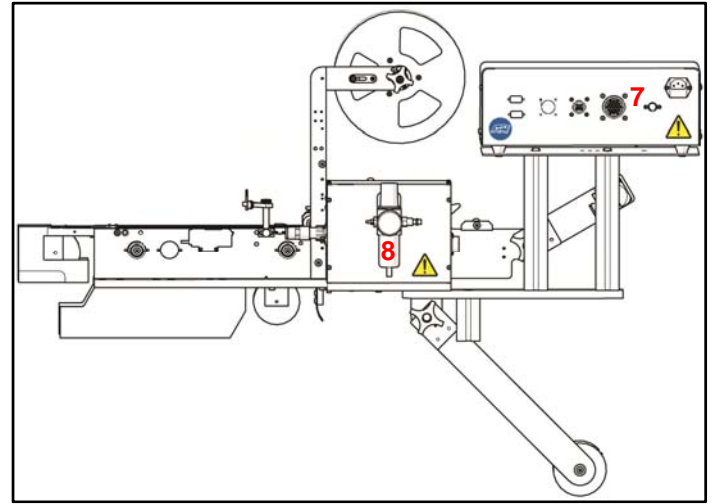
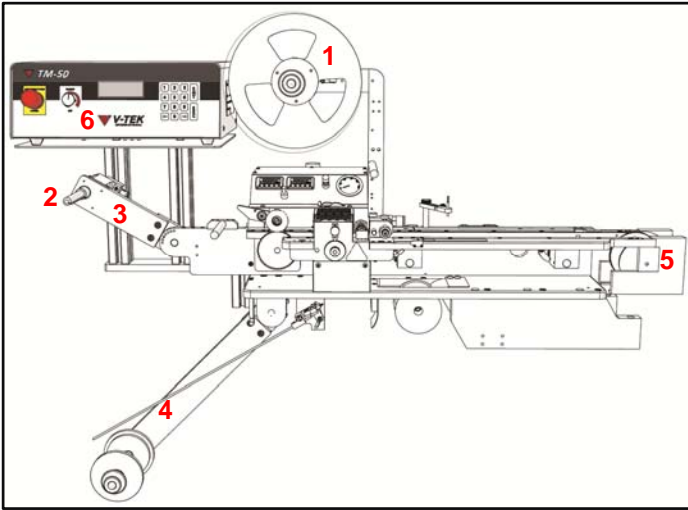


This quick start guide provides basic setup and operating instructions for the OEM TM-50. The intended use of the OEM TM-50 Taping Machine is to produce taped reels of individually sealed and consistently orientated components. Use of this equipment in any other way is not recommended.

**Work Area:** The OEM TM-50 is designed to be operated in a temperature-controlled, light industrial setting. The machine should be mounted on a flat, dry, stable surface in a well-lit area. Choose a mounting area that is at least 72" x 30" to provide sufficient space for the assembled machine. [See pages 2-4 for Quick Start instructions.](#)



**Front View**

- |                    |                |
|--------------------|----------------|
| 1. Cover Tape Arm  | 4. Payout Arm  |
| 2. Take-up Spindle | 5. Tape Guides |
| 3. Take-up Arm     | 6. Controller  |

**Back View**

- |                              |
|------------------------------|
| 7. Cable & Power Connections |
| 8. Air Regulator             |

Physical Specifications: **Height:** 18 inches (46 cm), **Width:** 42 inches (107 cm), **Depth:** 18 inches (46 cm), **Weight:** 105 lbs. (48 kg)  
 Power Required: 115/230 VAC, 50-60 Hz; 1.1 Amp, 120 Volts; .6 AMP, 220 Volts  
 Operating Environment: Operating Temperature: 0°C - 50°C (32°F - 122°F), Maximum Humidity: 90% non-condensing



- Only qualified personnel with the proper technical training, experience working on this type of equipment and awareness of the possible hazards should perform maintenance on the OEM TM-50.
- The user is protected from moving parts and exposure to objects being ejected under pressure by a metal enclosure. The OEM TM-50 should never be operated with the enclosure removed. There are no internal parts that can be serviced by the user.
- Always disconnect the machine from air and power supplies, placing the unplugged cables in clear view before performing any maintenance tasks.

Detailed User's Guides which include maintenance instructions, spare parts lists and troubleshooting information are available on the V-TEK, Inc. website: [www.vtekusa.com](http://www.vtekusa.com).

Contact Information

V-TEK, Inc.  
 751 Summit Ave  
 Mankato, MN 56001

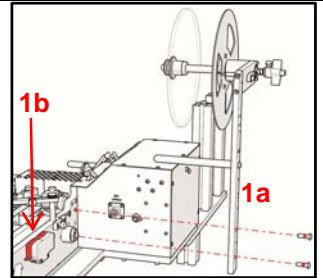
TEL: (507) 387-2039  
 website: <http://www.vtekusa.com>  
 email: [service@vtekusa.com](mailto:service@vtekusa.com)



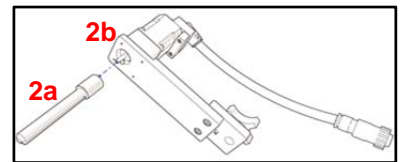
## Assembly

1. Attach the Cover Tape Arm  
Using a 3/16" hex wrench, remove the (2) 1/4" SHCS located on the backside of the loading track. Bolt the **Cover Tape Arm (1a)** to the track support bracket.

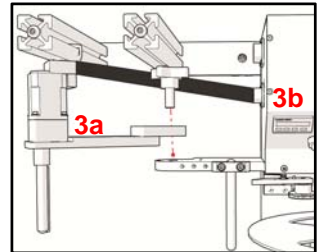
There are (2) amplifiers also located on the back side of the loading track. Lift the top of the **Amplifier (1b)** closest to the track to access the small grey switch inside. Push the switch UP, and then insert the double-pronged fiber optic cable from the cover tape arm into the matching opening on the amplifier.



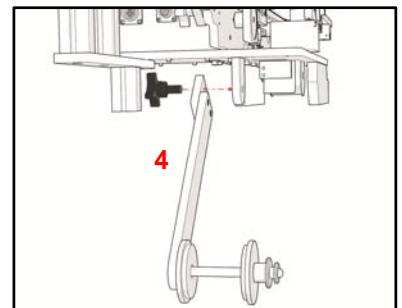
2. Attach the Take-up Spindle  
Attach the **Take-up Spindle (2a)** to the **Take-up Motor Assembly (2b)** by sliding it onto the pin and tightening the set screw with a 3/32" hex wrench.



3. Attach the Take-up Arm  
Remove the black knob from the left side of the track support bracket. The take-up arm has a dowel pin which locks into position holes on the track support bracket. Slide the **Take-Up Arm (3a)** onto the threaded rod, engage the dowel pin into the desired position, and secure it into place with the black knob. Plug the electrical connector into the **Take-Up Motor Receptacle (3b)**.



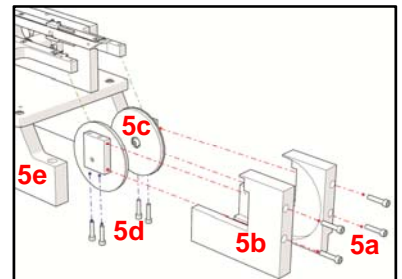
4. Attach the Payout Arm  
Remove the black knob from the right side of the track support bracket. The **Payout Arm (4)** has a dowel pin which locks into position holes on the track support bracket. Slide the feed reel support arm onto the threaded rod, engage the dowel pin into the desired position, and secure it into place with the black knob.



5. Attach the Tape Guide  
Remove the (4) 8-32 x 3/4" BHCS (**5a**) which attach the **Pulley Mounts (5a)** to the **Pulley Covers (5c)**.

Remove the (4) 8-32 x 3/4" BHCS from the top of the (2) pulley mounts and insert them in the bottom of the **Pulley Mounts (5d)**. Use the BHCS to attach the pulley mounts to the right end of the **Loading Track (5c)**.

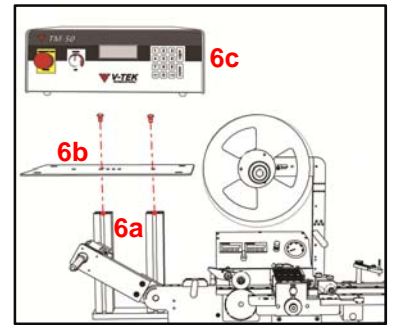
Attach the (2) pulley covers to the pulley mounts using the (4) 8-32 x 3/4" BHCS.



## 6. Mount the Controller

Using a 5/32" hex wrench, remove the (2) 5/16" BHCS from the top of the (2) **Controller Pedestals (6a)**. Attach the **Controller Baseplate (6b)** to the pedestals using the BHCS.

Place the **Controller (6c)** on the controller baseplate. Engage the four corner holes in the controller baseplate with the four rubber feet on the bottom of the controller so that it is seated securely.

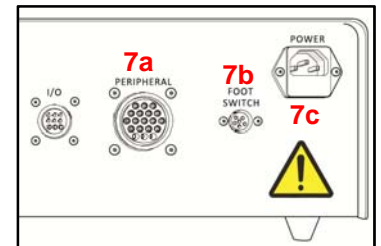


## 7. Connect Cables

Connect the peripheral cable to the right side of the machine and then to the receptacle labeled **Peripheral (7a)** on the back of the controller.

Plug the foot switch into the receptacle labeled **Foot Switch (7b)** on the back of the controller

Plug the power supply cord into the receptacle labeled **Power (7c)** on the back of the controller.

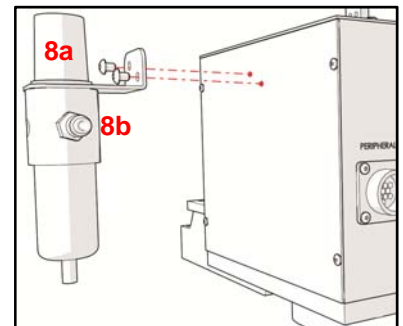


## 8. Install Air Regulator

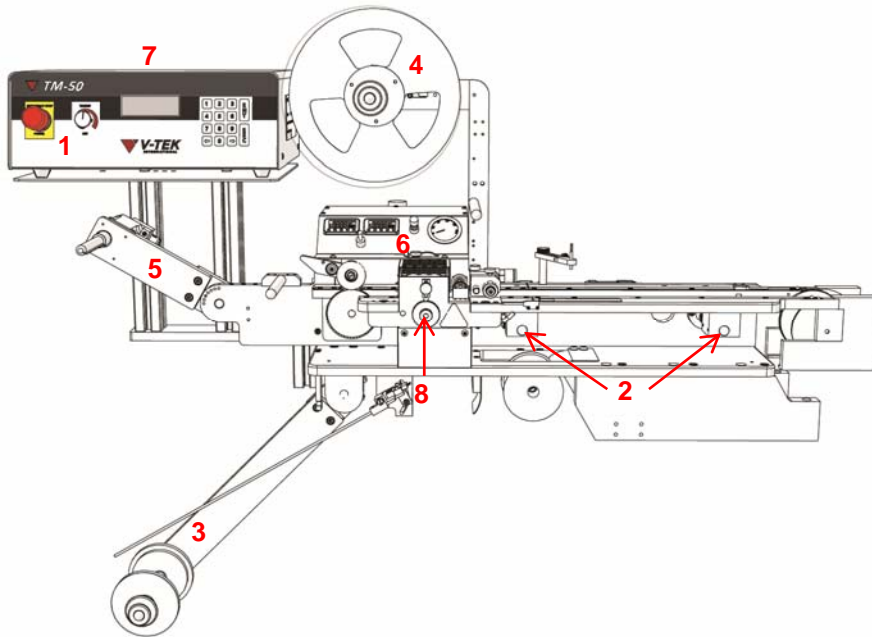
Attach the **Air Regulator (8a)** to the back of the sealer controller with the provided screws.

Attach the open end of the blue air hose to the right side of the controller. Connect an airline to the air regulator's **Air Connector (8b)** and set the regulator to 85 psi. It can be adjusted by lifting the adjustment knob and turning it. Once it reads 85 psi, push the knob back in to lock it into place.

**Note:** An air supply is only necessary for the operation of the heat sealer.  
Suggested settings are between 85-110 psi.



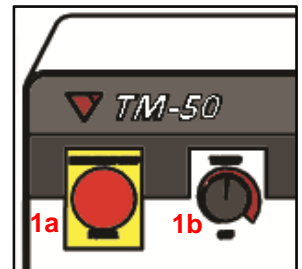
## Set up



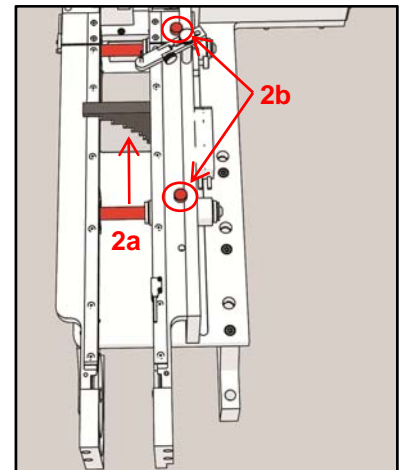
### Front View

1. Power/E-Stop & Take-up Controls
2. Track Shafts
3. Payout Arm
4. Cover Tape Arm
5. Take-up Arm
6. Sealer Controls
7. Controller
8. Sealer Position Adjusters

1. Power On  
Turn the **Power/Emergency Stop Button (1a)** on the front of the controller to turn the TM-50 ON. Ensure the **Take-up Tension Knob (1b)** is fully counterclockwise in the OFF position.

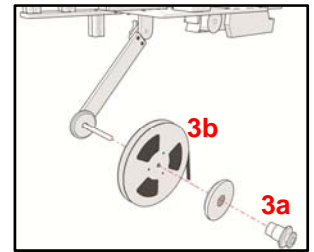


2. Set Track Width  
Insert the provided **Track Width Gauge (2a)** into the track, loosening the two **Thumb Screws (2b)** to adjust track width as needed.

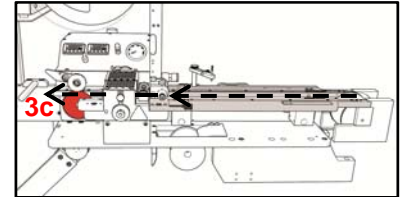


### 3. Load Carrier Tape

Remove the **Reel Lock (3a)** from the payout reel spindle by pulling the two disks apart and sliding it off the spindle. Place a bulk **Carrier Tape Reel (3b)** on the payout arm, positioning it so the tape unwinds from the top and the sprocket holes are on the inside. Replace the reel lock.



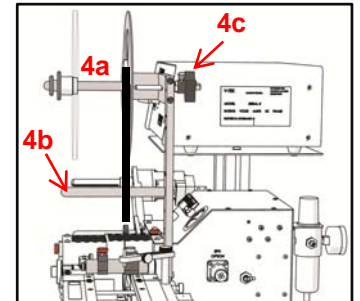
Guide the tape through the track and past the sealer. Engage the sprocket holes on the **Drive Sprocket** teeth. **(3c)**



### 4. Load Cover Tape

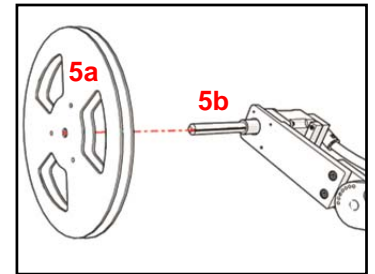
Remove the reel lock from the cover tape spindle. Place a **Cover Tape Reel (4a)** on the cover tape arm, ensuring the tape unwinds to the right from the bottom of the reel. Loosen the red knob on the **Cover Tape Guide (4b)** and set the guide at the correct width. Attach the cover tape to the carrier tape with blue tabbing tape. Thread both into the sealer assembly. Run the machine to advance the tapes through the sealer.

Adjust the cover tape tension, turning the **Tension Adjustment Knob (4c)** on the back of the cover tape arm IN to increase tension, and OUT to decrease tension.



### 5. Load Take-up Reel

Place an empty **Take-up Reel (5a)** on the **Take-up Spindle (5b)**. Ensure the reel is the same width as the carrier tape reel and its diameter is large enough to accommodate the current taping job.



### 6. Sealer Setup

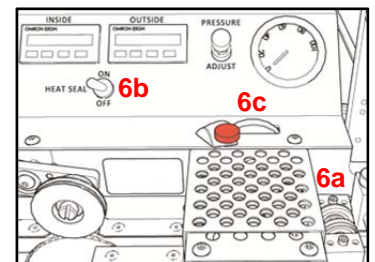
#### For Heat Seal:

Loosen the **Roller Pressure Screws (6a)** so the rollers are not in contact with the tape. Turn the **Heat Seal Switch ON (6b)**. Adjust heat shoe air pressure by turning the **Pressure Adjust Knob (6c)** clockwise to increase pressure.

**Note:** Recommended starting air pressure is 50 psi. The maximum air pressure is 110 psi.

#### For PSA Seal:

Ensure the **Heat Seal Switch (6b)** is OFF. Spin the roller while turning the **Roller Pressure Screws (6a)** clockwise until the wheel no longer spins freely, then turn the screw another 1/8 turn. The roller should be firmly in contact with the tape. Repeat for the other roller.



## 7. Configure Controller Settings

Set controller parameters for the current job, using the keypad to move through the controller *Setup Menu*. Select MODE, and then select HEAT or PSA seal.



## 8. Test Seal

Use the foot switch to advance tape through the sealer. Check the sealed tape for desired seal position. To adjust the inner shoe or outer shoe positions, loosen the **Position Lock (8a)** and turn the **Seal Adjuster (8b)**. Turning the adjuster counter-clockwise will move the seal toward the user.

Test a sample of the sealed tape with a peel force tester to ensure the cover tape is firmly adhered to the carrier tape. The seal should appear as a solid, consistent line. The TM-50 is now ready for operation.

