



# TWA1000-E

WATER ACTIVATED TAPE DISPENSER

# OPERATIONS MANUAL & PARTS LIST



Serial Numbers U9706 XX X XXX

# TABLE OF CONTENTS

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Section 1	<a href="#"><u>Table Of Contents</u></a> -----	2
Section 2	<a href="#"><u>Technical Assistance</u></a> -----	4
Section 3	<a href="#"><u>Warranty</u></a> -----	5
Section 4	<a href="#"><u>Description Of Tape Dispenser</u></a> -----	6
Section 5	<a href="#"><u>Safety Issues</u></a> -----	7
Section 6	<a href="#"><u>Specifications</u></a> -----	9
	<a href="#"><u>Water Activated Taper Dimensions</u></a> -----	9
	<a href="#"><u>Water Activated Taper Components</u></a> -----	10
	<a href="#"><u>Water Activated Taper Specifications</u></a> -----	15
Section 7	<a href="#"><u>Set Up Procedures</u></a> -----	16
	<a href="#"><u>Power Cord &amp; Power Switch</u></a> -----	16
	<a href="#"><u>Tape Loading</u></a> -----	17
	<a href="#"><u>Tape Threading</u></a> -----	18
	<a href="#"><u>Filling The Water Bottle</u></a> -----	19
	<a href="#"><u>Removing The Water Pot</u></a> -----	19
	<a href="#"><u>Removing The Moistening Roller</u></a> -----	20
	<a href="#"><u>Adjusting The Water Pot Water Level &amp; Weight</u></a> ----	21
	<a href="#"><u>Optional Dispense On Demand Photo Eye</u></a> -----	22
Section 8	<a href="#"><u>Operating Instructions</u></a> -----	23
	<a href="#"><u>Dispensing Tape</u></a> -----	23
	<a href="#"><u>Selecting The Tape Length</u></a> -----	23
	<a href="#"><u>30 Color Coded Pre-Set Tape Lengths</u></a> -----	24
	<a href="#"><u>2 Pre-Programmed "Repeat Buttons"</u></a> -----	25
	<a href="#"><u>Infinite Or Continuous Length Button</u></a> -----	26
	<a href="#"><u>Optional Dispense On Demand Photo Eye</u></a> -----	27
Section 8	<a href="#"><u>Troubleshooting</u></a> -----	29
Section 9	<a href="#"><u>Recommended Spare Parts List</u></a> -----	31
Section 10	<a href="#"><u>Preventive Maintenance</u></a> -----	32
	<a href="#"><u>Cleaning The Tape Path</u></a> -----	32
	<a href="#"><u>Cleaning The Water Pot Assembly</u></a> -----	33
	<a href="#"><u>Cleaning The Cutter Blade</u></a> -----	34
	<a href="#"><u>Cutter Blade Maintenance</u></a> -----	35
	<a href="#"><u>Cutter Blade Replacement</u></a> -----	36
Section 11	<a href="#"><u>Appendix A-Illustrations And Parts Lists</u></a> -----	37

# REVISION CONTROL

REV00

Initial Release

# TECHNICAL ASSISTANCE

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## Technical Support

This is the Interpack Model E-H2O Electric Water Activated Taper you ordered. It has been set up and tested in our factory with Intertape manufactured Water Activated 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 Water Activated Taper **model number and serial number** available. This information can be found on the nameplate on the inside of the roll carriage of the machine. Interpack Technical Support is available during normal business hours (Eastern Time).

**PHONE 813-621-8410 x3070**

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

MODEL:

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SERIAL NUMBER:

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DISTRIBUTOR PURCHASED FROM:

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DATE OF PURCHASE:

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# WARRANTY

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**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 E-H2O WATER ACTIVATED TAPER

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**Figure 4-1**

The Interpack Family of Water Activated Tapers are designed to dispense pre-determined lengths of pre-moistened Intertape or Central Brand water activated carton sealing tape. This tape is then manually applied to the top and bottom center seam of regular slotted corrugated cartons.

This E-H2O Electric dispenses tape by depressing a pre-programmed push button on the control panel. If the optional **Dispense On Demand** photo eye is enabled, an object simply needs to break the plane of the photo eye and the pre-programmed tape length will automatically be dispensed.

## **SAFETY ISSUES**

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There is a safety label used on all Interpack Water Activated Tapers. This label is to warn operators and service personnel of the sharp cutting edge of the blade. Please read the label and the following safety precautions before using the Water Activated Taper.

- ✓ **Read this manual for other important safety operating and service information.**
- ✓ **Only trained personnel are to operate and service Water Activated Taper.**
- ✓ **Wear safety glasses.**
- ✓ **Unplug electrical power before servicing (Heater Models).**
- ✓ **All covers and guards must be in place before operating.**
- ✓ **Stay clear of moving parts which can shear and cut.**

***Note: Should any of the safety labels placed on the Water Activated Taper be damaged or destroyed, replacements are available.***

## SAFETY ISSUES

The illustrated label shown in **Figure 5-1** is attached to the top of the hinged cover. The label warns operators and service personnel of the very sharp knife used to cut the tape at the end of the tape application.

Turn electrical supplies off before servicing the water activated tape dispensers.

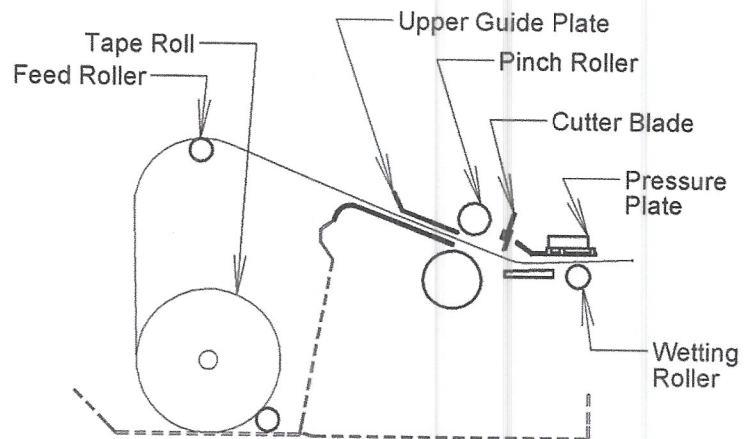


**Figure 5-1**

The illustrated label shown in **Figure 5-2** is attached to the inside cover of the water activated taper. The label provides operators and service personnel of the proper method of threading a new roll of tape through the machine.

More detailed information is provided in the "Set Up Procedures" portion of this manual.

Turn electrical supplies off before servicing the water activated taper.

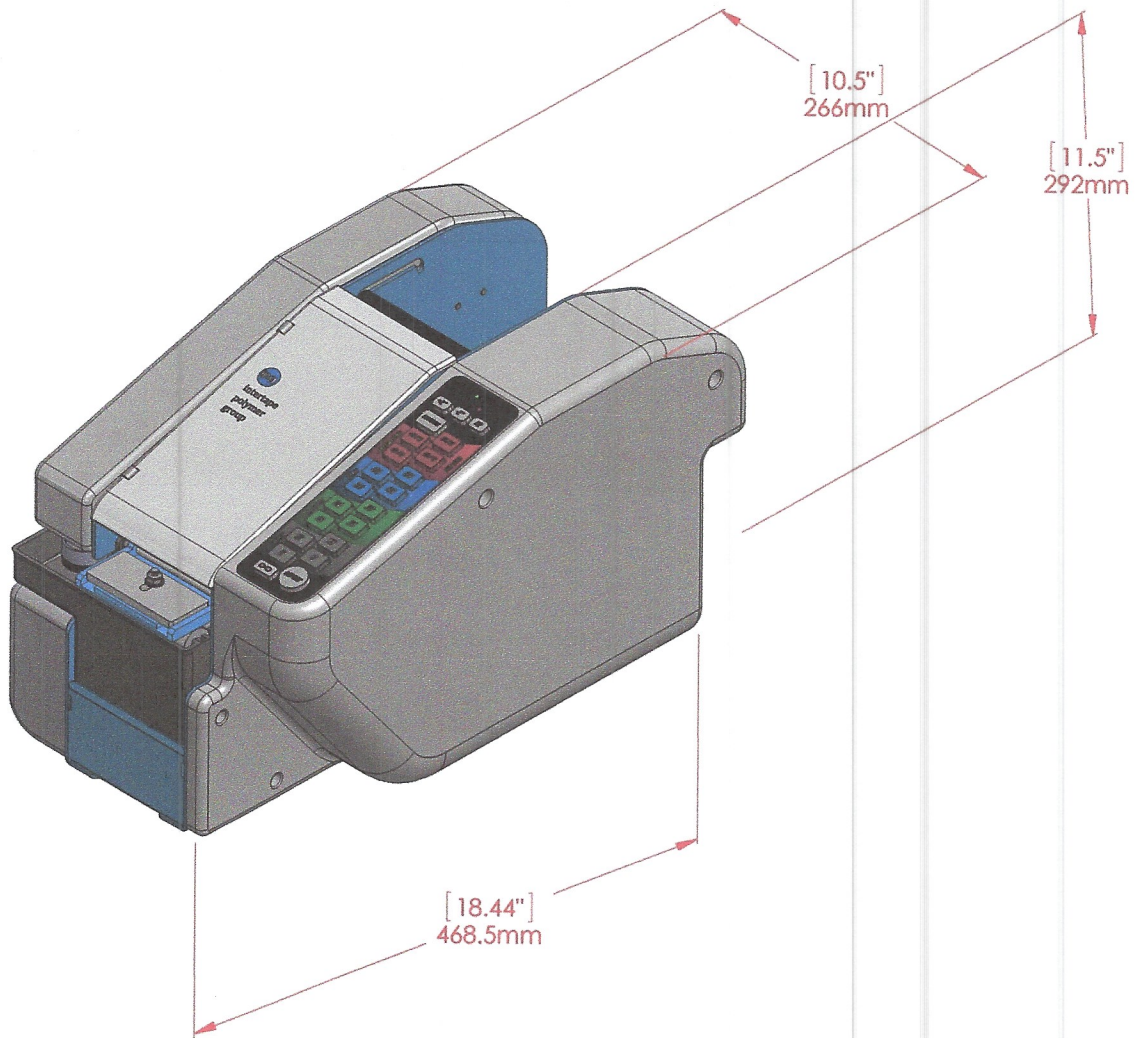


**Figure 5-2**



# SPECIFICATIONS

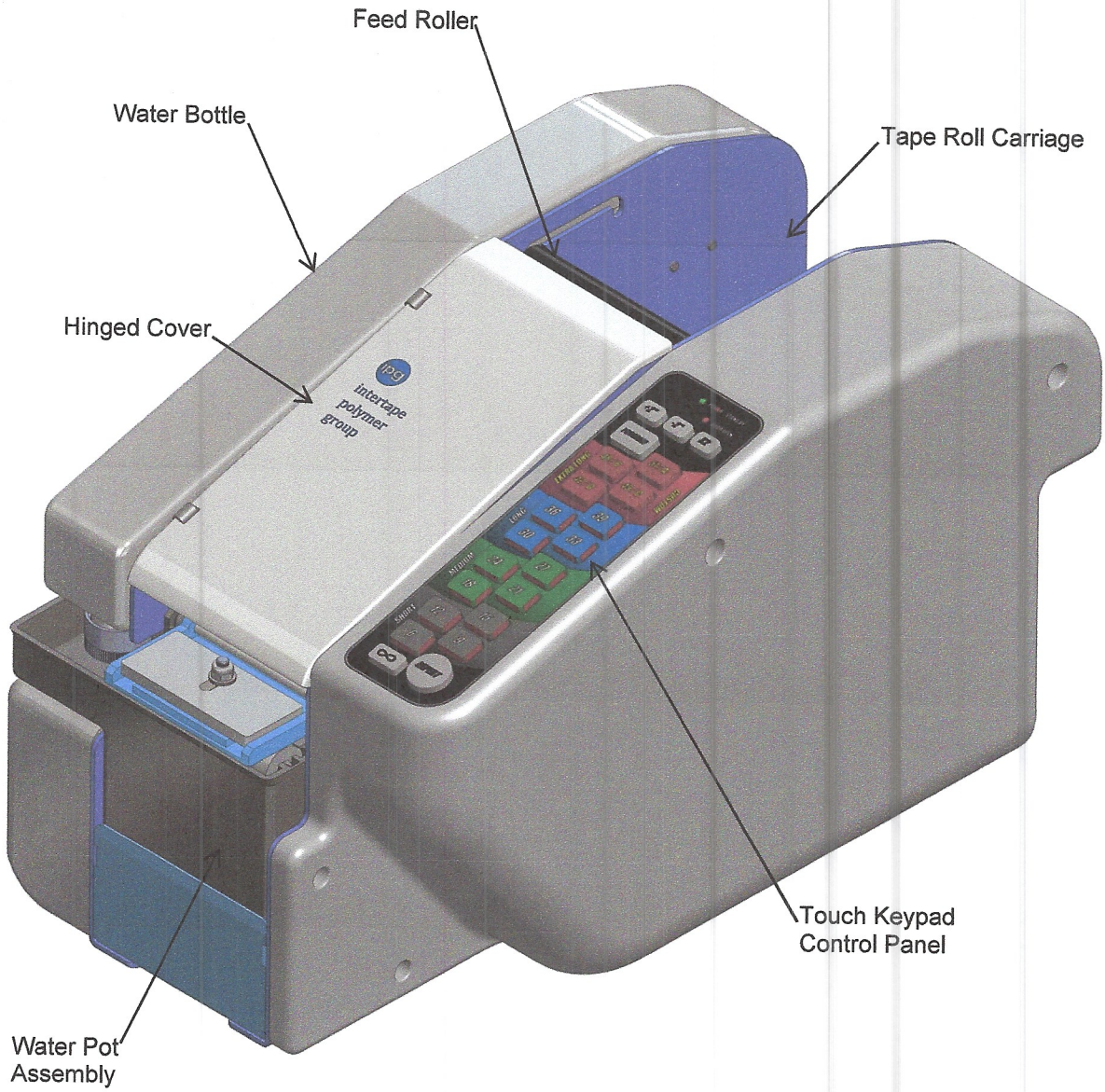
## Water Activated Taper Dimensions



**Figure 6-1**

# SPECIFICATIONS

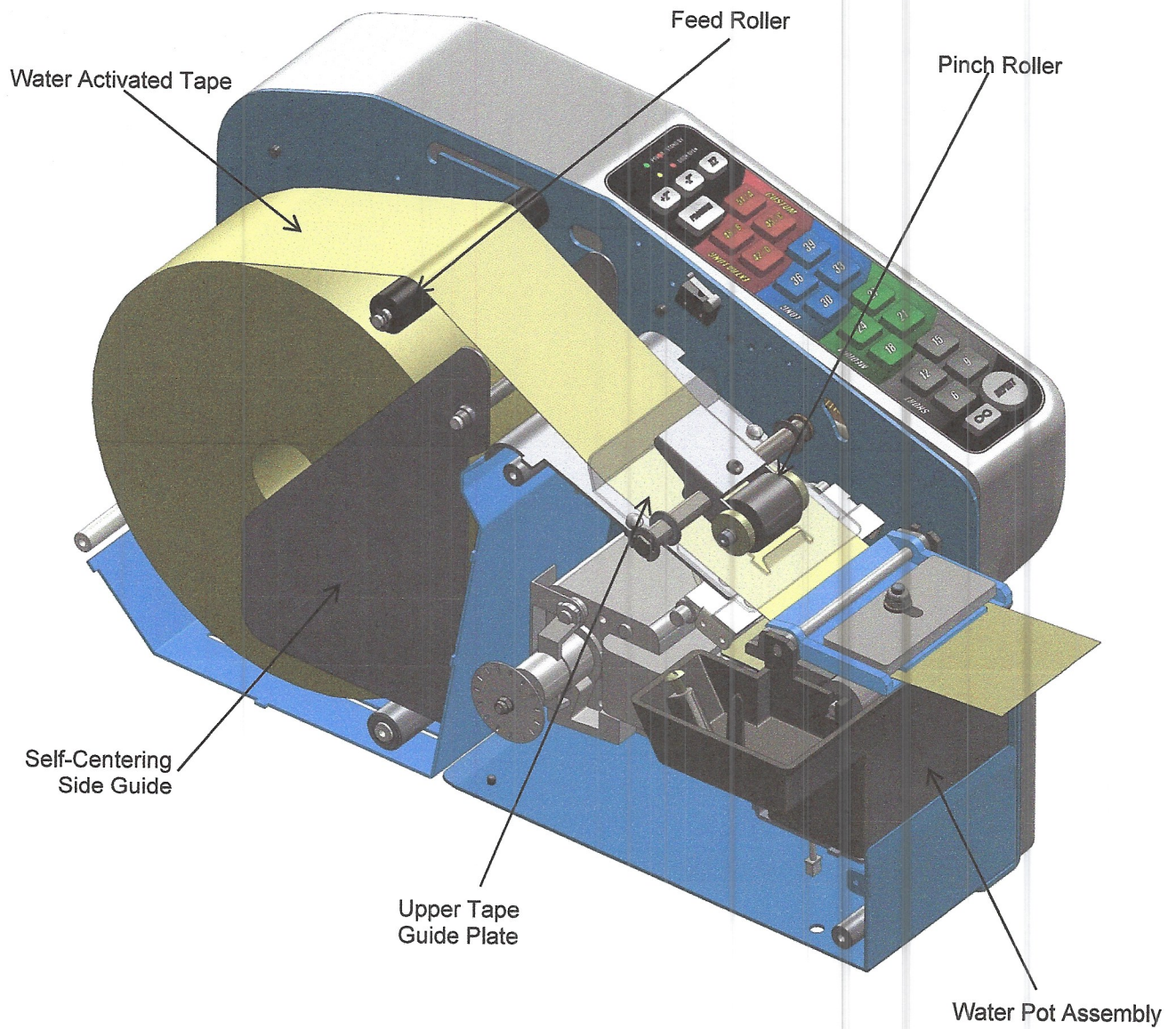
## Water Activated Taper Components



**Figure 6-2**

# SPECIFICATIONS

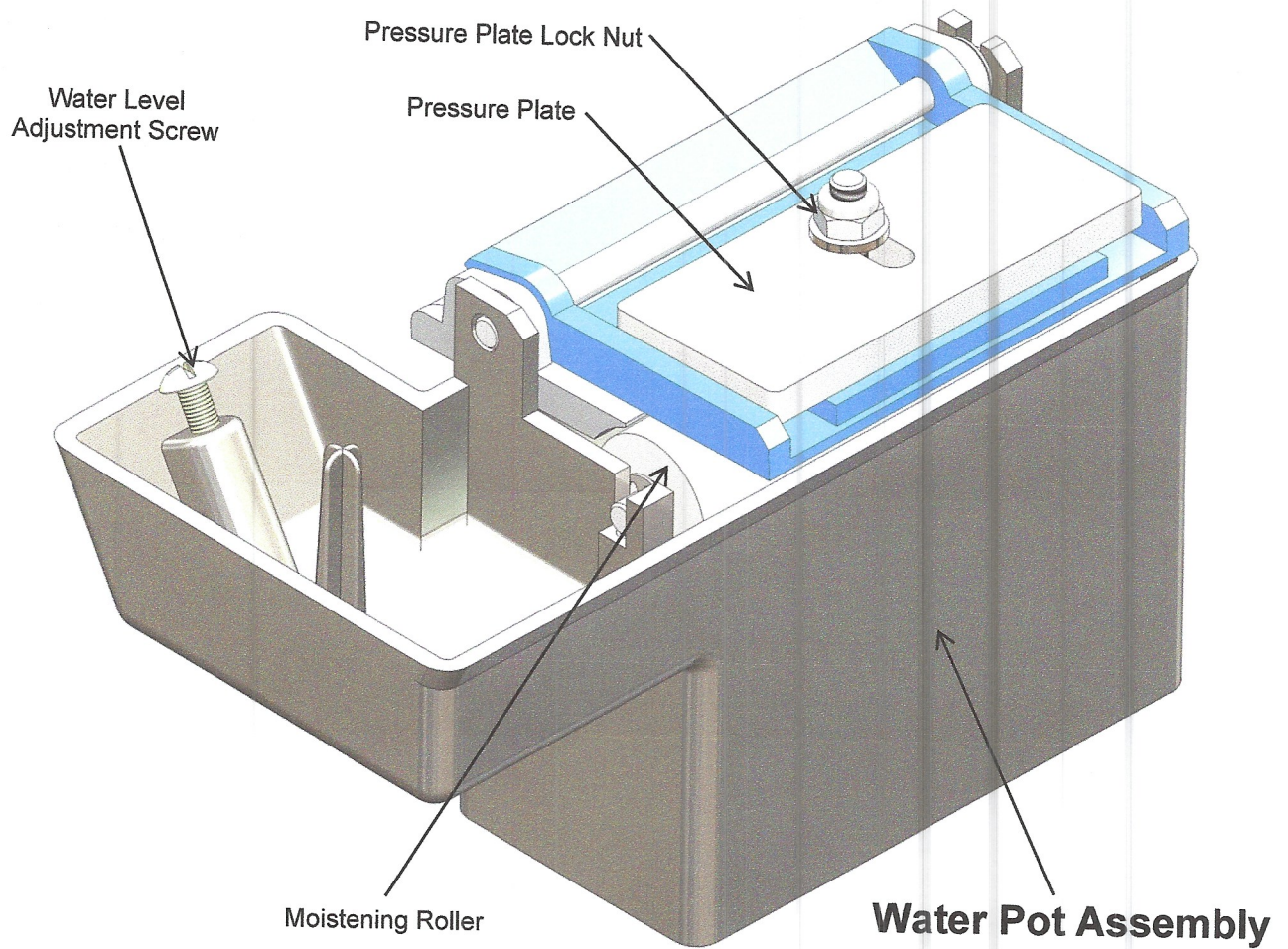
## Water Activated Taper Components



**Figure 6-3**

# SPECIFICATIONS

## Water Activated Taper Components



*Figure 6-4*

# SPECIFICATIONS

## Water Activated Taper Components

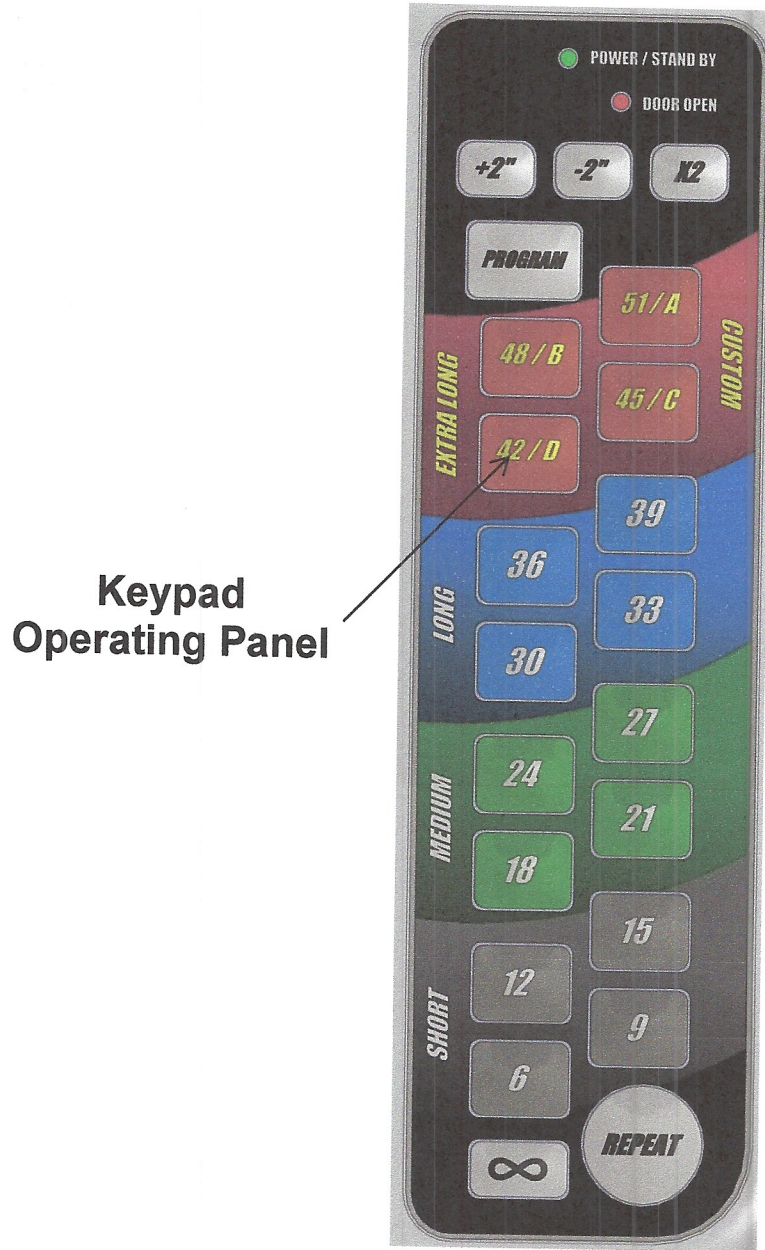


Figure 6-5

# SPECIFICATIONS

## Water Activated Taper Components



Figure 6-6

# **SPECIFICATIONS**

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## **Operating Conditions**

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

### **Note:**

*The E-H2O Dispenser should never be washed down or subjected to conditions causing condensation on components. Do not subject the E-H2O Dispenser to ANY harsh detergent or solvent wash down. The warranty will be voided as a result.*

## **E-H2O Electric Specifications**

### **General**

- Use Intertape or Central Brand Water Activated Carton Sealing Tape.

### **Style**

- Use with minimum 40 lb kraft or reinforced water activated tape

### **Tape Width**

- 1" to 3 ½" (will process Central "Red Alert" and IPG Double Tamper Evident grades of Water Activated Tape)

### **Tape Roll Diameter**

- Maximum of 10 inches (254 mm) core or coreless.  
(Accommodates 1000 foot (305 m) Central and Intertape roll lengths)

### **Minimum Tape Length (Using Preset Length Buttons)**

- 4 inches (101.6 mm)

### **Maximum Tape Length (Using Preset Length Buttons)**

- 102 inches (2591 mm)

### **Preset Tape Length Buttons**

- 16 Buttons

### **Auxiliary Buttons**

- 3 Length Modifier Buttons
- Program Button
- Infinite Button
- Repeat Button

### **Dispense On Demand Connector**

### **Water Heater**

- Water Temperature Automatically Maintained between 105-115 Degrees

### **Water Bottle Capacity**

- 60 ounces

### **Machine Weight (Shipped)**

- 39 lbs. (17.7 kg.)

# SET-UP PROCEDURES

## Receiving and Handling

All contents must be verified upon reception. The following items are included with each dispenser.

- E-H2O Electric Taper (Part Number U9706TW)
- Operators Manual (Part Number UDM9706)
- Power Cord (Part Number APE0133)

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

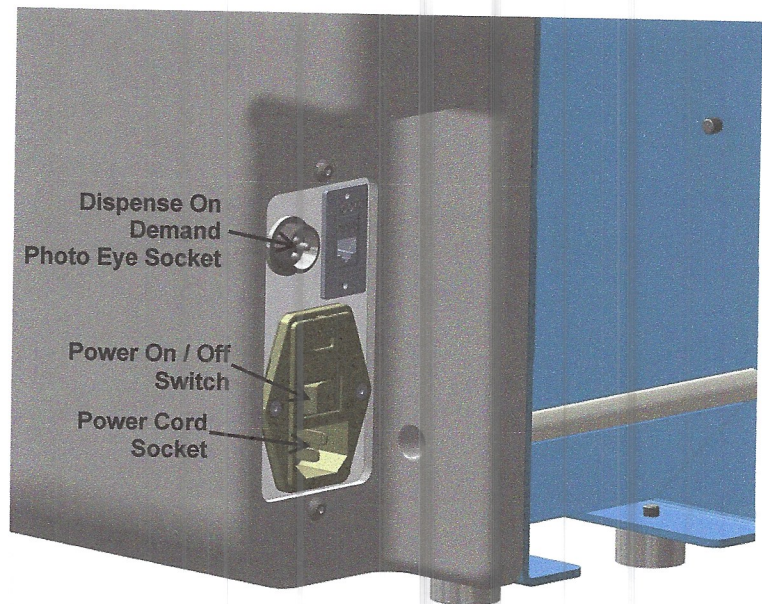
## Power Cord & Power Switch

On the rear of the dispenser is a panel with three (3) components.

To prepare the machine for use, it will be necessary to do the following:

1. Plug in the proper end of the power cord into the power cord socket.
2. Turn on the Power Switch.
3. If purchased, plug in and secure the "Dispense On Demand" photo eye (see page 21)

Further information in this manual will provide detailed information on the function of each of these components.



**Figure 7-1**



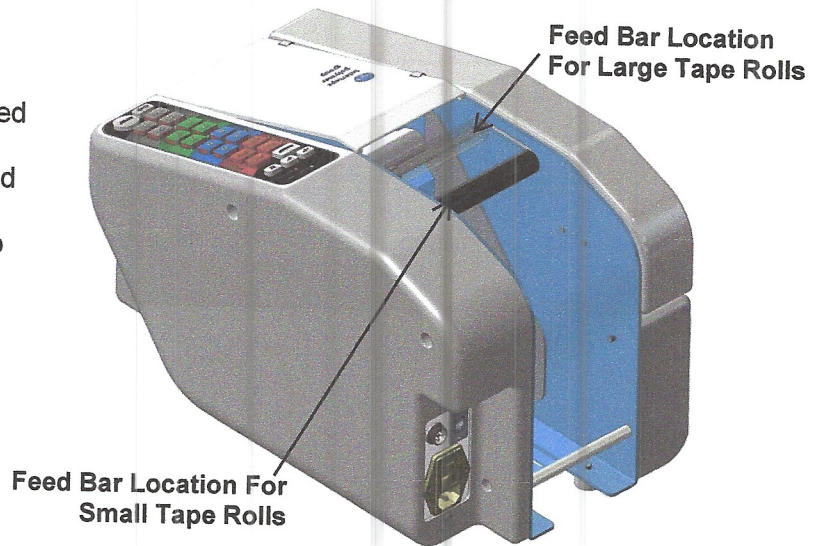
# SET -UP PROCEDURES

## Tape Loading

### Feed Bar Location Setting

The Feed Bar has two positions. The location is determined by the roll length.

1. Position the adjustable feed roller based on the roll length.
2. For larger, 1000 ft. rolls, locate the feed roller to the most forward position
3. For smaller rolls, locate the feed bar to the farthest rear position.



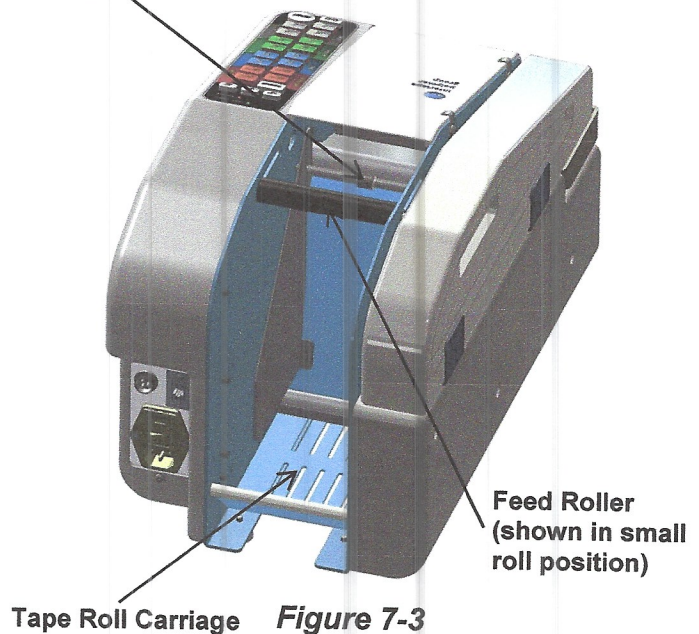
**Figure 7-2**

### Tape Roll Carriage

The Roll Carriage houses the tape roll and must be set up prior to use based on the roll width and roll length.

1. Open up the self-centering side guides using the adjustment knob to permit the insertion of the tape roll
2. Place the tape roll in the roll carriage with the tape tab feeding toward the discharge end of the machine
3. Adjust the width of the side guides using the adjustment knob so that they are about 1/8" away from the tape as it processes through the machine.

Side Guide Adjustment Knob

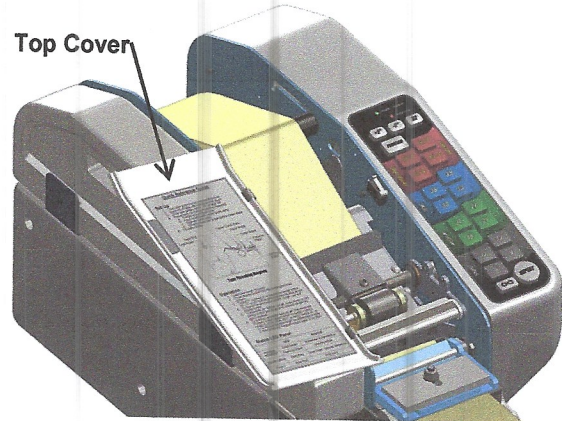


Tape Roll Carriage **Figure 7-3**

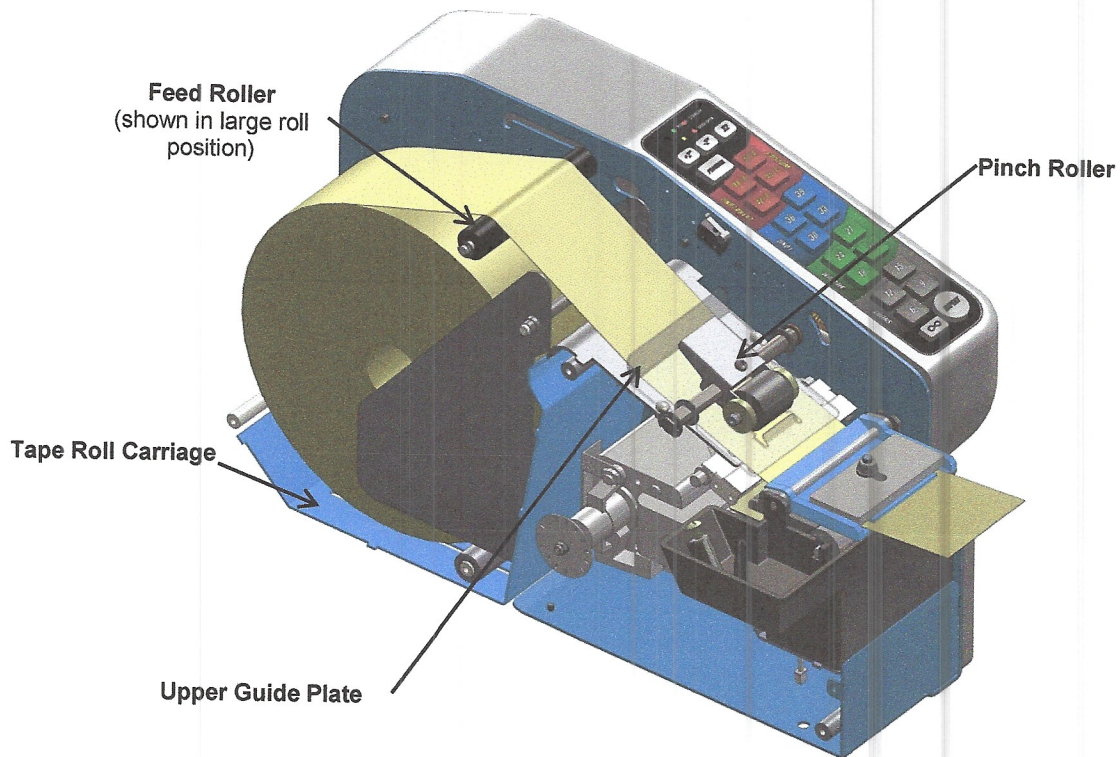
# SET-UP PROCEDURES

## Tape Threading

1. Open the **Top Cover** over the threading area
2. Depress the **Pinch Roller**.
3. Feed the tape leg over the **Feed Roller** and advance under the **Upper Guide Plate** and the **Pinch Roller** until you have reached the knife blade. Make sure to not feed too much tape so it passes underneath the blade as this may cause tape jams.
4. Close the top cover.



**Figure 7-4**



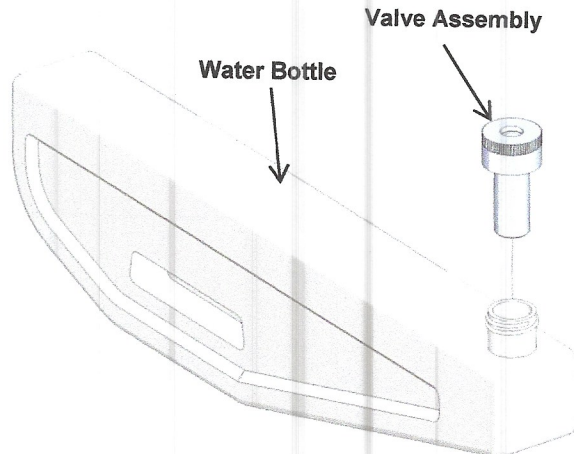
**Figure 7-5**

## SET-UP PROCEDURES

**WARNING!** THE KNIFE CONTAINED IN THIS WATER ACTIVATED TAPER IS EXTREMELY SHARP. USE CAUTION WHEN THREADING THE TAPE TO AVOID PERSONNEL INJURY.

### Filling the Water Bottle

1. Remove the **Water Bottle** by pulling it straight up from the water pot. ( See **Figure 7-7**)
2. Turn the bottle over so the water will not spill.
3. Unscrew the **Valve Assembly** and remove.
4. Fill the bottle with warm water.
5. Replace the **Valve Assembly**.
6. Reinstall the water bottle by inserting it over the **Water Pot Post** and into the **Support Brackets** located on the side of the taper.



**Figure 7-6**

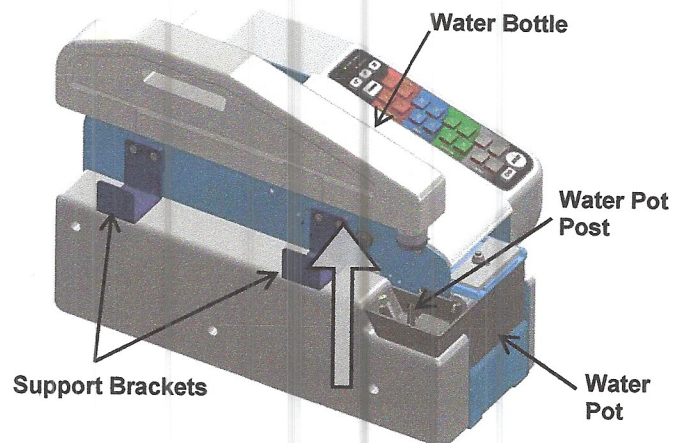
### Water Pot Assembly

The water pot contains the moistening roller and the roller weight assembly. This unit must be removed regularly to clean the moistening roller and water pot of any accumulated adhesive buildup. Failure to maintain a clean moistening roller will decrease the effectiveness of the wetting application and result in poorly moistened water activated tape.

### Removing The Water Pot

The water pot should be removed and cleaned regularly

1. Lift off the water bottle from the water pot post as shown in **Figure 7-7**.
2. Lift-tilt the water pot forward and pull the pot out.

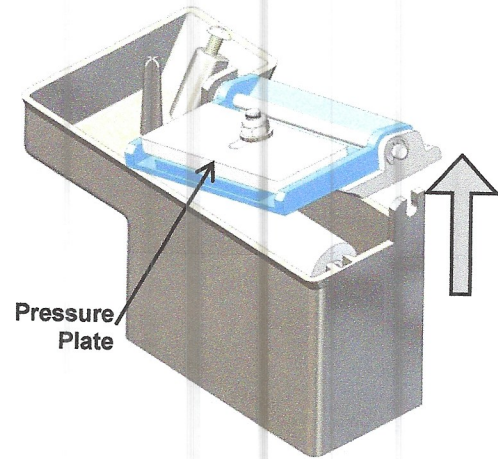


**Figure 7-7**

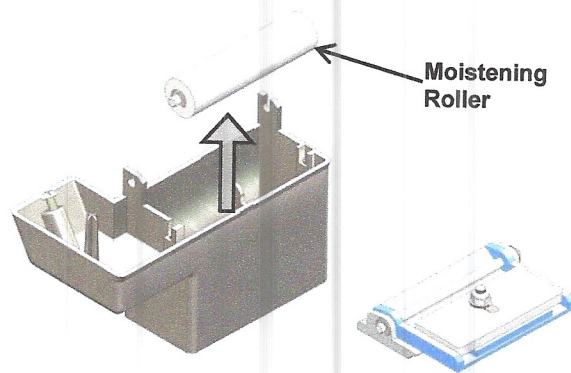
## SET-UP PROCEDURES

### Removing The Moistening Roller

1. Lift off the right side of the **Pressure Plate** assembly.
2. Slide the **Pressure Plate** from the left side of the water pot.
3. Pull the **Roller** straight out from the water pot.
4. Replace used **Roller** with new one, inserting in the same orientation.



**Figure 7-8**



**Figure 7-9**

## SET-UP PROCEDURES

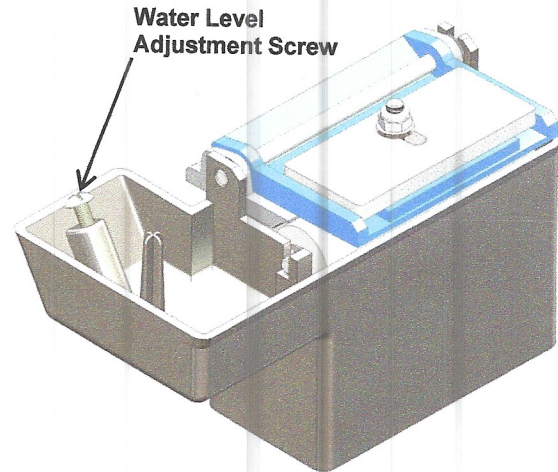
### Adjusting The Water Pot Water Level

If the tape is too wet as it is processed, you may need to Lower the water level in the water pot.

If the tape is too dry as it is processed, you may need to Raise the water level in the water pot.

To do so:

1. Lift off the water bottle and set it aside.
2. Using a Phillips screwdriver, rotate the **Water Level Adjustment Screw** counter clockwise to Raise the water level or clockwise to Lower the water level.

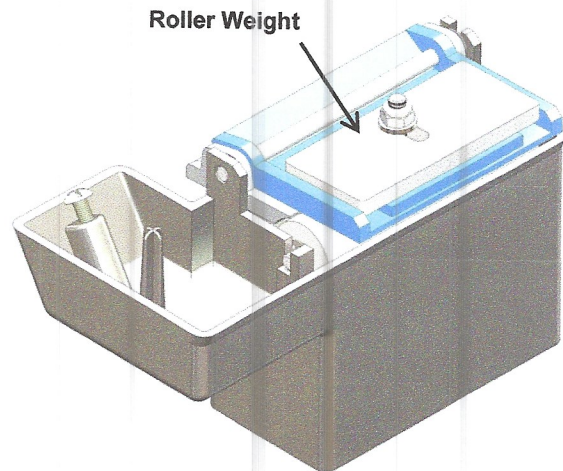


**Figure 7-10**

### Adjusting The Roller Weight

The function of the **Roller Weight** is to provide enough downward pressure on the tape as it travels over the moistening roller so that the adhesive is properly activated. The roller weight is adjusted at the factory and should not require further adjustment. However, should you process lightweight non-reinforced tapes, you may wish to reduce the weight on the moistening roller.

1. Loosen the locking nut.
2. Slide the weight forward to increase roller weight pressure.
3. Slide the weight to the rear to decrease the roller weight pressure.



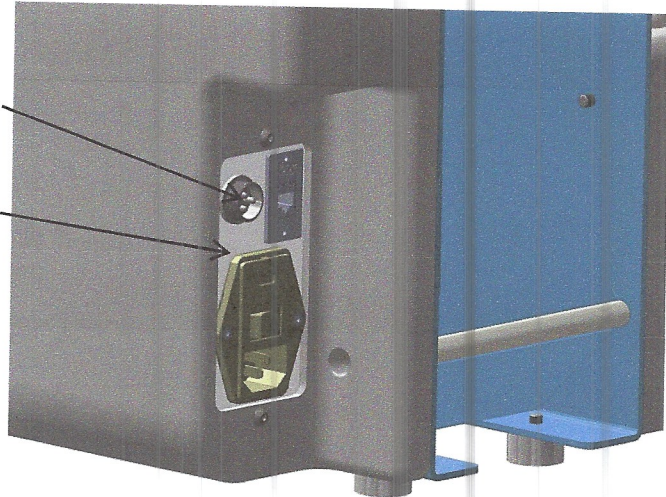
**Figure 7-11**

## SET-UP PROCEDURES

### Optional Dispense On Demand Photo Eye

Dispense On Demand  
Photo Eye Socket

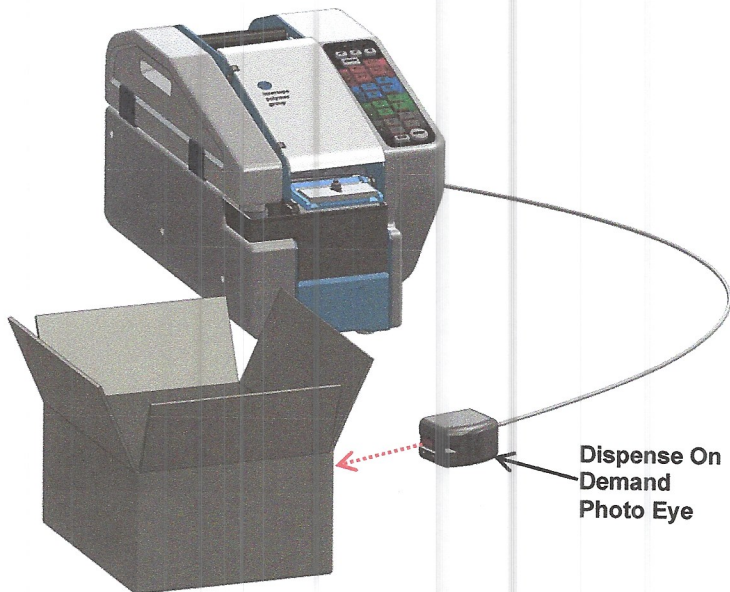
Rear Panel



To make the optional Dispense On Demand assembly operational, the photo eye housing must be installed and positioned before use.

**Figure 7-12**

1. Plug the photo eye into the rear panel socket. Tighten the threaded ring to secure the plug. (Figure 7-12)
2. Secure the photo eye housing to any packing table so that it can aim a beam of light in the direction of the corrugated case.
3. The photo eye is factory adjusted to "see" an object (either a corrugated case or a wave of the hand).



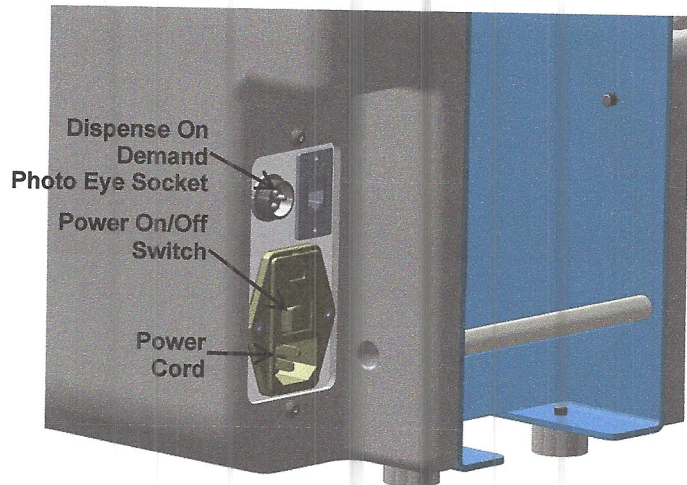
**Figure 7-13**

# OPERATING INSTRUCTIONS

The E-H2O Electric should now be set up with a tape roll, properly threaded and water in the water bottle. Operating the E-H2O Electric taper is a simple task. Depressing a single button will dispense fully moistened tape ready for application to a corrugated case.

## Dispensing Tape

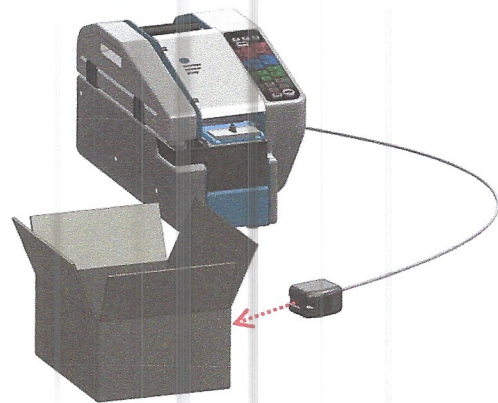
1. Be sure the power cord is inserted into the power cord socket.
2. Be sure the power switch (Figure 8-1) is on.
3. All tape length selection and dispensing will be controlled from the touch panel (Figure 8-2)
4. Dispensing the tape will be initiated by:
  - a. Manually depressing a button on the touch panel. (Figure 8-2)
  - b. Automatically Dispense On Demand through the optional photo eye. (Figure 8-3)



**Figure 8-1**



**Figure 8-2**



**Figure 8-3**

## Selecting The Tape Length

Water Activated tape can be dispensed in a number of methods:

1. **16 Pre-Programmed lengths using the push buttons.**
2. **Customized lengths using +2", -2", or X2 along with pre-programmed push buttons.**
3. **Programmed length using Program button and customized push buttons (51A/48B/45C/42D).**
4. **"Repeat" button.**
5. **"Infinite" or continuous length button.**
6. **Dispense on Demand utilizing the optional photo eye.**

# OPERATING INSTRUCTIONS

## 16 Color Coded Preset Tape Lengths From 10 Push Buttons

There are 16 pushbuttons which can be used with assigned pre-programmed tape length to dispense when depressed. The keypad is divided into four length “zones”. Each “zone” has four buttons with different lengths assigned to them and values increase as you move up on the keypad. The Short zone is color coded in grey and features lengths of 6”, 9”, 12”, and 15”. The Medium zone is color coded in green and features lengths of 18”, 21”, 24”, and 27”. The Long zone is color coded in blue and features lengths of 30”, 33”, 36”, and 39”. The Extra Long/Custom zone is color coded in red and features lengths of 42”, 45”, 48”, and 51”. Once a button is assigned a fixed length, simply continue to depress that button to repeat the tape length dispensed.

To use any of the 16 push buttons to dispense, follow these steps:

1. Determine which button offers the nearest length you wish to dispense
2. Depress the corresponding push button on the keypad.
3. The E-H2O will dispense the tape length you just selected.
4. If the same length is needed again, depress length button previously selected or the “Repeat” button.

### For Example

To Dispense 24” Of Tape:

1. Find button labeled “24” on the keypad.
2. Press the button with the “24”.
3. 24” of tape will be dispensed.
4. Pressing the button containing 24” will again dispense 24” of tape.

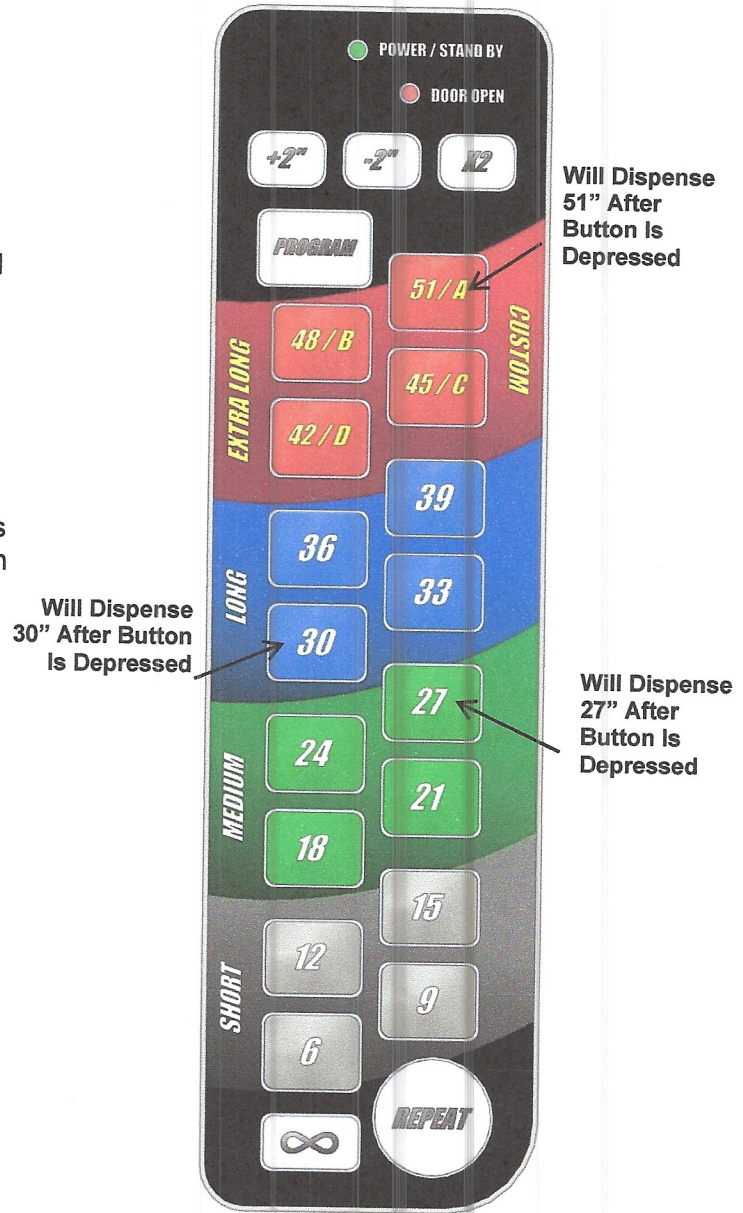


Figure 8-4



# OPERATING INSTRUCTIONS

## Program Button

The **PROGRAM** button will allow the programming of custom tape lengths on 4 dedicated programmable custom buttons. The programmable buttons on the keypad are labeled **51/A**, **48/B**, **45/C**, and **42/D**. The programmable buttons are located on the red portion of the keypad.

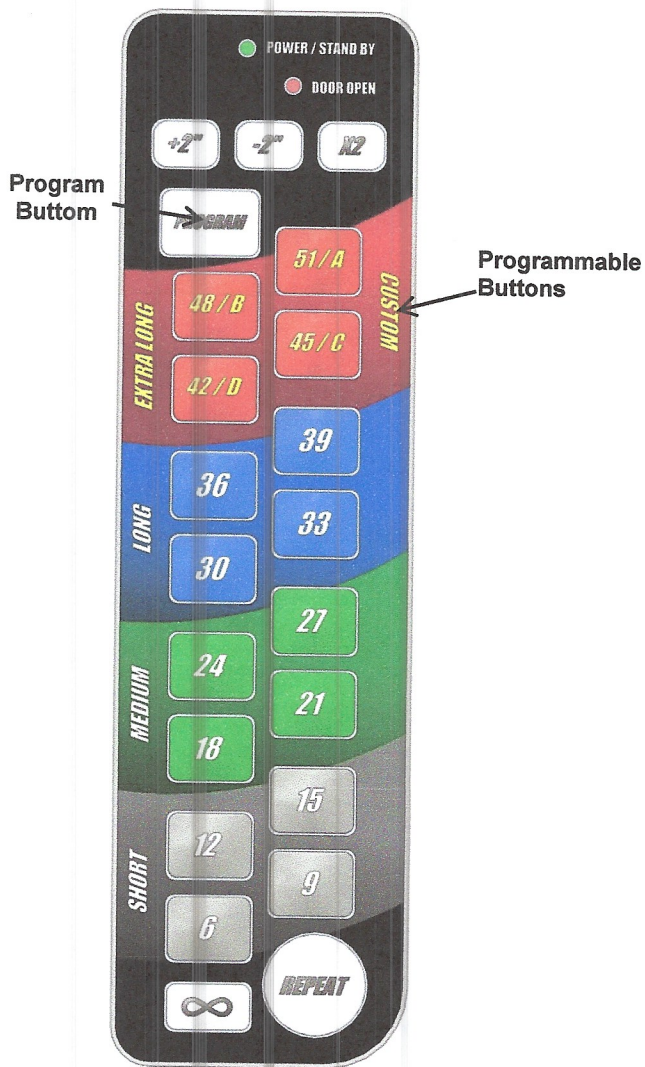
**To assign a tape length to any of the programmable buttons, follow these steps:**

1. Press PROGRAM button (you will hear one long beep sound).
2. Select one of the programmable custom buttons; 51/A, 48/B, 45/C, or 42/D.
3. If desired, select +2" or -2" or X2, then select one of the 12 pre-programmed tape length buttons.
4. Press PROGRAM button again (buttons are successfully programmed with an acknowledgement of 3 beeps sound and double flashing POWER/STAND BY LED light. A series of 4 beeps sound and all LED's flashing indicates an unsuccessful button program).

Custom tape lengths will be stored in memory during use and power cycles until they have been recalled from the button that has been programmed. Once the customization is recalled, the programmable button will dispense the factory default length labeled on the corresponding button.

**To recall a custom tape length from any of the programmable buttons, follow these steps:**

1. Press **PROGRAM** button
2. Select one of the programmable custom buttons; **51/A**, **48/B**, **45/C**, or **42/D**.
3. Press **PROGRAM** button again.



**Figure 8-5**

# OPERATING INSTRUCTIONS

## “Infinite” Or Continuous Length Button and “Repeat” Button

The E-H2O Electric Taper provides a button to dispense tape continuously. This dispensing method is useful when extremely long lengths (longer than 102”) of tape are required.

1. Press down the **INFINITE** button.
2. The machine will dispense tape continuously as long as the **INFINITE** button is pressed down.
3. To stop dispensing, stop pressing down the **INFINITE** button.

The E-H2O Electric Taper also provides a button to dispense previously selected/modified tape length. This dispensing method is useful when needing to repeat the same length multiple times without the need to find required length on the keypad every time.

1. Press down button for the required length.
2. The machine will dispense tape length selected.
3. To dispense the same length as just selected, press down **REPEAT** button.
4. The machine will dispense previously selected tape length.

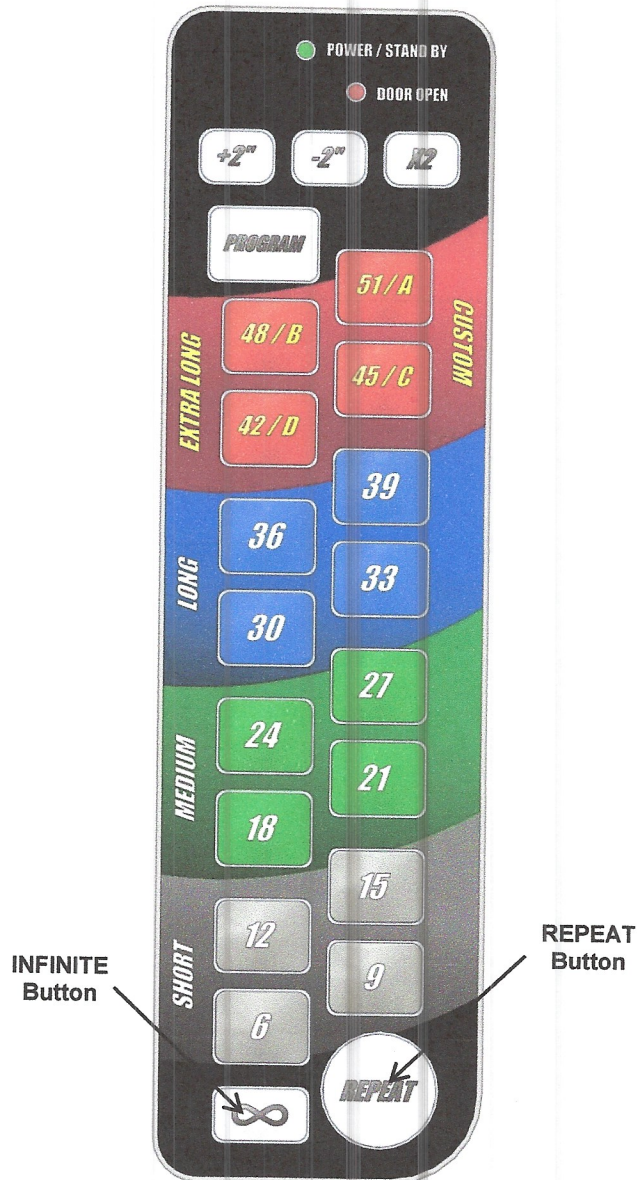


Figure 8-6

## OPERATING INSTRUCTIONS

### **"Dispense On Demand" Utilizing The Optional Photo Eye**

Pre-programmed lengths of water activated tape can be dispensed automatically with the optional "Dispense On Demand" photo eye. When installed on the rear panel (see page 14), this photo eye will enable the E-H2O Electric taper to dispense a pre-programmed tape length when an object is within 6" inches of the bracket (this distance is adjustable)

To properly use the Dispense On Demand photo eye, follow these instructions:

1. Install photo eye into socket (Figure 8-7) on rear of dispenser.
2. Turn the dispenser "ON".
3. Select the tape length desired. (see page 23)
4. The photo eye is mounted on a bracket. The bracket contains an opening which sends an optical beam of light which senses the presence or absence of an object
5. Position the bracket with the photo eye adjacent to the packing area.
6. Form a knocked down case and place it on the packing area within 6" of the photo eye.
7. The E-H2O Electric tape will automatically dispense the length selected.

To change the tape length, follow the instructions on pages 23-25

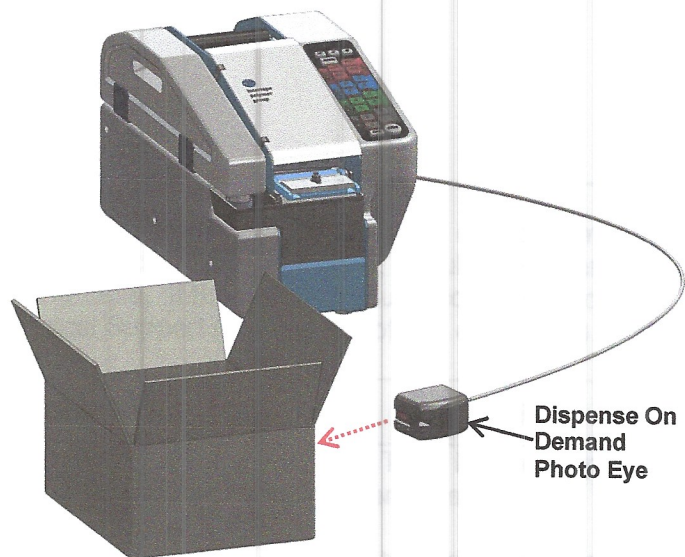
#### **To Disable Photo Eye:**

1. Turn the machine off and disconnect the photo eye.

**MACHINE HAS NO STORED MEMORY TO RETAIN PREVIOUS TAPE LENGTH DISPENSED.**



**Figure 8-7**



**Figure 8-8**

## TROUBLESHOOTING CONTINUED

Trouble	Possible Causes	Solutions
Tape is not evenly moistened	Dirty moistening roller  Dirty water pot	Clean or replace moistening roller (see preventive maintenance)  Clean water pot (see preventive maintenance)
Wrong tape length is dispensed	Button selected is not correct length	Review " <b>Selecting The Tape Length</b> " section starting on page 23
Dispense On Demand photo eye does not operate	Photo Eye not connected  Optical beam not adjusted properly	Review <b>Optional Dispense On Demand Photo Eye</b> on page 22  Adjust screw on top of photo eye for desired operating range
Tape is too wet	Water level in water pot too high	Adjust water level in water pot (see set up)

## RECOMMENDED SPARE PARTS LIST

We recommend that you stock the following spare parts. These parts are contained in the spare parts listing indicated below. The components of the spare parts kits are also referenced should individual components need to be ordered.

### E-H2O Electric Recommended Spare Parts Listing

QUANTITY	NUMBER	DETAIL		DESCRIPTION
1	WST 1001			<b>Cutter Blade Kit</b>
		1	WPT 0050	Cutter Blade
		1	WPT 0044	Striker Plate
		3	UF 6351	SS FHCS M4-0,7 x 6 mm
1	WST 1002			<b>Spring Kit</b>
		2	WPT 0008	Spring
		1	WPT0023	Spring
		1	WPT 0071	Spring
		1	WPT 0053	Spring
1	WPT 0087			<b>Moistening Roller</b>
1	WST 1014			<b>Water Bottle</b>
2	UPM 7122			<b>Fuse</b>

## PREVENTIVE MAINTENANCE

The E-H2O has been designed and manufactured with the finest components to provide long, trouble free performance. General preventive maintenance will improve performance and prolong the life of the water activated taper.

Please review the illustration and chart below for information regarding tape head maintenance.

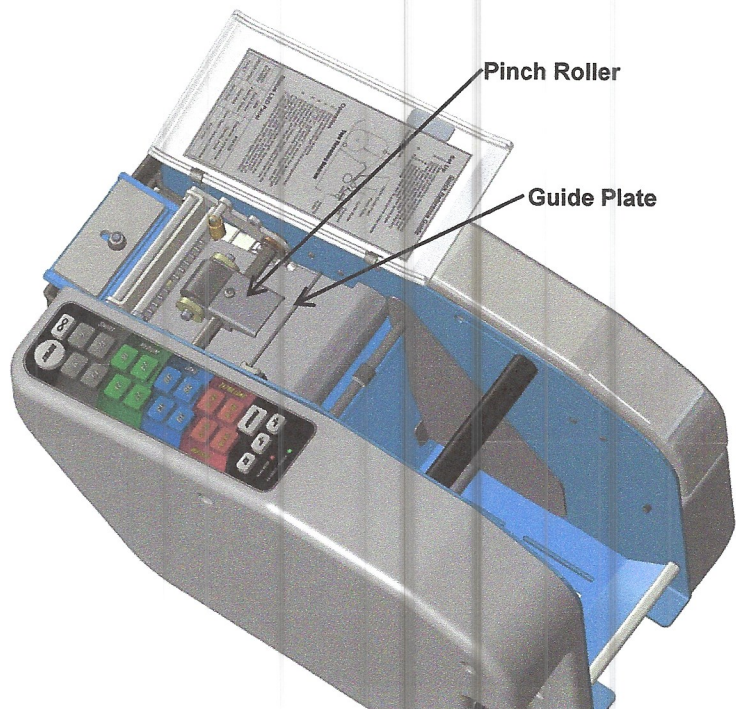


**Warning!** Turn off electrical power and disconnect the electrical supply cord before beginning cleaning or maintenance. If power cords are not disconnected, it could result in severe injury.



### Cleaning The Tape Path

1. Remove tape from tape path.
2. Remove Upper **Guide Plate**.
3. Clean **Pinch Roller** and idler roller with damp cloth and mild detergent.
4. Clean remaining tape path with damp cloth and mild detergent.
5. Clean both sides of the upper guide plate, dry, and put back in place.

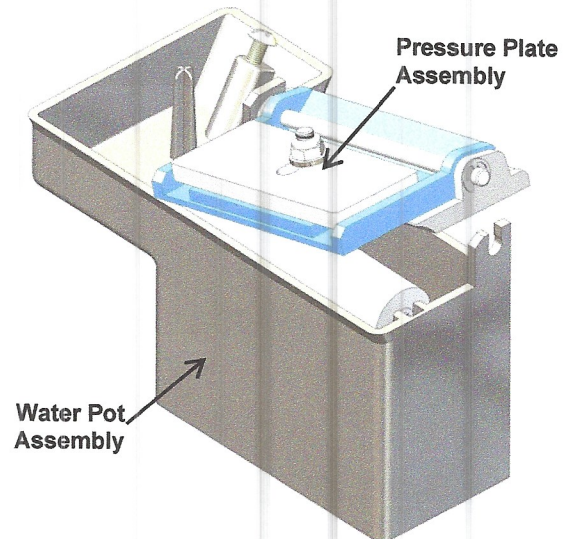


**Figure 10-1**

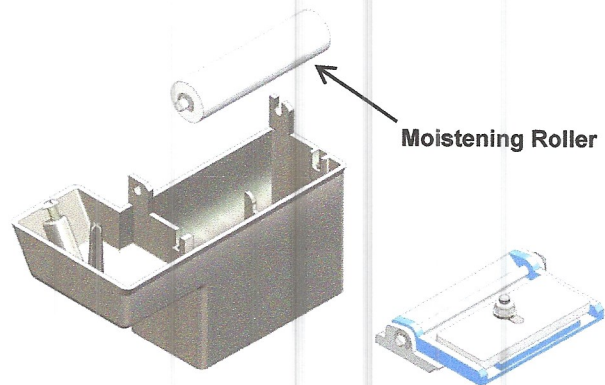
# PREVENTIVE MAINTENANCE

## Cleaning The Water Pot Assembly

1. Remove **Water Pot** assembly from the machine (*See Page 16*).
2. Remove pressure plate assembly.
3. Remove moistening roller.
4. Wash **Moistening Roller**
5. **Pressure Plate** and **Water Pot** in warm water and mild detergent.
6. Optional – Soak **Moistening Roller** overnight.
7. Reassemble and re-install in machine.



**Figure 10-2**



**Figure 10-3**

# PREVENTIVE MAINTENANCE

**WARNING!** THE KNIFE CONTAINED IN THIS WATER ACTIVATED TAPER IS EXTREMELY SHARP. USE CAUTION WHEN THREADING THE TAPE TO AVOID INJURY.

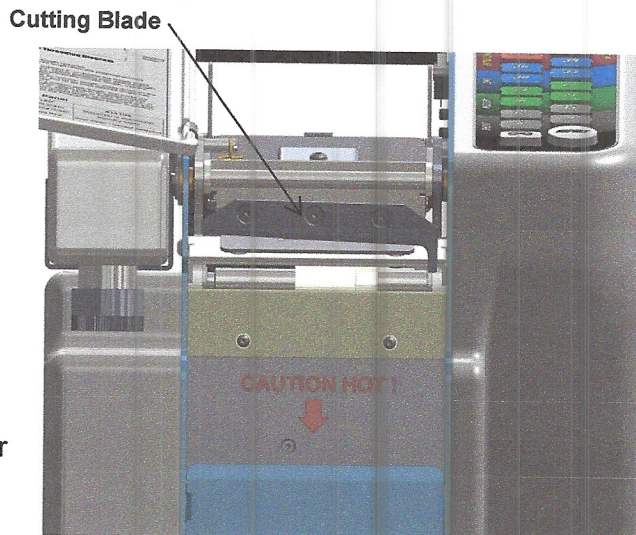


**Warning!** Turn off electrical power and disconnect the electrical supply cord before beginning cleaning or maintenance. If power cords are not disconnected, it could result in severe injury.

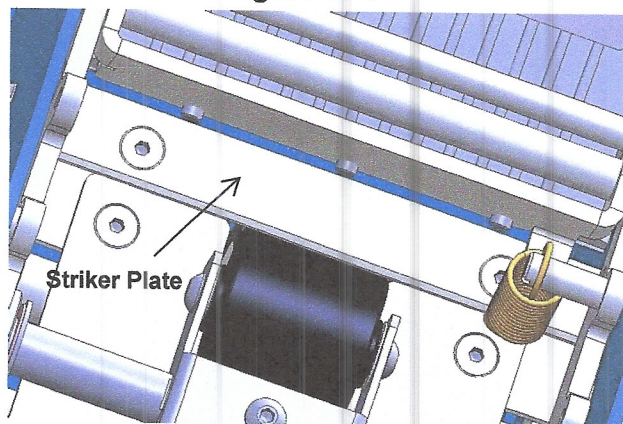


## Cleaning The Cutter Blade

1. Remove the water bottle.
2. Remove the water pot assembly.
3. Remove the upper guide plate.
4. Remove the knife spring and flip the cover up to clean.
5. While retaining the knife arm position, clean the blade on both sides using damp cloth and a mild detergent. **Use caution as blade is extremely sharp.**
6. Clean the **Striker Plate** using damp cloth and a mild detergent.
7. Replace the Upper guide plate, water pot assembly and water bottle.
8. Re-install the knife spring.



**Figure 10-4**



**Figure 10-5**



# PREVENTIVE MAINTENANCE

## Cutter Blade Maintenance



**Warning!** Turn off electrical power and disconnect the electrical supply cord before beginning cleaning or maintenance. If power cords are not disconnected, it could result in severe injury.

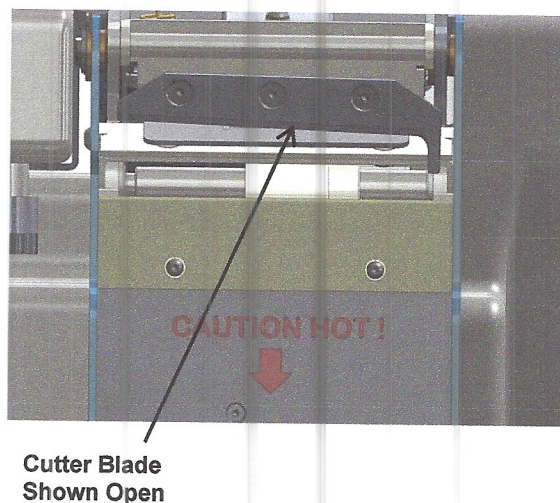


The cutter blade must raise when a button is pushed on the top control panel to allow the tape to proceed underneath. The blade must therefore raise and return without restriction. Should the blade not raise and return when the button is pushed, do the following:

1. Remove the water bottle
2. Remove the water pot assembly
3. Remove the upper guide plate
4. Observe to see when the blade raises that there is no hesitation or delay.
5. Observe to see that there is wide enough opening between cutter blade and the striker plate to allow the full tape width to pass through
6. If no clearance is observed, clean the **Striker Plate** and **Cutter Blade**. (See Pg.34)
7. If above does not fix the problem, return for factory maintenance.
8. Replace water pot assembly, upper guide plate and water bottle.



**Figure 10-6**



**Figure 10-7**

# PREVENTIVE MAINTENANCE

## Cutter Blade Replacement



**Warning!** Turn off electrical power and disconnect the electrical supply cord before beginning cleaning or maintenance. If power cords are not disconnected, it could result in severe injury.



1. Remove the water bottle
2. Remove the water pot assembly
3. Remove the upper guide plate
4. Remove the three 4mm countersink hex screws with a 2.5 mm hex key.
5. Remove the cutter blade.
6. Remove the two 4mm screws on the striker plate with a 2.5mm hex key.
7. Remove the striker plate
8. Replace the cutter blade and striker plate
9. Replace the water pot assembly, water bottle and upper guide plate

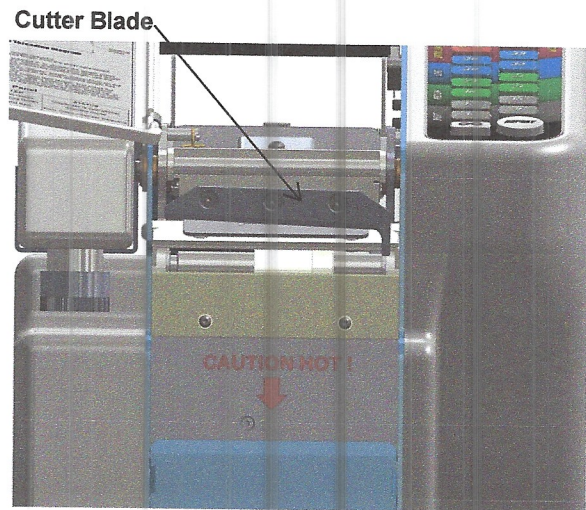


Figure 10-8

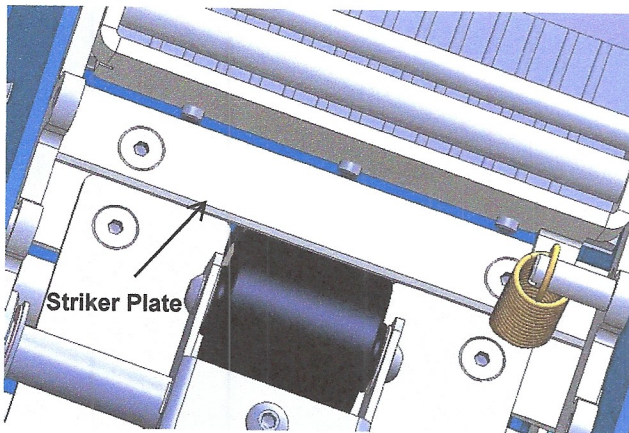


Figure 10-9

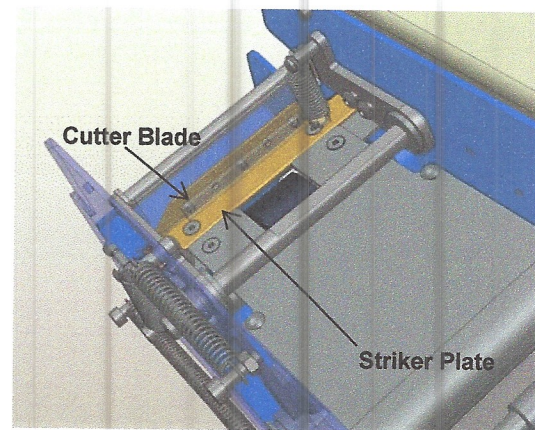


Figure 10-10

# PREVENTIVE MAINTENANCE

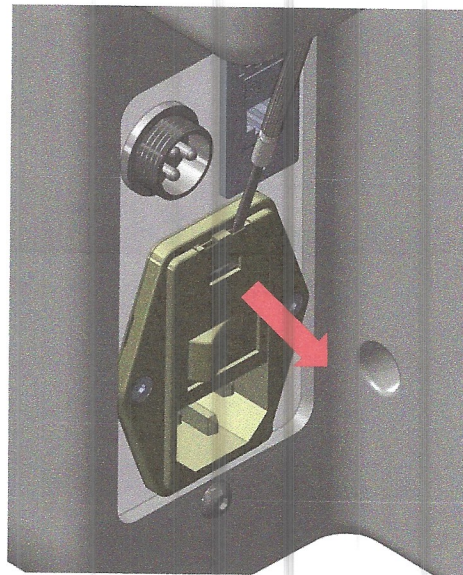
## Fuse Replacement



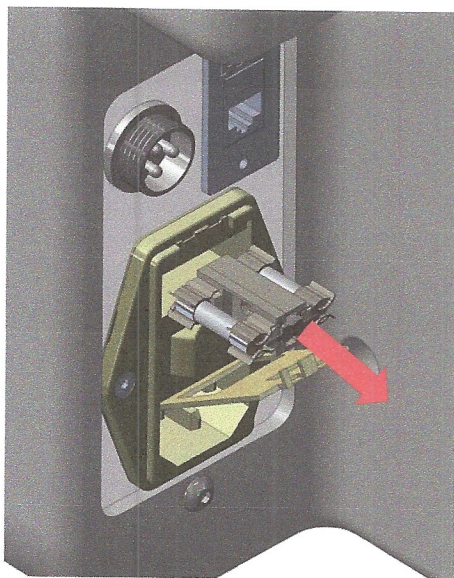
**Warning!** Turn off electrical power and disconnect the electrical supply cord before beginning cleaning or maintenance. If power cords are not disconnected, it could result in severe injury.



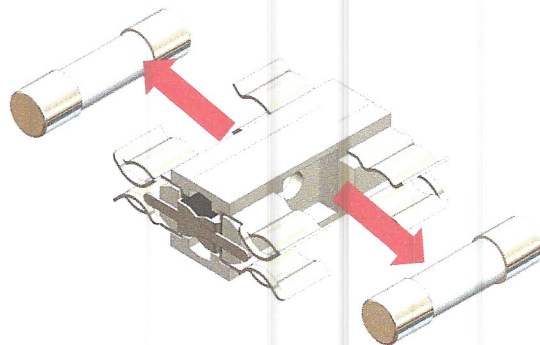
1. Using a small flathead screwdriver, open fuse compartment door.
2. Once door has been opened, remove fuse holder from compartment by pulling outward, you may need to use the flathead screwdriver if holder is difficult to pull.
3. Remove the two fuses from the holder and replace with two new fuses in the same location.
4. Insert fuse holder back into compartment and close the door to keep holder from becoming dislodged.



**Figure 11-1**



**Figure 11-2**

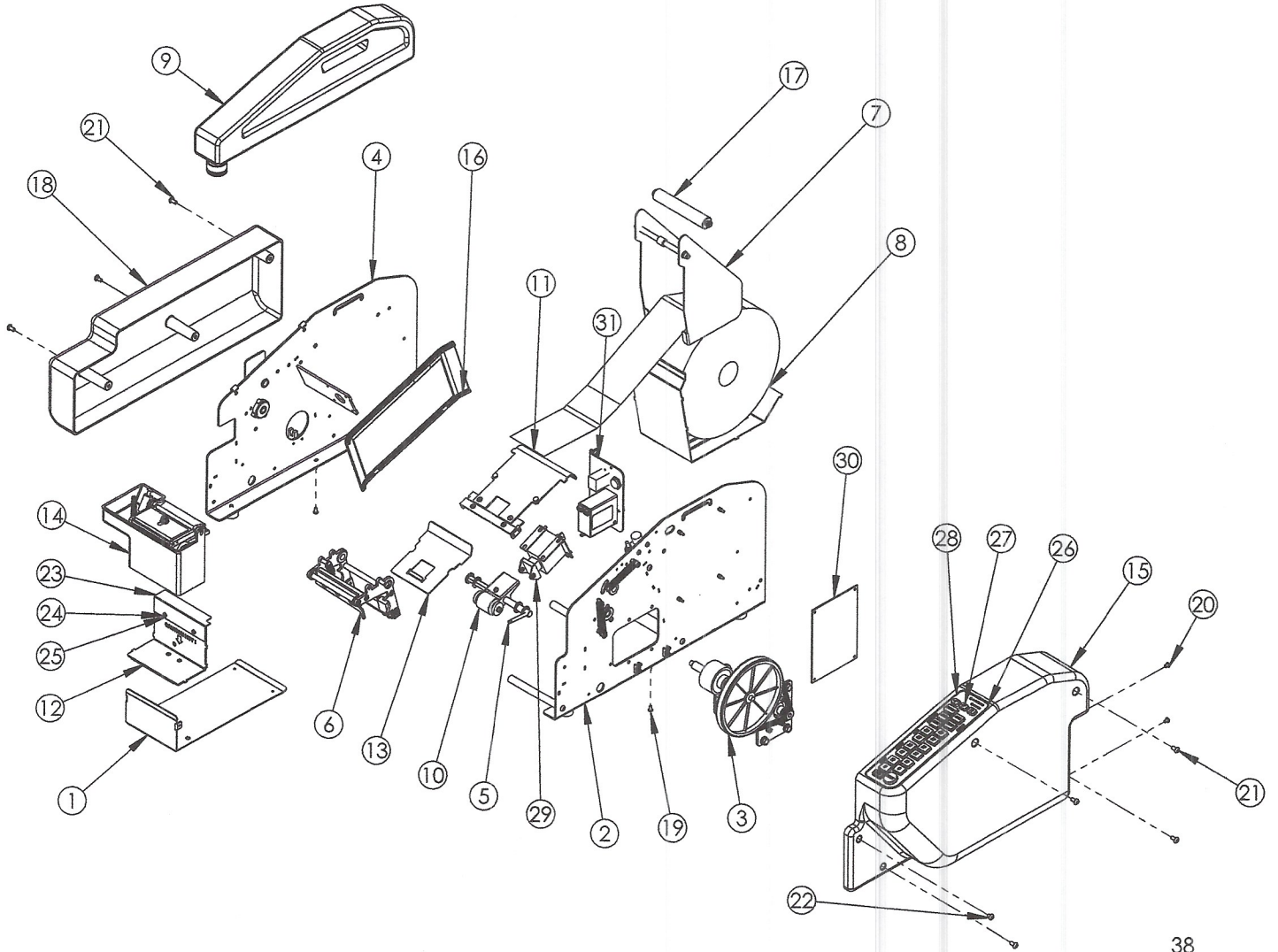


**Figure 11-3**

# APPENDIX A – ILLUSTRATIONS & PARTS LIST

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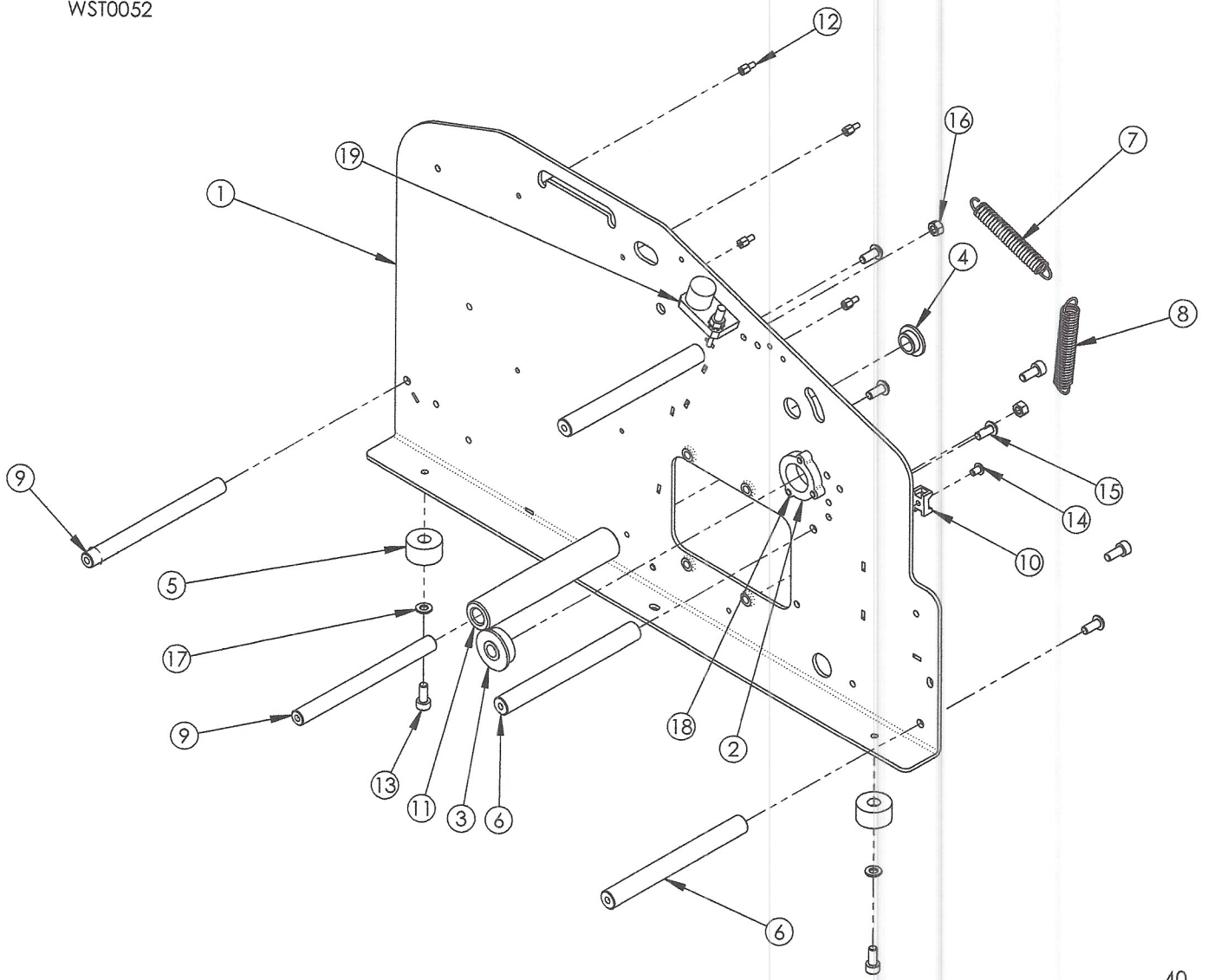
U9706T



U9706T

ITEM	PART #	DESCRIPTION	QTY.
1	WPT0058	WT BOTTOM PLATE	1
2	WST0052	WE Frame Right Side Ass'y	1
3	WST0054	Drivetrain Ass'y	1
4	WST0050	WE Frame left Side Ass'y	1
5	WST0010	WT CUTTER BLADE PIVOT SA	1
6	WST0051	WT KNIFE ARM BLADE SA	1
7	WST0004	WT SELF CENTERING SA	1
8	WPT0059	WT Bottom Plate Rear	1
9	WST1014	WT Bottle SA	1
10	WST0009	WT PINCH ROLLER SA	1
11	WST0013	WT TAPE GUIDE SA	1
12	WST0046	HEATING UNIT	1
13	WPT0063	UPPER GUIDE PLATE	1
14	WST1009	WETTING COMPARTMENT	1
15	WET0090	WAT RIGHT SIDE COVER	1
16	WST0042	TOP COVER	1
17	WST0041	FEED ROLLER ASS'Y	1
18	WET0008	WE LEFT SIDE COVER	1
19	UF7009	SS BHCS M4-0.7 x 8	2
20	UF7008	SS BHCS M4-07 x 6mm	2
21	UF3283	SS BHCS M5-0.8 X 10mm	7
22	UF5601	BHCS M5 X 0.8 X 6mm	1
23	WPT0096	SAFETY GAP FILLER	1
24	UF6385	BHCS M3 - 0.5 x 6	2
25	UF3718	M3 L.W.	2
26	WET0133	KEYPAD LABEL	1
27	WET0086	WAT Keypad	1
28	WET0091	KEY PAD COVER	1
29	WET0026	SOLENOID	1
30	WET0140	CIRCUIT BOARD U9706T	1
31	WST0056	EXTERNAL CONNECTIONS ASS'Y	1

WST0052

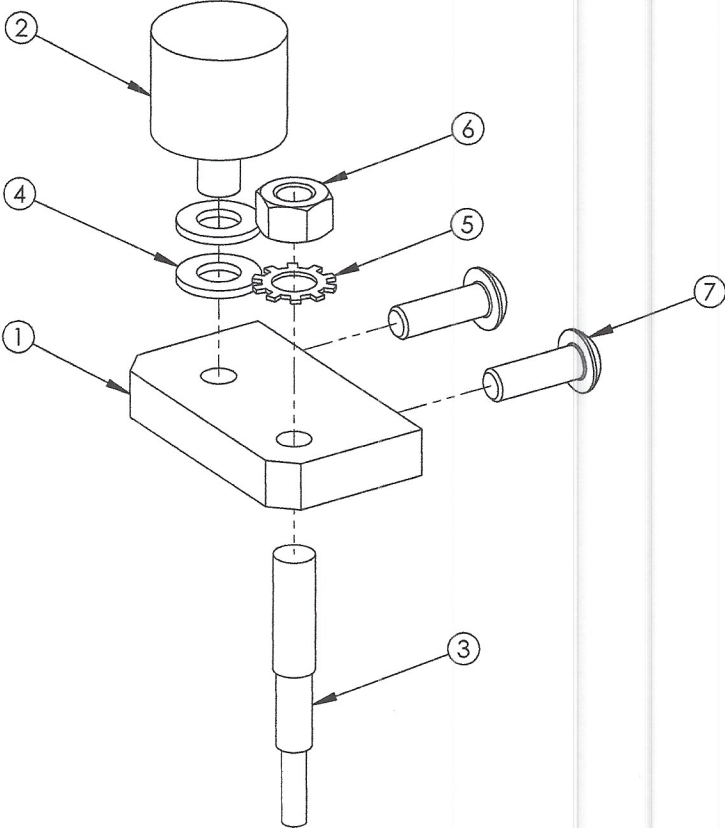


WST0052

ITEM	PART #	DESCRIPTION	QTY.
1	WET0129	WE Frame Right Side	1
2	WET0132	WE Bearing Housing	1
3	WPT0002	Flange Bearing 8mm	1
4	WPT0004	OILITE FLANGE BEARING 10mm	1
5	WPT0005	WAT Rubber Foot	2
6	WPT0007	WT Spacer Bar	3
7	WPT0008	WT SPRING	1
8	WPT0008	WT SPRING	1
9	WPT0009	WT Roller Shaft	2
10	WET0030	TIE WRAP HOLDER	2
11	WPT0068	WT Tape Roll Roller	1
12	WET0027	STAND-OFF M3 x (5+6)	4
13	UF7003	SS SHCS M5-0.8 x 12mm	4
14	UF6374	BHCS M4-0.7 x 6mm	2
15	UF7011	SS BHCS M5-0.8 X 12mm	4
16	UF7007	SS HEX NUT M5-0.8	2
17	UF6340	SS FW M5	2
18	UF6364	SS BHCS M4 x 0.7 x 10mm	3
19	WST1015	DOOR MAGNET/SENSOR SA	1



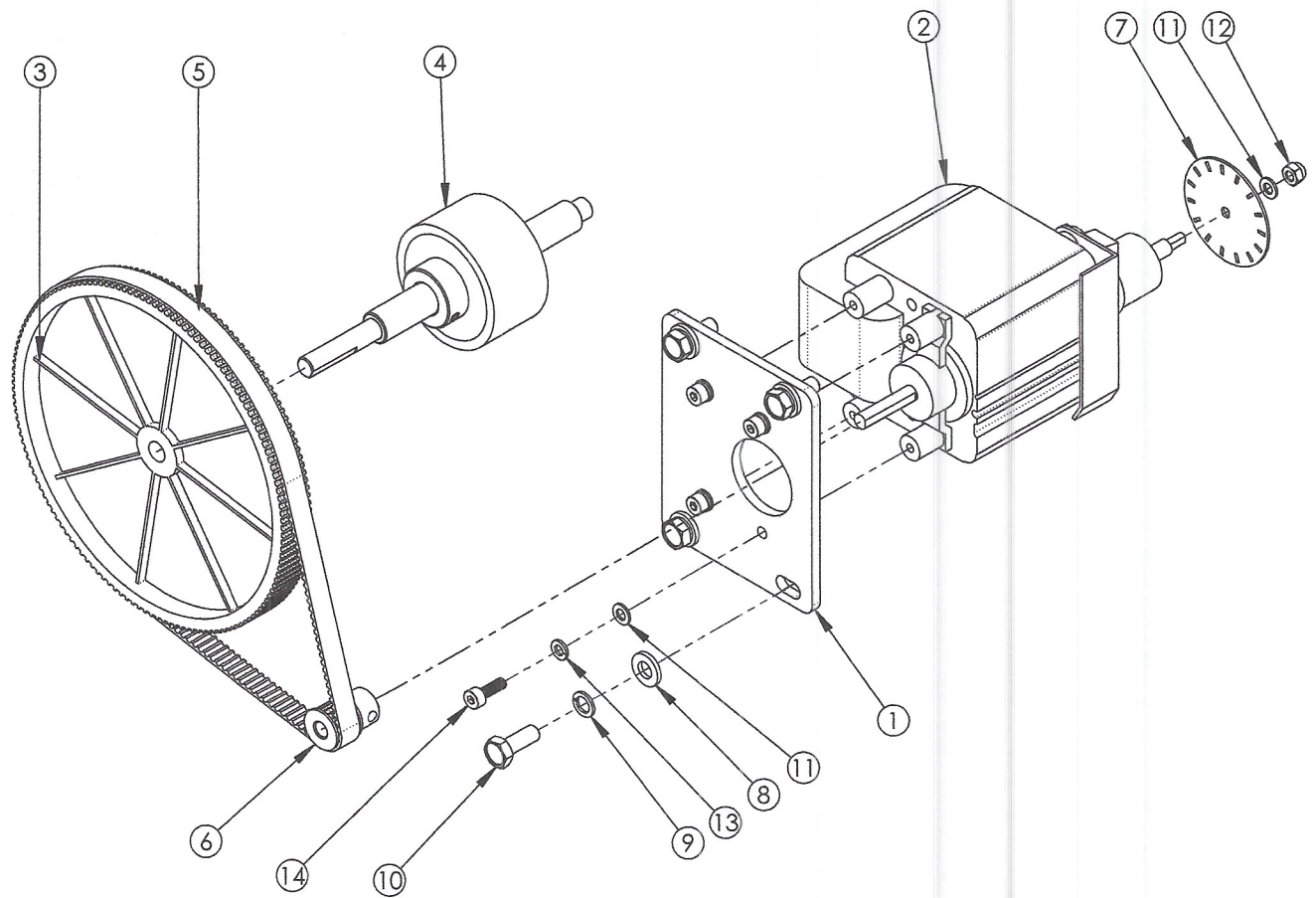
WST1015



WST1015

ITEM	PART #	DESCRIPTION	QTY.
1	WET0137	Door Catch Mounting Block	1
2	WET0138	Magnet	1
3	WET0139	Door Sensor	1
4	UF6340	SS FW M5	2
5	UF7022	SS External Tooth LW M5	1
6	UF6307	HEX NUT M5-0.8	1
7	UF4325	SS BHCS M4-0.7 x 12mm	2

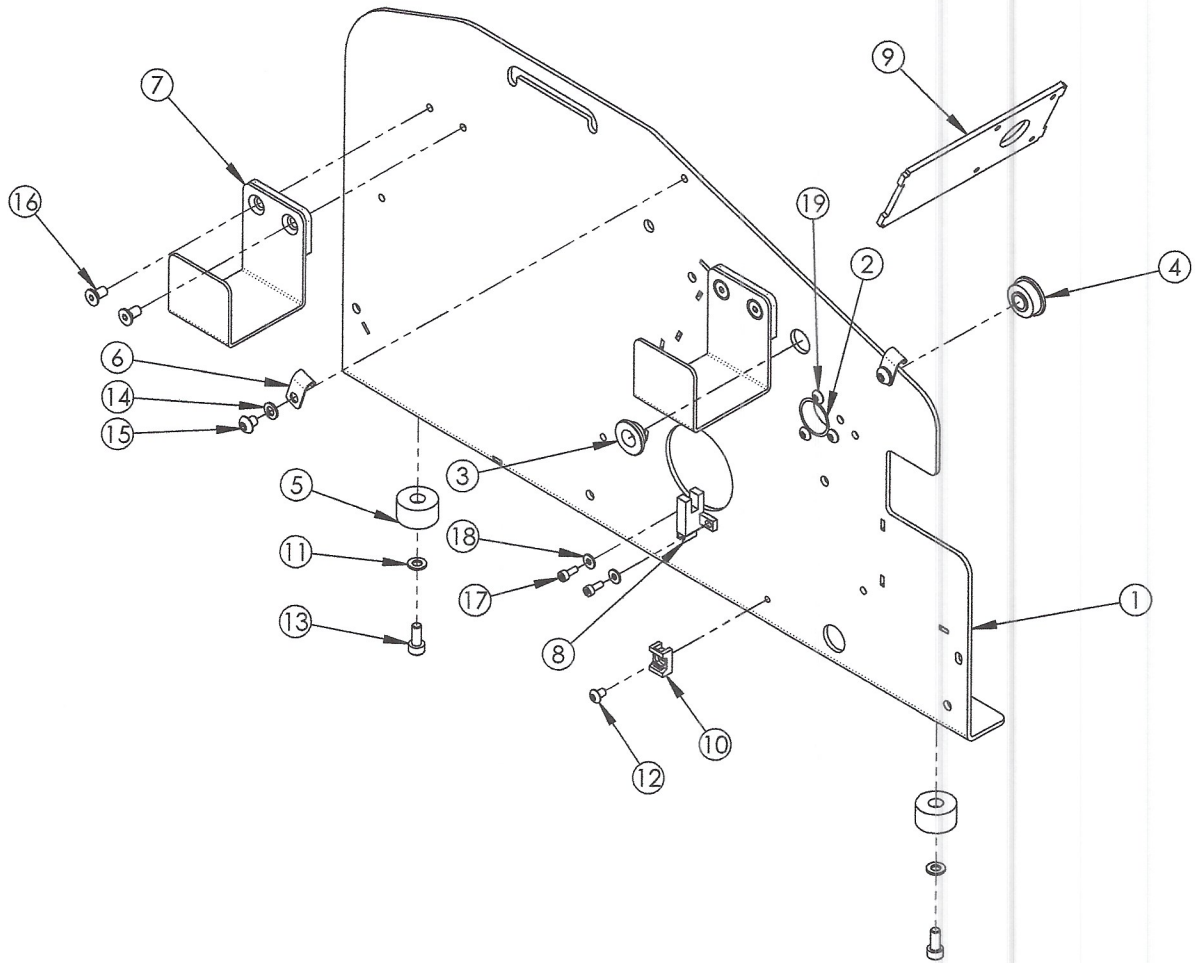
WST0054



WST0054

ITEM	PART #	DESCRIPTION	QTY.
1	WET0016	MOTOR MOUNT PLATE	1
2	WET0015	DOUBLE AXEL MOTOR	1
3	WET0022	SPROCKET WHEEL DRIVEN	1
4	WST0053	WE Drive Roll SA	1
5	WET0024	DRIVE BELT	1
6	WET0023	SPROCKET GEAR	1
7	WET0013	ACC	1
8	UF6341	SS FW M6	4
9	UF6411	SS LW M6	4
10	UF3751	SS HHCS M6-1.0 x 16mm	4
11	UF6339	SS FW M4	5
12	UF4324	SS NYLON LOCKNUT M4	1
13	UF3749	SS LW M4	4
14	UF3801	SS SHCS M4-0.7 x 12mm	4

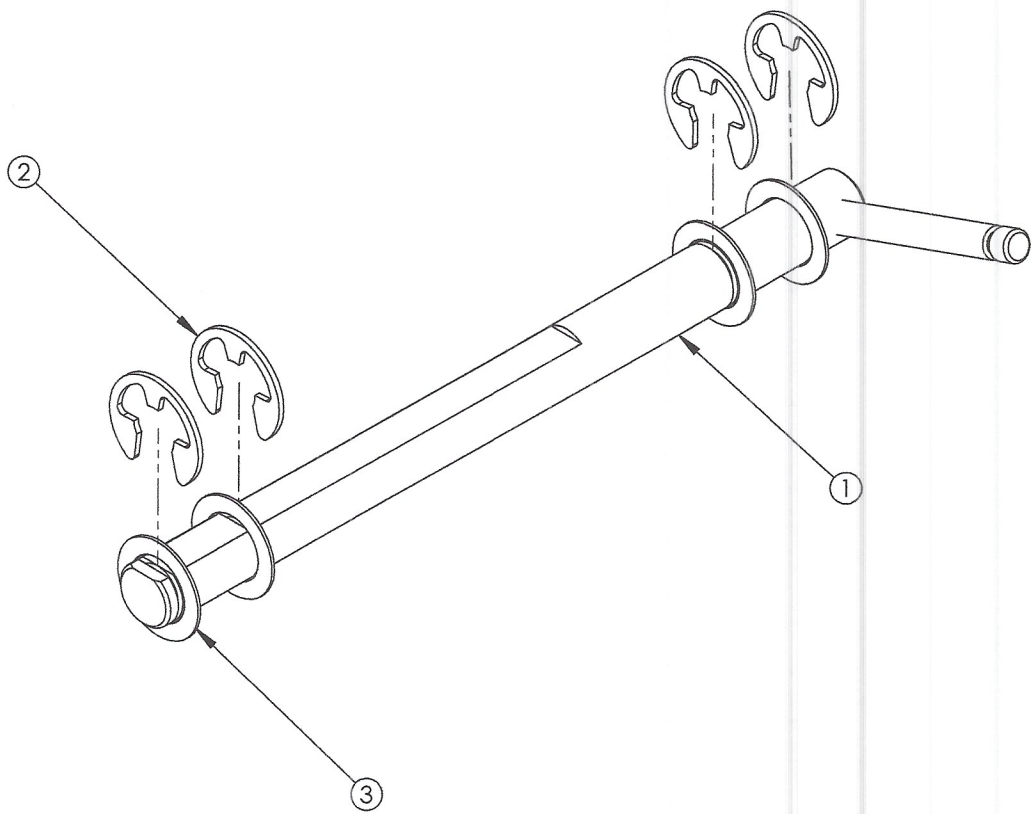
WST0050



WST0050

ITEM	PART #	DESCRIPTION	QTY.
1	WET0131	WE Frame Left Side	1
2	WET0132	WE Bearing Housing	1
3	WPT0004	OILITE FLANGE BEARING 10mm	1
4	WPT0109	FLANGE BALL BEARING 8 x 19 x 6	1
5	WPT0005	WAT Rubber Foot	2
6	WPT0056	HINGE	2
7	WPT0057	WT Bottle Locator	2
8	WET0014	WE DETECTOR SWITCH	1
9	WET0019	MOUNTING PLATE	1
10	WET0030	TIE WRAP HOLDER	1
11	UF6340	SS FW M5	2
12	UF6374	BHCS M4-0.7 x 6mm	1
13	UF7003	SS SHCS M5-0.8 x 12mm	2
14	UF7021	SS LW M5	2
15	UF3276	SS BHCS M5 X 0.8 X 6mm	2
16	UF6305	FHCS M5-0.8 x 10 mm	4
17	UF6401	SS SHCS M3-0.5 x 8	2
18	UF6338	SS FW 3 mm	2
19	UF6364	SS BHCS M4 x 0.7 x 10mm	3

WST0010

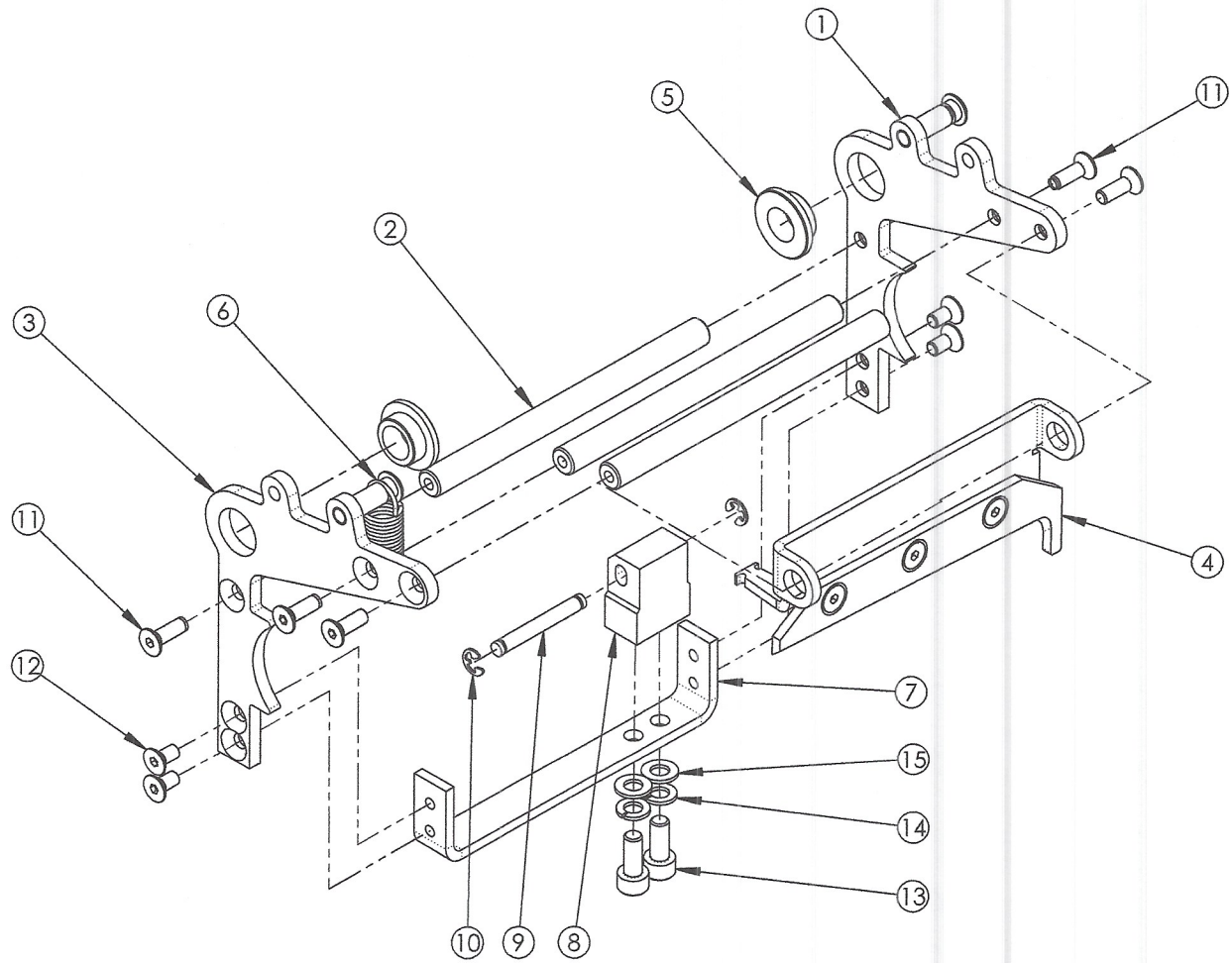


WST0010

ITEM	PART #	DESCRIPTION	QTY.
1	WPT0036	WT Cutter Blade Pivot Shaft	1
2	UF7019	SS E Ret'g ring external 10 mm	4
3	UF6389	NYLON F.W. 10.6 x 16 x 0.5 mm	4



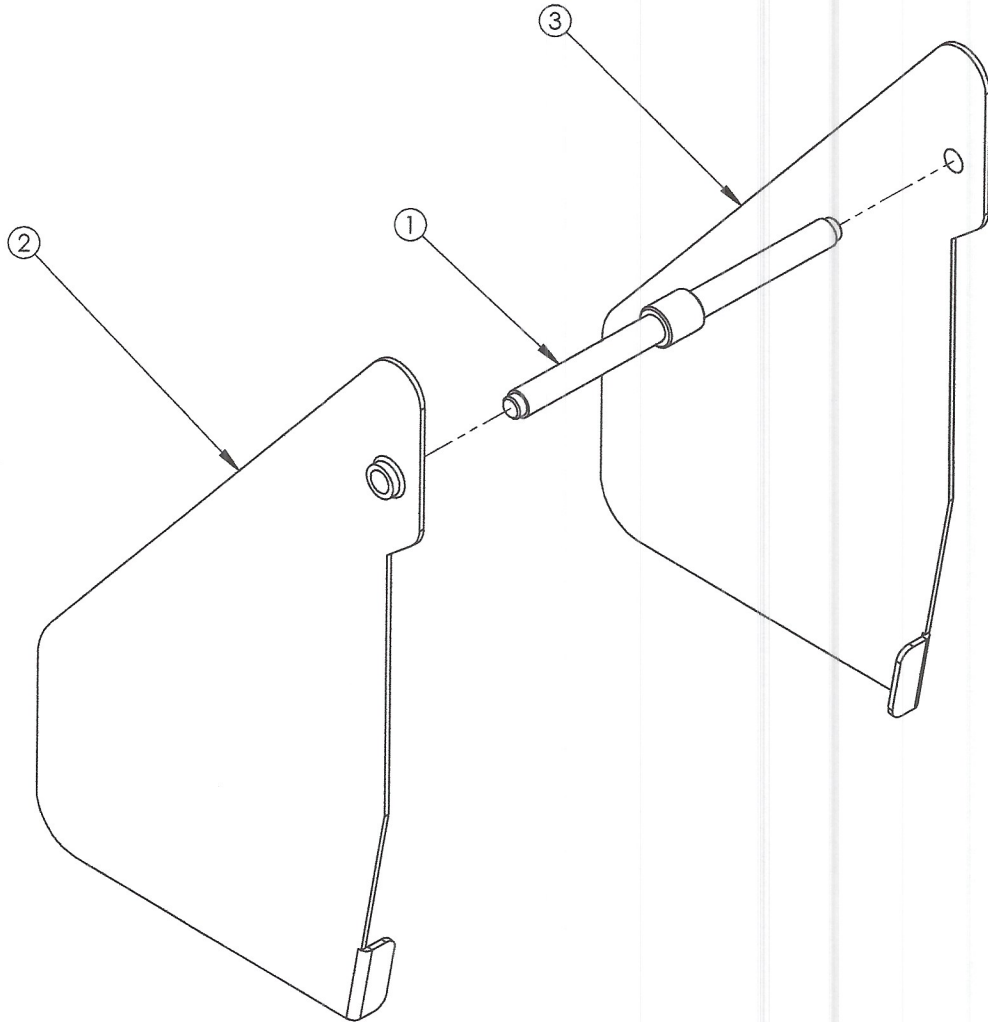
WST0051



WST0051

ITEM	PART #	DESCRIPTION	QTY.
1	WPT0075	KNIFE ARM RIGHT SIDE	1
2	WPT0048	WT Knife Arm Pivot Shaft	3
3	WPT0076	KNIFE ARM LEFT SIDE	1
4	WST0015	WT Cutter Blade SA	1
5	WPT0004	OILITE FLANGE BEARING 10mm	2
6	WPT0053	EXTENSION SPRING 14.75 COILS	1
7	WPT0104	WT KNIFE ARM SUPPORT	1
8	WPT0103	KNIFE ARM BLOCK	1
9	WPT0079	KNIFE ARM BLOCK SHAFT	1
10	UF3553	SS E RET RING EXTERNAL 4mm	2
11	UF3714	FHCS M4-0.7 x 12	6
12	UF3274	SS FHCS M4-0.7 x 8 mm	4
13	UF7003	SS SHCS M5-0.8 x 12mm	2
14	UF7021	SS LW M5	2
15	UF6340	SS FW M5	2

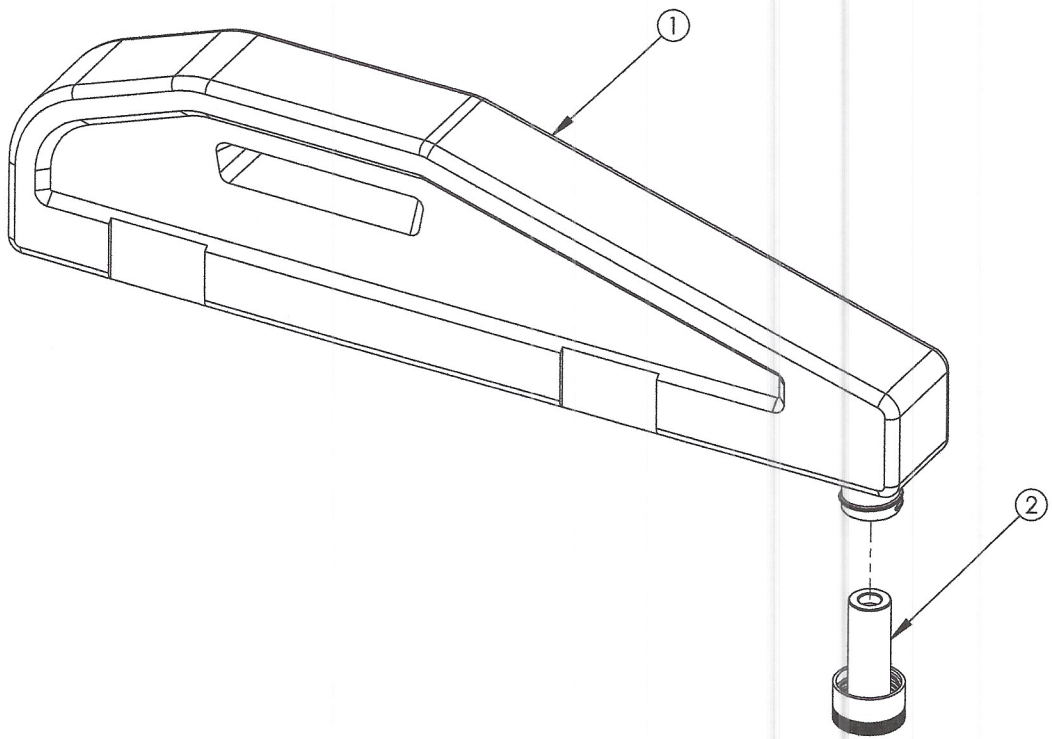
WST0004



WST0004

ITEM	PART #	DESCRIPTION	QTY.
1	WPT0015	WT DOUBLE THREAD SCREW	1
2	WPT0017	CENTRING GUIDE LEFT	1
3	WPT0016	CENTRING GUIDE, RIGHT	1

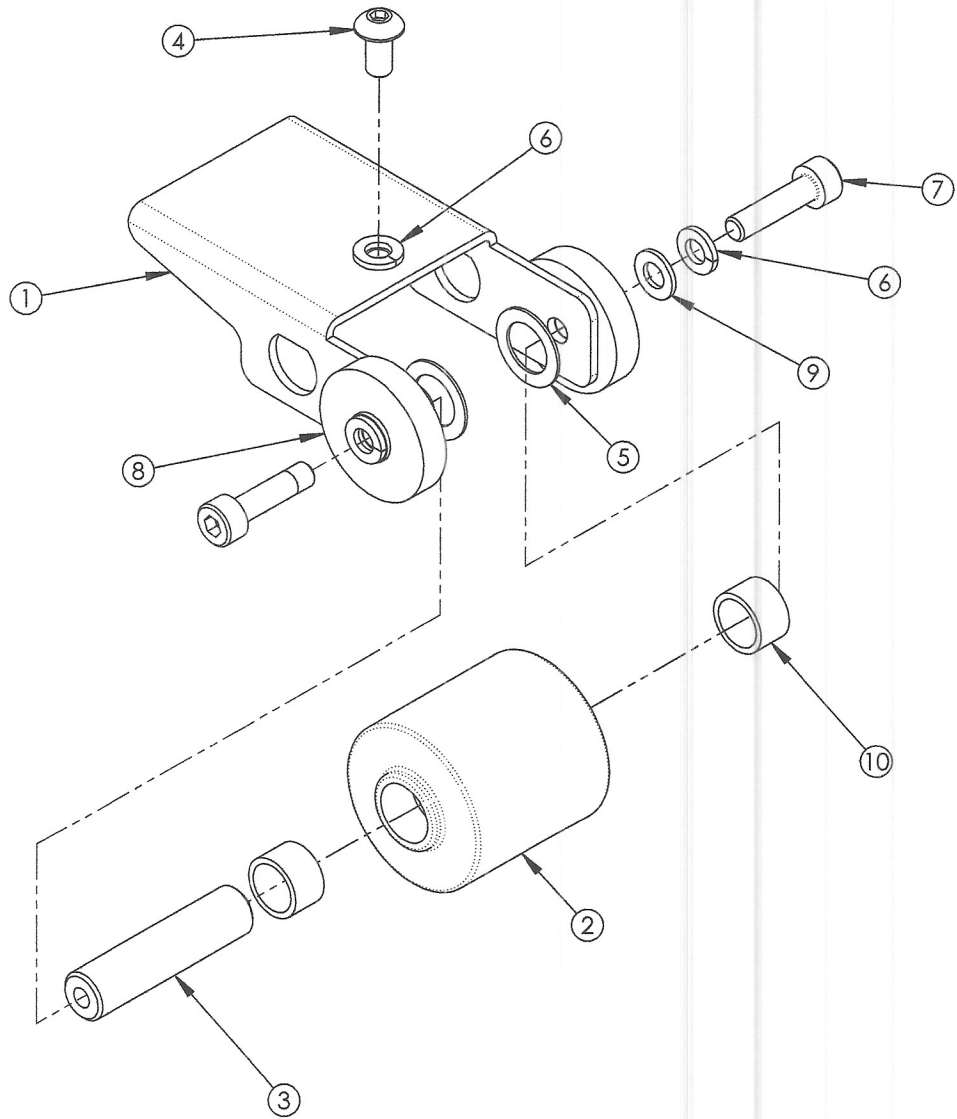
WST1014



WST1014

ITEM	PART #	DESCRIPTION	QTY.
1	WET0096	WAT BOTTLE	1
2	WST1013	WAT BALL CHECK VALVE ASS'Y	1

WST0009

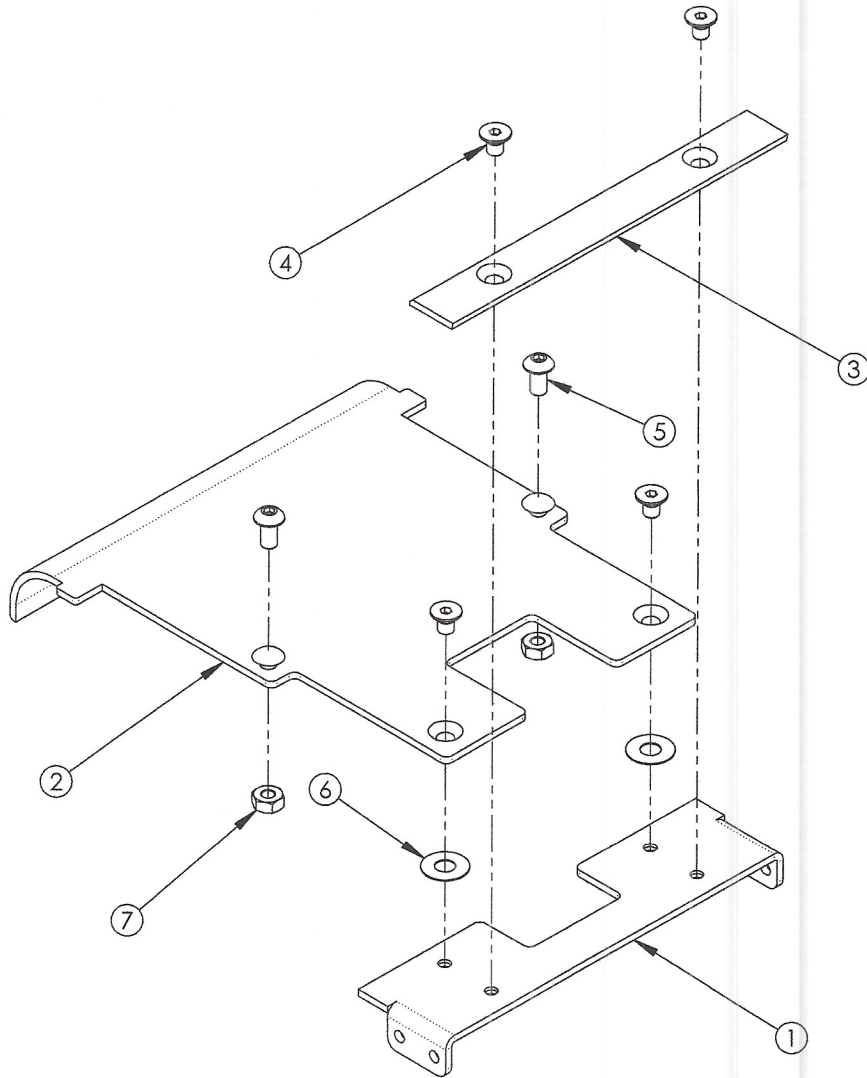


WST0009

ITEM	PART #	DESCRIPTION	QTY.
1	WPT0033	WT Pinch Roller Support	1
2	WPT0034	WT PINCH ROLLER	1
3	WPT0035	WT Pinch Roller Shaft	1
4	UF7009	SS BHCS M4-0.7 x 8	1
5	UF5608	SPECIAL WASHER	2
6	UF3749	SS LW M4	3
7	UF7005	SS SHCS M4-0.7 X 16MM	2
8	WET0070	Disk, Nylon	2
9	UF6339	SS FW M4	2
10	WPT0082	BUSHING 8 mm ID 6 mm L.	2



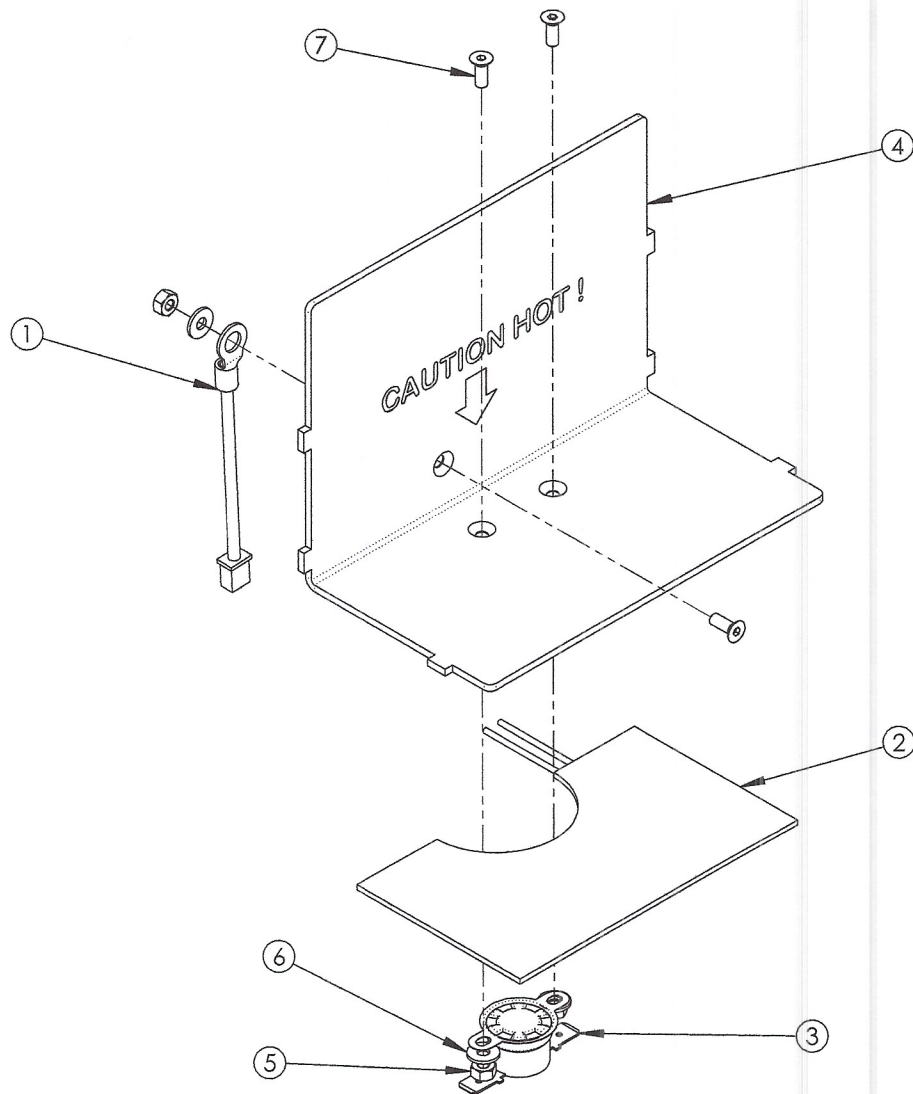
WST0013



WST0013

ITEM	PART #	DESCRIPTION	QTY.
1	WPT0043	Tape Guide Support	1
2	WPT0045	WT Tape Guide	1
3	WPT0044	STRIKER PLATE	1
4	UF6351	SS FHCS M4-0.7 x 6 mm	4
5	UF7009	SS BHCS M4-0.7 x 8	2
6	UF7030	BRASS WASHER 5.18x12x.28mm THK	2
7	UF4237	HEX NUT M4-0.7	2

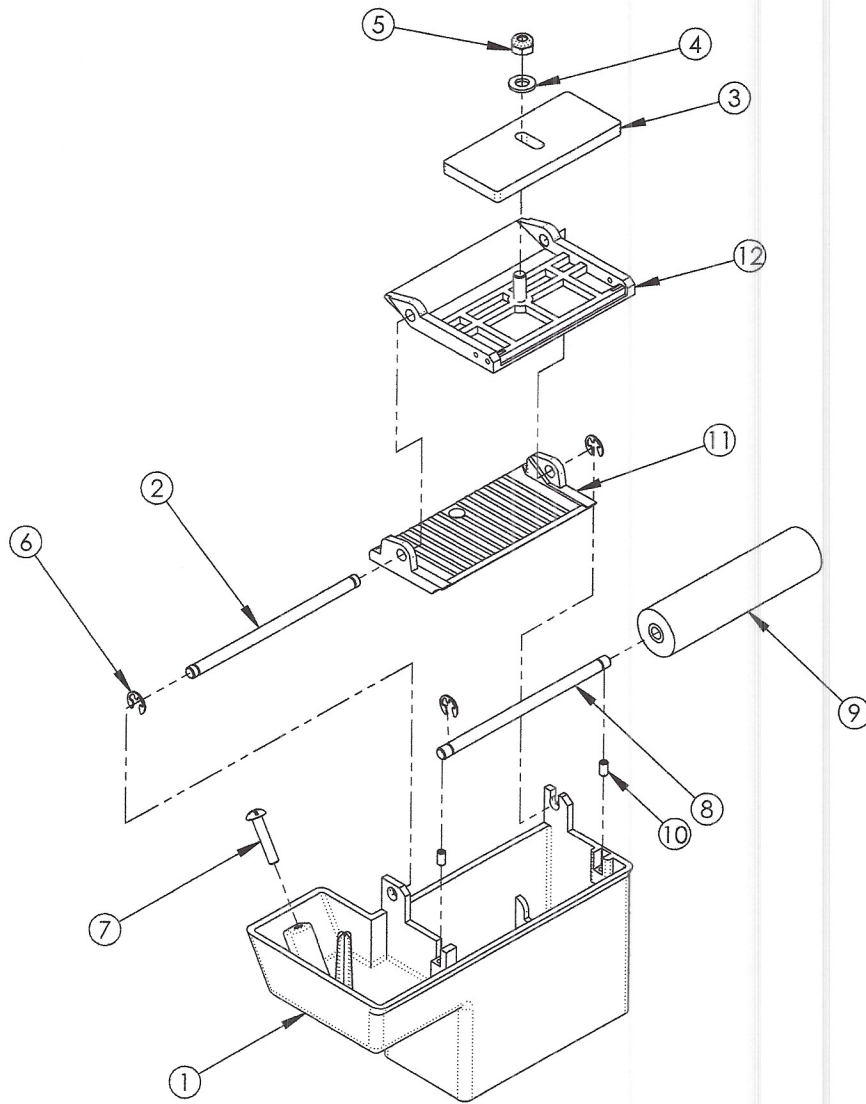
WST0046



WST0046

ITEM	PART #	DESCRIPTION	QTY.
1	WET0025	THERMAL COUPLE	1
2	WET0076	HEATER PAD	1
3	WET0077	212F THERMOSTAT	1
4	WET0083	WARMING TRAY	1
5	UF4112	HEX NUT M3-0.5	3
6	UF3707	FW 3 mm	3
7	UF6312	FHCS M3-0.5 x 8 mm	3

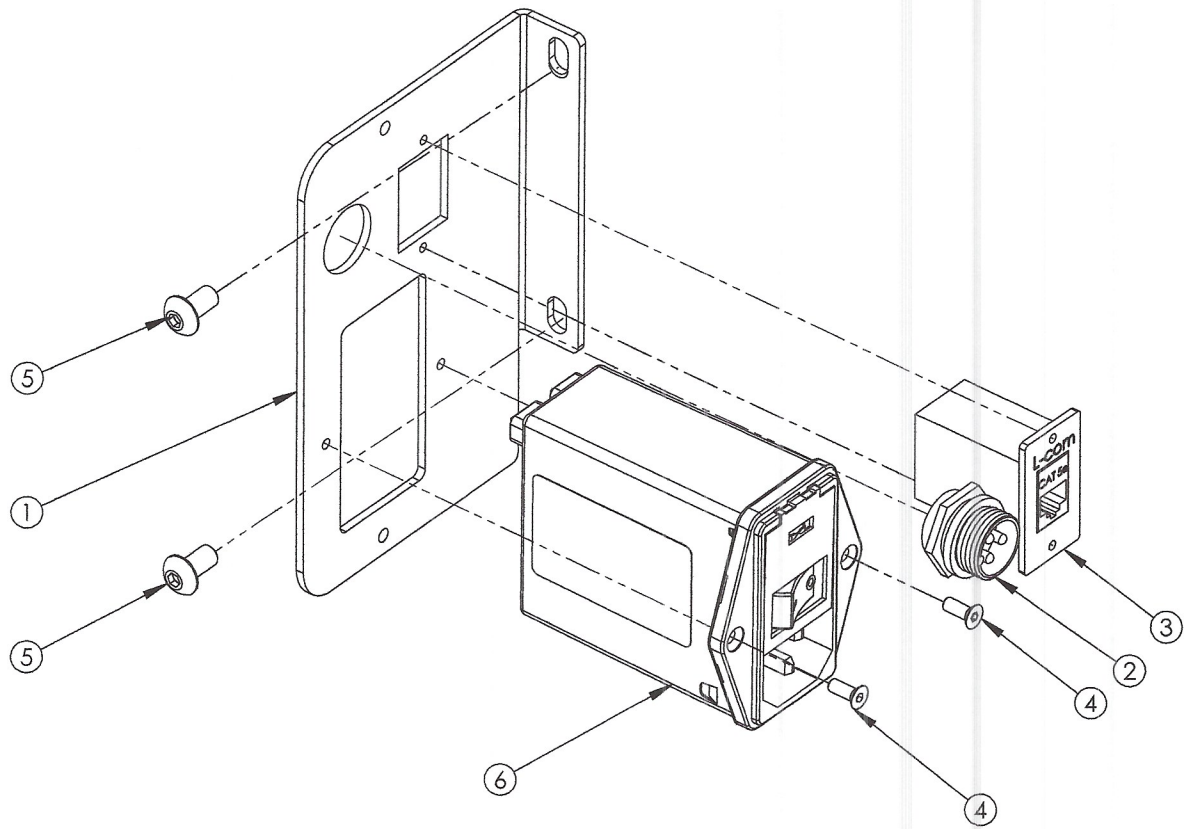
WST1009



WST1009

ITEM	PART #	DESCRIPTION	QTY.
1	WPT0089	WT WATER POT – ROL	1
2	WPT0027	WT PIVOT SHAFT	1
3	WET0063	WEIGHT	1
4	UF1828	FW M6	1
5	UF5900	NYLON LOCK NUT M6-1.0	1
6	UF7020	SS E Ret'g Ring External 6mm	3
7	UF7000	SS PHS M5 X 25mm	1
8	WPT0094	WT PIVOT SHAFT	1
9	WPT0087	WETTING ROLLER	1
10	UF4508	SS SSS M4-0.7 x 8	2
11	WPT0101	TAPE GUIDE	1
12	WPT0028	WT PRESSURE PLATE	1

WST0056



WST0056

ITEM	PART #	DESCRIPTION	QTY.
1	WET0108	POWER SUPPLY PANEL	1
2	WET0029	PHOTO EYE SOCKET	1
3	WET0079	JACK CAT5E RJ45-110 FLNG	1
4	UF6312	FHCS M3-0.5 x 8 mm	2
5	UF3283	SS BHCS M5-0.8 X 10mm	2
6	WET0117	POWER MODULE	1