DEKKA TAPE HEAD

MODEL 22, 23 WITH ADJUSTABLE TAPE CUTOFF

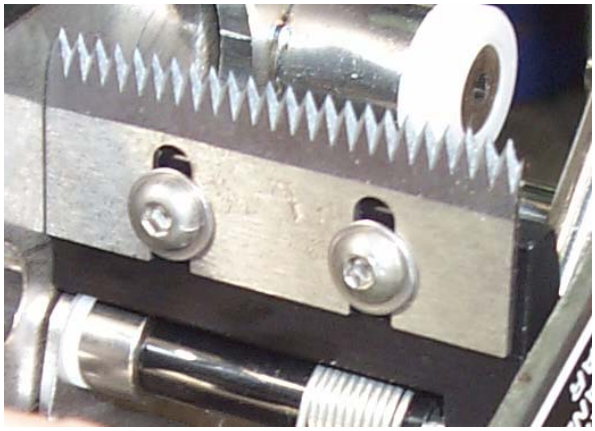
OPERATION & SERVICE MANUAL

69-06-4

DEKKA Industries
www.dekkaindustries.com
Phone: 604-278-7881
Fax: 604-270-7897

TABLE OF CONTENTS

CAUTION



AVOID CONTACT WITH THE CUTTER KNIFE BLADE MOUNTED BETWEEN THE TWO RUBBER CONTACT ROLLERS.

- **FAMILIARIZE YOURSELF WITH THE LOCATION OF THE BLADE BEFORE HANDLING THE TAPE HEAD OR THREADING TAPE.**
- **A SPRING-LOADED GUARD PROTECTS AGAINST CONTACT BUT IT CAN BE ACCIDENTALLY MOVED BY HAND, EXPOSING THE BLADE.**

TURN OFF ALL POWER TO THE SEALING MACHINE BEFORE ANY WORK IS PERFORMED ON THE TAPE HEAD.

The DEKKA Tape Head is a module that can be fitted into various brands of tape sealing machines. The host machine provides the power to drive the case past the Tape Head and apply the tape.

Familiarize yourself with the Operating Instructions of the machine you have before installing, loading or servicing the DEKKA Tape Head.

Note that Dekka tapehead technology is protected by U.S. Patent 5,938,097

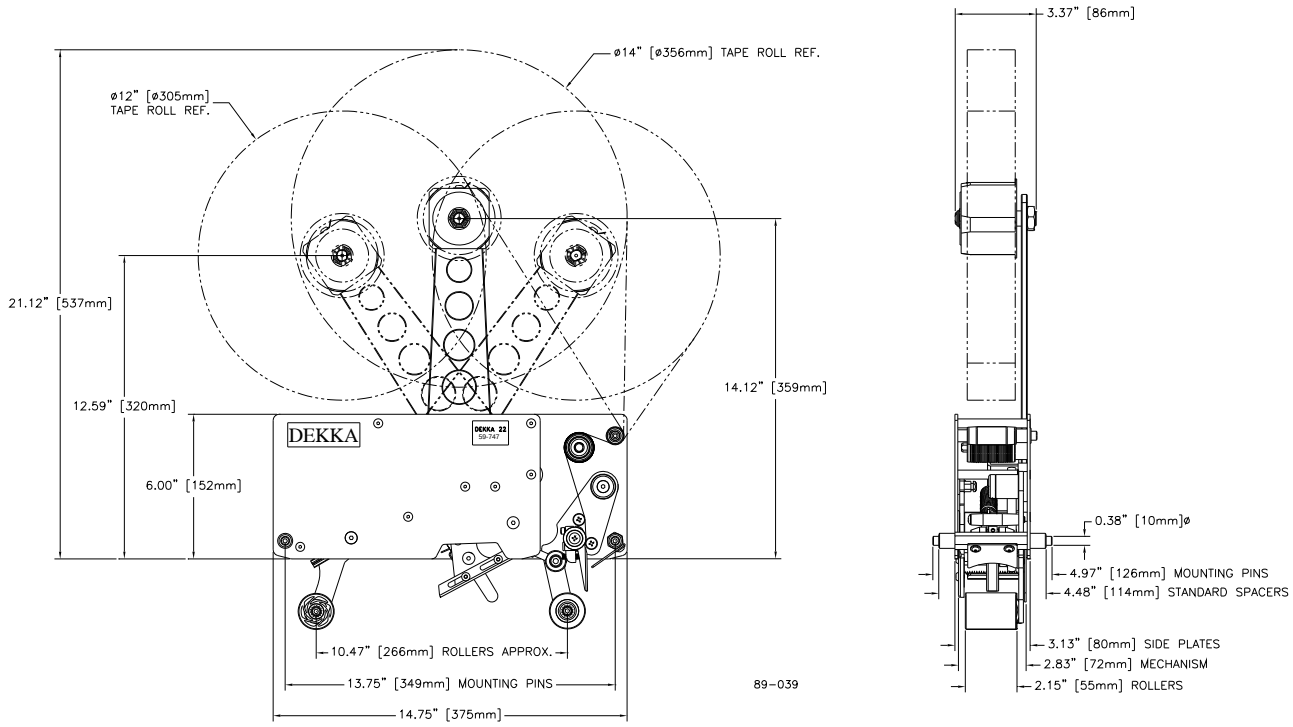
Additional copies of this manual are available by contacting the customer service desk at:

DEKKA Industries
Phone: (604) 278-7881
Fax: (604) 270-7897

sales@dekkaindustries.com

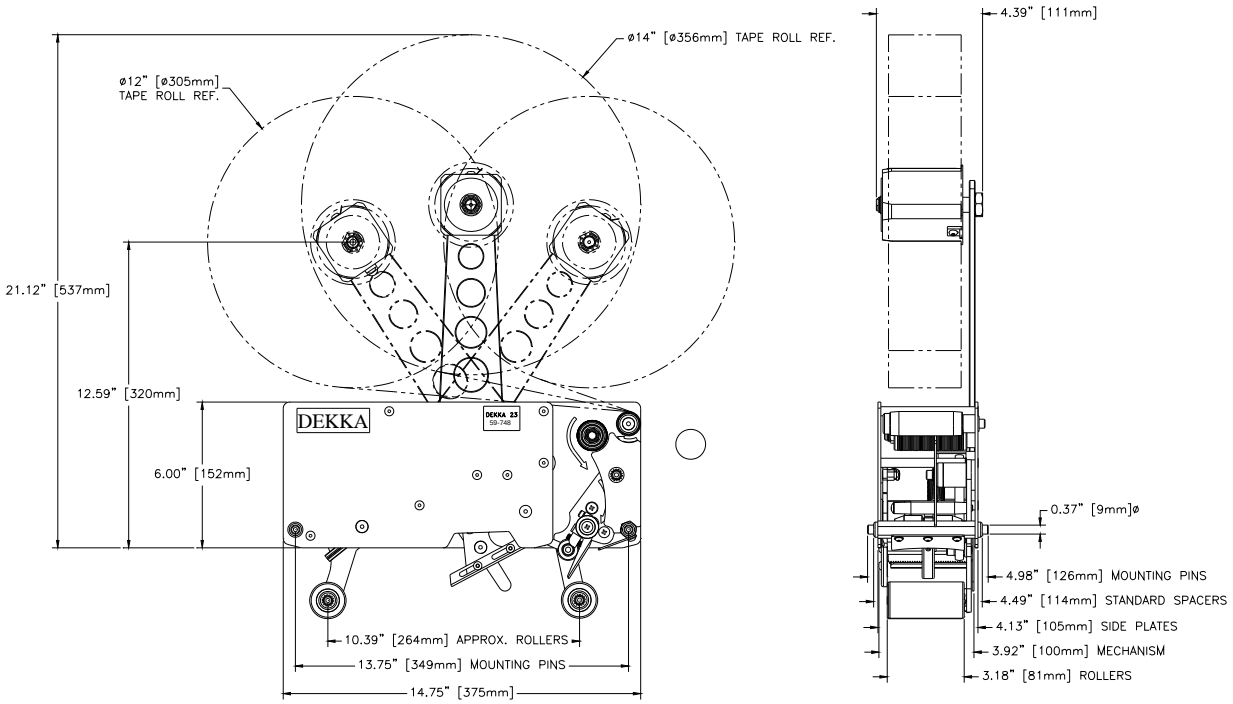
DEKKA 22 (2" width tape) with Adjustable Cutter Tapehead

Z59-010 / Z59-747 Mounting Layout



DEKKA 23 (3" width tape) with Adjustable Cutter Tapehead

Z59-030 / Z59-748 Mounting Layout



Mounting the Tape Head

CAUTION

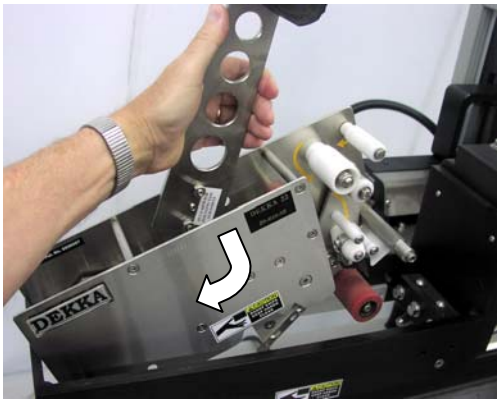
- **Keep hands clear of cutter blade and movable mechanical parts.**
- **Ensure that the tape head is mounted in the host machine facing in the right direction. The contact roller that holds the tape ready to apply to the box must face the infeed direction of the machine. FAILURE TO DO THIS CAN CAUSE DAMAGE TO THE TAPE HEAD.**

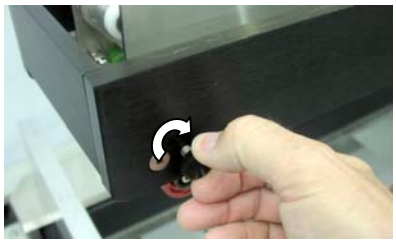
Since DEKKA Tape Heads can be mounted in different taping machines, securing the head in these machines can vary slightly.

Mounting the tape head into WEXXAR / BEL machines

With WEXXAR / *BEL* brand machines, the tape head is dropped into slots that capture the four round locating pins, properly locating the head in the machine. (Be sure that the tape head is seated properly.)

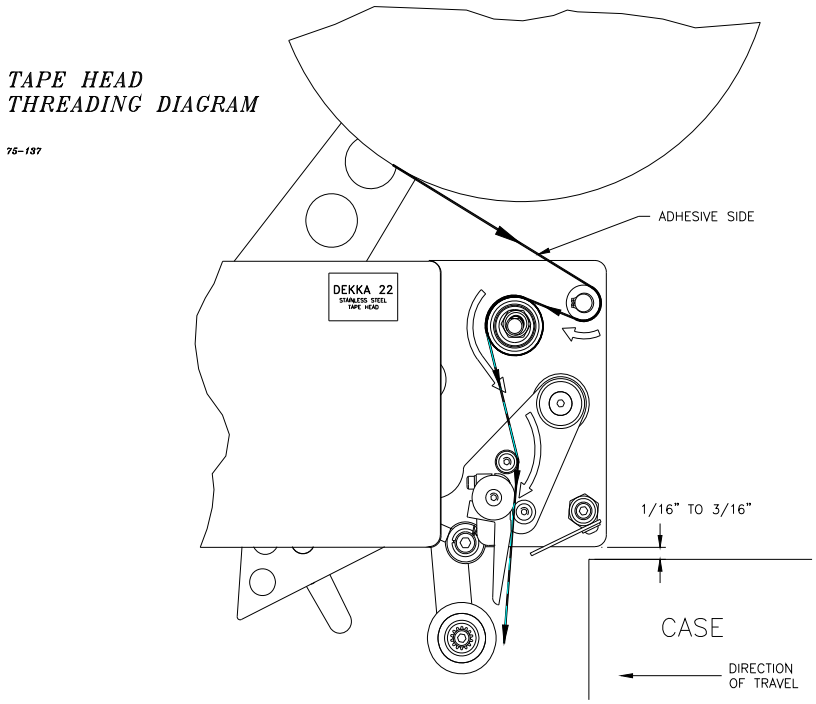
Top Holder





Bottom Holder

DEKKA 22/23 Threading Diagram



Threading of the Tape

Threading the DEKKA Tape Head is easy due to an open-sided design permitting threading over the end of the feed rollers. This can usually be done without removing the tape head from the machine.

Two common methods are used to reload the head.

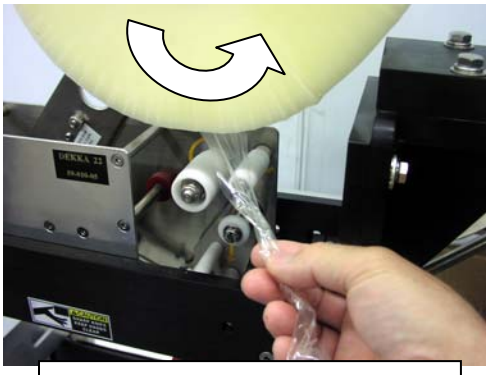
The first is to splice the tape together when the roll is almost finished. Do this by removing the old roll off the tape holder mandrel and replacing it with a new roll, then simply stick the new tape end onto the tail end of the old roll. This permits the new tape to be drawn through feed rollers without interrupting the supply of tape.

Secondly, if the roll has run out of tape or is being fed for the first time, the DEKKA open-sided design makes it very easy to feed the new tape.

Tape Threading Procedure

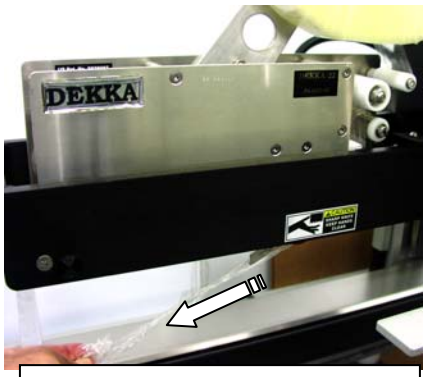
If the tape head is mounted in a WEXXAR / *BEL* tape-sealing machine, it is often not necessary to remove the tape head to replace the tape roll and re-thread the tape. This will save time and prevent undue handling wear to the head.

Be sure that the tape roll is mounted so that the sticky side of the tape will be out to contact the incoming box. When facing the open-side of the tape head the tape roll should rotate in a counter-clockwise direction.



1. Pull off some tape and make it into a 'rope'.

2. Thread it through the head according to the yellow arrows.

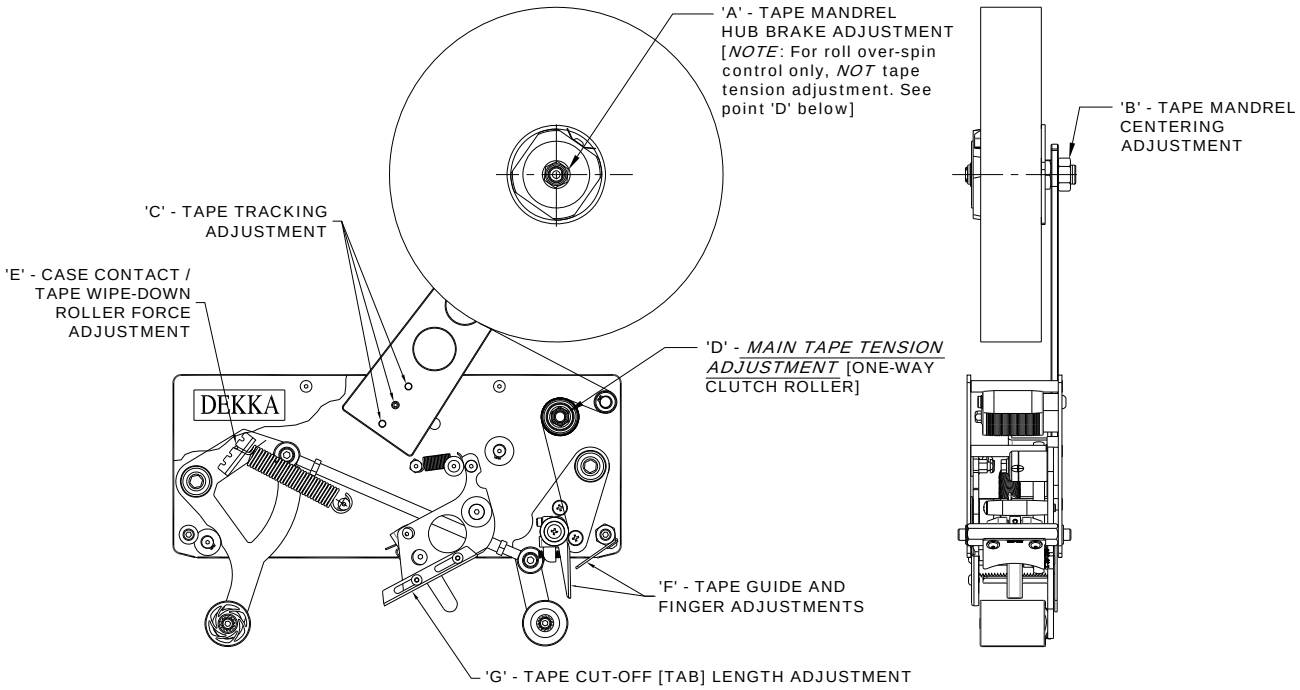


3. Pull the tape toward the rear while holding the tape roll from turning; it will open the blade guard just enough to bring the tape against the blade and cut it.

NOTE: Do not use a knife to cut the tape against the rubber roller. Cuts in this surface will cause problems with tape feeding and create jams.

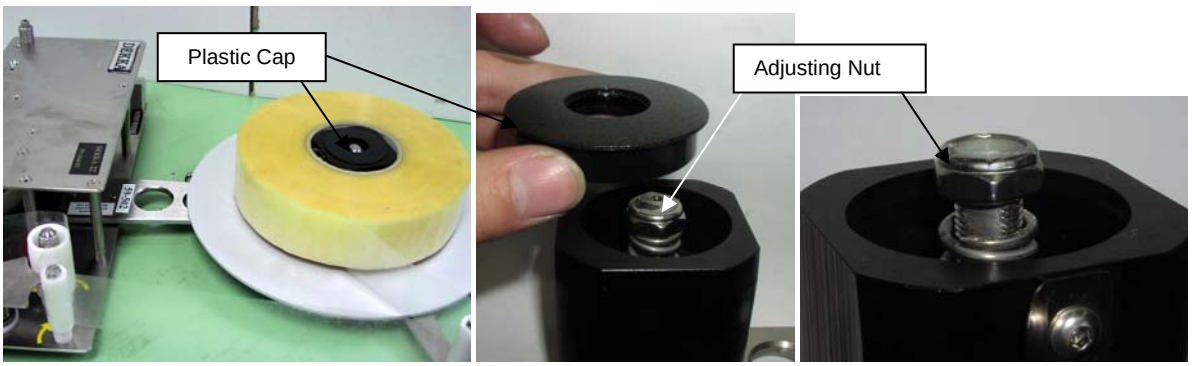
DEKKA Tape Head Adjustments

DEKKA Tape Head
Adjustment Point Diagram
Z129-030



Tape Holder or Mandrel Hub Brake

Adjustment Location 'A'



Point 'A' is an adjustable friction hub brake that ***should be used only to prevent over-spinning of the tape roll and adjusted to provide a minimum of resistance against tape pull– NOT MAIN TAPE TENSION***.

Note that the main tape tension adjustment is made at the one-way clutch roller, Point 'D' on the Adjustment Locations diagram. If adjusted too tight, the roll brake together with the clutch roller will cause too much tape tension and create tape application problems.

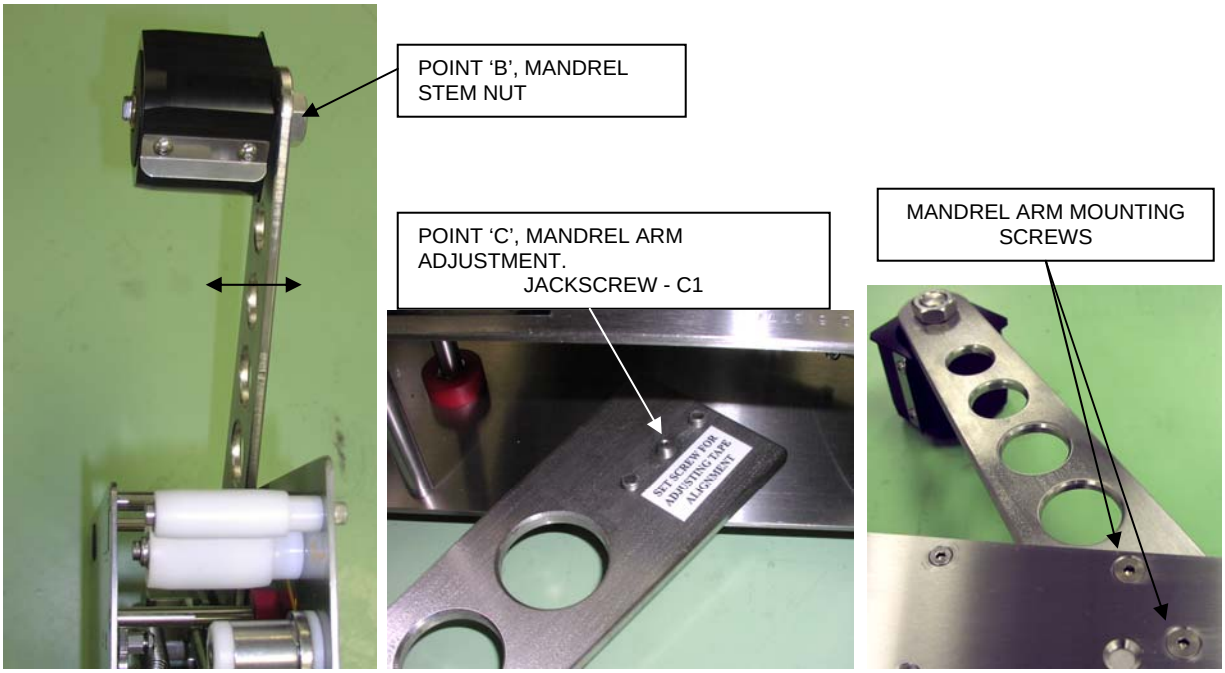
To adjust the Mandrel Hub Brake remove the plastic cap and tighten the center nut to increase tension; loosen to decrease. The pictures above illustrate this procedure.

- For best results adjust the hub brake with a *full* roll of tape in the tape head and **only enough to prevent more than ½ turn of tape roll over-spin**.
- Do not over-tighten as increased tape tension can cause problems with wipe-down and tape cut-off. Main tape tension is adjusted at the on-way clutch roller in the body of the tape head at point 'D'.
- Be sure to compensate for different unwind tension due to the tape adhesive when changing tape type or suppliers

Note: Different types of tape have different unwind "stickiness". This is due to materials and methods for making the tape so that it will unwind without 'blocking' together or breaking. These differences cause a variation in the unwind force needed, but do not effect the tape bonding to the case.

Tape Tracking

Adjustment Locations 'B' & 'C'



Two adjustments are provided to allow centering of tape along the box:

Point 'B' - A small amount of side to side position adjustment of the tape holder mandrel can be gained by releasing the stem nut on the back of the tape support arm and turning the stem to adjust and re-lock.

Point 'C' - This adjustment at the base of the mandrel support arm "steers" the tracking of the tape through the head so that it runs over the center of the rollers and onto the center of the box.

To adjust tape tracking, release the two screws that secure the arm to the side plate, then adjust the jackscrew at point C1. This is a recessed Allen head set screw, and is located between the two securing bolts. Relative adjustment of this screw with tightening of the upper and lower arm mounting bolts will lean the tape roll away from or toward the centerline of the tape head. Re-tighten the securing bolts before checking the tape centering. Readjust as needed.

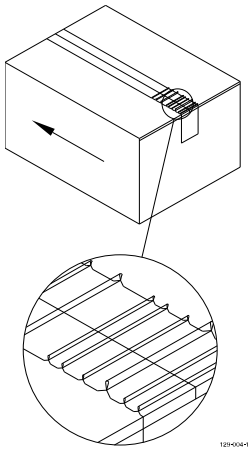
Note: The exclusive 'No Break Tape' feature of the DEKKA Tape Head depends on the tape being centered on the clutch roller at Point 'D'. Hence, tape alignment is essential.

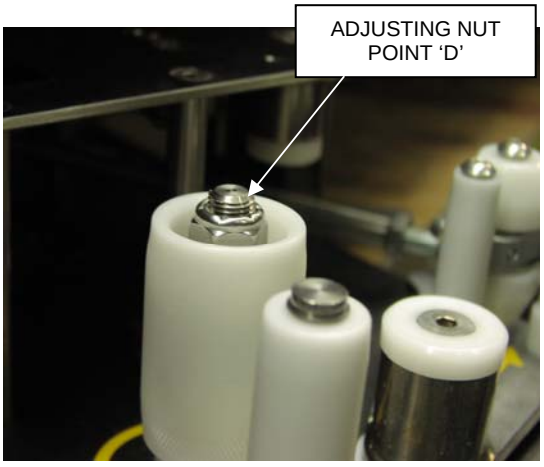
If extreme adjustments are needed to center the tape, this will cause the 'No Break Tape' feature to become ineffective and cause poor performance.

Check that the Tape Heads are not damaged and that the Tape Head mounting brackets have not been dislodged from being on the machine centerline.

Main Tape Tension Adjustment at One-Way Clutch Roller

Adjustment Location 'D'





The adjustment at the one-way clutch roller (Point 'D') affects the amount of "pull" or tension on the tape (i.e. more tension is necessary for heavier corrugated cases and less for lighter). This adjustment will affect "wipe-down" and cut-off characteristics. The illustration shows what happens if the tape is pulled too tight (tape snap-back after cutting can cause wrinkling). The Trouble Shooting Section of this manual covers these situations in more detail.

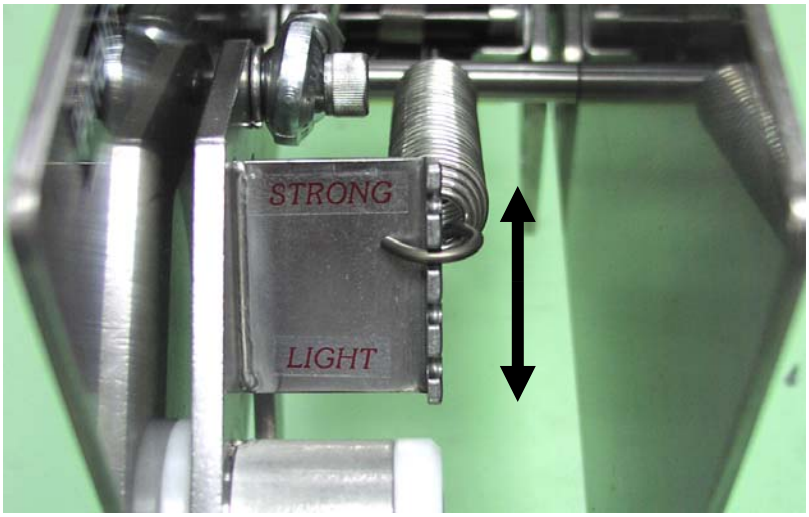
To increase tension tighten the center nut clockwise, to decrease tension turn counter-clockwise. It is best to use a *minimum* size tape roll (close to the core) to test and adjust the clutch roller for proper tension.

Note: This roller only spins one way and is used to prevent backspin in the tape after it is cut. Check that this feature is working by trying to turn the roller backwards by hand; it should not reverse turn.

- Tensioning of the roller at Point 'D' should be set so that it can be turned by hand. If it is too stiff to turn it may cause excessive tape force to be applied to the box. Check other settings as adjustments may be needed depending on box stiffness or tape type (particularly tape unwind tension).
- See the Trouble Shooting Section of this manual for specific conditions and remedies.

Case Contact Roller (Tape Wipe-Down) Spring Force

Adjustment Location 'E'

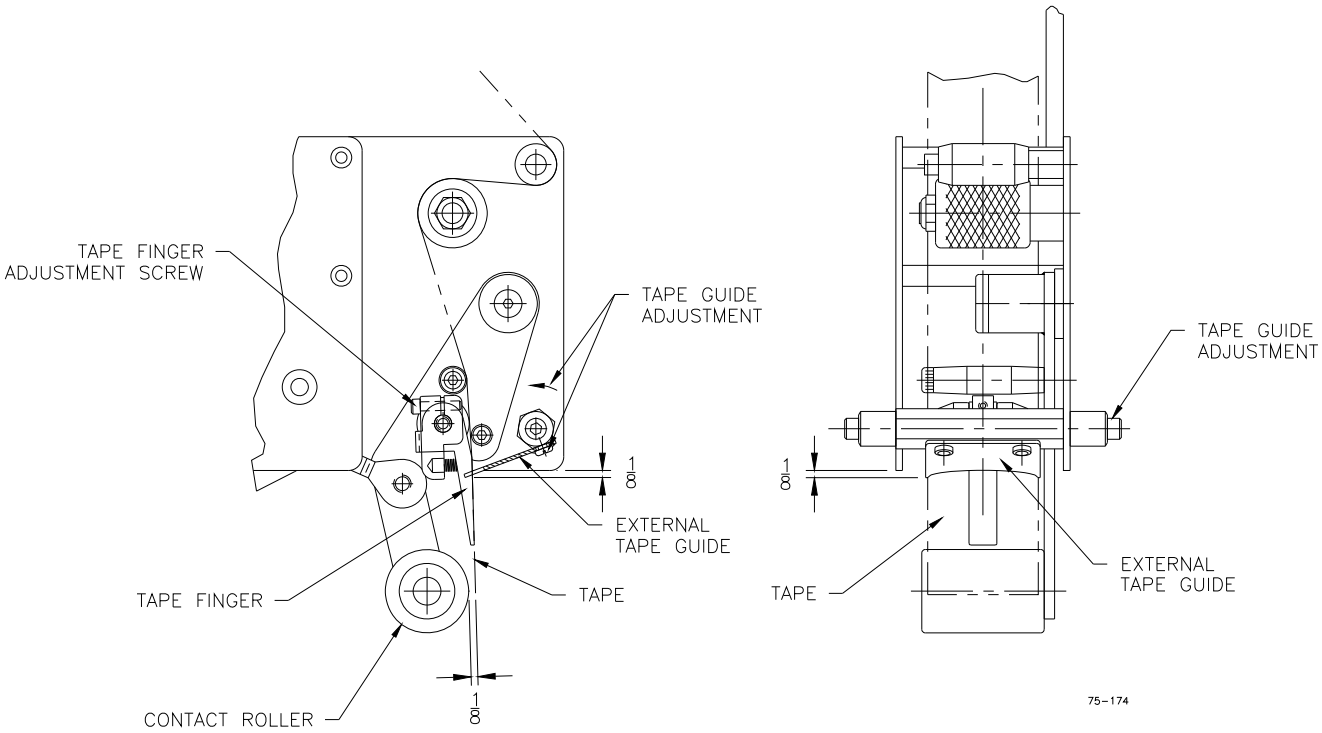


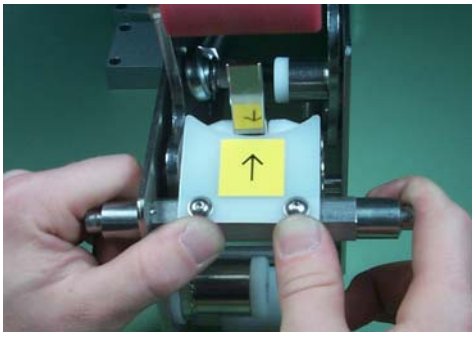
The main roller tension spring (Point 'E') provides wipe-down force at both the front and rear contact rollers (Points 'F' & 'G'). This action rolls the tape onto the box as it is being dispensed. The force adjustment is made by locating the main spring hook in one of the four (4) anchor slots that permit approximately 100% change in force from 'lightest' to 'heaviest'. In general, this is set to strong for heavy, stiff boxes and to lightest for light duty corrugated boxes.

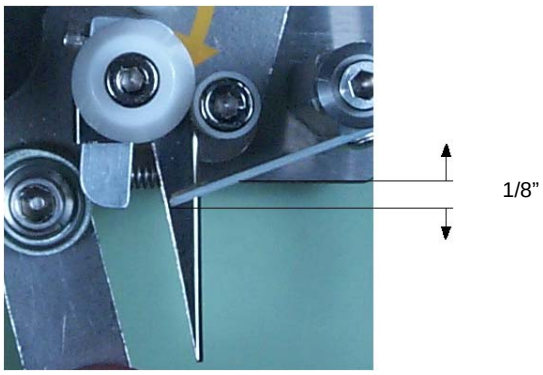
- See the Trouble Shooting Section of this manual for specific conditions and remedies.

Tape Guide and Finger Adjustments

Adjustment Location 'F'







The external plastic tape guide and spring loaded tape finger need to be correctly positioned to shape the free portion of the tape so that it is curved across its width. This gives the tape some "stiffness" to hold it in position in front of the contact roller.

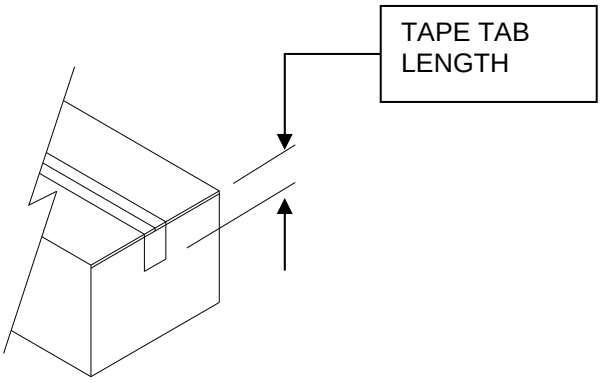
External Tape Guide - can be rotated on its front mount and adjusted in and out slightly by means of its mounting screws. It should be positioned so that the tips of the free end are 1/8" below the side plates.

Tape Finger - can be rotated around its mounting by loosening the screw on top of the mounting clamp. It should be positioned so that the tip of the finger is 1/8" ahead of the contact roller when free.

Tape Cut-Off [Tab] Length Adjustment

Adjustment Location 'G'

The tape tab length is the amount of tape applied up or down the front and back panels of the case.



The leading end or front tape tail that is made when the case first contacts the front tapehead roller is somewhat determined by the geometry of the head, particularly the length of the front roller arm. The tape tail must be long enough that the end of the tape reaches the face of the front roller. This ensures that the leading end of a case passing by is able to 'capture' the tape between the head body and front roller as it first contacts it.

The actual tape tail length however can vary more by the actual speed of the case moving past the head and/or characteristics of the tape and case flap corrugate material. Generally, the higher the case speed or stiffer the case flap material the longer the rear tape tail will tend to be at a given cut-off adjustment.

Tape characteristics such as stretching and roll unwinding resistance can significantly affect tape tail length. Tape tails that are too long can miss being fully wiped-down against the case by the tapehead rollers and leave a portion at the end of the tail unstuck. Sometimes the unstuck end will fold back and adhere to the next case in line causing problems when it comes time to place the individual cases on a pallet, particularly by an automatic process.

The cutter arm length adjustment provides control of the tape cutting action by timing exactly when the tape is cut as the arm drops off the end of the case passing by. A shorter arm length adjustment will result in a shorter tape tail; a longer or extended arm adjustment in a longer tail. The objective will usually be to have tails as long as possible for maximum case closure strength but ones that are fully wiped-down or adhered to the case ends.

To adjust the Tape Cut-off Length loosen the adjustment screws on the cutter arm and slide the assembly to the desired position.

Maintenance & Care of DEKKA Tape Heads

Lubrication Maintenance

The DEKKA series Tape Heads are designed as a low maintenance item and should not require lubrication in normal use. The felt pad on the inside of the knife guard cover, however, should be lubricated every few days with lubricating oil. This will prevent adhesive build-up on the cut-off knife and lengthen its life.

Wear Points

Periodically check for any excessive wear of the pivot points on the head or loose parts.

Cleaning

It may be necessary to clean any adhesive build-up that has occurred on the rollers and knives, depending on the type and quality of the tape used. This can be done by using a solvent - like acetone or lacquer thinner depending on the adhesive used (check with your tape supplier for specific recommended solvents).

If the Tape Heads are subjected to heavy use, daily removal of dust and debris is recommended as excessive dirt and dust may impair smooth running.

NOTE: If bearings become stiff, remove and clean. Lubricate before reassembling.

DEKKA Tape Head Service Component Replacements

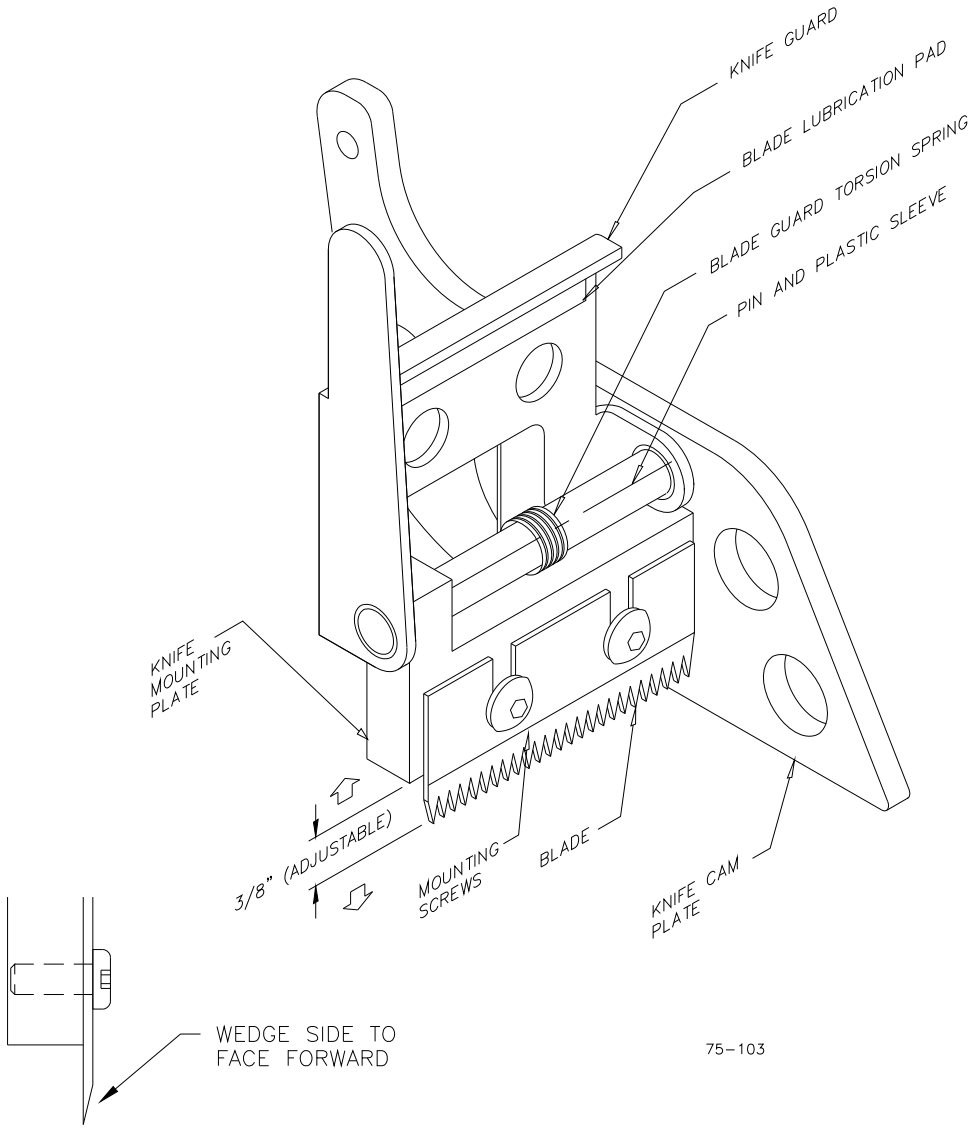
The following is a brief guide to parts replacements. **DEKKA Tape Head Spare Parts Kits, when ordered as an accessory item, come with labelled parts and illustrated instructions that show how each part is replaced**

NOTE: '*Loctite*' thread locking compound is used in the assembly process and can cause screws & nuts to be stiff to loosen; if they can't be removed with some extra force, apply gentle heat to the screw to ease removal.

Knife Replacement

CAUTION

KNIFE BLADES ARE VERY SHARP AND CAN CAUSE SERIOUS CUTS

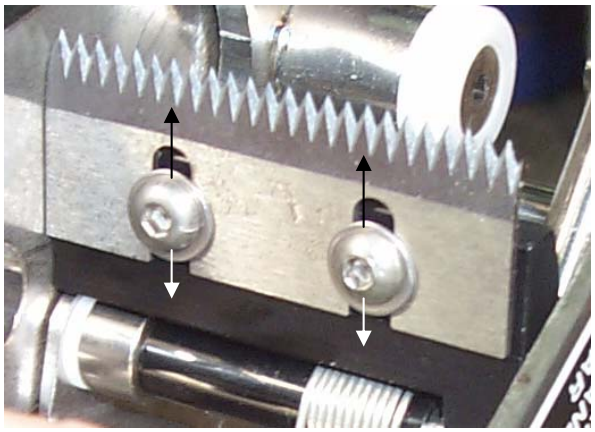


Procedure

1. Loosen the two blade mounting screws to remove the old blade. Screws can be loosened and tightened through holes in the blade guard for added safety.

2. Open the knife guard and carefully remove the old blade. Replace it with a new blade (2 inch Z06-015 and 3 inch Z06-020).

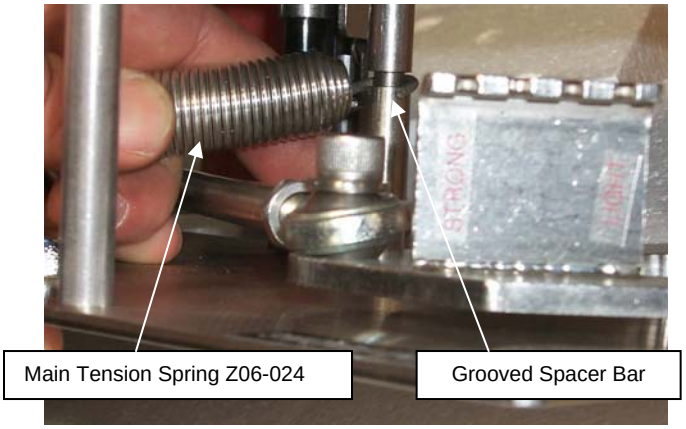
3. Check that the blade bevel side faces the outfeed direction as shown for proper cutting. Adjust blade extension. Extend the blade more for cutting heavy tape but not so that it will touch the guard. The guard must never hit the blade when closing.

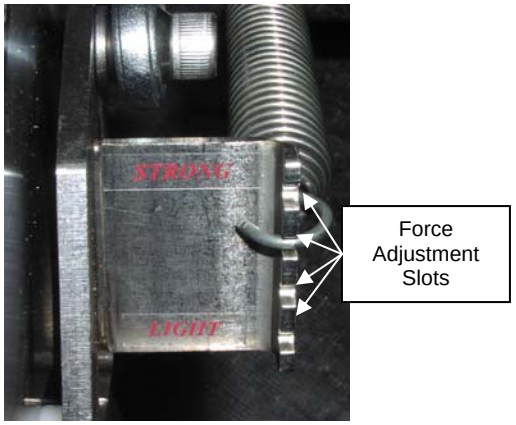


4. Lubricate the felt pad on the guard and use only plastic to scrape adhesive or tape off the blade. Using a metallic object to scrape the blade will shorten its life.

Main Roller Tension Spring Replacement

Refer to Tape Head General Assembly Parts Diagram 129-010A in the DEKKA 22 / 23 Technical Reference Information.

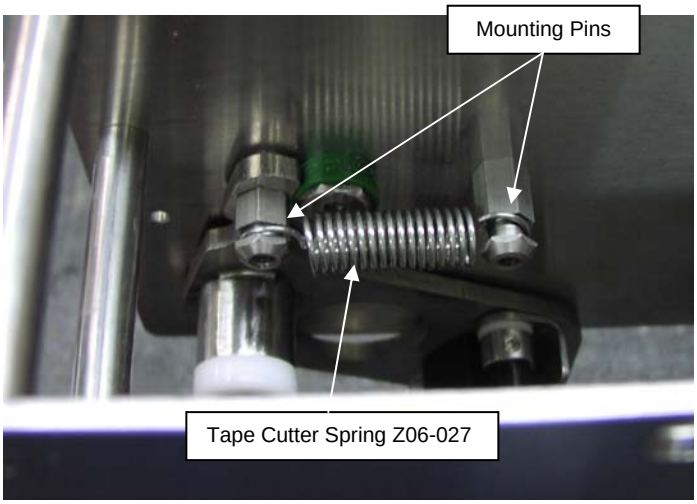




If the Main Roller Tension Spring (Z06-024) is broken or stretched, replace it with a new spring. (See Tape Head Adjustment Section for readjusting). Hook it onto the head spacer anchor end first, then the other into one of the four slots on the arm end depending on the strength of force needed.

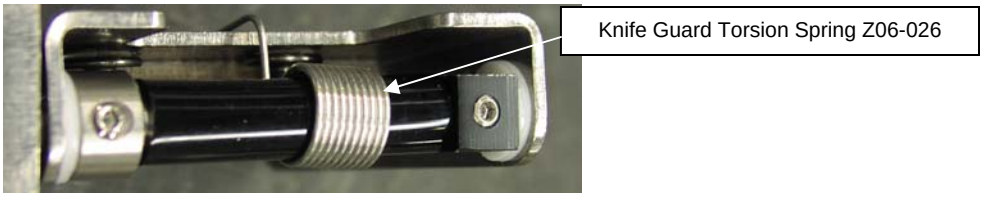
Cut-off Spring Replacement

Refer to Tape Head General Assembly Parts Diagram 129-010A in the Technical Reference Information.



Unhook old spring and replace with the new spring (Z06-027). Check the action of the cut-off arm after replacement is complete. This action must be free to snap back quickly after being depressed to facilitate a clean tape cut off.

Knife Guard Torsion Spring Replacement



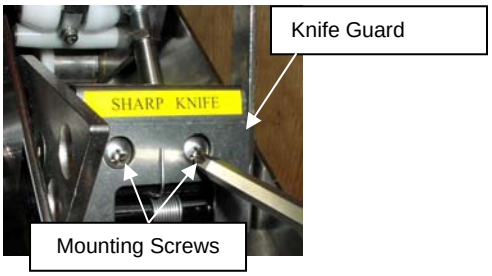
See also parts diagrams 59-038[22], 59-473[23] in the Technical Reference Information.

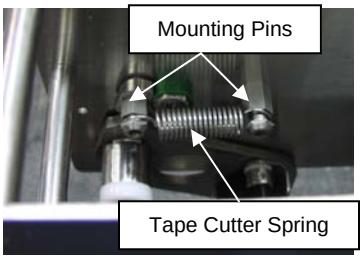
Replacement Part: Z06-026 Knife Guard Torsion Spring

Tools required:
1 1/8" Allen Hex Socket Key
1 5/64" Allen Hex Socket Key
1 Pair of Pliers

Procedure:

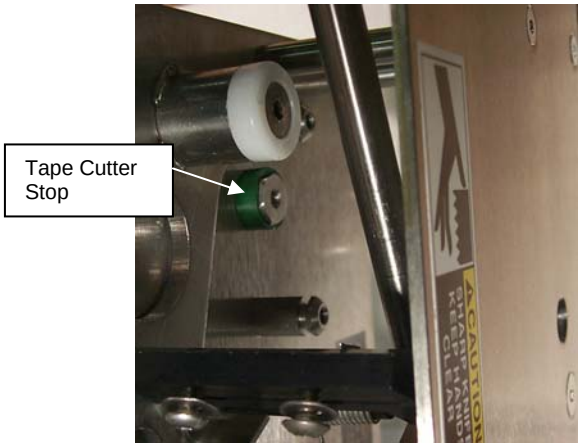
1. **SAFETY - Remove the tape cutter knife by loosening the mounting screws and sliding it out of the knife holder.**

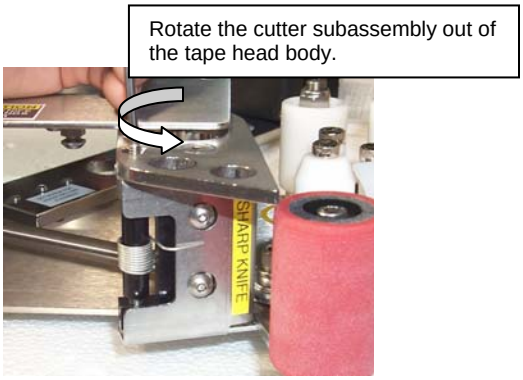




2. **Unhook and remove the knife cutter assembly tension spring.**

3. **Remove Tape Cutter Sub-Assembly Movement Stop**



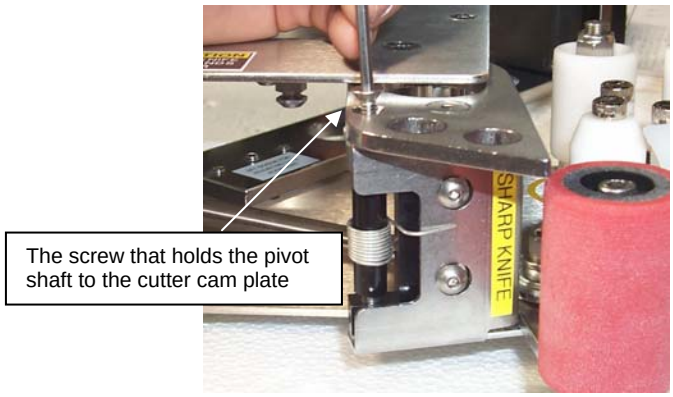


Identify the stop that limits the travel of the tape cutter sub-assembly. It has a rubber cushion around a stud that the upper or inside end of the cutter assembly is pulled against by the spring removed in step 2. Hold the rubber cushion and the stud inside with the pliers and remove the socket flat head screw from outside the side plate using the 1/8" Allen key.

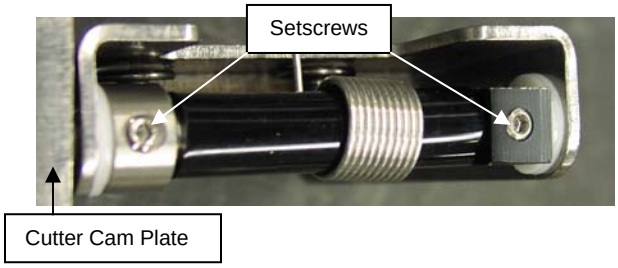
The cutter assembly can then be rotated out of the tape head so that the screws on the side of the knife cam plate are exposed.

4. Disassemble the Knife Guard Mechanism and Replace the Spring

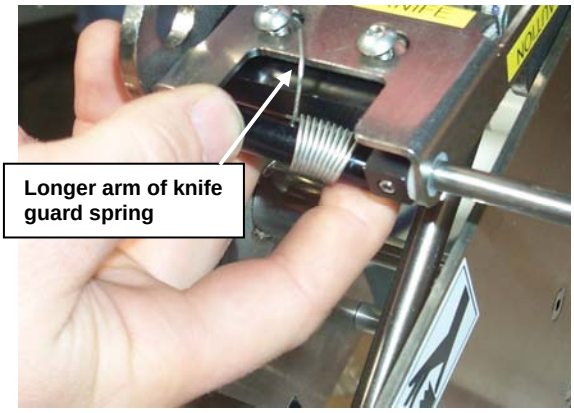
(Refer to Tape Cutter Assembly Drawings 59-003-M1 [22], 59-022-M1 [23] in the Technical Reference Information.



Use the 1/8" hex key to remove the screw that holds the knife guard pivot shaft to cam (side) plate. If the pivot shaft wants to rotate, tighten the setscrew that holds one end of the shaft to the knife mounting plate with a 5/64" Allen hex socket key.



Loosen both setscrews with the 5/64"Allen hex socket key. Using the long arm of the 1/8" Allen key, push the knife guard pin through the end of the knife mounting plate until the lock collar, plastic sleeve and old spring can be removed. It helps to use the arm of the Allen key as a temporary pin to thread and retain the new parts.



Slide the replacement spring onto the plastic sleeve, turning it so that the longer arm will extend down onto the knife guard. Hold the spring open and place the plastic sleeve in line with the knife guard pin. One arm of the spring should be on the knife guard and the other on the knife mounting plate. Push the knife guard pin back into the plastic sleeve, through the lock collar and the other side of the knife guard side plate.

5. Reposition the Tape Cutter Assembly

Rotate the cutter assembly back up into the tape head and replace the stop removed in step 3.

Case Contact Roller Replacements

Refer to Front Tape Roller Assembly Drawings Z59-002[22], Z59-023[23] and Rear Tape Roller Assembly Drawings Z59-005[22], Z59-025[23] in the Technical Reference Information.

If rollers are damaged or cut, the tape will not feed properly and may back-wind around the rollers.

Replacement Parts: Z59-001 DEKKA 22 Contact Roller Assembly - FRONT

Z59-001-M1 DEKKA 22 Contact Roller Assembly - REAR

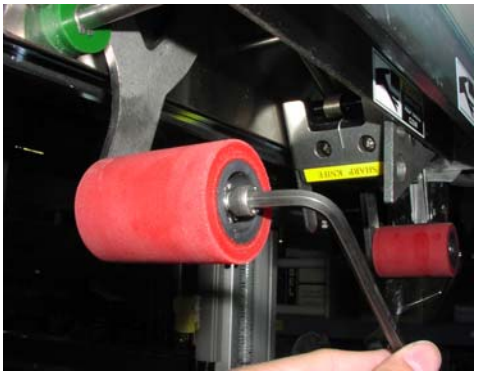
Or Z59-024 DEKKA 23 Contact Roller Assembly

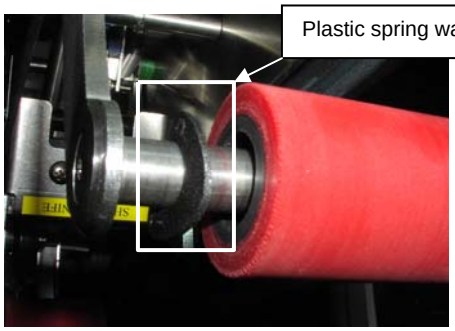
Tools required: 1 3/16" Allen Hex Socket Key

7/16" Wrench

Procedure

1. Using a 3/16 '' Allen Hex Socket Key, remove the hex socket screw and the two washers.
   Caution: These are small and may be lost easily.

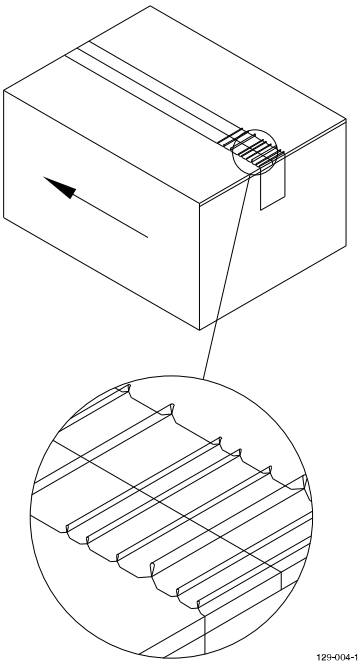




Assemble the new plastic washer onto the shaft of the contact roller with the convex surface or 'belly' of the curved washer facing the arm.

Check to see if the roller drag system is working. It should offer a little smooth resistance to stop the roller from over spinning as this could cause the tape tail on the case to wrinkle.

TROUBLE SHOOTING GUIDE



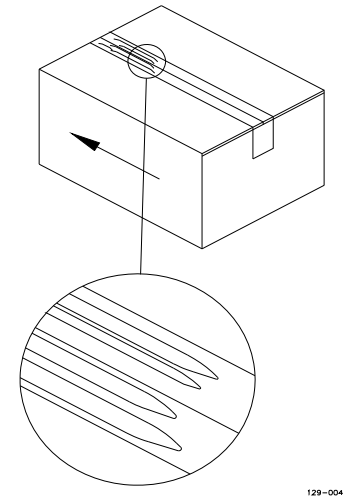
Problem:

Tape is wrinkled across top/bottom of box.

Reasons:

Tape is pulled too tight (Tape snap-back after cutting can cause wrinkling).

1. Loosen unwind tension at tape roll mandrel, Figure 4 – Tape Head Adjustments Diagram at point 'A'. Refer to Item 1 under Tape Head Adjustments.
2. Check main tape tension adjustment at the one-way clutch roller, point 'D', Figure 4. Roller rotation must not be too tight. Refer to Item 3 under Tape Head Adjustments.
3. Check that the main contact (wipe-down) roller tension spring force is not too high. Adjust at point 'E', Figure 4. Refer to Item 4 under Tape Head Adjustments.
4. Check that front contact roller turns freely. Both contact rollers should turn easily but *not* spin loosely. See Contact Roller Replacement.

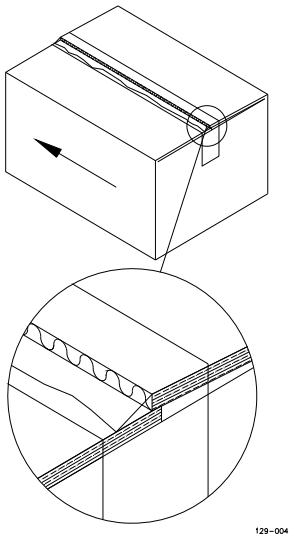


Problem:

Lengthways wrinkling resulting in poor coverage & poor adhesion.

Reasons:

1. Tape Head possibly too high above box. The tape head side plates should be approximately 1/8" or less away from the box.
2. Box is under-filled or flaps sagging inwards, so that the tape does not to stick well (causes wrinkling).
3. Tape threading. Check that tape is threaded and centered correctly. Refer to Figure 3 – Tape Threading Diagram.
4. Loosen unwind tension at tape roll mandrel, Figure 4 – Tape Head Adjustments Diagram at point 'A'. Refer to Item 1 under Tape Head Adjustments.
5. Check main tape tension adjustment at the one-way clutch roller, point 'D', Figure 4. Roller rotation must not be too tight. Refer to Item 3 under Tape Head Adjustments.

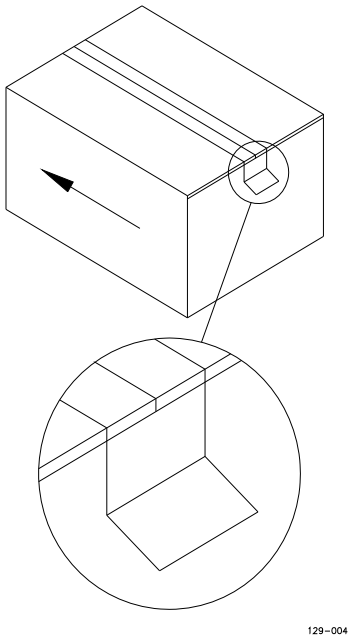


Problem:

Major flaps overlap at box center causing tape to bridge the gap, resulting in very poor adhesion.

Reasons:

1. Check box dimensions. If a flap overlap is present, contact your box supplier. Fold flaps by hand so they meet.
2. Excessive pressure on sides of box. Release side guides or belt pressure on the taping machine until the problem diminishes.
3. Check that the main contact (wipe-down) roller tension spring force is not too high. Adjust at point 'E', Figure 4. Refer to Item 4 under Tape Head Adjustments.

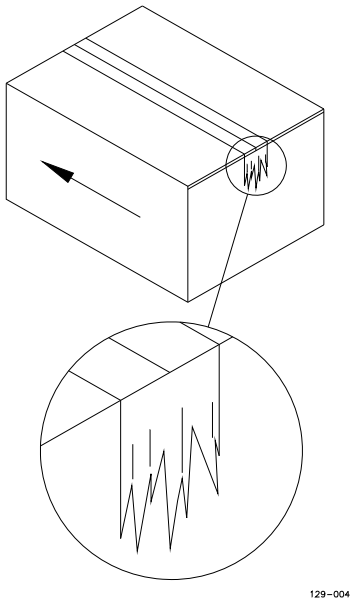


Problem:

Tape over the rear minor flap is not sticking to the case.

Reasons:

1. Tape threading. Check that tape is threaded and centered correctly. Refer to Figure 3 – Tape Threading Diagram.
2. Contact roller "drag" brake may not be working properly. It must turn easily, but not spin freely. See points 'G' and 'F' in Figure 4 – Tape Head Adjustment Diagram.
3. Contact roller condition. Check that contact rollers are clean and free from nicks or cuts; clean with solvent if necessary. Replace if necessary – Section E.
4. "Hold" of tape to contact rollers by static electricity. Dusting the rollers with talcum (baby powder) can help by increasing the static hold and ensuring a smooth release of the tape.
5. Check main tape tension adjustment at the one-way clutch roller, point 'D', Figure 4. Roller rotation must not be too tight. Refer to Item 3 under Tape Head Adj.
6. Dull cut-off knife blade. It can cause tape snap-back causing wipe down problems. See Knife Replacement.
7. Tape quality. Check suitability of tape for the application.
8. Tape Head possibly too high above box. The tape head side plates should be approximately 1/8" or less away from the top or bottom of the box.



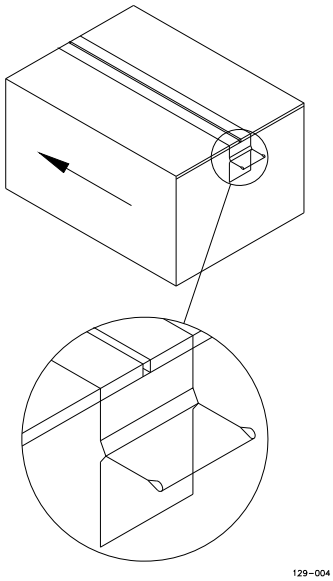
Problem:

Ragged cut-off of tape tail.

Reasons:

CAUTION: Knives are very sharp!

1. Dull cut-off knife blade. Check that blade is sharp. Replace if necessary. See Knife Replacement.
2. Tape or debris on the knife, clean carefully with solvent and a plastic scraper. Never use a hard or metal object to clean knives. Even minor damage to the sharp blade teeth can cause a blade to stop cutting tape.
3. Blade may not be sufficiently extended as mounted in its holder. Slots in the blade allow its position to be adjusted but it must not interfere with blade guard operation. Refer to Figure 7 – Cutter Blade Replacement Diagram and Knife Replacement.
4. Loosen unwind tension at tape roll mandrel, Figure 4 – Tape Head Adjustments Diagram at point 'A'. Refer to Item 1 under Tape Head Adjustments.
5. Check main tape tension adjustment at the one-way clutch roller, point 'D', Figure 4. Roller rotation must not be too tight. Refer to Item 3 under Tape Head Adjustments.
6. Tape Head possibly too high above box. The tape head side plates should be approximately 1/8" or less away from the top or bottom of the box.

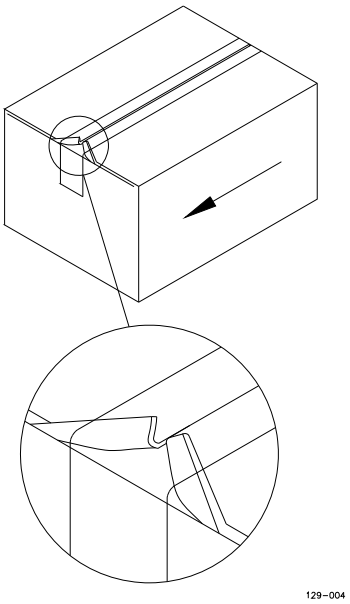


Problem:

The tape end is folded over on itself (it is stuck sticky side to sticky side).

Reasons:

1. Loosen unwind tension at tape roll mandrel, Figure 4 – Tape Head Adjustments Diagram at point 'A'. Refer to Item 1 under Tape Head Adjustments.
2. Check main tape tension adjustment at the one-way clutch roller, point 'D', Figure 4. Roller rotation must not be too tight. Refer to Item 3 under Tape Head Adjustments.
3. Contact (wipe-down) roller "drag" brake may not be working properly. Check that front contact roller turns freely. Both contact rollers should turn easily but *not* spin loosely. See Contact Roller Replacement and points 'G' and 'F' in Figure 4.

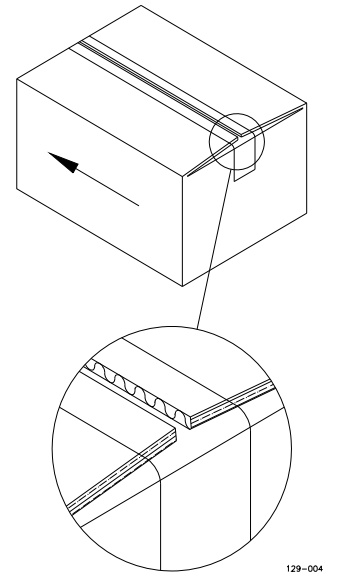


Problem:

The tape has peeled back top corners/corner of major flaps on leading edge of the box. The flaps are sticking out ahead of the box causing tape to stick on the end of major flaps and cause back folding of the extreme edges.

Reasons:

1. Excessive contact (wipe-down) roller pressure can cause the end wall of the box to collapse in; therefore making the major flap edges hit the tape first. Check that the main contact roller tension spring force is not too high. Adjust at point 'E', Figure 4. Refer to Item 4 under Tape Head Adjustments.
2. The box has entered the tape head out of square (one flap will then fold back), correct this by ensuring that the case enters the machine squarely.
3. Box quality - particularly the manufacturer's joint (corner glue lap).
4. Ensure that the tape head is pressing the flaps down firmly when the tape hits the front edge of the box.
5. Tape Head possibly too high above box. The tape head side plates should be approximately 1/8" or less away from the top or bottom of the box.

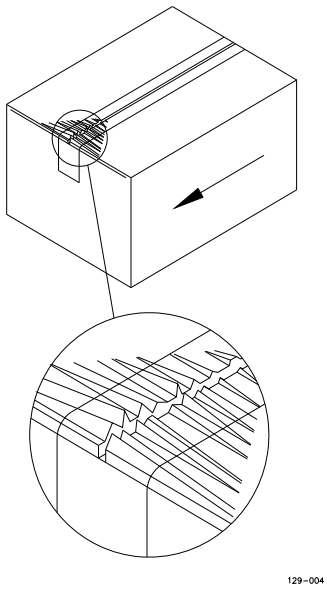


Problem:

The major flaps are not held down tightly and are 'tented' at the center of the box.

Reasons:

1. Excessive box over-fill. Check that the box will close by hand and that flaps are fully depressed before entering the tape head.
4. Tape tension is not high enough to pull flaps down. Check main tape tension adjustment at the one-way clutch roller, point 'D', Figure 4 – Tape Head Adjustments Diagram. Roller rotation must not be too tight. Refer to Item 3 under Tape Head Adjustments.
2. Tape Head possibly too high above box. The tape head side plates should be approximately 1/8" or less away from the top or bottom of the box.

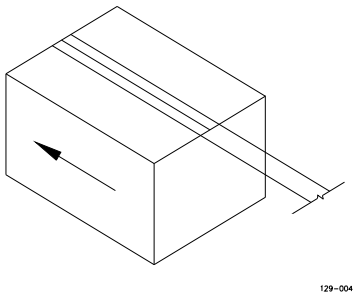


Problem:

Crinkles appear on top of the box in leading edge of corrugated major flaps.

Reasons:

1. Tape head too close to box. Raise the tape head up slightly and retry.
2. Hang-ups or obstructions on the tape head or tape head bracket/mounting.
3. Tape head may not be level and parallel to the machine frame. Correct by adjusting the tape head-mounting bracket to a level and straight position.



Problem:

The tape is not being cut.

Reasons:

1. Knife blade condition. Check that blade is sharp. Replace if necessary. See Knife Replacement.
2. Tape or debris on the knife, clean carefully with solvent and a plastic scraper. Never use a hard or metal object to clean knives. Even minor damage to the sharp blade teeth can cause a blade to stop cutting tape.
3. Blade may not be sufficiently extended as mounted in its holder. Slots in the blade allow its position to be adjusted but it must not interfere with blade guard operation. Refer to Figure 7 – Cutter Blade Replacement Diagram and Knife Replacement.
4. Tape Head possibly too high above box. The tape head side plates should be approximately 1/8" or less away from the top or bottom of the box.
5. "Soft" box quality. If so, lessen contact roller pressure by adjusting spring force. Check that the main wipe-down roller tension spring force is not too high. Adjust at point 'E', Figure 4 – Tape Head Adjustments Diagram. Refer to Item 4 under Tape Head Adjustments.