle	1
14	Subtense 14*116	T3-11	Locking square axle of main tension spring	1
15	Subtense 14*17	T3-19	Locking hexagonal axle of main tension spring	1
16	φ 1.8* φ 13.5*220	dh-01-02	Lower long tension spring	1
17	φ 10		Axle calliper (outside calliper)	1
18	φ 1.6* φ 12.5*25	dh-01-06	One-way wheel pressure spring	1

## Tension Arms



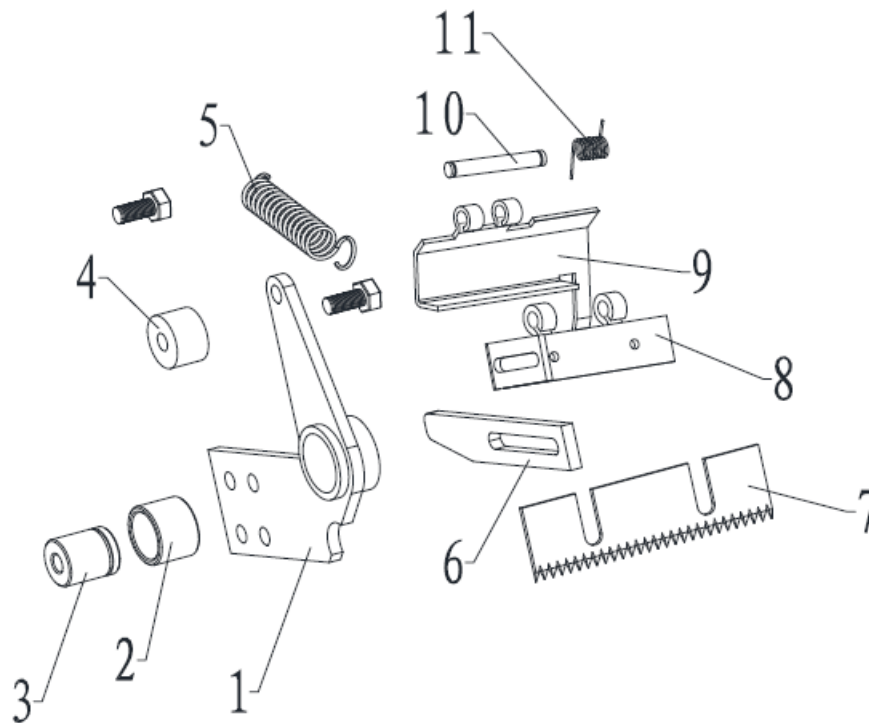
### Part List

S/N	Specification	Drawing No.	Name	Quantity
1		T3-003	Front swing arm/forward direction	1
2	$\phi 16 * \phi 20 * 12$	TG-101	Front and rear swing cutter copper bush	4
3	15.9*43	T3-15	Front and rear swing fixed axle (eccentric axle)	2
4	$\phi 8 * \text{step } 10 * 4.9$	T3-901	Connecting rod copper bush	2
5	10*10*15. 5//45/ galvanized	T3-18	Connecting rod hexagonal threaded axle	2
6		T3-004	Rear swing arm/forward direction	1
7	356*20*5	T3-005	Connecting rod	1

8	φ 8* φ 18*12	T3-50	Connecting rod catch wheel	1
9	Subtense 17*20	T3-24	Tape sticker wheel adjusting hexagonal column	1
10	φ 8*50	T3-12	U-shape guide belt seat axle	1
11		T3-009	Tape support frame (right, U-shape)	1
12	φ 1.2* φ 10*14		Top plate torsional spring/right torsional spring	1
13	78*12*2	T3-008	Tape top plate	1
14		T3-27	Buckle slab	2
15	φ 10*81	T3-05	3-cun tape sticker wheel axle	1
16	φ 10.1* φ 28*82/ Black rubber	FX03A-14	Front rubber wheel core sleeve 3 cun	1
17	φ 26*38*80.5/ Black rubber	FX03A-15	Front rubber wheel 3 cun	1
18	φ 1* φ 14*22//65N/Galvanized	FX03-01-14-22	Rubber wheel pressure spring -pressure spring	1
19	φ 11*84	T3-04	Knurl guide wheel axle	1
20	φ 15*80	T3-02	Knurl guide wheel	1
21	φ 8* φ 9.9*12//65N/ Galvanized	dh-01-10	Small knurl guide wheel pressure spring	1

22	φ 10*85.5//A3/ Galvanized	T3-05E	Tape wheel axle	1
23	φ 10.1* φ 16*83/ Black rubber	FX03A-17	Rear rubber wheel core sleeve 3 cun	1
24	φ 15*43*82/ black rubber	FX03A-16	Rear rubber wheel 3 cun	1
25	φ 8		Axle calliper (outside calliper)	2
26	φ 10		Axle calliper (outside calliper)	2
27	φ 16		Axle calliper (outside calliper)	2

## Tape Cutter

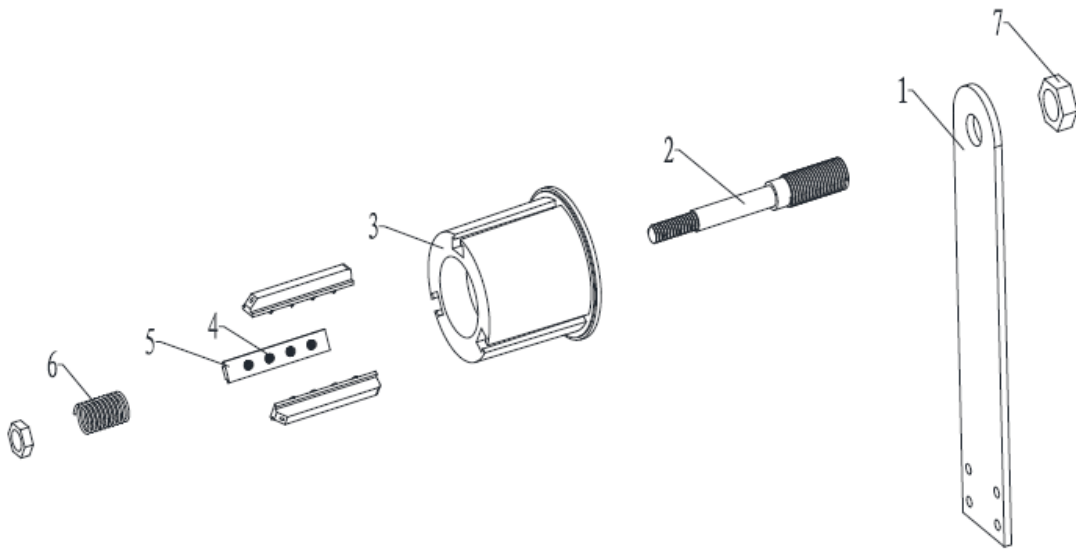


### Part List

S/N	Specification	Drawing No.	Name	Quantity
1	95.2*95*12//45 /Galvanized	T3-012	Cutter holder: One side is a triangle (front)	1
2	φ 16* φ 20*12	TG-101	Front and rear swing cutter copper	1
			Set(s)	
3	φ 15.9*15.5	T3-17	Fixed axle for cutter holder	1
4	φ 18* φ 22*6	T3-51	Catch wheel for cutter holder	1
5	φ 1.2* φ 10*51.6	dh-01-03	Cutter tension spring	1

6	90*15*4	T3-007	Extension sheet	1
7	K-84*25*1.5-28 T		Blade: 3 cun/old	1
8	93*20	FX500-00-01-50	Bracket/cutter holder: L-Shape	1
9	85*66	FX500-00-01-52	Protective cutter cover	1
10	φ 5*50	T2-05A	Protective cutter cover axle center	1
11	φ 0.8* φ 6*10.2	dh-01-08	Protective cutter cover knob spring	1

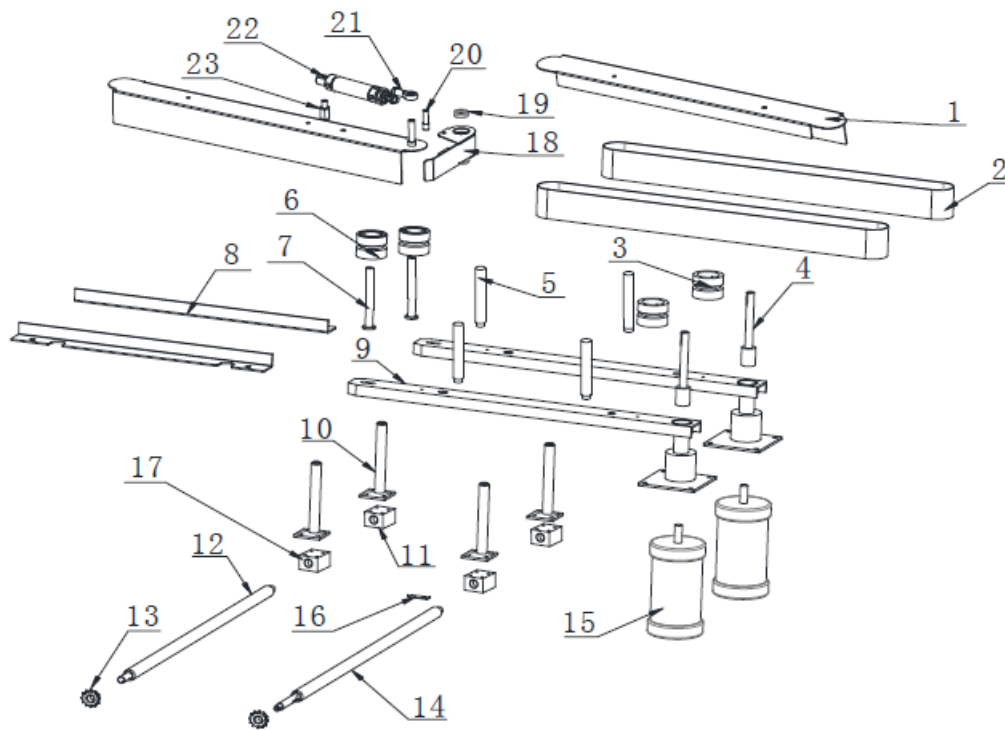
## Tape Arm



## Part List

S/N	Specification	Drawing No.	Name	Quantity
1	270*50*5	T3-010	Tape holder support chip	1
2	M18*1*130	T3-25	Tape holder fixed axle	1
3	φ 85* φ 12.1*64/ Polyamide (PA)	FX3A-10	Tape holder (round)	1
4	φ 0.6* φ 3.5*13//65N/ galvanized	dh-01-05A	Tape wheel small pressure spring	12
5	12*9*61/ Polyamide (PA)	FX3A-10	Tape holder tensioning block/tape holder (round) attachment	3
6	φ 2.2* φ 18*32	dh-01-09	Tape wheel pressure spring	1
7	M18*1*10	T3-20	Tape holder fixing nut	1

## Conveyor Belt



Part List

S/N	Name	Quantity	Remarks
1	Belt cover	2	
2	Belt	2	1520*75
3	Aluminum driving wheel	2	
4	Driving axle	2	
5	Belt cover support column	4	
6	Aluminum driven wheel	2	
7	Driven axle	2	
8	Belt guide plate	2	
9	Belt seat	2	
10	Bracket	4	

11	Right threaded block	2	
12	Left and right driven threaded rod	1	
13	Chain Wheel	2	3分12T \$ 15
14	Left and right driving threaded rod	1	
15	Motor	2	CV-18-100-15A
16	Index	1	
17	Left threaded block	2	
18	Upper belt cover-carton blocking bracket	1	
19	Bearing	2	NSK6001
20	Fisheye axle of carton blocking bracket	1	
21	Fisheye (right)	1	M10*1. 25
22	Cylinder	1	MAC32*50-S-CA
23	Fixed axle of cylinder for carton blocking bracket	1	