

EasyPack® Strata™ Automated Dispenser

Tech Service Hotline: 886-904-6979 (US), +39 33 11 34 16 65 (Italy),
00800 888 888 44 (All other European Countries).
Original Instructions.

Pregis
EasyPack® Strata™
Automated Dispenser

Operator Manual

REV B



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LANGUAGES OF OPERATION DISCLAIMER

The original version of this manual is in English and denoted "Original Instructions" in the top center header. All translated versions are denoted "Translation of Original Instructions" in the same location.

It is illegal to operate this machine in an EU member state if this (or any other related) manual is not written in that State's language. If a translated version is needed, contact Pregis to order the manual.

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EU DECLARATION OF CONFORMITY

PREGIS LLC
858 Meridian Lake Drive, Suite A
Aurora, IL 60504
USA

***Name and address of the company established in the European Union
and authorized to compile the Technical File:***

ACC – Services Contact
78 Allée Primavera
Centre Ubidoca 2402
74370 Annecy
FRANCE

PREGIS LLC declares under our sole responsibility that the product described as:

Equipment Name: Recycled Paper Void Fill Dispenser
Model /Type: Easypack Strata
Serial number(s):

Complies with the requirements of the following European Union Directives:

Machinery Directive 2006/42/EC
Electromagnetic Compatibility Directive 2014/30/EU
RoHS Directive 2011/65/EU and amendments

Main standards considered:

EN ISO 12100:2010
EN 60204-1:2018, EN ISO 13849-1:2023
EN 61000-6-2:2019, EN 61000-6-4:2019
EN 63000:2018

Date: September 4, 2025

At: Aurora, Illinois USA

Name of authorized company representative: Mr. David Joyce
Director of Engineering

Signature: _____



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UK DECLARATION OF CONFORMITY

**PREGIS LLC
858 Meridian Lake Drive
Aurora, IL 60504
USA**

***Name and address of the company established in the United Kingdom
and authorized to compile the Technical File:***

**ACC – Services Contact
International House
10 Churchill Way
Cardiff CF10 2HE
UNITED KINGDOM**

PREGIS LLC declares under our sole responsibility that the product described as:

Equipment Name: Recycled Paper Void Fill Dispenser
Model /Type: Easypack Strata
Serial number(s):

Complies with the requirements of the following United Kingdom Regulations:

Supply of Machinery (Safety) Regulations 2008
Electromagnetic Compatibility Regulations 2016
RoHS Regulations 2012

Main standards considered:

BS EN ISO 12100:2010
BS EN 60204-1:2018, BS EN ISO 13849-1:2023
BS EN 61000-6-2:2019, BS EN 61000-6-4:2019
BS EN 63000:2018

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Property of Pregis LLC

227 W Monroe St

Suite 4100

Chicago, IL 60606

United States of America

Authorized CE Representative

ACC – Services Contact

1877 Kirby Lane

Kyle, Texas 78640

United States of America

1 Introduction

The Strata dispenses a paper-based pad that provides structured void fill cushioning. The machine automatically stitches and cuts the pads at a high rate of speed, allowing for faster packaging.

Strata Paper Void Fill Material:

Item #	Formulation	Bundle Width	Bundle Length
4069622	30#	14.75"	1690'
4069622*	30/30#	14.75"	1690'
4077694	45#	14.75"	1340'
4077694*	45/45#	14.75"	1340'
4095969	55#	14.75"	990'

*Running 2-ply through the Strata requires two 1-ply bundles that are loaded into the machine at the same time

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2 General Safety

Operator safety and the safety of others in the work area depend on the operator using good judgment and reasonable care while utilizing the machine. This manual and the warning labels affixed to the machine provide notification of specific potential hazards.

Please read and understand the manual including all the danger, warnings, and caution statements. If after reading the manual you have questions, contact your supervisor or your Pregis service technician to get answers before working with the machine.

1. Only authorized personnel may use the equipment.
2. Only trained authorized persons will carry out any adjustments, repairs, maintenance, or cleaning with the equipment isolated from power supply and no longer in motion.
3. Never deface or remove factory installed warning decals. If a decal ever becomes lost, damaged, or illegible, report this condition to a supervisor and obtain a replacement decal from Pregis.
4. Keep the work area clean and uncluttered. Walking surfaces should always be free of packing material and debris to prevent a slipping or tripping hazard.
5. Ensure that all covers, guards, and other safety devices are in place. NEVER defeat a safety device for any reason.
6. Follow the recommended procedures in this manual.
7. Never leave the equipment unattended while operating. Shut the machine off if you must leave the work area.
8. Keep body parts and clothing away from moving components. NEVER reach into the machine for any reason while it is in motion.
9. Understand proper material path and safe loading procedures.
10. Understand which adjustments are operator adjustments; contact maintenance person for all other adjustments.
11. DO NOT operate equipment if you are under the influence of alcohol, drugs or medications that can make you less alert or affect your judgment.
12. The Strata shall be lifted by two persons.

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2.1 Warning Labels

The Operating Safety section of this manual, the Operator's manual, and warning labels affixed to the machines provide notification of specific potential hazards.

Safety signs are used to alert operating and maintenance personnel to potential hazards. The machine manual also calls attention to potential hazards with statements describing the hazard. Warning labels used on the machine are depicted below.



Electric Shock



Refer to Instruction Manual



Cutting Hazard



Two Person Lift



Disconnect Main Plug



No Maintenance performed by End User

The meanings of the warning labels and the potential hazards they represent must be clearly understood before attempting to operate or maintain the machine. If, at any time, a warning label on the machine becomes lost, damaged, or illegible, contact Pregis to order replacement signs.

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3 Machine Specifications

Machine Weight: 75 lbs (34 kg)

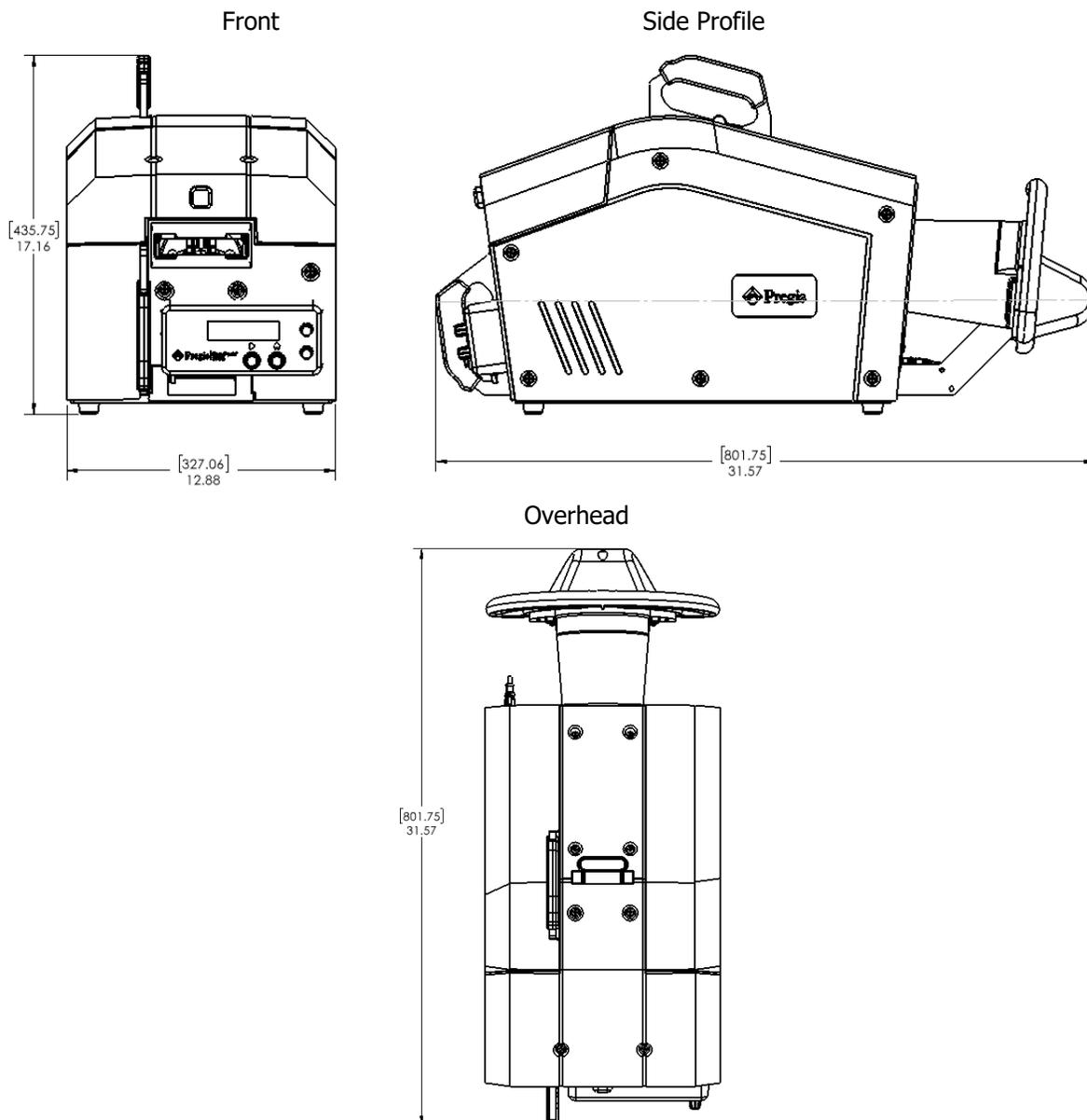
Power Requirements: 110/220 VAC, 60/50 Hz, 6.3/3.15 A

Maximum Speed: 60 inches/second

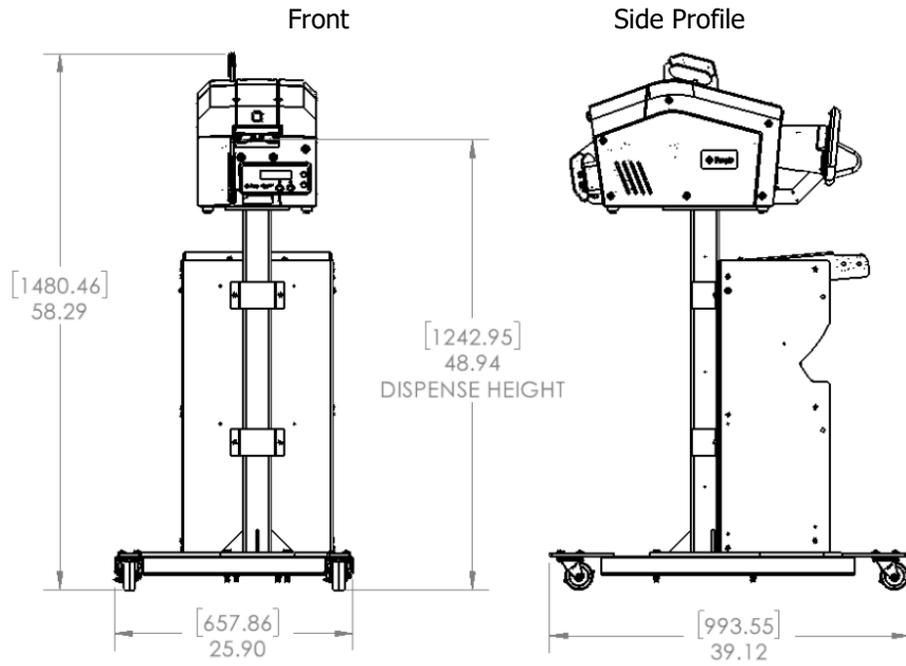
The sound pressure level measured at the operator station is 78.2dB(A).

3.1 Overall Dimensions

UNITS: [mm] INCH



3.2 Machine Stand – Right Side



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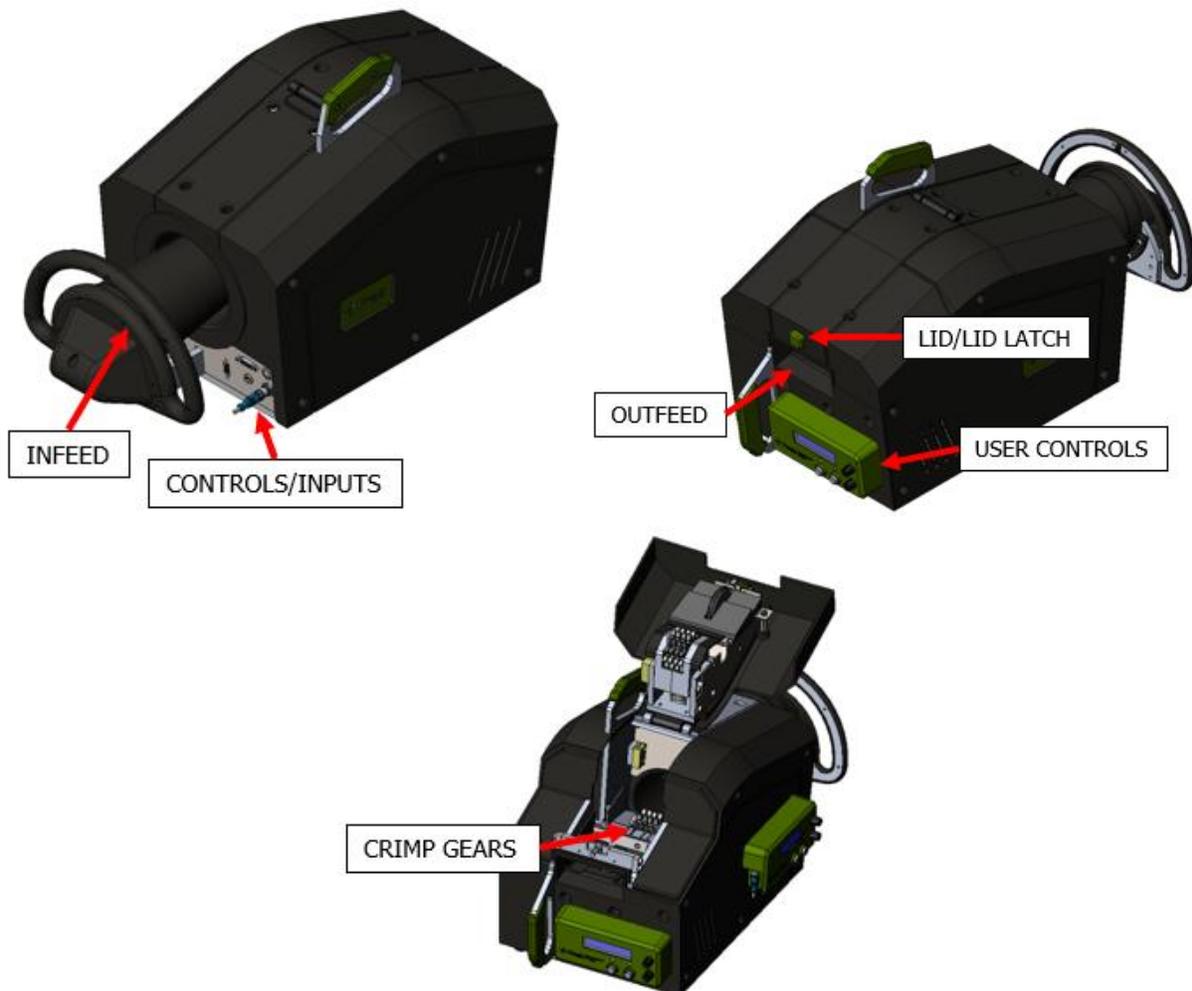
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4 Scope and Limits

4.1 Introduction

The Strata folds the paper, stitches it together and then cuts the paper into pads. The paper goes through an Infeed former located at the back of the machine that will fold the paper. The Outfeed Rollers are located at the front of the machine so that the pads can immediately dispense.

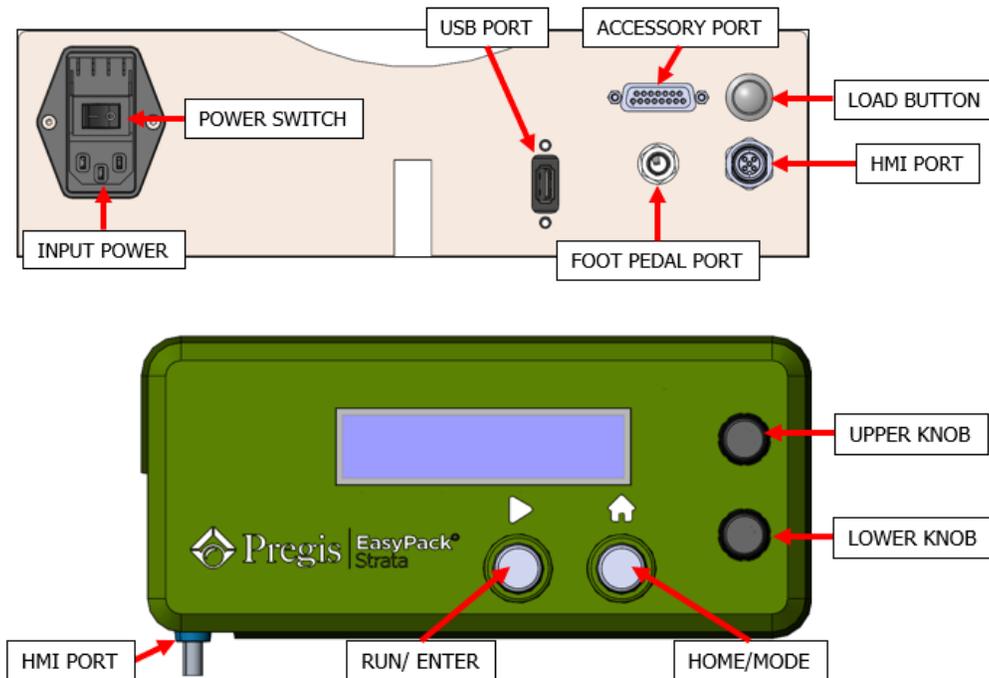
Strata includes a Snip tray to easily clear any paper snips or paper dust that accumulated from the paper being cut.



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4.2 Strata Controls



The POWER SWITCH is used to turn the electrical power “ON” or “OFF”. It is located on the back side of the machine. Power can also be disconnected from the machine by pulling the cord out of the inlet.

The USB PORT is a programming port for service technicians only.

The ACCESSORY PORT is for connecting Pregis provided accessories.

The LOAD BUTTON will engage and disengage a timed jog. This button should be pressed to initiate paper loads, then can be pressed again to stop an active jog. If the button is not pressed to stop, the jog will timeout after 10 seconds. A load, or jog, can also be stopped by pressing the FOOT PEDAL.

The FOOT PEDAL PORT is for connecting the foot pedal to the machine.

The HMI PORT is for connecting the HMI to the machine.

The RUN button is used to run a cycle on the machine by pressing the button. While in “MANUAL” mode, holding the button will continuously run the machine until the button is released.

The HOME/MODE button changes the mode of the machine by pressing the button.

The UPPER KNOB, depending on the machine mode, changes the speed or the quantity of batches the machine produces.

The LOWER KNOB changes the length of the pad that the machine produces and changes the active preset.

4.3 Strata Connections

The INPUT POWER is used to power the machine. See the Specifications Page for power requirements. This cable can be removed to de-energize the machine for maintenance and cleaning.

The FOOT PEDAL is used to dispense paper. In a normal running state, the Strata will dispense pads if the FOOT PEDAL is held, then stop when the FOOT PEDAL is released.

The HMI PORT is used to connect the HMI to the machine.

The ACCESSORY PORT is used to connect accessories to the machine.

The USB PORT can be used to reprogram the machine or pull data logs.

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5 Set-up

5.1 Lifting

Machine Weight: 75 lbs (34 kg)

The Strata machine should be lifted by two persons by the bottom of the machine.

5.2 Machine Set-up

The machine can be used in a Tabletop or Stand Mounted

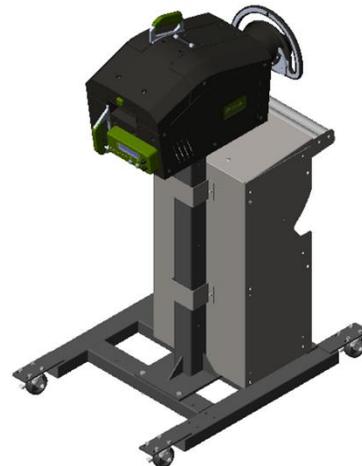
If using the Tabletop configuration, place the machine, on its feet, onto the work surface. Ensure that the work surface is sturdy enough to support the dispenser, and all other necessary work supplies.

If using the Stand Mounted configuration, the machine should be installed by a Pregis Technician.

Ensure that the machine has been connected to power and that a Foot Pedal is connected.



TABLETOP



STAND MOUNTED

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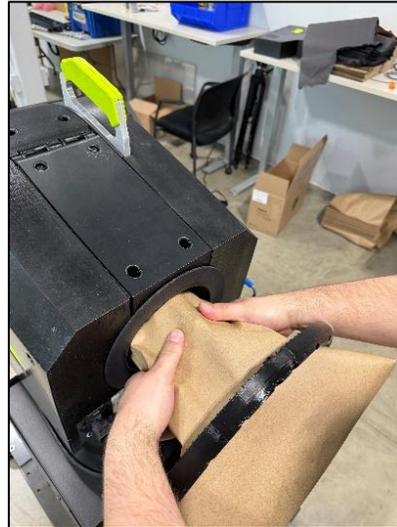
6 Operation

6.1 Loading Strata: 1 Ply Paper Bundle

- 1) Place the paper bundle into the paper tray.



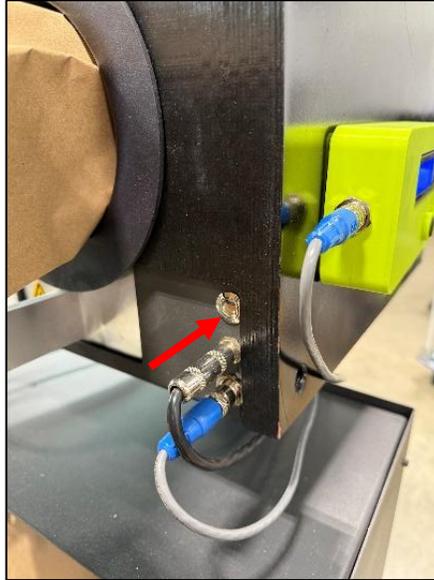
- 2) The paper should feed between the two rollers. Place the paper through the INFEED ENTRY FORMER. Wrap the paper as shown around INFEED INNER FORMER.



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- 3) Press the LOAD BUTTON. This will slowly jog the machine until one of the following occurs:
- Ten seconds have passed.
 - The LOAD BUTTON is pressed again (during the jog).
 - The FOOT PEDAL is pressed (during the jog).



- 4) Insert the paper into the machine until the CRIMP GEARS engage the paper.
- 5) Wait for the paper to enter the outfeed area.



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6.2 Loading Strata: 2 Ply Paper Bundle

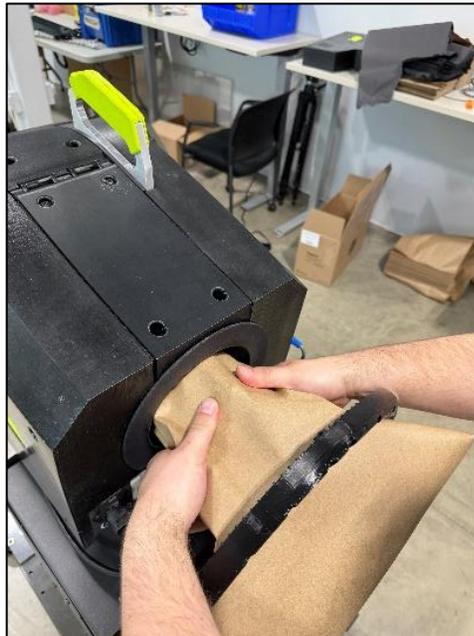
- 6) Place the first paper bundle onto the top shelf of the paper tray and the second bundle onto the bottom shelf.



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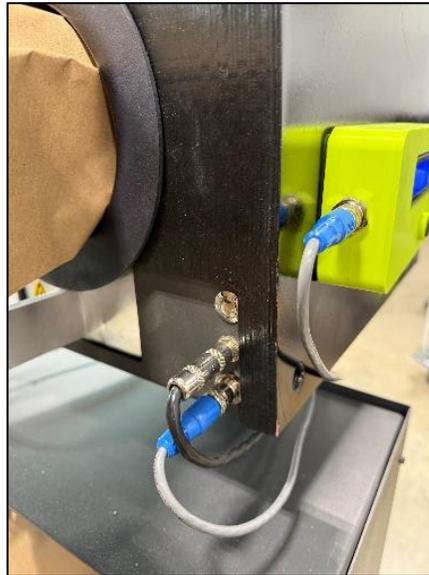
- 7) The paper should be placed together and put between the outer and inner roller of the paper tray. Place the paper through the INFEEED ENTRY FORMER. Wrap the paper as shown around INFEEED INNER FORMER.



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- 8) Press the LOAD BUTTON. This will slowly jog the machine until one of the following occurs:
- Ten seconds have passed.
 - The LOAD BUTTON is pressed again (during the jog).
 - The FOOT PEDAL is pressed (during the jog).



- 9) Insert the paper into the machine until the CRIMP GEARS engage the paper.

- 10) Wait for the paper to enter the outfeed area.



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6.3 Operation

HMI CONTROLS

The operation modes are "MANUAL" and "AUTO" modes. 3 presets are also available to the operator with specific settings.

To change modes, press the HOME/MODE button.

To customize the presets, holding the HOME/MENU button will bring the user to the preset menu. Use the UPPER and LOWER KNOBS to change the mode and the length of the pads. Pressing the RUN button will change the preset and pressing the HOME/RUN button will take the user out of the preset menu.

Once the specific mode is selected, press the RUN button to operate the machine.

Note: Some versions may come already locked in/out of certain modes. See section 12 "HMI Tech Menu" for mode lock instructions.

MANUAL MODE

The manual setting allows the operator to dispense pads using the foot pedal or the RUN button on the HMI. In this mode, only the machine speed can be adjusted, between 1 and 10.

To adjust the speed of the machine, turn the UPPER KNOB to increase or decrease the speed. The speed set here will carry over to all modes.



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AUTO MODE

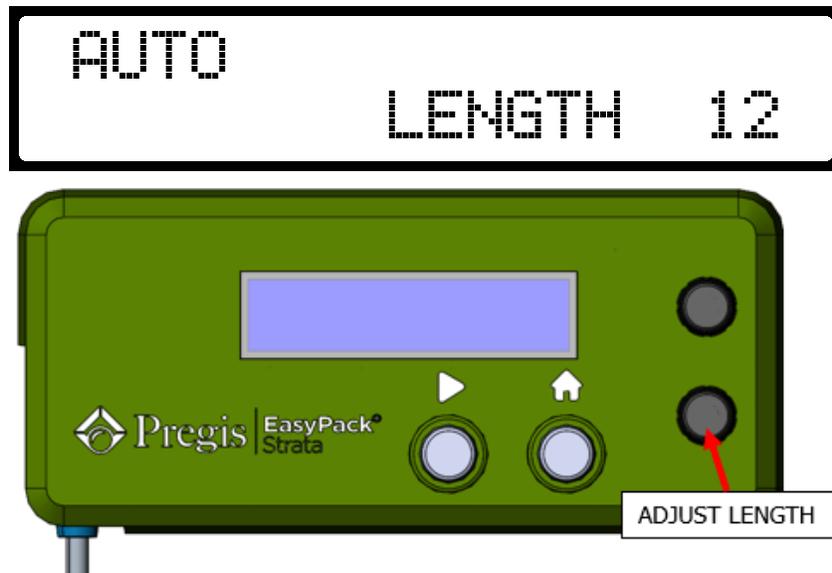
The auto setting allows the operator to adjust the length of the pad. In this mode, the machine will produce a pad and hold it. Once the pad is removed, it will dispense another pad.

To adjust the length of the pad, between 8 and 600, turn the LOWER KNOB to increase or decrease the length.

A long press of the RUN button or FOOT SWITCH will cause the machine to dispense paper the entire time it is depressed. The set length is ignored in this instance. This function performs like running the machine in MANUAL mode.

When running the machine in auto mode, "TAKE PAD" will appear in the bottom left of the HMI underneath "AUTO". This shows that the machine is ready to produce another pad once the pad in the OUTFEED is removed.

Pressing the RUN button or FOOT SWITCH while the "TAKE PAD" prompt is shown will clear this prompt and cause the machine to standby idle. Now, when the pad in the outfeed is removed, the machine will not automatically produce another. Press the RUN button or FOOT SWITCH to resume production in AUTO mode.



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PRESET MODE

This mode has three presets available to the operator to avoid the need to change modes or settings.

To change the preset, turn the LOWER KNOB. This will change the preset between PRESET 1, PRESET 2, and PRESET 3.

BATCH	QTY	10
PRESET	1LENGTH	12



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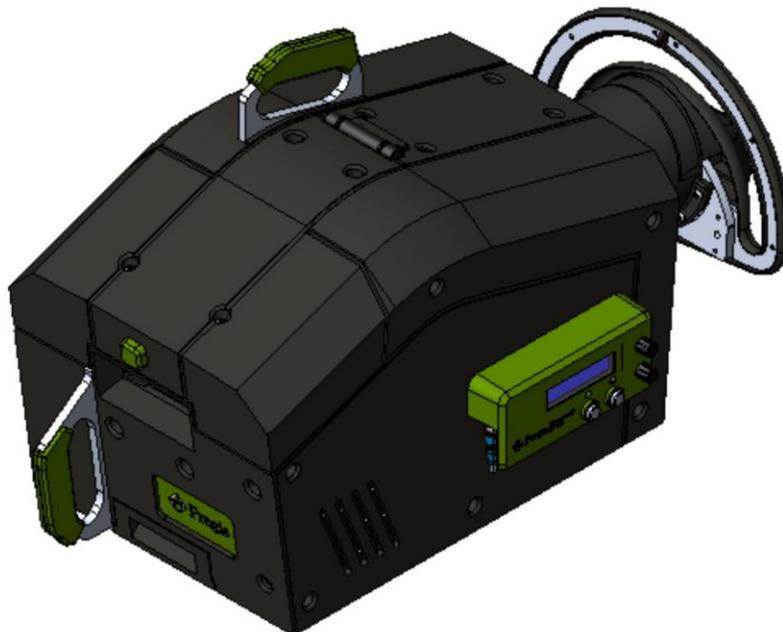
HMI MOUNTING

The HMI can be mounted on the

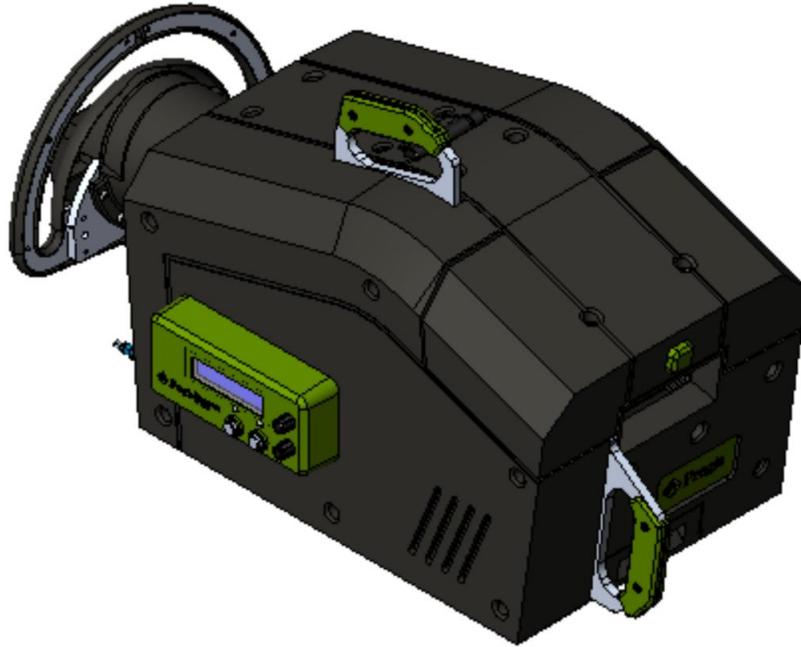
- 1) FRONT COVER



- 2) RIGHT COVER



3) LEFT COVER



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6.4 HMI Manager Menu

To access the manager menu:

- 1) Hold down the HOME button until the "ENTER PASSWORD" screen shows up.
- 2) Enter 487 by turning UPPER KNOB

To change features:

- 3) Scroll to desired feature using the UPPER KNOB
- 4) Select using the RUN button
- 5) Select ON/OFF using the UPPER KNOB

ITEM	DESCRIPTION
VERSION	FIRMWARE VERSION OF CONTROL BOARD
LOCK KNOBS ON/OFF	LOCKS KNOB FUNCTION ON MODE/HOME SCREEN
AUTO MODE ENABLED/DISABLED	ENABLES/DISABLES AUTO MODE AS A MODE OPTION IN HOME MENU AND PRESET MODE SELECTION
MANUAL ENABLED/DISABLED	ENABLES/DISABLES MANUAL MODE AS A MODE OPTION IN HOME MENU AND PRESET MODE SELECTION
CRIMP SPEED	SPEED OF CRIMP GEARS DURING RUN CYCLES
UNITS	CHANGES UNITS BETWEEN ENGLISH AND METRIC

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7 Troubleshooting

7.1 Common Problems

Problem	Cause	Solution
Machine is powered on but will not run.	<ol style="list-style-type: none">1) LID is not closed all the way.2) Machine is starting up.3) HMI is not properly connected.4) FOOT PEDAL issue.	<ol style="list-style-type: none">1) Open the LID and close again. Ensure LID has latched.2) Wait 30 seconds after Power On before attempting to use the machine.3) Unplug the HMI cable and re-plug for a proper connection.4) Confirm FOOT PEDAL is plugged in. If still not working, try pressing LOAD BUTTON. If that does not work, move on to "Machine not powering."
Machine not powering on.	<ol style="list-style-type: none">1) Power Cord Issue.2) Power Outlet Issue.3) Blown Fuse.	<ol style="list-style-type: none">1) Unplug POWER CORD and ensure there are no cuts/nicks in the wire. Plug in again.2) Confirm outlet has power by plugging another device into the machine's outlet.3) Call Maintenance.
Error code 200 & 210- Jam	<ol style="list-style-type: none">1) Paper has jammed	<ol style="list-style-type: none">1) Open LID and clear jam. - See section 7.2
Error code 250 & 251	<ol style="list-style-type: none">1) Pad has not reached the outfeed2) Pad jammed or tore before reaching the outfeed	<ol style="list-style-type: none">1) Open LID and clear pad. - See section 7.2
Error code 600	<ol style="list-style-type: none">1) LID is open	<ol style="list-style-type: none">1) Ensure LID is properly closed and latched.
Error code 601	<ol style="list-style-type: none">1) Snip tray is open	<ol style="list-style-type: none">1) Ensure SNIPS TRAY is properly closed and latched.
Error code 800	<ol style="list-style-type: none">1) HMI connection error	<ol style="list-style-type: none">1) Unplug and re-plug HMI cord to ensure proper connection.

If problems persist, call Pregis Tech Service Hotline.

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7.2 Clear Jam

If the machine jams, DO NOT use a tool or sharp object to clear jam.

To clear a jam

- 1) Open the LID
- 2) Pull paper out of the machine
- 3) Close the LID and ensure LID latched properly
- 4) Reload paper.



7.3 Snips Tray Alert

The snips tray should be emptied as needed but as a precautionary measure, the user is prompted to empty the snips tray every 20,000 cuts.

The HMI will state "SNIPS TRAY FULL EMPTY SNIPS TRAY".

To resolve, open the snips tray to dump the contents, then the user may reinsert the tray and resume production.

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8 Preventive Maintenance

The Easypack Strata Paper System requires very little to no maintenance. The following items should be checked on the indicated intervals.

8.1 Monthly Maintenance:

- 1) Wipe down exterior surfaces.
- 2) Open the SNIP TRAY and clean out any paper debris or dust.
 - 1) Inspect exterior of machine for any signs of damage including cuts, gouges, bent parts, etc.
 - 2) Call tech service if problems noted.
- 3) Inspect power and foot switch wires for any abrasion.

9 Revision Table

REV	DATE	DESCRIPTION	AUTHOR	ECN NUMBER
A	24 SEP 2025	INITIAL RELEASE	RV	EC-2166
B	23 DEC 2025	UPDATED OPERATING MODES. UPDATED FUNCTIONS IN AUTO MODE. ADDED HMI MANAGER MENU. ADDED SNIPS TRAY ALERT.	CM	EC-2238