

RollCraft Closer 1.0

Professional Operator & Maintenance Manual

Sesh Technologies Manufacturing



⚠ IMPORTANT: READ BEFORE PROCEEDING

To prevent damage to the RollCraft Mini RocketBox and ensure warranty validity, all operational and maintenance procedures must be followed exactly as described in this manual. Only trained personnel should operate or service this machine.

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1. Quick Start Guide (Operator)

1.1. Connect compressed air and set regulator to 50 PSI.



1.2. Turn machine power ON.



1.3. Release Emergency Stop by lifting Knob to display yellow band.



1.4. Verify Gantry UP. (SEE Section 3 for Machine Assembly Details)



Gantry Up



Gantry Down

1.5. Jaws OPEN.

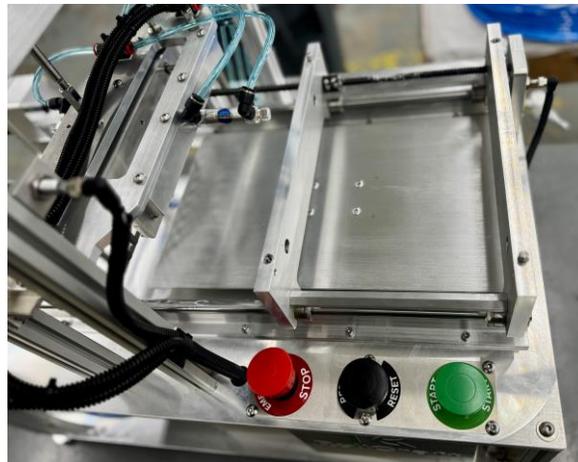


Jaws Open



Jaws Closed

1.6. Trolley HOME.



1.7. Ensure correctly sized Rod Set is installed for prerolls being closed. (SEE Section 11 for Details)

1.8. Install preroll tray and secure with thumbscrews. (SEE Section 9 for Details)

1.9. Set table height according to Joint Size. (SEE Section 9 for Details)

1.10. Put catch bin below Ejection Chute to catch closed prerolls.

1.11. Mist Joints

- With supplied spray bottle (MIXTURE OF 10% ISO, 90% WATER), mist the top of the tray with 2 to 3 full sprays evenly but not too wet. If the pinchers do not keep the papers pinched tightly, you need to spray more. If the paper is oversaturated, it can tear and fall apart, therefore, use less water.

NOTE: The fine mist sprayed onto the joints helps to seal the paper for a smoother, crisper crown. The moisture also serves as a micro antimicrobial agent and evaporates quickly, ensuring the joints are dry by the time they are fully closed.

1.10. Press **START** to begin automatic cycle.

2. Safety Information



IMPORTANT Only trained personnel should operate this machine.

CAUTION Never place hands inside machine while powered.

CAUTION Disconnect power and compressed air before servicing.

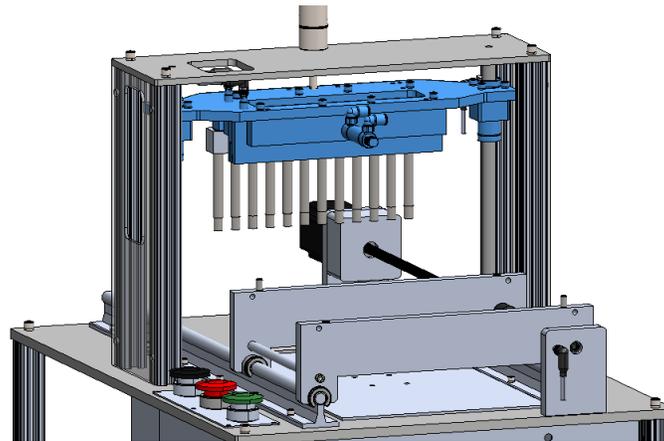
IMPORTANT Observe all safety labels on machine.

3. Machine Overview

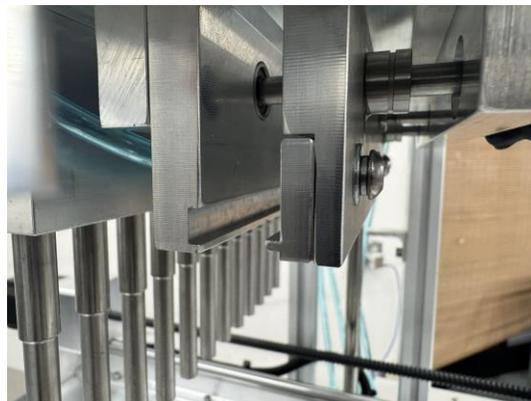


Major assemblies include:

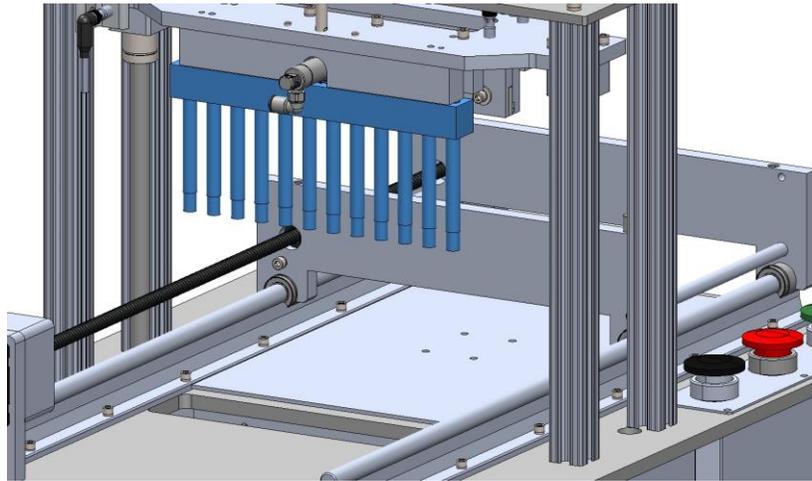
- Gantry Assembly



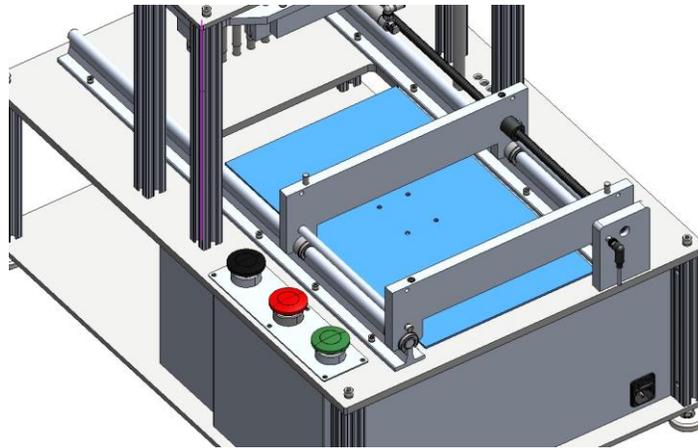
- Jaw Plate Creasing System



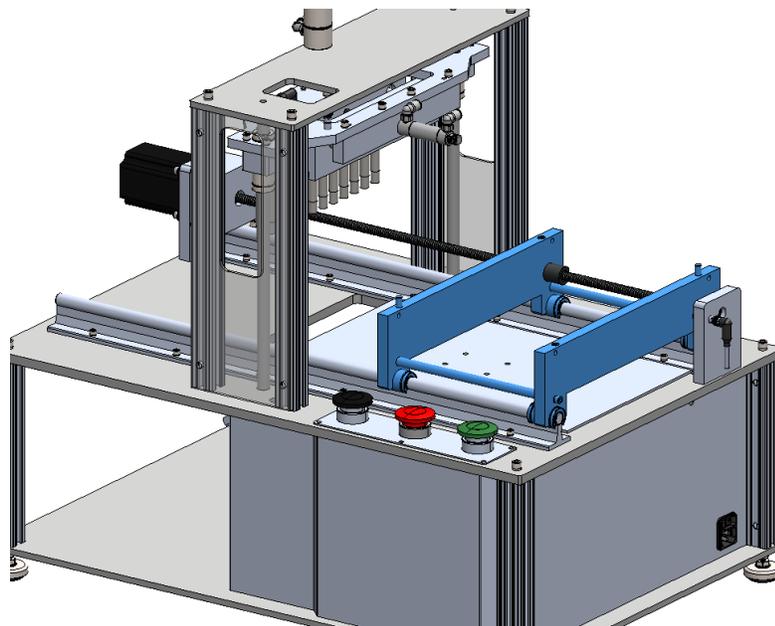
- Rod Set Assembly



- Tray Lift Table



- Trolley System



- Control Panel (SEE Section 5)



- Air Regulator and Water Separator



4. Machine Specifications

Power Supply — 120 VAC

Control Voltage — 48 VDC

Stepper Motor — STP-MTR-23079

Drive System — 3/8-16 Ball Screw

Air Supply Operating Range — 35-65 PSI

Recommended Pressure — 50 PSI

Tray Capacity — 72 prerolls

5. Control Panel



START — Begins automated closing cycle

RESET — Returns trolley to HOME after E-Stop or power loss

EMERGENCY STOP — Immediately halts machine and vents air pressure

6. Pneumatic System

i IMPORTANT It is recommended to use an air drying system with your compressor!

6.1 Compressed air connects through a standard quick-connect fitting.

6.2 Air passes through water separator and pressure regulator.

6.3 Drain separator regularly depending on air quality.

6.4 Ensure Regulator is set to safe operation Range: Quick Start at 50 psi, (MAX OPERATING PRESSURE IS 80 psi)

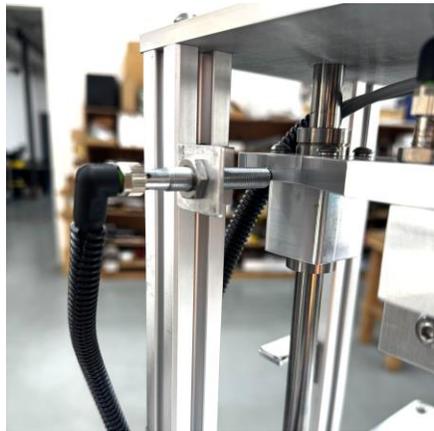


7. Sensor System

7.1 Trolley Home Sensor — Detects trolley home position

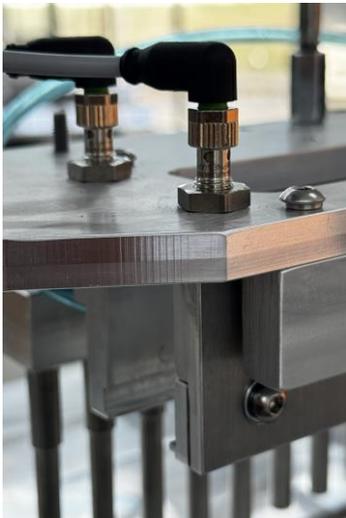


7.2 Gantry Sensor — Detects gantry raised position



7.3 Left Jaw Sensor — Detects jaw open position

7.4 Right Jaw Sensor — Detects jaw open position



8. Machine Startup

8.1. Connect air supply and set regulator to ~50 PSI.

- Pull Back Release on Quick Connect



8.2. Release Emergency Stop.

8.3. Power ON machine.

8.4. Confirm machine state:

Gantry — UP

Jaw Plates — OPEN

Trolley — HOME

8.5. Verify all sensor lights are ON. (SEE Section 7 for Details)

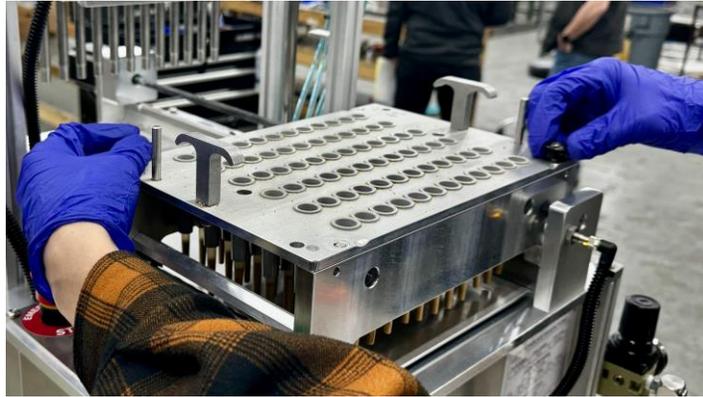
9. Loading the Machine

9.1. Install preroll tray onto trolley platform.



9.2. Align tray with mounting studs.

9.3. Secure tray using supplied thumbscrews.



9.4. Adjust lift table height to match preroll size.



9.5 Verifying Table Height

- Using adjustment knob from above, raise or lower table until material inside joints is even with the plastic cone top, as shown below. Material level is even with plastic.



- Image below shows table being too high and material being above the plastic cones, which allows clamps to crush material and tear paper.



- Image below shows table being too low and material well below the plastic cones, which will cause incomplete closures.



10. Automatic Cycle of Operation

10.1. Press START

10.2. Trolley moves to Row 1

10.3. Gantry lowers

10.4. Jaw plates close to crease prerolls

10.5. Jaw plates open

10.6. Gantry raises

10.7. Ejector rods push prerolls through tray

10.8. Trolley moves to next row

10.9. Cycle repeats for all rows

10.10. Trolley returns HOME

11. Rod Set Selection/Installation

❑ **IMPORTANT** Each preroll size has a predetermined Tray and Rod Set that corresponds. Each Tray has color coordinated handle, and are stamped on the underside with the correct prerolls to be closed, as shown below. Rod sets are stamped on the front face, as shown in 11.2 Image.



11.1. Power OFF machine AND Remove Power Cord

11.2. Remove mounting bolts



11.3. Remove rod set

11.4. Install correct rod set (Joint size is Stamped on Rod Sets), aligning Dowel Pins on Gantry



11.5. Tighten fasteners evenly

12. Jaw Insert Replacement

⚠ CAUTION ENSURE MACHINE IS POWERED DOWN AND UNPLUGGED FOR ALL MAINTENANCE AND ADJUSTMENTS UNLESS OTHERWISE STATED.



12.1. Remove insert bolts



12.2. Remove worn insert



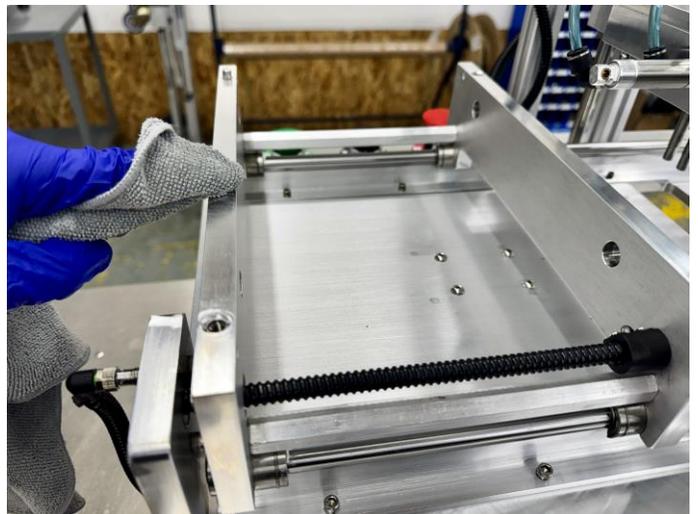
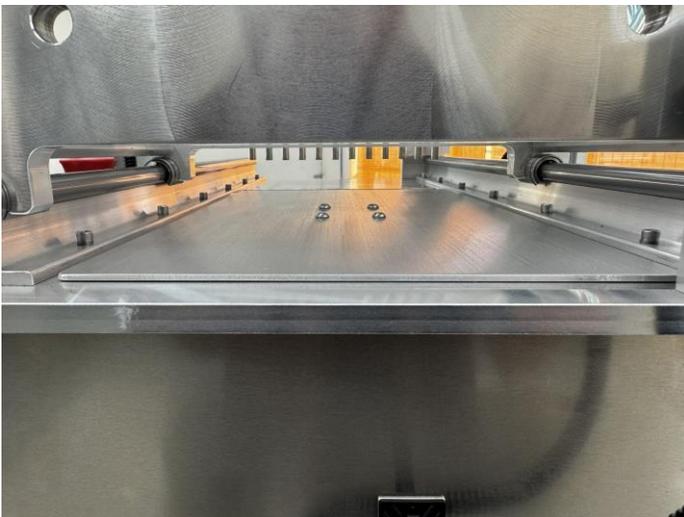
12.3. Install new insert

12.4. Tighten bolts evenly

13. Maintenance Procedures

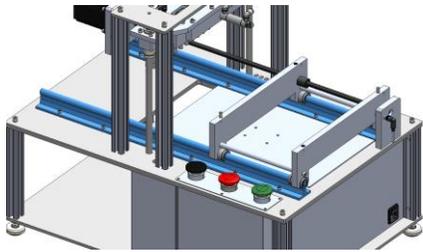
13.1 Clean machine surfaces

- Table Surface
- Jaw Faces/Surfaces
- Top Surface of Trolley for even Tray Mounting

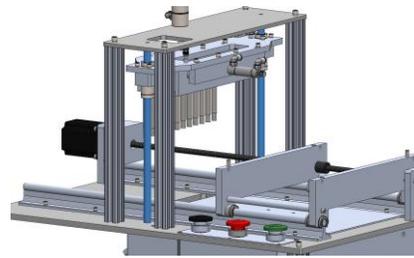


13.2 Inspect rails

- Horizontal Trolley Linear Rails • Vertical Gantry Linear Rails



Horizontal Rails



Vertical Rails

13.3 Lubricate ball screw • Wipe down ball screw with clean cloth to remove debris prior to applying new lubricant

- Apply even to the Ball Screw, ensuring grease gets into grooves as shown.



13.4 Visually/Physically Inspect pneumatics and replace as necessary

- Cracked Air Lines
- Audible Air Leaks

13.5 Full mechanical inspection

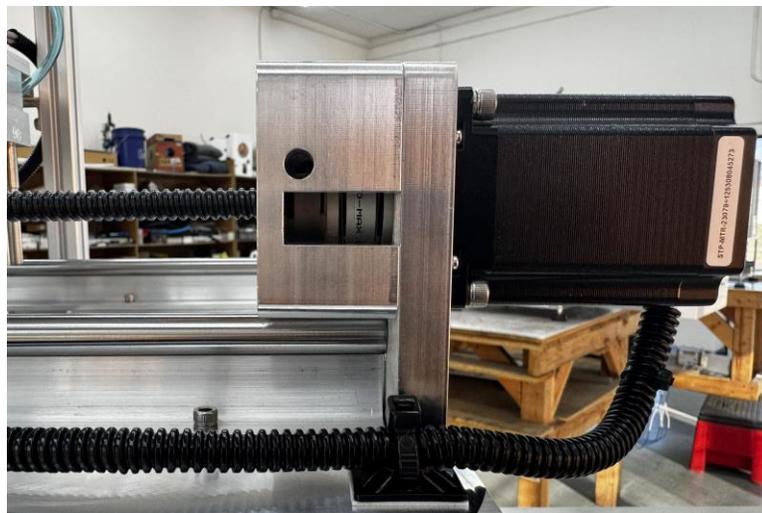
- Verify all Components are tight fitting

14. Troubleshooting

14.1 Machine will not start — one of four sensors not in home position



14.2 Trolley will not move — Stepper drive fault. Ball Screw Coupler Loose



14.3 Gantry will not lower — Low air pressure

14.4 Prerolls not ejecting — Low Air Pressure

15. Maintenance Schedule

⚠ CAUTION ENSURE MACHINE IS POWERED DOWN AND UNPLUGGED FOR ALL MAINTENANCE AND ADJUSTMENTS UNLESS OTHERWISE STATED.

Daily — Clean machine surfaces. Inspect Air Lines for any cracks or leaking connections. Disconnect Air at the end of each day. Power Down Machine.

Weekly — Inspect and clean vertical and horizontal rails as well as trolley ball screw, lubricate. Inspect pneumatic system, ensuring water separator never accumulates beyond max limit on unit.

Monthly — Full mechanical inspection: Ball Nut, Ball Screw, Trolley Linear Bearings, Gantry Linear Bearings

16. Service Log

Date | Technician | Machine Serial | Service Performed | Notes