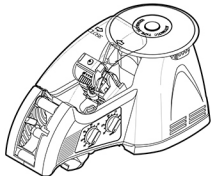




Electric Carousel Tape Dispenser TDA025B INSTRUCTION MANUAL



** Please read the instruction manual in order to use the product appropriately and safely.

BEFORE USE

Please read this Instruction Manual carefully. For your safety, keep this Instruction Manual for reference and troubleshooting.

SAFETY INSTRUCTIONS

The safety guidelines in this Instruction Manual must be observed in order to prevent damage to the machine, and injury to the operator or those nearby. The safety guidelines under "Warning" and "Caution" describe possible injury or damage that may be suffered from operating or maintaining the machine in a manner other than described in this Instruction Manual. Read and follow the safety precautions carefully before operating the machine.

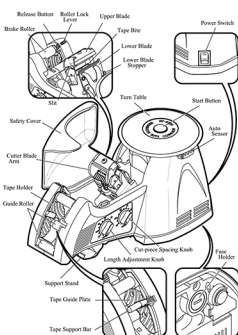
DEFINITION OF WARNING SYMBOLS

- Warning** Indicates a potentially hazardous situation which, if not avoided, could result in serious injury
- Caution** Indicates that careless handling may result in operator injury or machine damage.

- Indicates Caution
A symbol within the triangle, or the description, will indicate a specific hazard.
- A Prohibited Action
A symbol within the circle, or with a diagonal stroke, will indicate a prohibited action.
- A Required Action
A symbol within the circle in black, or the description, will indicate the required action.
- Warning**
 - Do not plug in, unplug the cord, or operate the machine with wet hands. Failure to observe this may result in injury due to electric shocks.
 - Never insert your finger, any body part, or any foreign object into the machine. Failure to observe this may result in injury.
 - Keep hair or loose clothing away from the machine while it is operating. Failure to observe this may result in injury.
 - This machine is intended for industrial use only. Do not allow untrained operators or children to operate the machine. Failure to observe this may result in injury.
 - Turn off the power switch and unplug machine prior to replacing the blade or performing any maintenance on the machine. Failure to observe this may result in injury.

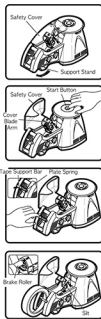
- Do not use this machine for anything other than that specified applications. Use of the machine for any unintended applications can cause injury to the operator or failure of the machine.
- Caution**
 - Do not install the machine in a wet environment. Doing so may cause electric shock or damage to the product.
 - Do not disassemble product. Doing so may cause accidents product failures.
 - Hold the plug base when unplugging the power cord. Pulling on the cord can cause electric shock if power cord is damaged.
 - Do not put waste in the label outlet. It may cause accidents or breakdown of the product.
 - Only trained operators should use this machine. When the machine is left unattended, make sure to turn it off and unplug it. Improper use may cause accidents or machine damage.
 - Properly secure the power plug. Not plugging the power cord in to the outlet properly may cause fire or electrical shock.

IDENTIFICATION OF PARTS

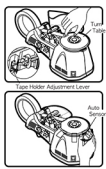


LOADING THE TAPE ROLL

- Make sure to turn the **POWER SWITCH** off when loading or removing tape.
- When loading tape, do not touch the Upper or Lower Blades. Blade contact may cause injuries and accidents.
- Make sure the **Support Stand** is extended.
- Make sure the power cord is plugged in.
- Turn the power switch **ON**.
 - A short beep will sound and the Start Button will light up indicating the dispense mode.
- Open the **Safety Cover**.
 - The Start Button will flash red.
- Press the Start Button to jog the Cutter Blade Arm.
 - Press and hold the Start Button to jog Cutter Blade Arm continuously.
 - Stop when the Cutter Blade Arm is on its way back.
- Turn the power switch **OFF**.
- Pull the **Tape Support Bar** out until it latches in place.
- Lead the tape roll and unlatch the Tape Support Bar.
- Thread the tape under the Brake Roller, through the slit in the Cutter Blade Arm, and press the tape on the Turn Table.

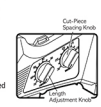


- Adjust the **Tape Holder** to the width of the tape roll by sliding the **Tape Holder Adjustment Lever**.
- Close the **Safety Cover**.
- Turn the **Power Switch ON**.
- Select Mode and press the **Start Button** to dispense tape.



SETTING THE TAPE LENGTH & CUT-PIECE SPACING

- Set the **Length Adjustment Knob** to the approximate length setting.
 - Actual length may vary with tape type and condition.
- Set **Cut-Piece Spacing Width knob** to the desired turn table spacing.
 - Set enough space to prevent overlapping.



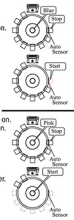
SETTING THE DISPENSE MODES

You can choose from 3 different dispensing modes. Press and hold the Start Button until you hear a short beep when holding down the Start Button, the modes will change as shown in the chart below:

```

  graph LR
    Start((Start)) --> Blue[Blue Light]
    Start --> Pink[Pink Light]
    Start --> Red[Red Light]
    Start --> Purple[Purple Light]
    
    Blue --- Mode1[Automatic Mode]
    Pink --- Mode2[Manual Mode]
    Red --- Mode3[Manual Mode]
    Purple --- Mode4[Pre-setting Mode]
    
    Mode1 --- Hold1[Hold longer]
    Mode2 --- Hold2[Hold longer]
    Mode3 --- Hold3[Hold longer]
    Mode4 --- Hold4[Hold longer]
    
    Mode1 --> Start
    Mode2 --> Start
    Mode3 --> Start
    Mode4 --> Start
  
```

- Dispense Modes can only be changed when the Safety Cover is in the closed position.
- Automatic Mode (Blue Light)**
 - Press and hold Start Button until blue light is on.
 - Move the Auto Sensor to the desired stop position.
 - Press the Start Button to start dispensing.
 - When the tape blocks the Auto Sensor the dispenser will stop.
 - If the dispenser fails to stop, reposition the Auto Sensor.
- Manual Mode (Pink Light)**
 - Press and hold the Start Button until pink light is on.
 - Move the Auto Sensor to the desired stop position.
 - Press the Start Button to start dispensing.
 - When the tape blocks the Auto Sensor the dispenser will stop.
 - If the dispenser fails to stop, reposition the Auto Sensor.
- Pre-setting Mode (Purple Light)**
 - Press the Start Button will restart the dispense.



Manual Mode

- Press and hold the Start Button until red light is on.
- Press the Start Button to start Manual Mode dispensing.
- The dispenser will stop when the selected number of cuts has dispensed.
- Pressing the Start Button will restart the dispenser.



Selecting Number of Manual Mode Cuts (Preset Mode)



- Turn Power Switch to OFF position.
- While holding down the Start Button, turn power switch back on.
- After a short beep, release the Start Button. The dispenser will keep again.
- Start Button alternates between red and blue.
- Keep pressing the Start Button to set the number of pieces desired minus two.
- Example: pressing the Start Button 8 times will select 10 pieces.
- The Maximum selected cut pieces is 15.
- After selecting number of pieces, press and hold Start Button until short beep sounds to finish programming.
- Press the red Start Button to dispense tape manually.
- The preset number will be retained in memory until reset.
- To stop the dispensing operation prematurely, press the Start Button.

Positioning Mode

Blade Stop (Closed Position)

- Hold Start Button until Pink light is illuminated.
- Hold Start Button until Blue light is illuminated.
- Press the Start Button.
- After cutting, the Cut Arm Blade will stop in closed position.



Blade Stop (Open Position)

- Hold Start Button until Pink light is blinking.
- Press Start Button once. (Blue light is illuminated)
- Press the Start Button.
- After cutting, the Cut Arm Blade will stop in open position.



Dealing with Curling Tape

- Press the Roller Lock Lever inward.
- Rotate the Brake Roller until cannot turn.
- With the roller locked, the cut length may vary.
- Adjust length as necessary.
- Press the Release Button to release the lock.



Replacing the Upper & Lower Blades

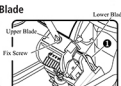
The blades are consumable, and they will eventually wear out. When this happens, they should be replaced with new blades. The life of the blades are determined by many factors; the tapes adhesive, material, thickness, as well as other factors.

- The blades are very sharp.
- Do not touch the blades when replacing them.



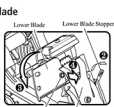
How to replace the Upper Blade

- Turn the Power Switch off and unplug the cord.
- Open the Safety Cover.
- Remove the screw from the Upper Blade.
- Remove and replace with new blade.
- Load tape and close Safety Cover.
- Plug in, turn on and test the dispenser.



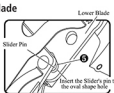
How to remove the Lower Blade

- Turn the Power Switch off and unplug the cord.
- Open the Safety Cover.
- For easy removal, turn the Length Adjustment Knob counter-clockwise to its maximum open position.
- Press the Lower Blade Press and raise the Lower Blade Stopper. (1)-(2)
- Raise right side of the lower blade. (3)
- Rotate the blade 180 degrees to the left and take the Lower Blade out of the fulcrum. (4)-(5)



How to replace the Lower Blade

- Put the new Lower Blade back on the fulcrum.
- Turn the Lower Blade until the Slider Pin is inserted into the oval shape hole of the Lower Blade. (1)
- Push the Lower Blade Stopper down.
- Assure that the blades are set properly or the machine may incur damage.
- Load tape and close the Safety Cover.
- Plug in, turn on and test the machine.



Maintenance

- After thorough use of the TDA025B, tape residue may appear on the blades which can cause deterioration in cut quality. Remove the tape residue with an alcohol swab or Q-tip.
- Check the screw of Upper Blade regularly. If the screw is loose, TDA025B may not operate properly.
- If dispensed tape has trouble sticking to the Turn Table, clean the Turn Table with alcohol on a clean dry cloth, swab or Q-tip.

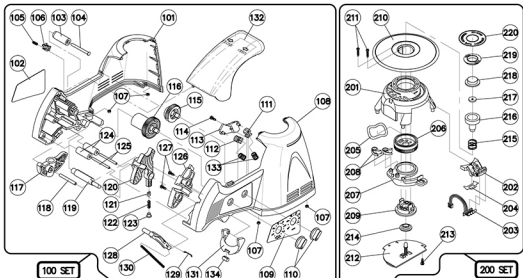
Troubleshooting

Please try the following before contacting START International Technical Service

PROBLEM	Possible Cause	SOLUTION
Machine will not turn on.	AC cord disconnected Blown Fuse	Ensure the cord is plugged in. Replace the fuse with a new one. If replacing the fuse does not fix the problem, discontinue operation of the product.
Type no longer dispenses tape automatically (Auto Mode)	Manual Mode is activated. The sensor is dirty. There is a light source close to the sensor.	Change to Automatic Mode. Clean the TDA025B. Move machine away from light source.
TDA025B sensor doesn't detect tape (Auto Mode)	Tape is not detected by sensor. Extremely transparent tape is being applied.	Adjust the position of the sensor. Some tapes do not work when unit is in Automatic Mode.
Type lengths are inconsistent.	Tape used has very aggressive adhesive. Slippery tape is used. An elastic tape is used.	Adjust the cut length and test, if inconsistent cuts continue, please contact START International. Not all tapes are suitable for consistent cuts.

! If the Troubleshooting guide above does not solve your technical issues, please discontinue use of the machine and call START International at +1 (972) 248-1999 or email support@startinternational.com.

TDA025B Exploded Parts Views



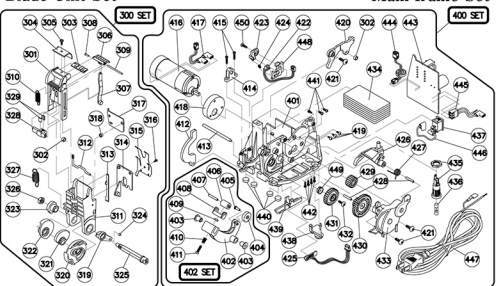
Cover Set

Turn Table Set



Questions? Call Us at +1 (972) 248-1999
or visit www.STARInternational.com

Blade Unit Set



Main frame Set

Specifications

Power Requirement	AC 100-230V	Machine Body Material	Special ABS resin
Input Voltage Range	±5%	Moving speed	70 rpm/min
Power Consumption	25 W	Cut Width (mm)	3-25
Dimensions	126 * 258 * 1500(mm)	Cut Length (mm)	15-70
Weight	1.8kg	Tape Roll Diameter	φ150

* The parts for this machine may be updated or changed. Please contact us to get an updated parts list.