

**Fujian, China - Zhangzhou**

**Fujian Jialong Adhesive Tape Co.,Ltd.**  
No.11 Xiazhai Road, Hua An County, Zhangzhou City,  
Fujian, 363000, China.  
Tel: +86-596-728-0001

**Fujian, China - Xiamen**

**Fujian Jialong Adhesive Tape Co.,Ltd. Xiamen Branch**  
20F Haiguang Building, No.33, Shuixian Road, Siming  
District, Xiamen, Fujian, 361001, China.  
Tel: +86-592-207-5506  
Email: info@jl3tape.com  
Web: www.jl3tape.com

**Guangdong, China**

**Fujian Jialong Adhesive Tape Co.,Ltd. Guangdong Office**  
Qinling Bld, No.1 East Kangle Road, Houjie Town  
Dongguan,Guangdong, 523960, China.  
Tel: +86-769-3386-2122

**Shanghai, China**

**Shanghai Jialong Fiber Tape Co.,Ltd.**  
No.80 Xiangmin Road, Chedun Town, Songjiang  
District, Shanghai, 201611, China.  
Tel: +86-21-5108-3676

**USA**

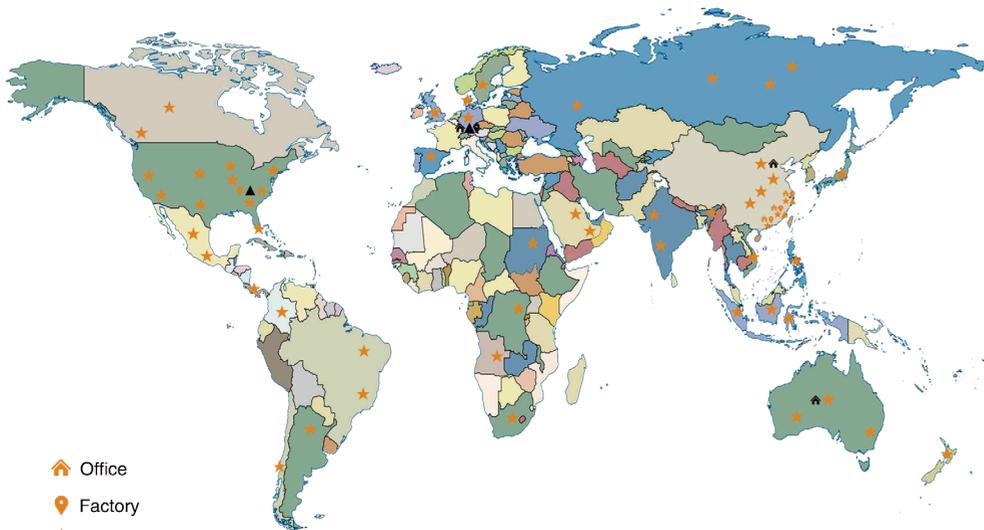
**Kingnode America Inc.**  
130 Spring Ridge Dr Roswell, GA, 30076, USA.  
Email: info@kingnodetech.com  
Web: www.kingnodetech.com



# Operating Manual



## M-204 Manual Water Activated Gummed Paper Tape Dispenser



- Office
- Factory
- R & D
- Marketing Network
- In Planning



JL3 Website



LinkedIn



Facebook



Kingnode Website

Manufacturer: Kingnode (Fujian) Technology Co., Ltd.  
Address: Jiulong Industry Park, Hua An, Zhangzhou, Fujian China.  
Consultation: info@kingnodetech.com  
Website: www.kingnodetech.com

# TABLE OF CONTENTS

## ■ Part I Preface

Part I Preface ----- 02

Part II Technical Data and Illustration ----- 03

Part III Operating Instructions ----- 04

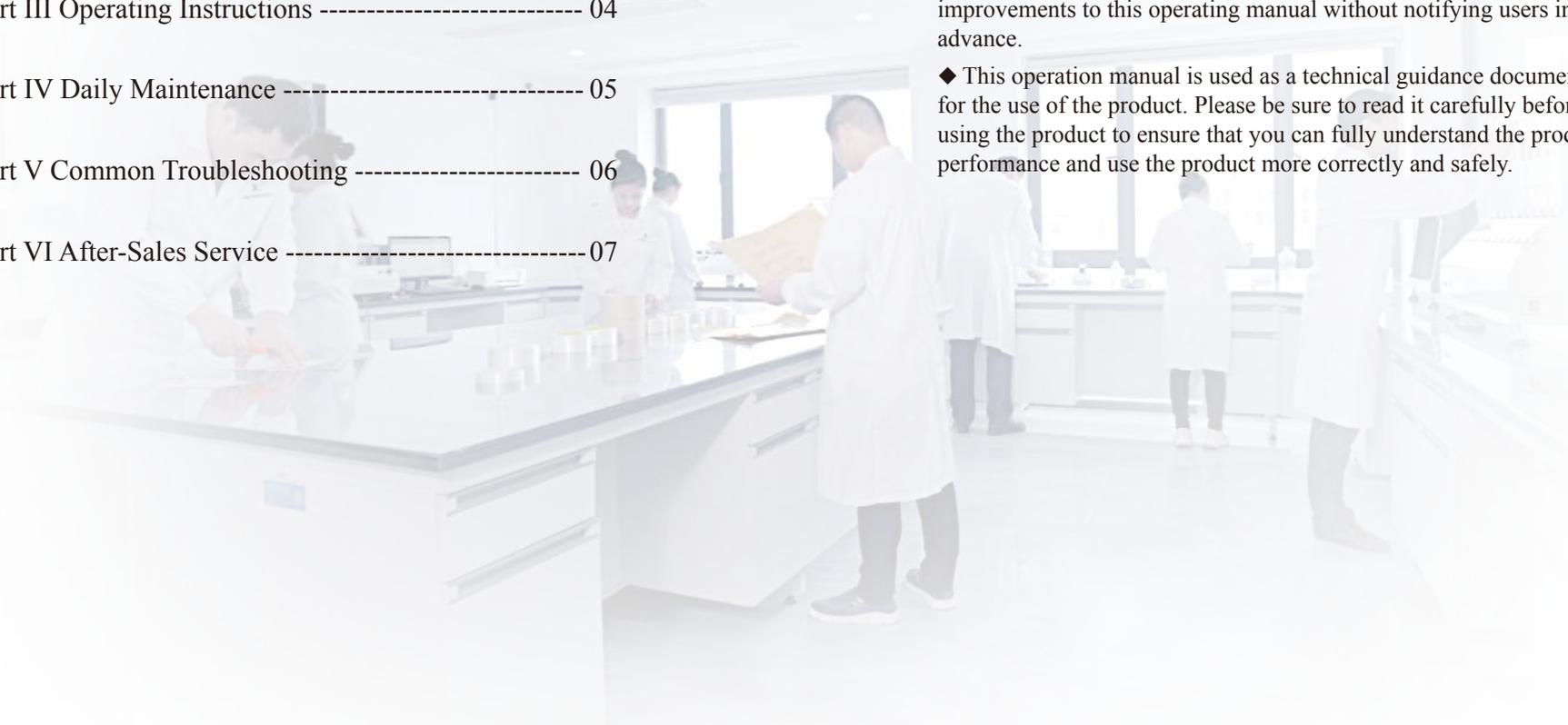
Part IV Daily Maintenance ----- 05

Part V Common Troubleshooting ----- 06

Part VI After-Sales Service ----- 07

Thanks for choosing M-204 WAT (Water Activated Tape) Dispenser, we hope it brings you a different carton sealing experience with WAT.

- ◆ This Operating Manual only provides necessary information about the operation of the machine, maintenance, and repair of the M-204 Manual WAT Dispenser, does not serve as a warranty of the machine.
- ◆ In order to provide better service and guidance to our users, we reserve the right to make continuous necessary revisions and improvements to this operating manual without notifying users in advance.
- ◆ This operation manual is used as a technical guidance document for the use of the product. Please be sure to read it carefully before using the product to ensure that you can fully understand the product performance and use the product more correctly and safely.



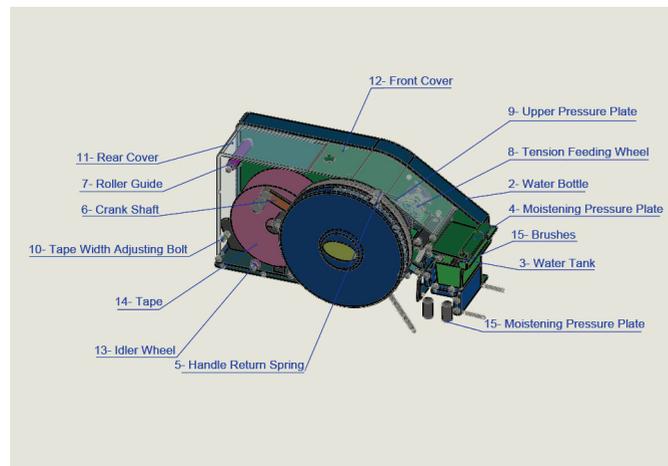
## Part II Technical Data and Illustration

### Technical Data

Technical Data Of P-104 Series WAT Kraft Paper Tape Dispenser:

MODEL	M-204
Carton Dimension (mm)	550*290*290
Product Dimension (mm)	470*275*248
Gross Weight/Net Weight (kg)	9.8/8.8
Tape Width (mm)	≤76
Dispensing Length (mm)	15-75
Diameter Roll (mm)	≤200
Capacity of Water Tank (L)	2.3
Brushes Piece/Set	2
Pressure Plate Weight Piece/Set	2

### Illustration of the Machine



## Part III Operating Instructions

The specific operation method of M-204 is as follows:

### 1. First Step: Filling Water.

Remove the water bottle( black) and the side water tank (white) from dispenser in turns. Fill water up to 4/5 of water bottle and fill water full of water tank. Install water bottle and water tank back to the original position to finished the filling process.

### 2. Second Step: Increase/Decrease Weight on Pressure Plate.

When choose reinforced water activated tape, the weight (fixed on the press plate and needs to unscrew) on press plate needs to be installed into the cylinder to ensure the tape wet evenly. When choose non-reinforced water activated tape, do not need to install weights to avoid any blocks in channel or unevenly wet on the tape.

### 3. Third Step: Install the Tape Roller.

Open the front and rear covers, pull the spring pressure roller and remove the pressure plate. Place the water activated tape (Glue side should be up) between the two rollers in the dispenser channel. Pull the tape (front-end) backwards through the feed roller (glue side will be down) and make it under the pressure roller. Put the press plate back to its original position to complete the installation.

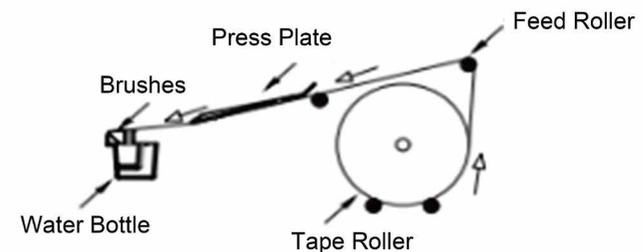


Figure 1: Introduction Diagram for Placing the Tape Roller

#### 4. Fourth Step: Set the Slitting Length and Start the Slitting Operation.

Confirm the length of the tape that needs to be slit, compare the length value on the length disc, gently pull up the length circlip and move it to a specific length position to complete the slitting length setting. Then use your left hand to quickly pull the handle on the length disc to the position of the length circlip and release it to complete a preset length cutting operation. At the same time, extend your right hand to the tape outlet of the cutting machine to get the score. The cut tape is used for sealing operations. Next, open the front and back covers on top of the machine, pull off the Spring Pressure Roller to remove the Pressure Plate and put it aside, put the tape into the Tape Basket, adhesive side up, then feed the open end of the tape through the Guide Roller to the rail and press it under the Spring Pressure Roller, put the Pressure Plate back to its original position. To set for the desired length, pull outwardly on the feed stop knob until the pin disengages the hole in the drum skirt. Then slide the feed stop assembly until the length desired is set on the scale just above the feed stop assembly. Release the knob, being sure the pin on the feed stop engages with the proper hole in the skirt. Take the cut tape for sealing the box.

## Part IV Daily Maintenance

The best way to keep long and carefree service from your M-204 is to follow the steps below:

1. Check the water level of the water tank frequently to avoid the poor effect of the tape wet due to lack of water in the water tank.
2. Regularly clean the water brushes, water tank and water storage tank with soapy water to avoid the accumulation of adhesive and affect the wet water effect of the tape.
3. Regularly use lubricating oil to lubricate the rotating parts of the equipment, such as the bearings and transmission belts, to avoid inflexible parts that cause running jams or blockages.
4. When the tape is jammed, carefully check and clean the channel to avoid another paper jam.

## Part V Common Troubleshooting

During use, some minor faults may occur due to improper installation or operation. In order not to affect your work, we recommend that you first check and resolve the faults according to the following methods.

S/N	Machine Failures	Failure Analysis	Troubleshooting measures
1	Unevenness of the moistening, loose seal.	(1) Accumulation of adhesive jammed on the tape path, brushes, or on the tip of the spout of the water tank. (2) Insufficient amount of water in the water bottle or water tank. (3) User replaced with defective brushes or improper installation of the brushes. (4) Inferior quality of the water activated tape used. (5) The way of sealing tape is not pressed evenly.	(1) Scrape out all the possible accumulation of adhesive from the tape path, the tip of the spout, wash the brushes with mild detergent thoroughly from time to time. (2) Fill up the water tank and water tank with enough amount of water. (3) Use appropriate brushes, and install them properly. (4) Try to use the qualified water activated tape. Increase or decrease pressure plate weights according to the type of tape. (5) Press the surface of the sealed tape evenly with palms.
2	Jammed or crumpled paper tape in operation.	(1) Improper feeding of the tape roll. (2) Accumulation adhesive stuck on the tape path or the brushes. (3) Defective tape is used.	(1) Put the tape roll accordingly, especially the right position of the pressure plate. (2) Check and clean both the tape path and the brushes in accordance with the maintenance requirement. (3) Use quality water activated tape rolls.
Note: In case the problem is not solved through above troubleshooting, please contact our professional after-sales service personnel to assist you.			

## Part VI After-Sales Service

The warranty period is one year from the date of purchase of the equipment. We provide the service of repairing and replacing defective parts of the machine free of charge during this period.

The expired warranty period and the repair services outside the warranty range are not covered by the warranty. The repair cost will be charged under the following situations:

1. The damages caused by equipment handling, equipment installation and improper use;
2. The damages caused by natural disasters or other force majeure factors if user arranges transportation individually;
3. The damages caused by individually dismantling or replacing any internal components of the equipment;
4. The equipment is damaged due to the guidance of non-our professional technicians or failure to follow this operation manual;
5. Quick-wear part such as blades, water tanks, brushes, etc. are not covered by the warranty.

### Water Activated Tape Dispensers Appendix:

No.	Item No.	Product Name	Remark
1	P-104	Pull and Tear Water Activated Dispenser	
2	M-204	Manual Water Activated Dispenser	
3	E-304	Electric Water Activated Dispenser	
4	E-304H	Electric Water Activated Dispenser (with heater)	
5	E-304BH	Electric Water Activated Dispenser(with lithium battery and heater)	
6	E-304HL	Electric Water Activated Dispenser(larger size with heater)	
7	E-404	Electric Water Activated Dispenser	
8	E-404H	Electric Water Activated Dispenser(with heater)	
9	E-404BH	Electric Water Activated Dispenser(with lithium battery and heater)	

## Appendix: Maintenance Service / Repair Record

### Maintenance Service / Repair Record Card

User Information				
Customer Name		Purchase Date		
Model No.		Telephone Number		
Email Address		Postal code		
Address				
Dealer Information				
Dealer Name		Telephone Number		
Email Address		Postal Code		
Address				
Maintenance Records				
S/N	Warranty Reasons	Repair Content	Customer Acceptance	Maintenance Personnel
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				