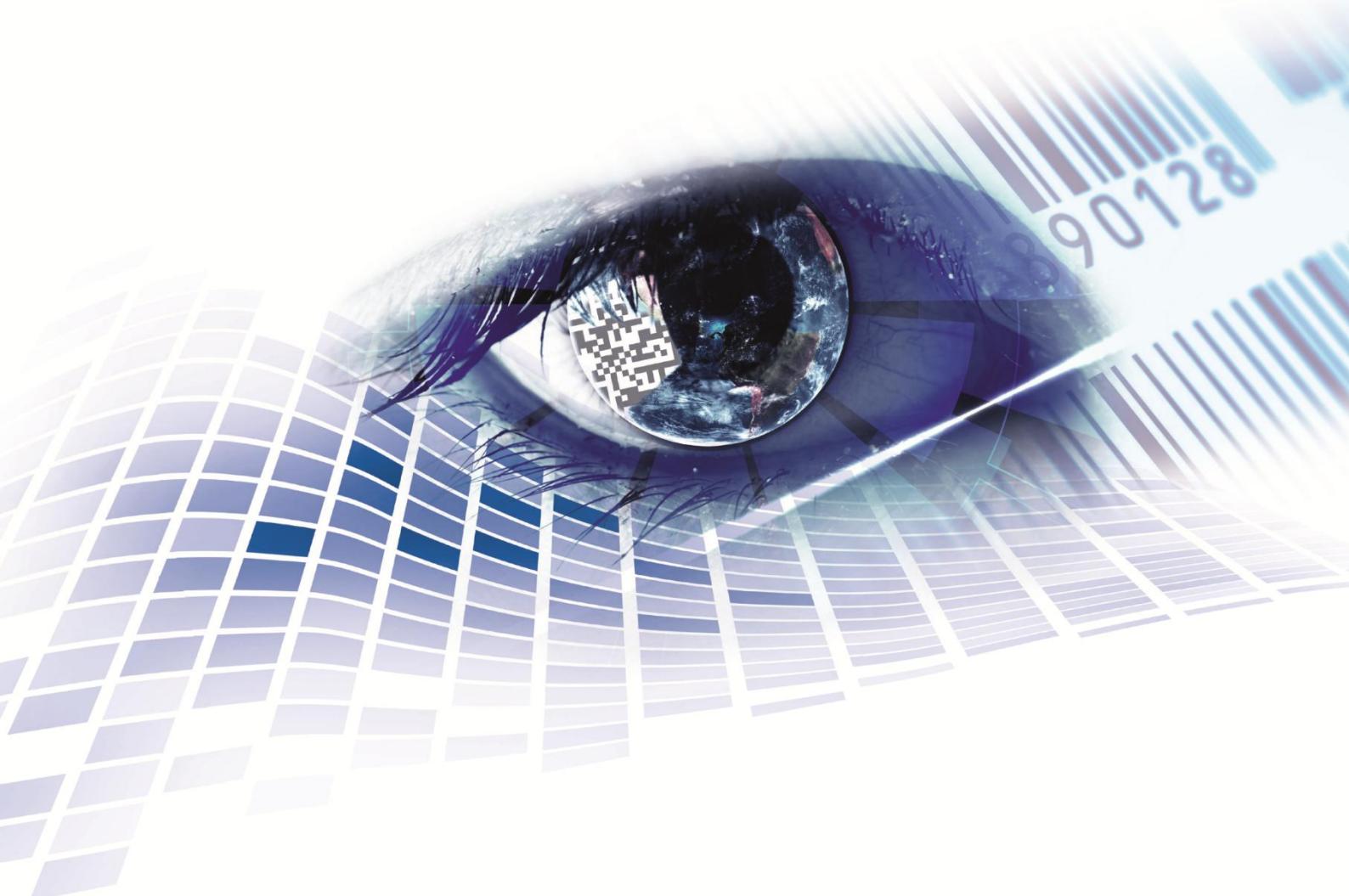


APX V

Operating Manual



Edition: 12/25

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1 Introduction

1.1 General Instructions

Basic information and warning references with the corresponding signal words for the danger level are as follows specified in this manual:



DANGER identifies an extraordinarily great and immediate danger which could lead to serious injury or even death.



WARNING identifies a possible danger could lead to serious bodily injury or even death if sufficient precautions are not taken.



WARNING of cutting injuries.
Pay attention that cutting injuries caused by blades, cutting devices or sharp-edged parts are avoided.



WARNING of hand injuries.
Pay attention that hand injuries caused by closing mechanical parts of a machine/equipment are avoided.



WARNING of hot surfaces.
Pay attention so as not to come into contact with hot surfaces.



CAUTION indicates a potentially dangerous situation which could lead to moderate or light bodily injury or damage to property.



NOTICE gives you tips. They make a working sequence easier or draw attention to important working processes.



Gives you tips on protecting the environment.



Handling instruction



Optional accessories, special fittings

Date

Information in the display

1.2 Intended Use

The print module is an ultramodern device which follows the recognized safety-related rules and regulations. Despite this, a danger to life and limb of the user or third parties could arise, and the print module or other property could be damaged while using the device.

The print module may only be used while in proper working order and for the intended purpose. Users must be safe, aware of potential dangers and must follow the operating instructions. Faults, particularly those which affect safety, must be remedied at once.

In connection with the printing systems of ILX V series, the device is used exclusively for the automatic transfer of suitable materials approved by the manufacturer onto a product. Any other or more use is not intended. The manufacturer/supplier is not liable for damage resulting from misuse. Any misuse is at your own risk.

Intended used includes heeding the operating manual, including the maintenance recommendations/regulations specified by the manufacturer.

2 Safety Instructions

- Before mounting the delivered components disconnect the printing system from the power supply and close the shutoff valve at the applicator.
- Couple the applicator to devices using extra low voltage only.
- Before making or undoing connections, switch off all devices involved (computer, printer, accessories etc.).
- Operate the applicator in a dry environment only and do not get it wet (sprayed water, mist etc.).
- Do not use the applicator in explosive atmosphere and not in proximity of high voltage power lines.
- Operate the applicator only in an environment protected against abrasive dust, swarf and other similar impurity.



NOTICE!

With the open printing unit (due to construction) the requirements of EN 62368-1 regarding fire protection casing are not fulfilled. These must be ensured by the installation into the end device.

- Maintenance and servicing work can only be carried out by trained personnel.
- Operating personnel must be trained by the operator based on the operating manual.
- Carry out only the actions described in these operating instructions. Any work beyond this may only be performed by especially trained personnel or service technicians.
- Unauthorized interference with electronic modules or their software can cause malfunctions.
- Other unauthorized work or modifications to the applicator can endanger operational safety.



WARNING!

In operation, moving parts are easily accessible. This applies especially for the zone, where the pad is moved between the starting and the labelling position.

There is a risk of crushing due to the movement of the stamp downwards and upwards.

- ⇒ Do not reach into the working area of the stamp.
- ⇒ Keep hair, loose clothes and jewellery away from this area.
- ⇒ Before accessing this area, switch off the power supply and compressed air supply.

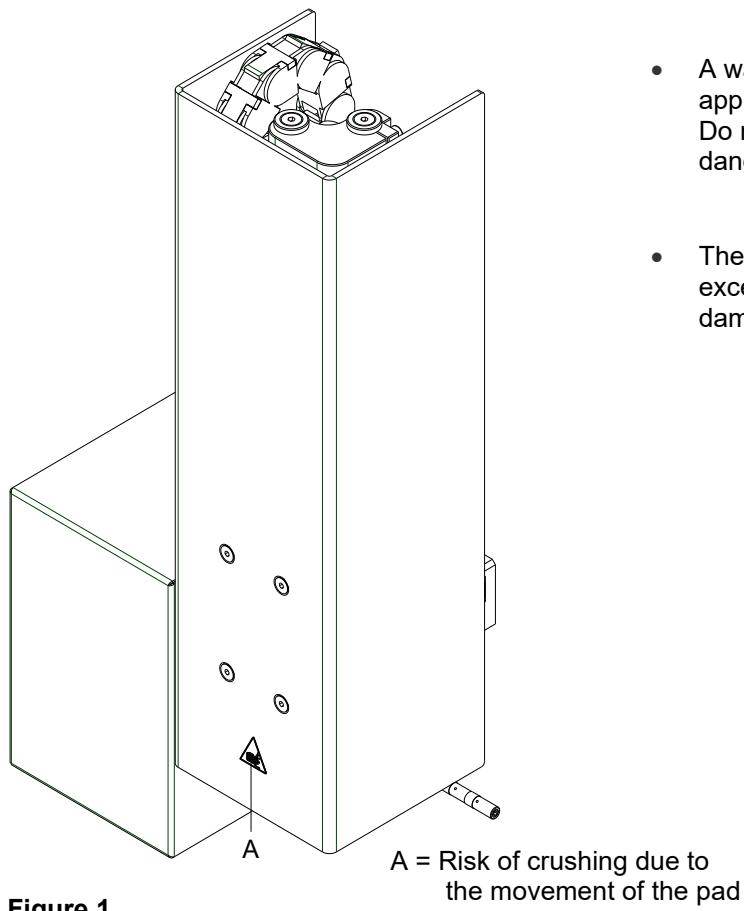


Figure 1

- A warning sticker is applied to the applicator to draw attention to dangers. Do not remove this label, otherwise the danger can no longer be recognized.
- The used operating pressure must not exceed 5 bar. Otherwise, this can lead to damages to the components.



CAUTION!

Damages of the plunger rod, cylinder tube or the seals caused by lateral forces that affect the plunger rod of the cylinder. This can lead to a reduction of lifetime and to leakages up to destruction of the cylinder.

⇒ Lateral forces must be avoided necessarily.

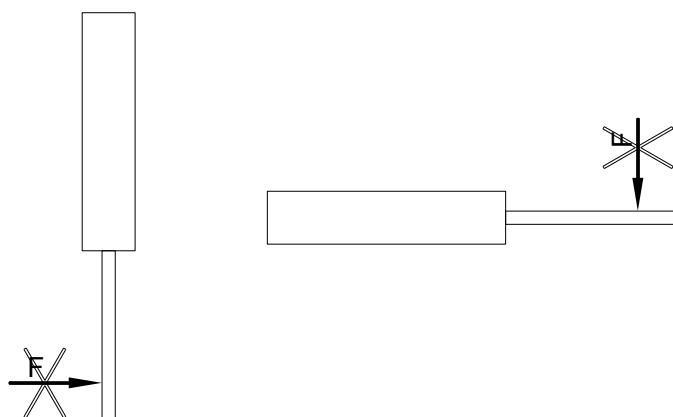


Figure 2

Installation position**CAUTION!**

Depending on the installation position, when swivelling the applicator, it may descend uncontrollably and hit the ILX V, potentially damaging the printing system.

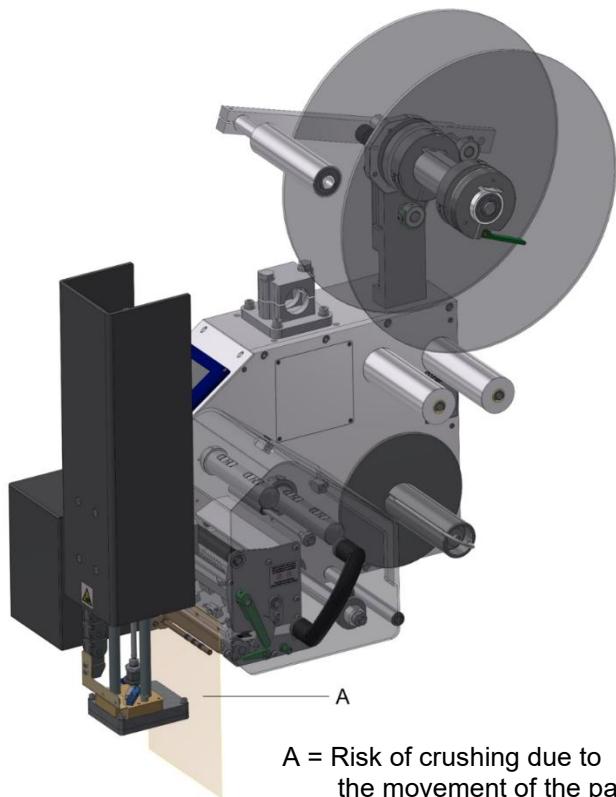
⇒ When swivelling the applicator, it must be manually supported by hand depending on the installation position.

2.2 Danger Zone**CAUTION!**

Moving parts are accessible when using the applicator. Especially in the area in which the pad is moved between the basic and the labelling position.

There is a risk of injury due to the movement of the pad downwards and back up again.

- ⇒ Before accessing this area, switch off the power supply and the compressed air supply.
- ⇒ Keep hair, loose clothing, and items of jewellery out of this area.
- ⇒ Turn off the compressed air supply before accessing this area.

**Figure 3**

2.3 Safety Precautions



NOTICE!

The applicator has been designed to reduce the risk of injury.

For the cylinder movement, the pressure is throttled at the factory compared to the operating pressure of the complete labelling system. This setting must not be changed!

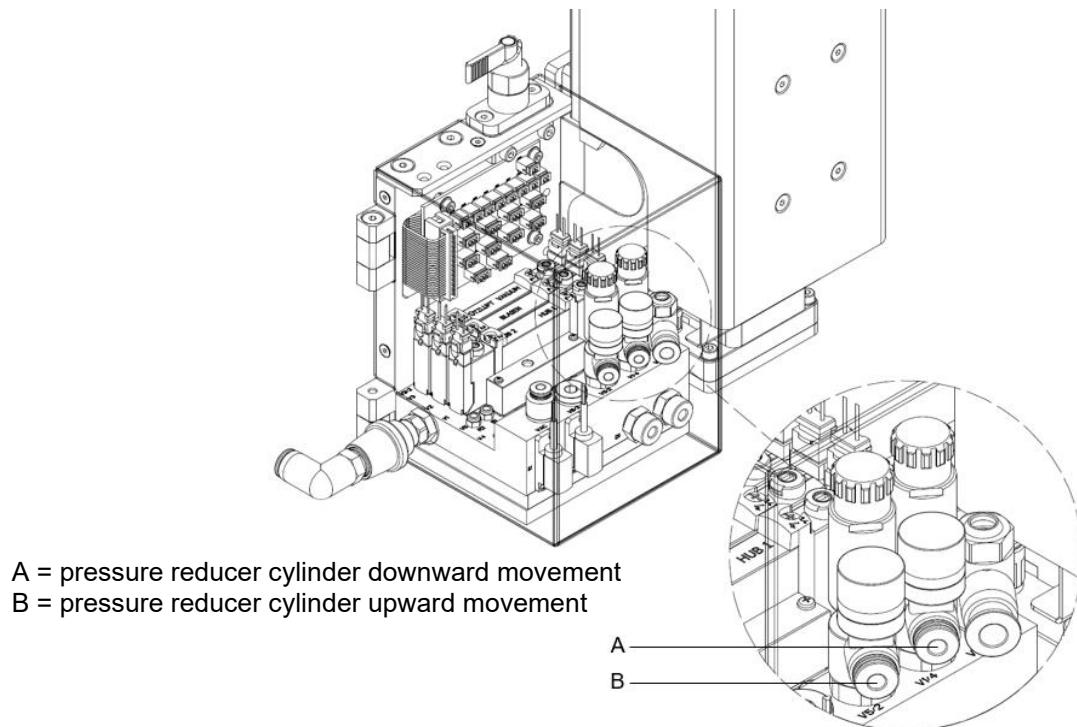


Figure 4

According to DIN EN 61010-1 (VDE 0411-1), section 7.3.4, the highest acceptable sustained contact pressure is 50 N/cm² with a maximum power of 150 N. To further reduce the risk of injury, the cylinder movement has been internally adjusted so that the maximum power is limited to 75 N.



CAUTION!

Risk of crushing fingers.

⇒ The pressure reducers must not be changed at any time. Increasing the pressure of the cylinder movement does not meet the requirements of DIN EN 61010-1 (VDE 0411-1), section 7.3.4.

The applicator can be stopped at any time by interrupting the compressed air supply. For this purpose, a manual slide valve is attached directly to the applicator (see Figure 5). When the manual slide valve is in Off mode, the compressed air supply is interrupted, which immediately stops the applicator and automatically releases the compressed air. This applies also for the power-off mode: As soon as the power supply is interrupted, the compressed air in the system is automatically released and the applicator immediately comes to a standstill.

**NOTICE!**

If the compressed air supply is interrupted, the cylinder of the applicator can sink downwards due to gravity, depending on the installation position of the printing system.

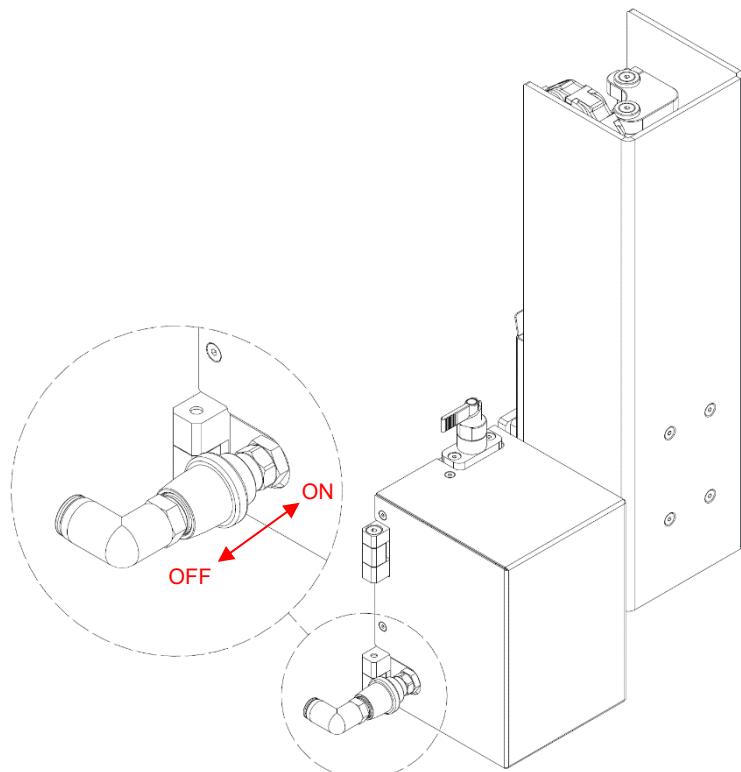


Figure 5

2.4 Operating Conditions

Before initial operation and during operation these operating conditions must be observed to guarantee save and interference-free service of our printing systems.

Therefore, please carefully read these operating conditions.

Shipment and storage of our printing systems are **only** allowed in original packing.

Installation and initial operation of printing system is only allowed if operating conditions were **fulfilled**.

Commissioning is prohibited until it can be set up that, where relevant, the machine into which the partly completed machinery is to be incorporated complies with the provisions of Machinery Directive 2006/42/EC.

Initial operation, programming, operation, cleaning, and service of our printing systems are only recommended after careful study of our manuals.

Operation of printing system is only allowed by especially trained persons.



NOTICE!

Perform trainings regularly.

These indications are also valid for someone else's equipment supplied by us.

Only use original spare and exchange parts.



NOTICE!

This is a machine of type A. This machine can cause interferences in residential areas; in this case it can be needed from operator to carry out proper measures and be responsible for it.

Air convection

To avoid inadmissible heating, free air convection has to be ensured.

Limit values

Ambient temperature °C (operation): Min. +5 Max. +35

Ambient temperature °C (storage): Min. -25 Max. +60

Relative air humidity % (operation): Max. 80

Relative air humidity % (storage): Max. 80
(bedewing of printing systems not allowed)

Guarantee

We do not take any responsibility for damage caused by:

- Ignoring our operating conditions and operating manual.
- Incorrect electric installation of environment.
- Building alterations of our printing systems.
- Incorrect programming and operation.
- Not performed data protection.
- Using of not original spare parts and accessories.
- Natural wear and tear.

When (re)installing or programming our printing systems please control the new settings by test running and test printing. Herewith you avoid faulty results, reports and evaluation.

Only specially trained staff is allowed to operate the printing systems.

Control the correct handling of our products and repeat training.

We do not guarantee that all features described in this manual exist in all models. Caused by our efforts to continue further development and improvement, technical data might change without notice.

By further developments or regulations of the country illustrations and examples shown in the manual can be different from the delivered model.

Please pay attention to the information about admissible print media and the notes to the printing system maintenance, to avoid damages or premature wear.

We endeavoured to write this manual in an understandable form to give you as much information as possible. If you have any queries or if you discover errors, please inform us to give us the possibility to correct and improve our manual.

3 Product Description

The applicator APX V is an optional device to use with printing systems of ILX V series for automatically applying the printed label onto the product.

The labels are transferred with a pad, which moves between the two positions, starting position and labelling position, by a compressed-air-driven pneumatic cylinder.

In the starting position, the label is picked up from the printing system.

A sensor at the cylinder signals when the pad is in the starting position.

The label is removed from the carrier ribbon directly at the dispensing edge of the printing system. It is sucked on the pad by a vacuum via drillings at the bottom of the pad.

For support, the label is also blown against the pad (supporting air) with an air current coming from a blow tube.

The correct transfer of the label is controlled by a vacuum sensor.

Next, the pad is moved down into the labelling position. Reaching the labelling position is confirmed by another sensor (labelling position sensor).

In the labelling position the label is transferred onto the product.

The supporting air and the vacuum as well as the speed of the cylinder are adjustable. That way the applicator can be adapted to different label materials and sizes.

For the cylinder movement, the pressure is throttled at the factory compared to the operating pressure of the complete labelling system. This setting must not be changed!

To avoid contamination within the vacuum channels they are cleaned by air pressure impulse at the end of each application.

For integration into a superordinated process the printing systems are equipped with 'Dispenser I/O'.

3.1 Apply the Labels

For applying the labels on the products, there are three different possibilities available:

Stamp-on

The label is pressed directly onto the product.

Blow-on

The pad moves to a pre-adjusted position approximately 10 mm away from the product. The label is blown onto the product by an air stream.

Roll-on

In the starting position the label is forwarded until touching the roller of the roll-on pad. At the labelling position the roller is pressed onto the product. Then the label is applied and rolled on by the movement of the product.

3.2 Device Overview

Front view

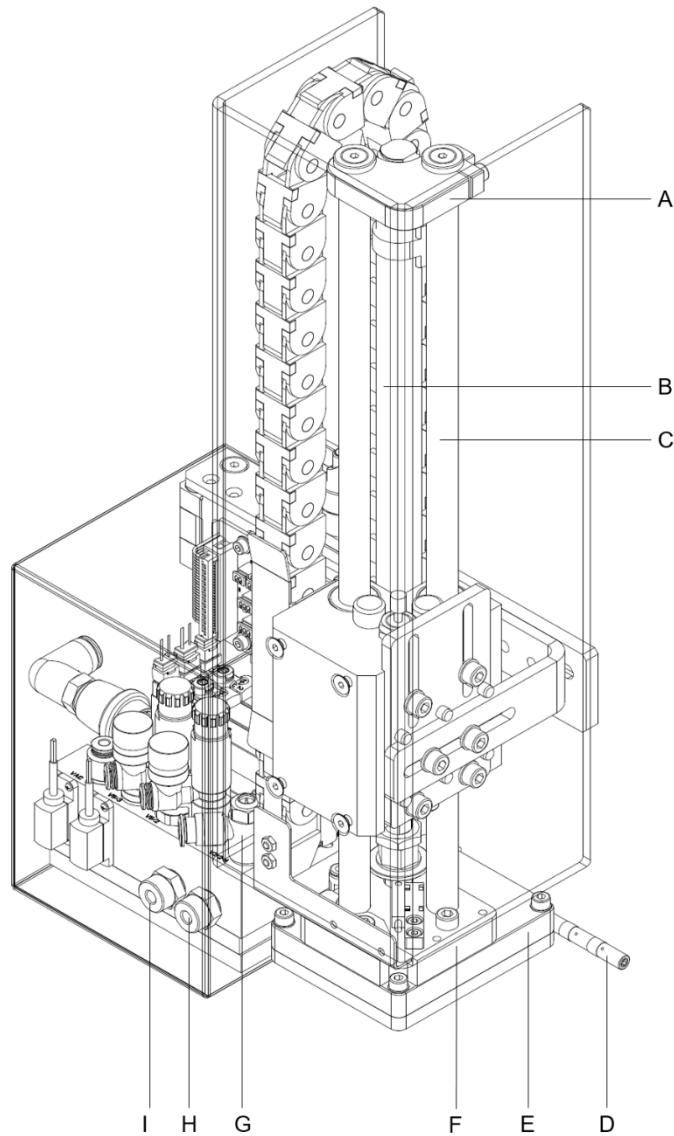
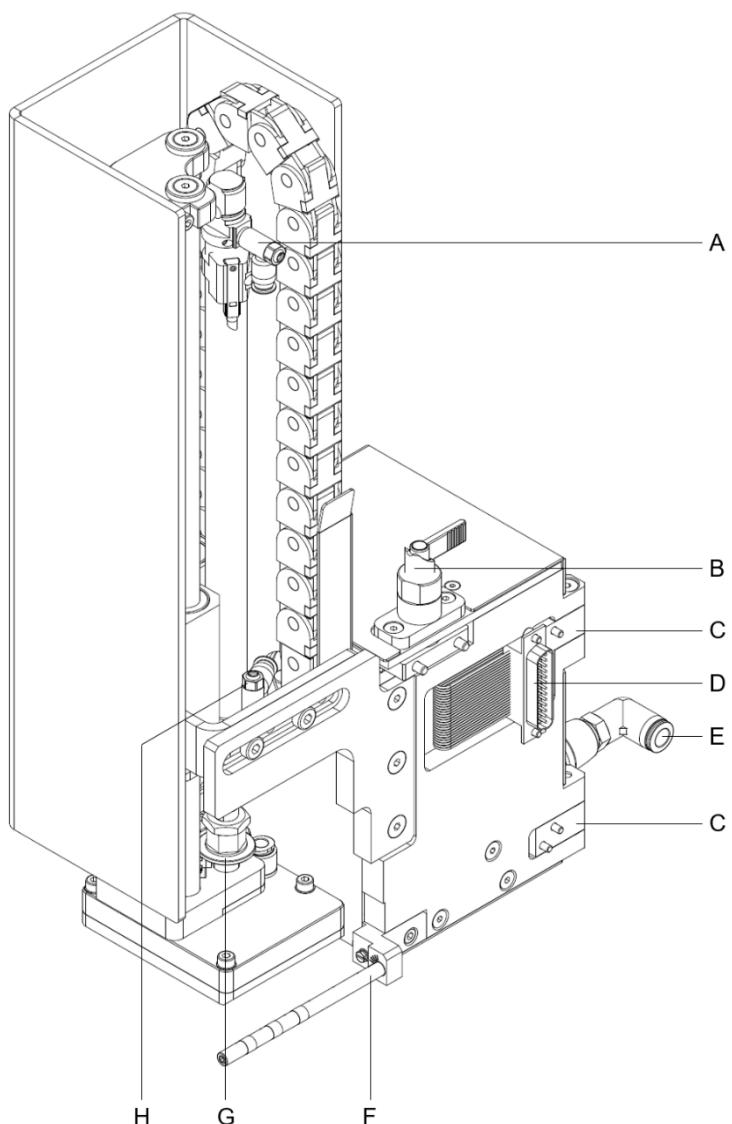
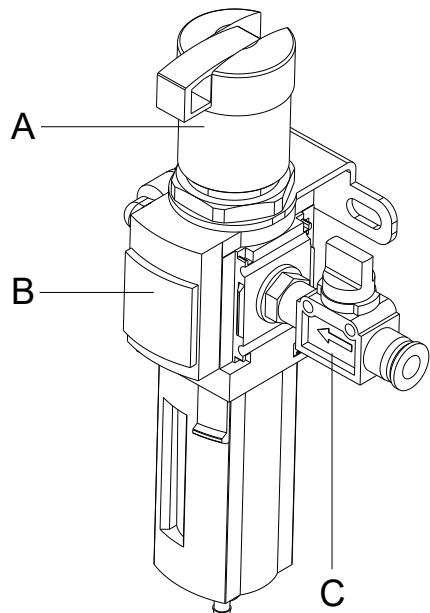


Figure 6

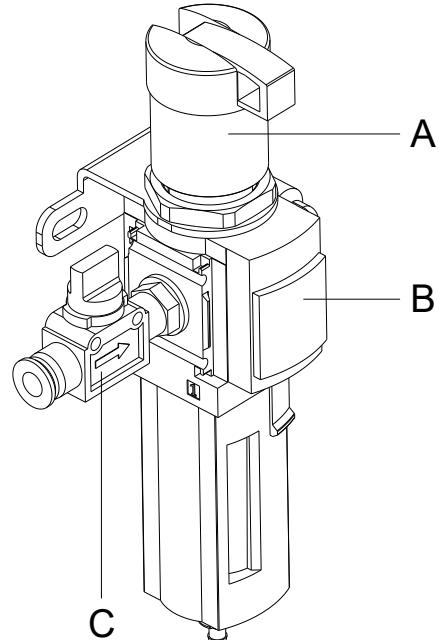
- A = Stopper for the operation mode "blow on"
- B = Pneumatic cylinder
- C = Cylinder unit
- D = Blow tube for supporting air
- E = Pad (application specific)
- F = Pad holder
- G = Throttling valve 'blowing air'
- H = Throttling valve 'vacuum'
- I = Throttling valve 'supporting air'

Rear view**Figure 7**

- A = Throttling valve 'cylinder' (top)
- B = Locking pin with interlock
- C = Hinge for fixing the applicator to the printing system
- D = Interface to the printing system
- E = Compressed air connector
- F = Blow tube for supporting air
- G = Pad holder
- H = Throttling valve 'cylinder' (bottom)

**Service unit -
right version****Figure 8**

- A = Adjusting knob of pressure control valve with filter
- B = Manometer
- C = Shut-off valve

**Service unit -
left version****Figure 9**

- A = Adjusting knob of pressure control valve with filter
- B = Manometer
- C = Shut-off valve

3.3 Pads

Tamp pad

Universal tamp pad

Standard size:
70 x 85 mm

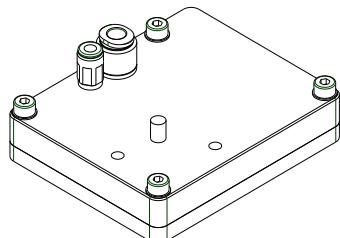


Figure 10

Spring-mounted universal tamp pad

Standard size:
90 x 120 mm

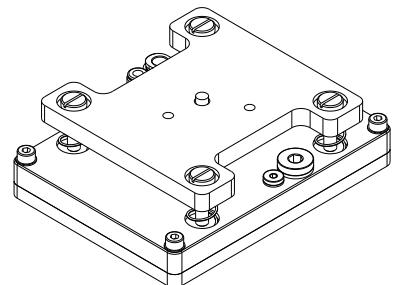


Figure 11

Universal tamp are available in different standard sizes. According to the size of the label the holes may be pierced by the customer. For that purpose, a piercing pin is included in the delivery contents.

On request, tamp pads customized to the label sized are delivered.

Roll-on pad

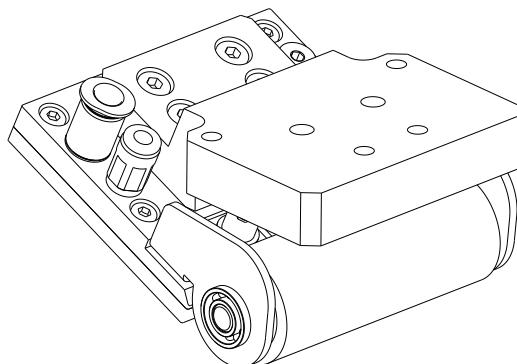


Figure 12

Roll-on pads are only produced on request customized to the label size.

Blow pad (w/o teflon tape)

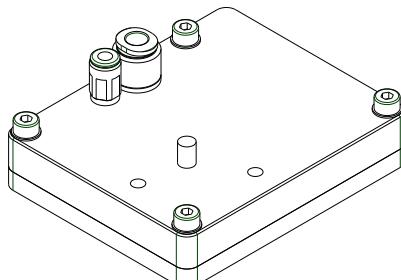


Figure 13

Blow pads are only produced on request customized to the label size.

3.4 Remove the Covers

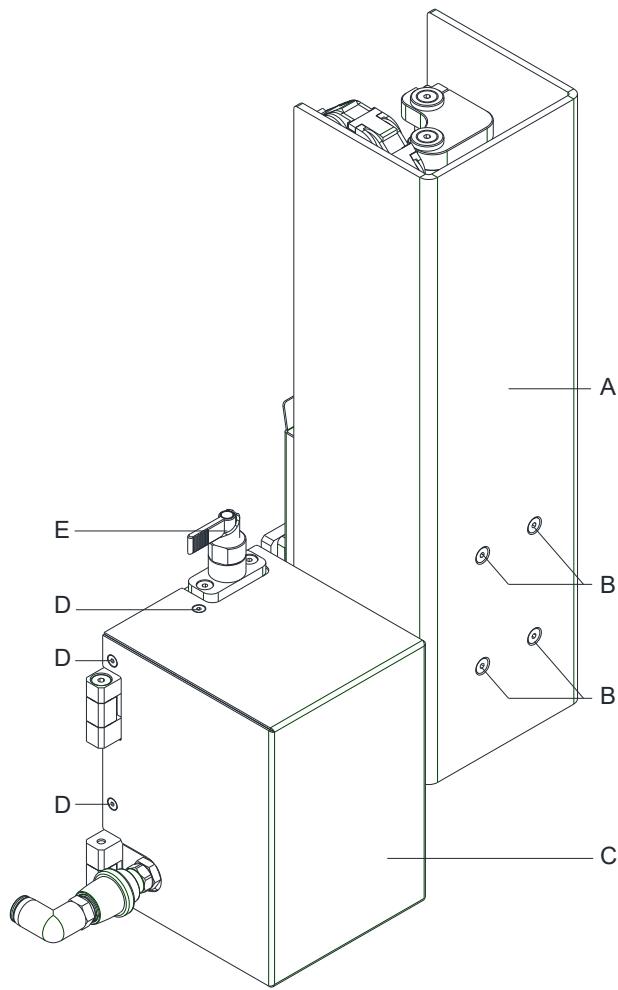


Figure 14

Removing the cylinder cover

1. Loosen screws (B).
2. Remove the cover (A).

Removing the electronics cover

1. Loosen screws (D).
2. Remove the cover (C).

4 Technical Data

Label transfer / Operating modes	Stamp on	Blow on	Roll on
Label width			
V V 5X	20 ... 56 mm	20 ... 56 mm	20 ... 56 mm
ILX V 8X	20 ... 86 mm	20 ... 86 mm	20 ... 86 mm
ILX V 10X	20 ... 112 mm	20 ... 112 mm	20 ... 112 mm
Label height (mm)	15 ... 210 mm	15 ... 100 mm	70 ... 210 mm
Label height universal pad	15 ... 80 mm	15 ... 80 mm	70 mm
Utilizable cylinder stroke			
200 mm cylinder	170 mm	170 mm	200 mm
300 mm cylinder	270 mm	270 mm	300 mm
400 mm cylinder	370 mm	370 mm	400 mm
Operating pressure	5 bar	5 bar	5 bar
Product surface	even	even	even
Product height variable	✓	-	✓
Product height fixed	✓	✓	✓
Product fixed	✓	✓	-
Product linear movement	-	✓	✓
Labelling from top	✓	✓	✓
Labelling from bottom	✓	✓	✓
Labelling from the side	✓	✓	✓
Retraction depth	25 mm	-	-
Direction	right and left version		
Compressed air control/vacuum control	available		
Service unit	filter regulation with manometer and shut-off valve		
Voltage supply/current supply	by label printing system		
Dimensions (w x h x d)	237 x 423 x 126 mm		
APX V200	237 x 423 x 126 mm		
APX V300	237 x 523 x 126 mm		
APX V400	237 x 623 x 126 mm		
Weight	5 kg*		

* measured by APX V200

5 Installation

5.1 Scope of Delivery



NOTICE!

Please keep the original packaging in case the applicator must be returned.

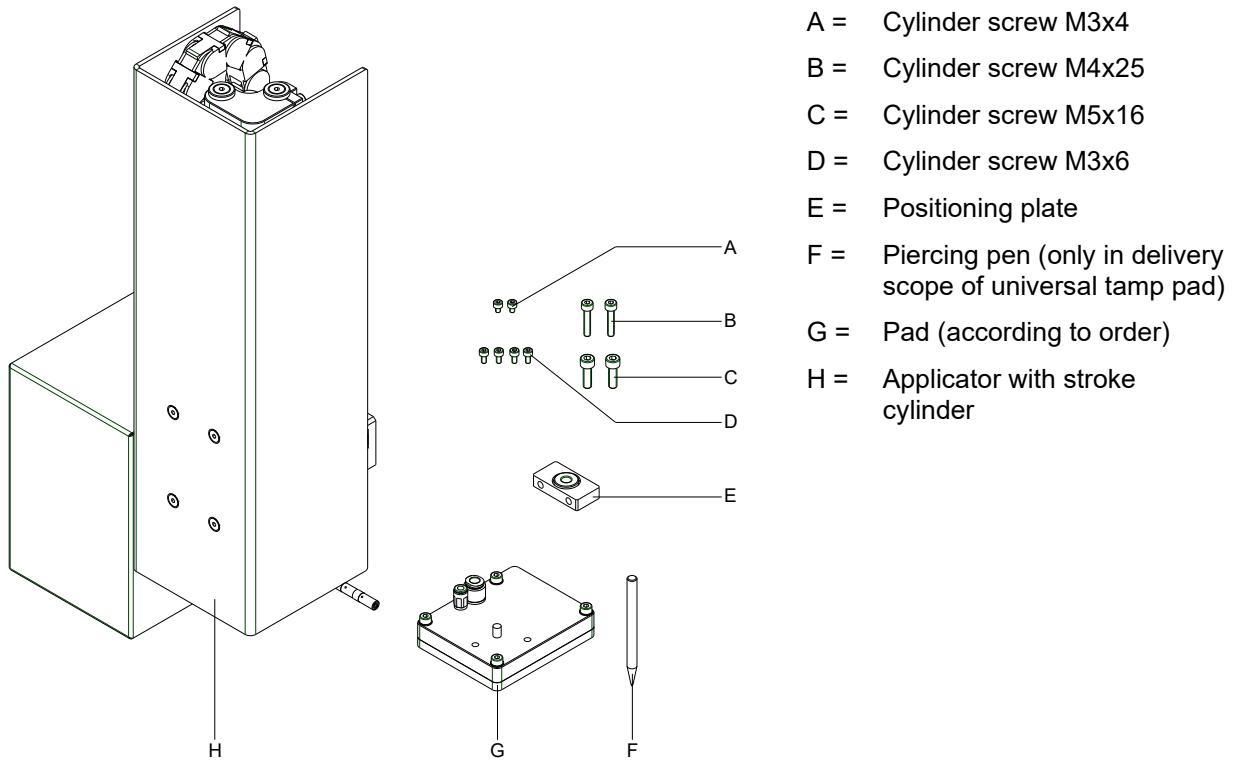


Figure 15



CAUTION!

The printing system and the applicator can be damaged by moisture and water.

⇒ Set up the printing system with applicator only in dry locations protected from splash water.

5.2 Installation Positions



CAUTION!

Depending on the installation position, when swivelling the applicator it may descend uncontrollably and hit the ILX V, potentially damaging the printing system.

⇒ When swivelling the applicator, it must be manually supported by hand depending on the installation position.



NOTICE!

All models of the printing system can be installed rotated vertically by up to 360° or installed in horizontal position.

Installation position 0°

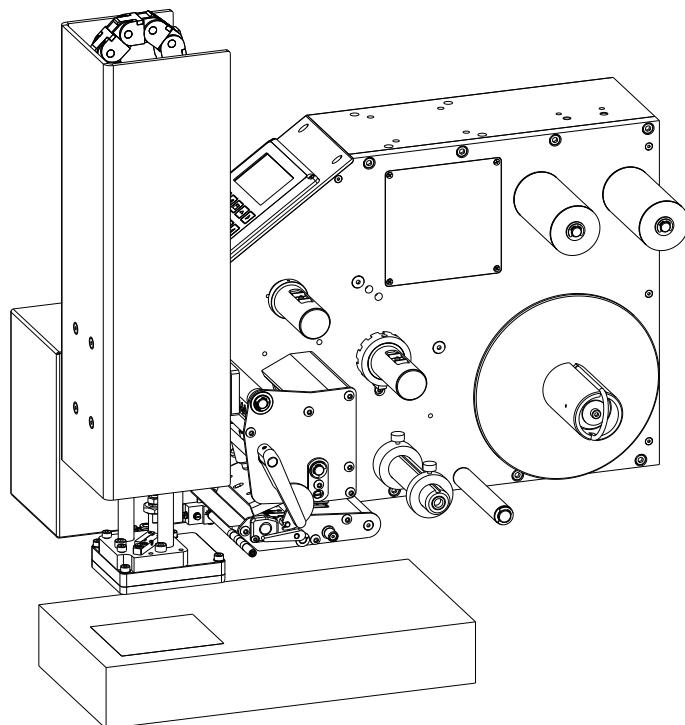
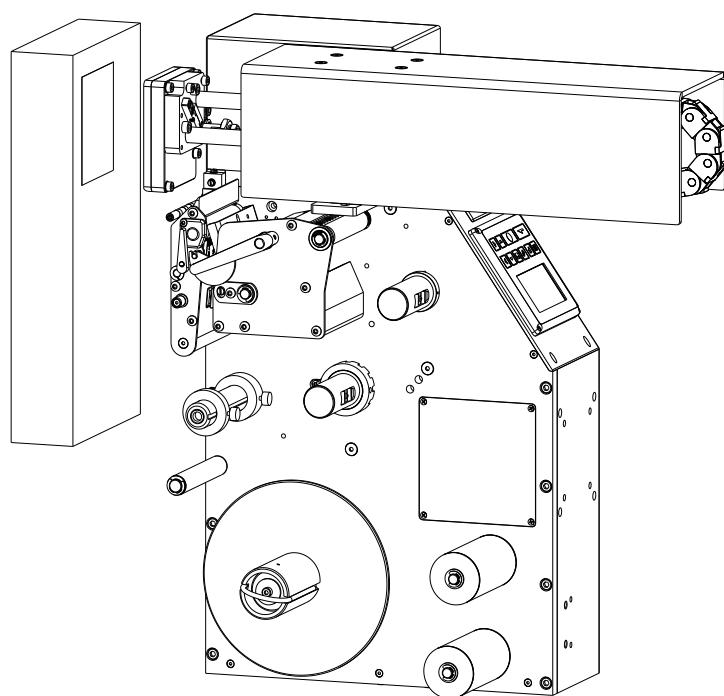
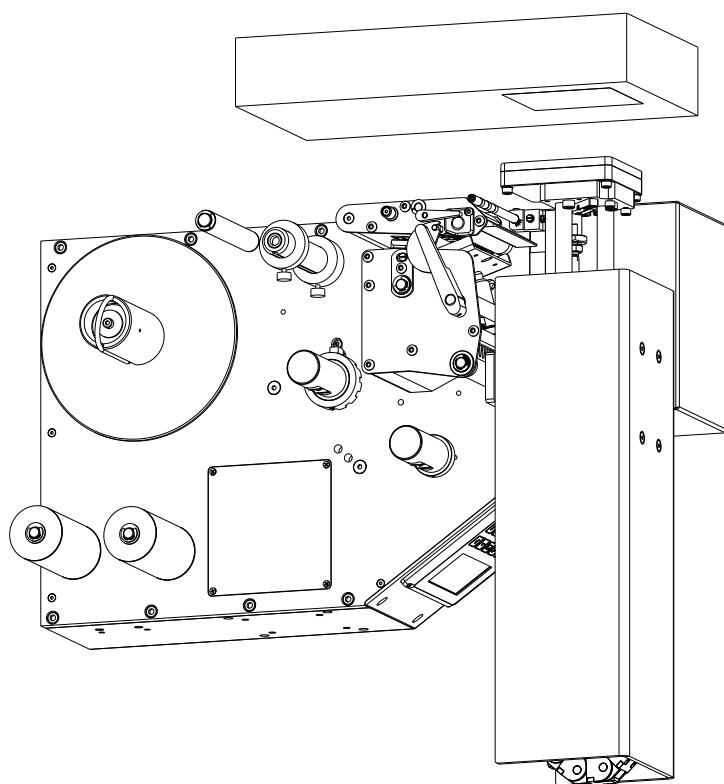


Figure 16

Installation position 90°**Figure 17****Installation position
180°****Figure 18**

**Installation position
270°**

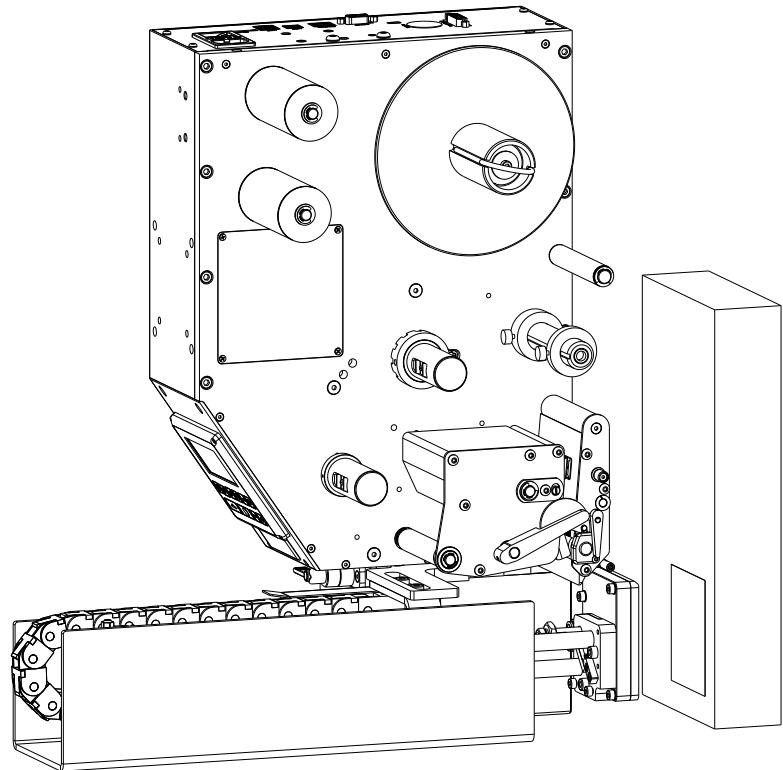


Figure 19

**Horizontal installation
position**

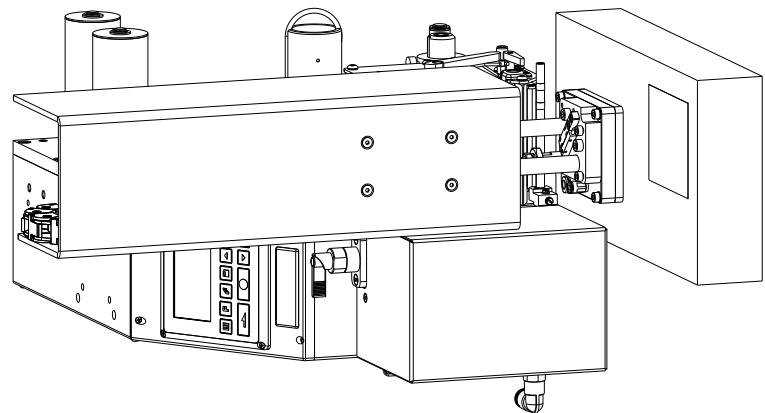


Figure 20

5.3 Install the Applicator to the Printing System



NOTICE!

- ⇒ Before assembly/disassembly of the supplied components, disconnect the printing system from the mains and shut off the compressed air supply.
- ⇒ Only connect the compressed air to the printing system after the applicator has been installed.
- ⇒ Use the applicator's slide valve (Figure 5, page 11) to switch the compressed air supply On/Off.
- ⇒ The slide valve is a vent valve. Switching off the compressed air supply depressurizes the system.

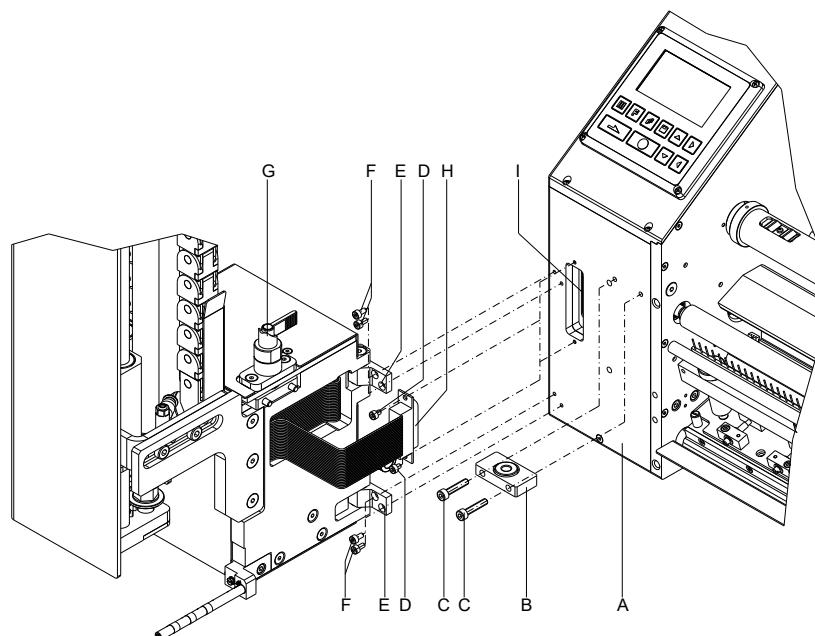


Figure 21

1. Attach the support plate (B) to the front plate (A) of the printing system using screws (C).
2. Attach the hinges (E) of the applicator to the front plate (A) of the printing system using screws (F).
3. Connect the plug (H) of the applicator with the peripheral connection (I) of the printing system and secure with the screws (D).
4. Pivot the applicator and secure with the locking pins (G).

5.4 Pierce the Universal Tamp Pad

On the bottom of the pads there are holes for sucking and holding the labels by vacuum. When an universal tamp pad is delivered these holes are covered by the sliding foil and must be opened according to the label size. For that purpose a piercing pin is included in the contents of delivery.

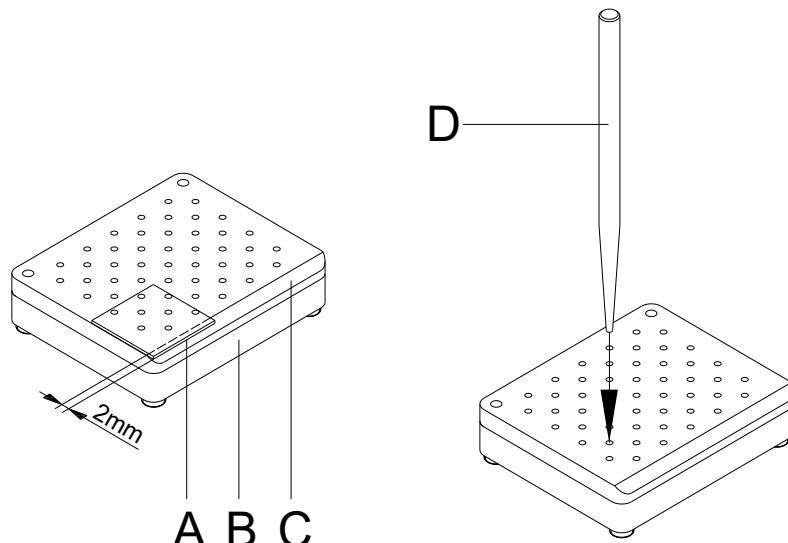


Figure 22

1. Place a label (A) to be operated on the bottom side of the pad (B). Note the position of the slanted edge (C).
2. Align the label to the side edge in such a way that it reaches over the rear edge of the pad by 2 mm.
3. Open all holes, which are certainly covered by the label. Open the holes completely by turning the piercing pin (D) inside the holes.



CAUTION!

Malfunctions by a too weak vacuum.

⇒ Do not open holes which are located less than 1 mm from a label edge.

5.5 Prepare for Using a Sprint-Mounted Tamp Pad



NOTICE!

For using a spring-mounted universal tamp pad (90 x 120 mm) the fitting of the cylinder unit must be changed.

The cylinder unit (E) can be mounted on the bracket (A) in multiple different positions.

When the applicator is delivered, the cylinder unit (E) is mounted on the bracket (A) using the upper threaded hole. That position is suitable for the most pads.

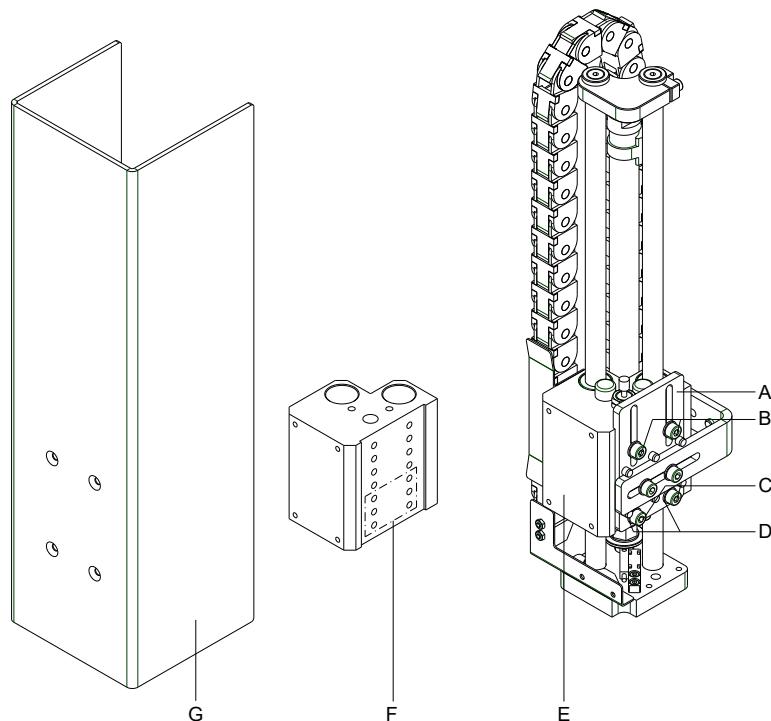


Figure 23

1. Remove the cylinder cover (G).
2. Remove the screws (B+C) and washers (D).
3. Push the cylinder unit (E) on the support plate (A) upwards.
4. Attach the cylinder unit (E) to the support plate (A) at the lower holes (F) using the screws (C) and washers (D).

5.6 Install the Pad

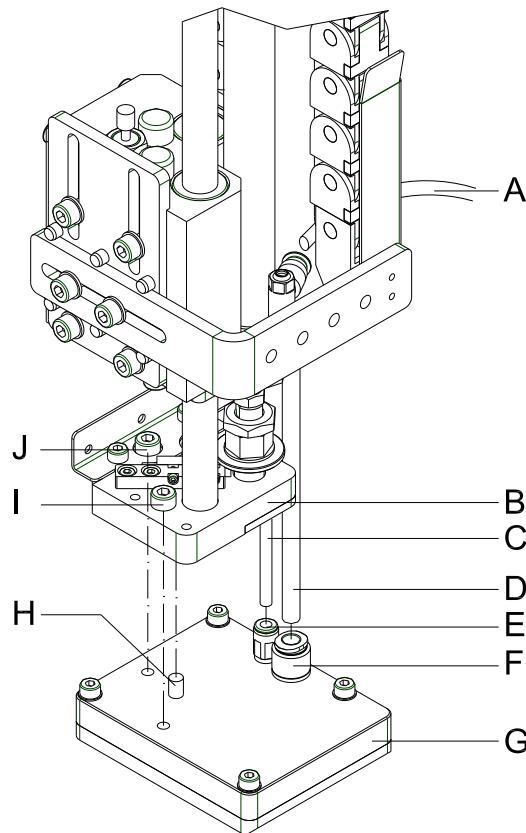


Figure 24

1. Pull the tube (A) out of the push-in-fitting.
2. Insert the pin (H) on the pad (G) into the hole on the bottom side of the guiding plate (B).
3. Fix the pad (G) with the cylinder screws (I, J) at the pad holder (B) and make a rough adjustment of the pad to the dispensing edge of the printing module.
4. Insert the vacuum tube (C) and the blowing air tube (D) into the proper push-in-fittings (E, F) of the pad.
5. Insert the tube (A) into the connection of throttling back valve on the cylinder.



CAUTION!

Danger of collision of the pad with other parts of the labelling system.

⇒ Before connecting the applicator to the compressed air supply please roughly align the pad in all directions.

5.7 Install the Connections

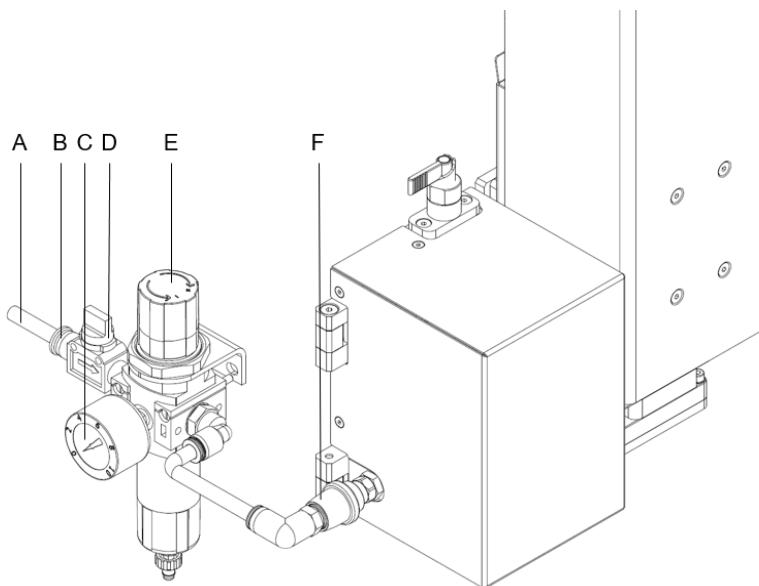


Figure 25

1. Prepare the power supply and interface at the printing system (see operating manual of the printing system).
2. Close the shut-off valve (D / lever at the valve is turned across the air flow direction).
3. Switch the slide valve (F) to Off (see chapter 2.3, Safety Precautions, page 10).
4. Connect the applicator to the compressed air supply. The push-in fitting (B) for the compressed air connection is located on the rear of the maintenance unit. The connection is designed for a tube (A) with Ø 8 mm.
5. The operating air pressure for the applicator is pre-adjusted to 0.5 MPa (5 bar). Check the pressure at the manometer (C) of service unit. Correct the adjustment if necessary:
 - pull knurled knob (E) up.
 - turn knob to tune required operating pressure of 5 bar.
 - push knob down.



NOTICE!

The used operating pressure must not exceed 5 bar. Otherwise, this can lead to damages to the components.

6. Open the shut-off valve (D / lever is turned in the air flow direction).
7. Switch the slide valve (F) to On (see chapter 2.3, Safety Precautions, page 10).
8. Switch on the printing system at the power switch.

**CAUTION!**

The printing system is factory-adjusted so that the applicator (during the printer switch On process) only moves to its home position when this process has been confirmed on the display.

- ⇒ Do not reach into the working area of the pad.
- ⇒ Keep hair, loose clothing, and items of jewellery out of this area.
- ⇒ Danger of striking by the moving rods. Do not reach or bend into the zone of the moving rods.

6 Options

6.1 Quick Apply

The optional "quick apply" function allows reduction of the impact pulse of the pneumatic cylinder.

"Quick apply" is an adjustable pneumatic absorption and/or brake with an added pneumatic valve.

The cylinder is set to the maximum speed. The "quick apply" function decelerates the pad of the applicator just before the application surface of the product. In this way, cycle times are increased without damaging the product.



NOTICE!

The 'Quick Apply' option is only active in the operating modes 'Stamp on' and 'Blow on'.

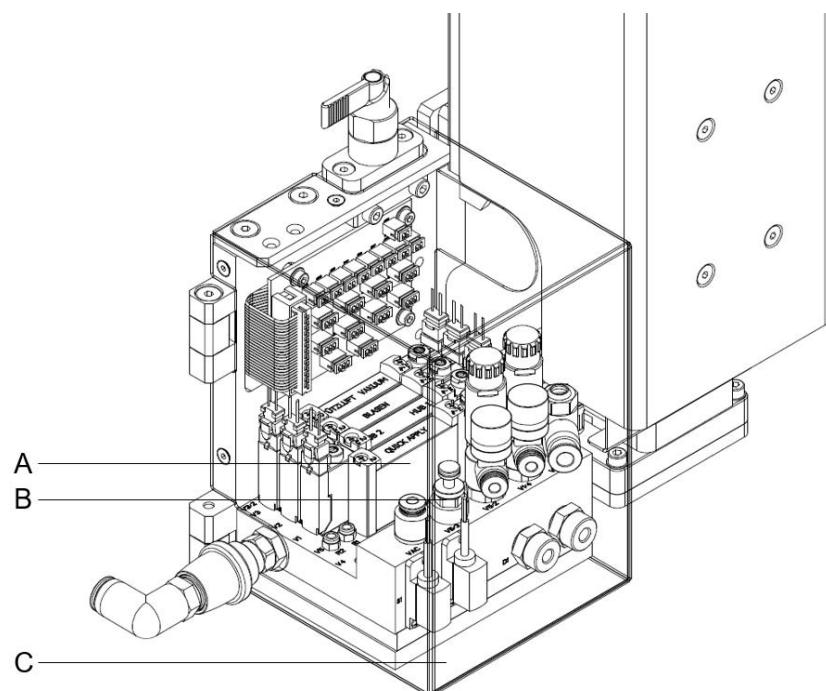


Figure 26

1. Unscrew and remove the protective cover (C) (see chapter 3.4, page 20).
2. Turn the adjusting screw (B) to set the absorption of solenoid valve (A).
3. Attach the protective cover (C).
4. In the "quick apply" menu of the printing system, set the desired delay in ms for valve activation.

6.2 Shock Absorber

The optional shock absorber allows reduction of the impact pulse of the pneumatic cylinder.

The additionally installed shock absorber absorbs the impact forces of the cylinder and ensures a soft limit position of the pad.

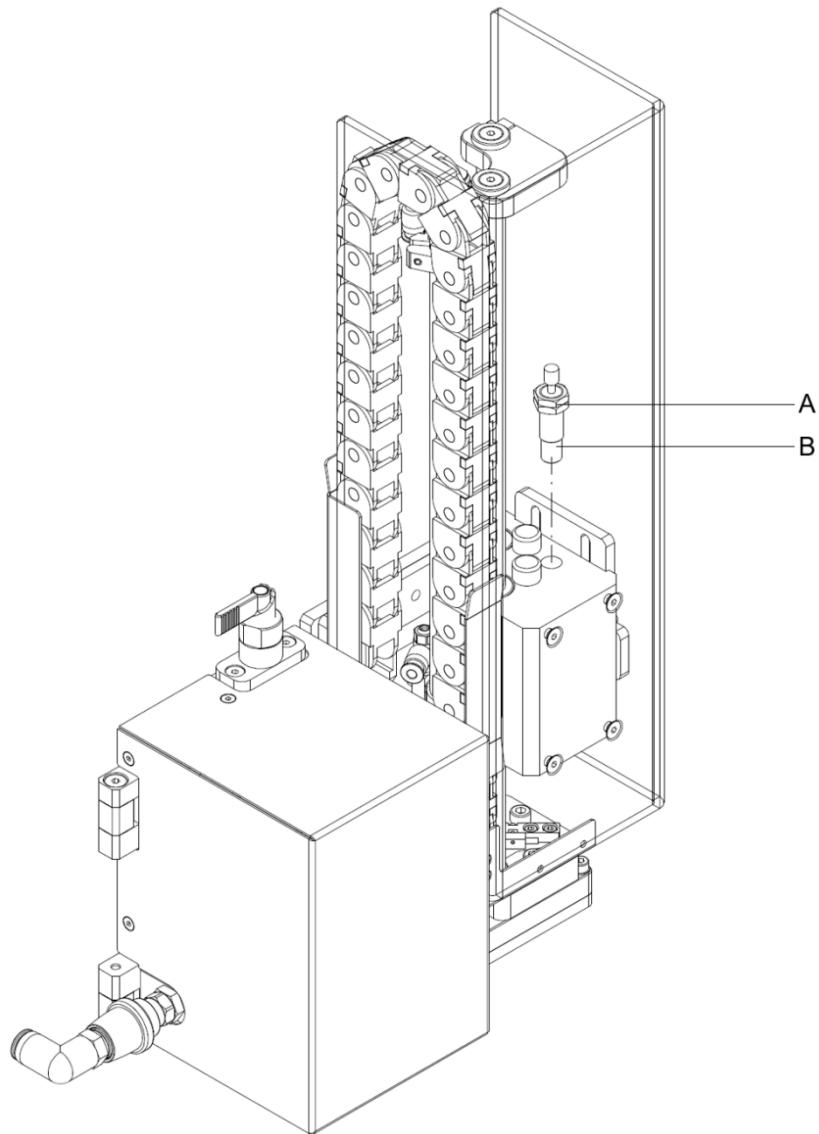


Figure 27

1. Move the shock absorber (B) to the desired height by screwing it in.
2. Secure the position of the shock absorber (B) against unintentional loosening using the locknut (A).

6.3 Product Sensor

The "product sensor" option is used for optical, contact-free registration of products to obtain input signals for the printing system.

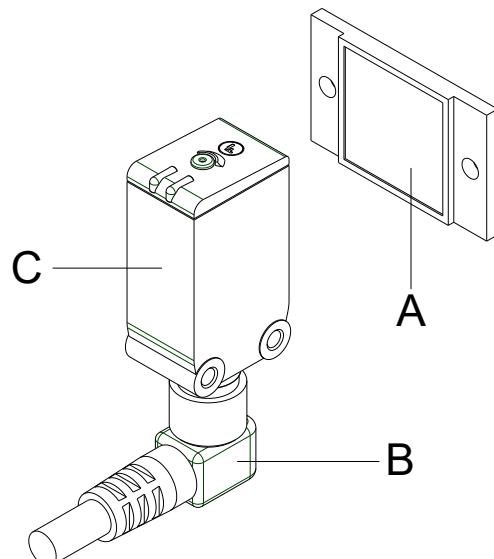


Figure 28

A = Reflector

B = Connecting line

C = Reflexion photocell



NOTICE!

When using reflection photocells, you should observe that other light (e.g. working lamp) on the photocell is prevented.

1. Connect the connecting line (B) of the reflection photocell (C) to the I/O 24 interface.
2. Attach the reflector (A) at right angles with the reflection photocell (C).

7 Configuration

The label applicator can be used in diverse ways. While the original process stays the same, the operation mode can be chosen within the function menu of the connected printing system.

The most important setting is the selection between the operating modes "stamp-on", "blow-on" and "roll-on". Additionally, the applicator has different application modes concerning the order of printing and applying within one labelling cycle.

	Stamp on	Roll on	Blow on
Print-Apply	✓	✓	✓
Apply-Print Waiting position up	✓	✓	✓
Apply-Print Waiting position down			✓

7.1 Configuration Parameter

Parameter	Meaning	Selection
Operating mode	Setting of operating mode Default: Stamp on	Stamp-on, Blow-on, Roll-on
Mode	Setting of application mode Default: Print-apply	Print-apply Apply-print
Vacuum delay On	Setting of switch-on delay Vacuum Default: 0 ms	0 ... 5000 ms in 10 steps of ms
Vacuum delay Off	Setting of switch-off delay Vacuum Default: 500 ms	0 ... 5000 ms in steps of 10 ms
Support delay On	Duration of switch-on delay for supporting air Default: 0 ms	0 ... 2500 ms in steps of 10 ms
Support delay Off	Duration of switch-off delay for supporting air Default: 500 ms	0 ... 2500 ms in steps of 10 ms
Pressure control	Function of compressed-air control Default: On	On Off
Vacuum control	Function of vacuum control Default: On	On Off
Pressure time	Duration of pressure time Default: 100 ms	0 ... 5000 ms in steps of 10 ms
Blow time	Duration of blow time Default: 100 ms	0 ... 2500 ms in steps of 10 ms

Parameter	Meaning	Selection
Waiting position	Waiting position of pad with dispensed label for "blow on + Apply-print" Default: Up	Up Down
Roll on time	Duration of roll-on time Default: 0 ms	0 ... 5000 ms in steps of 10 ms
Cleaning time	Duration of cleaning time Default: 100 ms	0 ... 2500 ms in steps of 10 ms
Timeout hub	Moving up/down of pad Default: 0 ms	0 ... 5000 ms in steps of 10 ms
Delay lower end position	Duration of the delay for the monitoring of sensor 'Lower end position' Default: 0 ms	0 ... 1000 ms in steps of 10 ms
Quick-Apply (option)	Duration of switch-on delay of the additional cylinder valve	0 ... 2500 ms in steps of 10 ms
Transverse axis (not available)	Setting, if a transversal movement is to be effected before the downwards movement of the pad Default: Off	On Off
Labelling signal	Setting, if printing and labelling of the label is to be released separately Default: Off	Off Print position Labelling position
Applicator release	Setting, if the applicator moves to the initial position with or without acknowledgement when the printer is switched On. Default: Off	On Off
Test functions	Hub setting Test run of pad without label	

7.2 Settings in Printing System Function Menu

Switch on the printing system and the display shows the main menu.

Press the key  to access the function menu.

Press the key  until the menu *Label applicator* is displayed.

Press the key  to select the menu.

Press the key  to move to the next mode.

Operating modes

Off: The print order is processed without using the applicator.

Stamp on:

The label stays in a fixed position. The label is pressed directly onto the product.

Blow on:

The pad moves to a pre-adjusted position approximately 10 mm away from the product. The label is blown onto the product by an air jet stream. The print and apply cycle perform in a fixed position or in linear movement of the product.

Roll on:

The label is dispensed and moved until touching the roller of the roll-on pad. In the labelling position, this roll is pressed onto the product. Then the label is applied and rolled on by the movement of product.

Press the key  to move to the next parameter.

Mode

The applicator can be operated in two different ways concerning the order of printing and labelling within one labelling cycle (see chapter 1, page 47).

Print-Apply:

The print of a label is released by an external start signal. At the same time the vacuum on the pad as well as the supporting air from the blow tube are switched on. If the label is printed and picked up completely from tamp, the supporting air is switched off, and the lift cylinder is controlled to move the pad down towards the labelling position. A sensor signals when the labelling position is reached.

Following, the vacuum is switched off, and the label is transferred to the product. After applying the label, the lift cylinder is so controlled that the pad is again moved back to the starting position.

Now the labelling cycle is finished.

Apply-Print:

At the beginning of the cyclic operation 'Apply-Print' the first label is printed at once and passed to the pad.

The pad with the printed label is in starting position and the vacuum at the pad is switched on.

At start of the cyclic operation when sending the start signal, the first label is already on the pad. The following process is like the mode 'print-apply' but at the end of the cycle the next label is printed and picked up by the pad.

Now the labelling cycle is finished.

Press the key  to move to the next parameter.

Vacuum delay On

The vacuum is not switched on at once at print start, but only after the label has been feed for a certain period. This delay causes the label to run under the pad more easily, as it is not immediately sucked in and thereby slowed down.

Value range: 0 ... 5000 ms

Step size: 10 ms

Default: 0 ms

Press the key  to move to the next parameter.

Vacuum delay Off

The vacuum is not switched off at once when the lower end position is reached, but only after the label has been pressed for a certain period. This delay ensures that the label does not move underneath the pad during stamping.

Value range: 0 ... 5000 ms

Step size: 10 ms

Default: 0 ms

Press the key  to move to the next parameter.

Support delay On

The supporting air from the blow tube is not at once switched on at print start but only if the label has covered a distance.

This delay helps to prevent a turning or swinging at the front of the label and consequently avoids faults when the label is being picked up from printing system.

Value range: 0 ... 2500 ms

Step size: 0 ms

Default: 0 ms

Press the key  to move to the next parameter.

Support delay Off

Delayed to the process of the label being picked up, the supporting air is switched off.

In many cases, after being picked up by the pad the label edge may still stick on the liner. This may affect the accuracy of the label positioning or even cause faults in the labelling. Therefore, switching off the air blow delayed can be useful to separate the label from liner and neatly place the label on the surface of pad.

Value range: 0 ... 2500 ms

Step size: 10 ms

Default: 500 ms

Pressure control

Press the key  to move to the next parameter.

With activated compressed air control, with help from a compressed air sensor it is checked at each labelling cycle if the compressed air fits with the valve block. If no compressed air is presented, the labelling cycle is stopped, and the error message 'compressed air' is displayed.

If the parameter 'pressure control' is set to Off, the error treatment as described above will not be effected. This can be especially helpful for the initial operation of the labelling system.

For standard operation, set the parameter to On.

Press the key  to move to the next parameter.

Vacuum control

The label transfer from printing system to applicator is controlled by a vacuum sensor. If the transfer of label fails, the sucking holes on the pad will not be covered by the label and therefore no vacuum can originate on the pad. Afterwards an error message appears, and the label strip will be fed back.

If the parameter 'vacuum control' is set to Off, the error treatment as described above will not be effected. This can be especially helpful during adjustments, because the immediate backfeed will be cancelled and therefore it is easier to check the reasons for the faulty transfer.

For standard operation, set the parameter to On.

Press the key  to move to the next parameter.

Pressure time

This parameter is only active if the operating mode "stamp on" is selected. The time period can be adjusted while the pad is kept in the labelling position for applying the label onto the goods.

Press the key  to move to the next parameter.

Blow time

This parameter is only active if the operating mode "blow on" is selected. The time can be adjusted, while the blowing air is switched on for transferring the label onto product.

Value range: 0 to 2500 ms

Step size: 10 ms

Default: 100 ms

Press the key  to move to the next parameter.

Waiting position**NOTICE**

This parameter is only active if the operating mode "blow on" and mode 'apply-print' are selected.

Waiting position up:

In cyclic mode the pad with the printed label waits in the labelling position near the dispensing edge of printing system for the external start signal.

Waiting position down:

In cyclic mode the printed label is transported to the labelling position at the end of a cycle.

So the next cycle begin with blowing up the label.

	Press the key  to move to the next parameter.
Roll on time	This parameter is only active if the operating mode "blow on" is selected. The time can be adjusted while the roll-on pad is stopped in labelling position. Value range: 0 ... 5000 ms Step size: 10 ms Default: 0 ms
	Press the key  to move to the next parameter.
Cleaning time	This parameter is only active if the operating mode "blow on" and "roll on" are selected. The time can be adjusted for the cleaning period of pad after application procedure. Value range: 0 ... 2500 ms Step size: 10 ms Default: 100 ms (No error message is triggered, and the printing system waits until the pad has achieved the corresponding limit position)
	Press the key  to move to the next parameter.
Stroke timeout	Moving up and down of pad. If the pad does not reach the corresponding final position within the set time, then an error message appears ('final position above' at moving up and/or 'final position below' at moving down). Value range: 0 ... 5000 ms Step size: 10 ms Default: 0 ms
	Press the key  to move to the next parameter.
Delay lower end position	The reaching of the lower end position within the labelling cycle is not checked at once after the start of the downward movement, but only when the pad has moved downwards for a certain time. This ignores a mistaken release of the lower end position (e.g. by inertia of the pad). Value range: 0 ... 1000 ms Step size: 10 ms Default: 0 ms
	Press the key  to move to the next parameter.
Quick-Apply delay	Only with available option quick-apply: With this function, the travel speed of the cylinder may be reduced before it hits the product. The time until the delay begins may be set. The exhaust throttle (bottom) on the cylinder must be opened completely for this (see page 33). Value range: 0 ... 2500 ms Step size: 10 ms Default: 0 ms

	Press the key  to move to the next parameter.
Transverse axis	Only with available option transverse axis: This function allows you to set if the pad makes a transversal movement before the upwards movement, and/or accordingly after the upwards movement back into the print position. If the parameter 'transverse axis' is set to On, in each case a transverse movement takes place. At setting Off, no transversal movement takes place, and the application procedure begins in the print position.
	Press the key  to move to the next parameter.
Labelling signal	If printing and applying of the label are to separately be released, a separate signal for applying the label can be activated (port 4, start applying). Off: No labelling signal is used, i.e. after printing the label and takeover onto the pad, the applying procedure begins at once. Print position: After printing the label and takeover onto the pad, the printer waits in print position for the labelling signal. Labelling position: After printing the label and takeover onto the pad, the pad makes a transversal movement into the labelling position. There the printer waits for the labelling signal. With applicators without transversal axis, this setting is identical with the setting 'print position'.
	Press the key  to move to the next parameter.
Applicator release	The behaviour of the applicator when switching on the printer is set. Off: After the printer is switched on, the applicator is moved to the initial position without confirmation in the initialization phase. On: After the printer is switched on, the applicator is only moved to the initial position in the initialization phase after the release has been shown on the display.
	Press the key  to move to the next parameter.
Setting of switching threshold for vacuum control	Vac = Vacuum valve On: Vacuum valve is switched On Off: Vacuum valve is switched Off V = Vacuum setting range Value range: 0 ... 255 Step size: 5 Default: 0 InputV = Tamp control 0 – Label is not detected on the tamp 1 – Label is detected on the tamp

	Press the key  to move to the next parameter.
Setting of switching threshold for pressure control	<p>P = Setting range Pressure Value range: 0 ... 255 Step size: 5 Default: 0</p> <p>InputP = Pressure control 0 – Pressure below the set pressure 1 – Pressure above the set pressure</p>
	Press the key  to move to the next parameter.
Test functions	Stroke adjust The arrester can be adjusted, and the stroke speed can be set. The pad makes a stroke movement and returns again to the basic position after reaching the lower end position.
	Press the key  to start the stroke movement.
	Press the key  to move to the next parameter.
Input/Output	This menu serves for the applicator setup as well as for error tracing. Input signals of the applicator can be monitored, and output signals can be set or reset separately. Press the keys  and  to select the corresponding output for set/reset the output signals. Press the keys  and  to set/reset the corresponding output.
	Input signals
	<p>I₁ = Pre-dispense key 1 = key pressed 0 = key not pressed</p> <p>I₂ = Final position up 1 = pad in final position up 0 = pad not in final position up</p> <p>I₃ = Final position down 1 = pad in final position down 0 = pad not in final position down</p> <p>I₄ = Compressed air 1 = compressed air available 0 = no compressed air available</p> <p>I₅ = Vacuum 1 = vacuum at pad available 0 = no vacuum at pad available</p> <p>I₆ = Final position right 1 = pad in final position right 0 = pad not in final position right</p> <p>I₇ = Final position left 1 = pad in final position left 0 = pad not in final position left</p>

Output signal

O₁ = Move pad downwards
1 = On
0 = Off

O₂ = Move pad upwards
1 = On
0 = Off

O₃ = Transverse right
1 = On
0 = Off

O₄ = Transverse left
1 = On
0 = Off

O₅ = Blowing air
1 = On
0 = Off

O₆ = Supporting air
1 = On
0 = Off

O₇ = Vacuum
1 = On
0 = Off

8 Signal Diagrams

8.1 Print – Apply (w/o transverse axis)

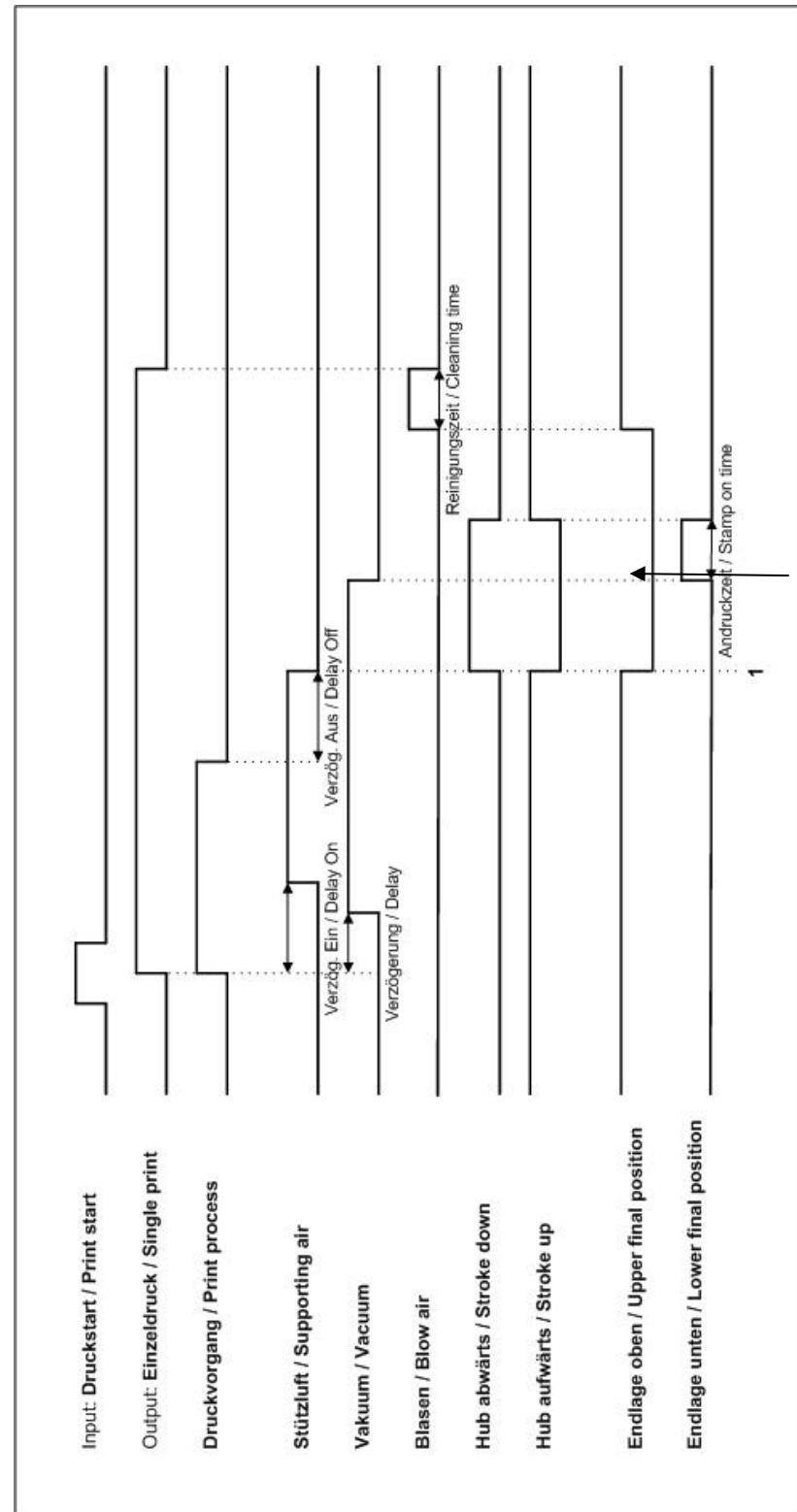
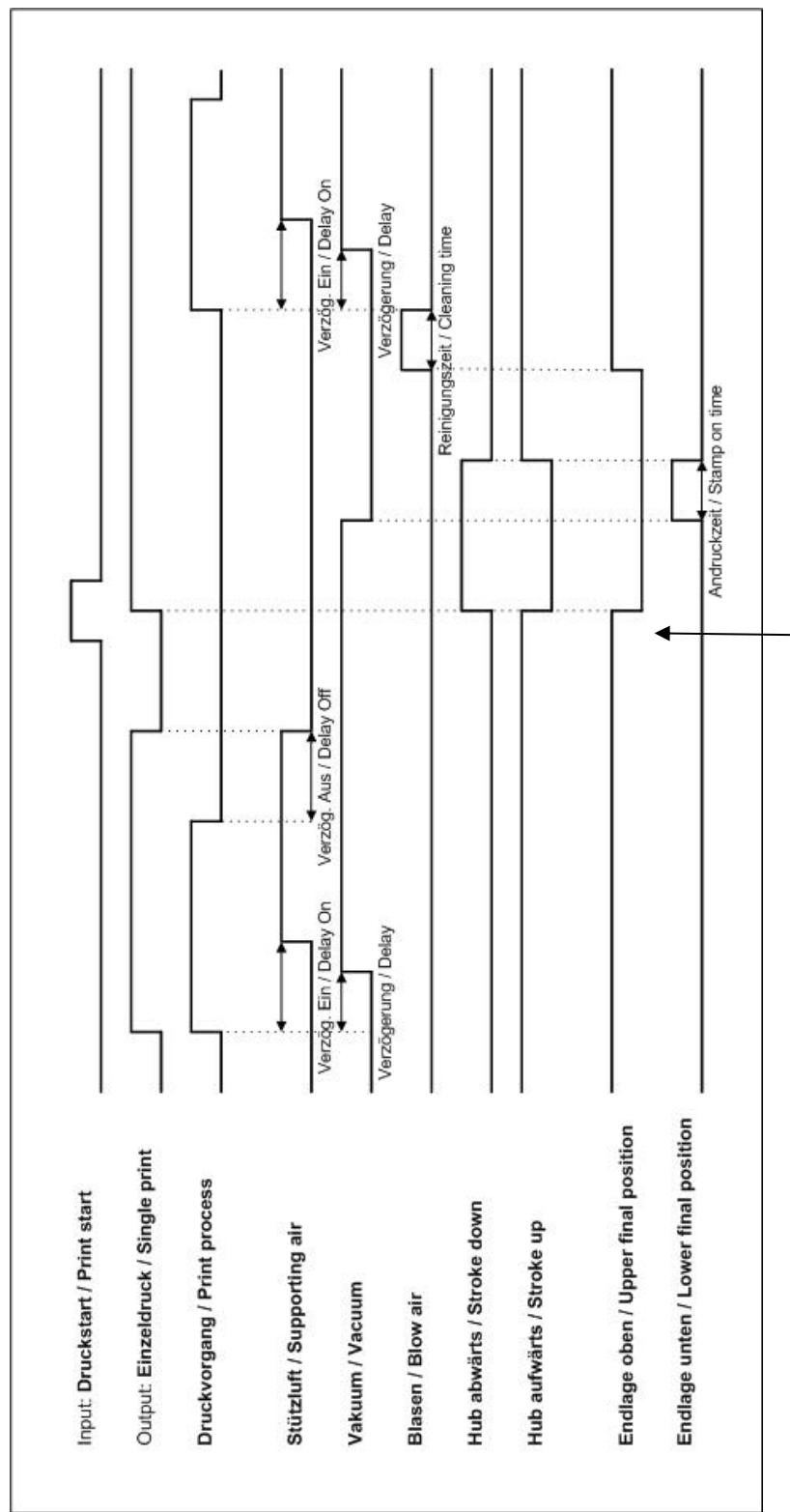


Figure 29

At labelling signal = print position/labelling position, the printer waits here in the print position (identical with the labelling position) for the signal 'applying start' before the label is applied.

8.2 Apply – Print (w/o transverse axis)



At labelling signal = print position/labeling position, the printer waits here in the print position (identical with the labelling position) for the signal 'applying start' before the label is applied.

Figure 30

9 Mechanical Adjustments



NOTICE!

Before starting with the mechanical adjustments, remove the plexiglass cover (D) by loosening four screws.

Perform the mechanical adjustments in two steps.

- ⇒ Roughly align the pad in all directions to avoid collisions of the pad with other parts when switching on the compressed air.
- ⇒ Perform the fine adjustment with compressed air switched on to optimize the labelling process.

9.1 Align the Pad

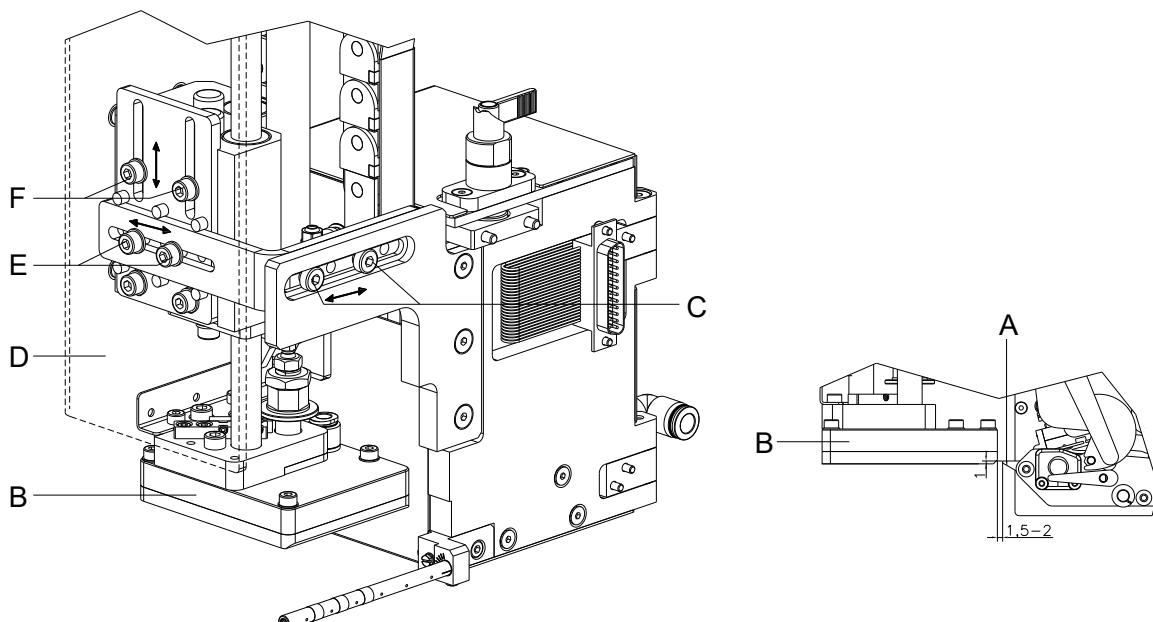


Figure 31

Adjustment in print direction

1. Loosen the screw (E).
2. Shift the cylinder unit including the pad (B) inside the elongated hole in such a way, that the distance between the pad and the dispensing edge (A) is about 2 mm.
3. Tighten the screw (E).

Height adjustment

1. Loosen the screw (F).
2. Shift the cylinder including the pad (B) inside the elongated hole in such a way that the lower rear edge of the pad (4) is found about 1 mm below the dispensing edge (A) of the printing system.
3. Tighten the screw (F).

Side adjustment

1. Loosen the screw (C).
2. Shift the cylinder unit including the pad (B) inside the elongated hole in such a way, that the dispensed label is aligned centrally to the pad respectively to the open holes in a universal pad.
3. Tighten the screw (C).

**NOTICE!**

Check the adjustment with switching compressed air.

9.2 Adjust the Parallelism between Pad and Dispensing Edge

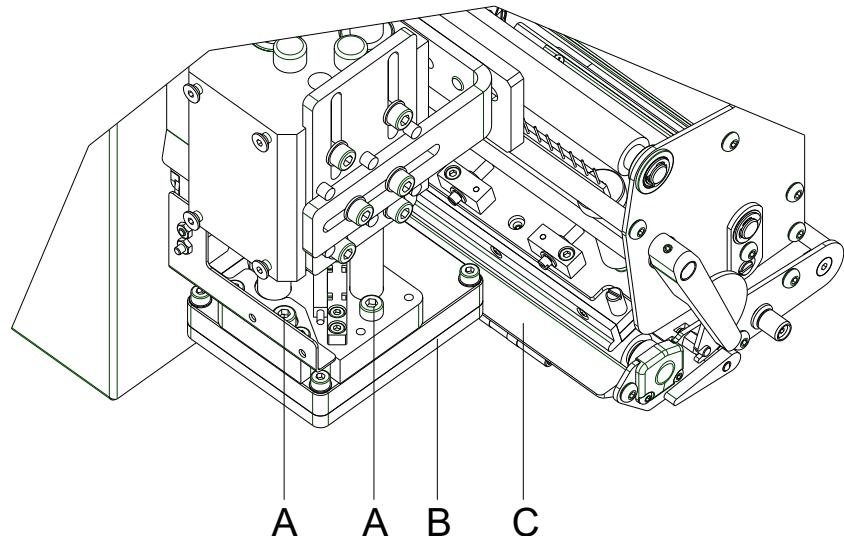


Figure 32

1. Loosen the cylinder screws (A).
2. Align the pad (B) parallel to the dispenser edge (C) by turning it slightly.
3. Tighten the cylinder screws (A).

9.3 Open the Holes on the Blow Tube

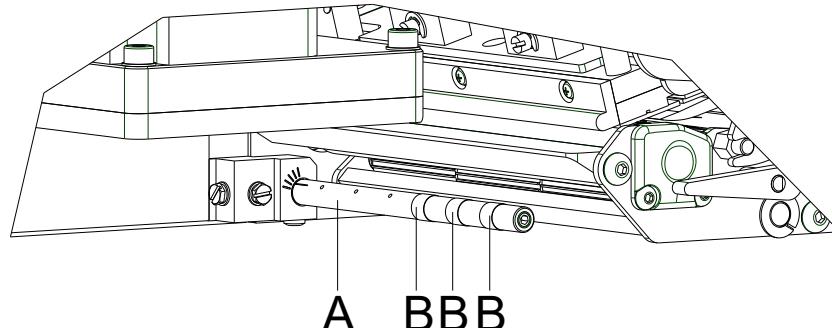


Figure 33

1. The blow tube (A) has holes for the supporting air in regular distances of 14 mm.
2. When the applicator is delivered only the two inner holes are open. The other holes are closed by plastic rings (B).
3. To adjust the supporting air to the label width, the plastic rings (B) can be removed from the holes.
4. Open all holes, which affect certainly the area of the label.

9.4 Align the Blow Tube

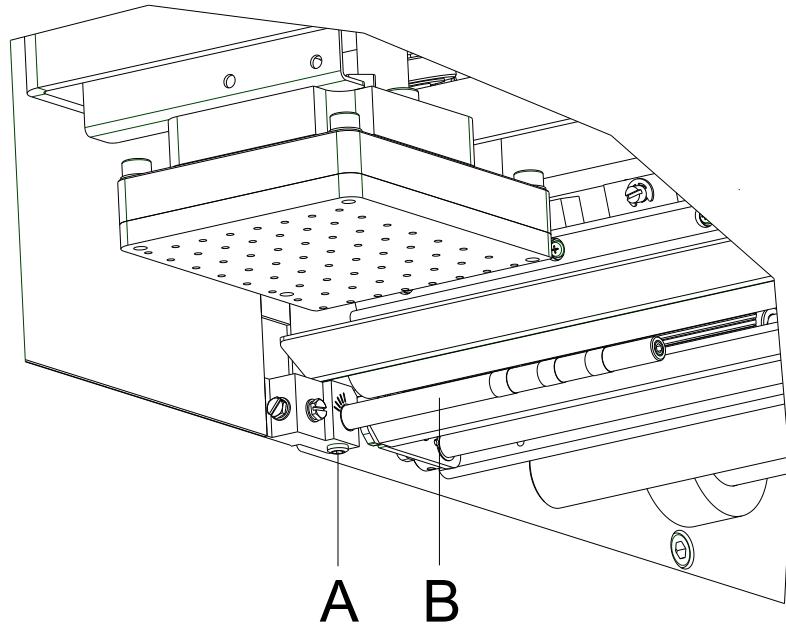


Figure 34

The blow tube (B) for the supporting air can be rotated around its axis. That way the direction of the supporting air can be improved.

1. Loosen the screw (A).
2. Turn the blow tube (B) in the direction that the air current supports the sucking of the label by the pad.

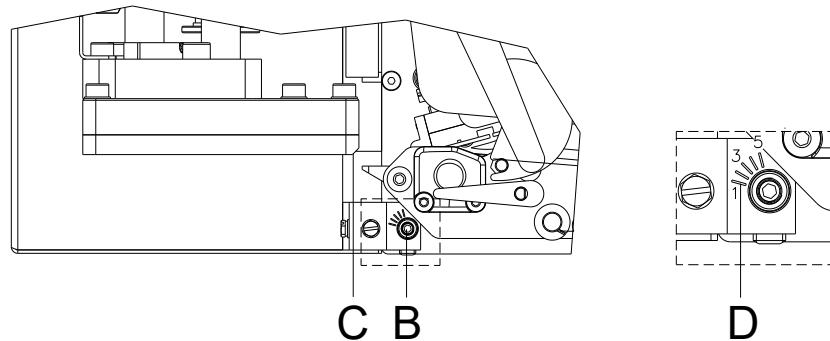


Figure 35

3. For small labels direct the air current to the dispensing edge (C) of the printing system (setting 3 or 4 at the scale (D)).
4. For larger labels direct the air current away from the dispensing edge (C / setting 1).
5. Tighten the screw (A).

9.5 Adjust the Stopper



NOTICE!

The description for adjusting the stopper is only relevant for the "blow on" operating mode.

The stopper is not needed in the operating modes "stamp on" and "roll on". It may not limit the pad movement (see next page).

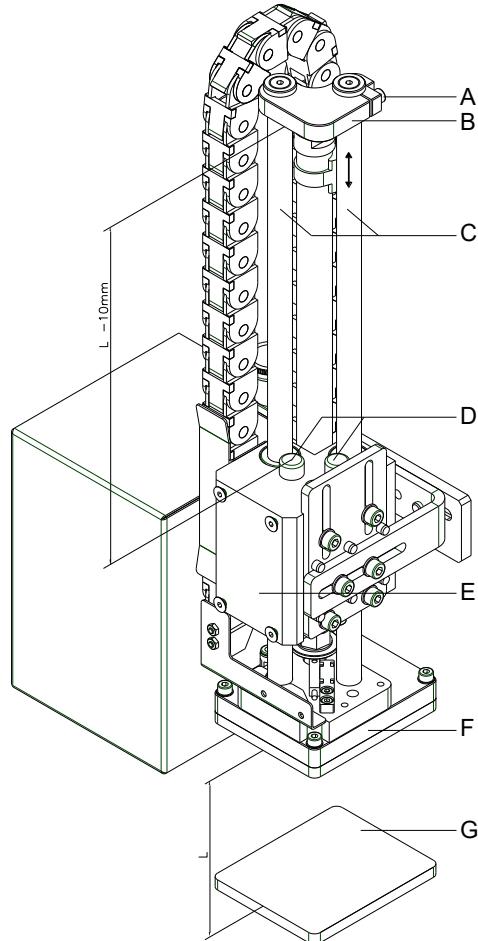


Figure 36



CAUTION!

Moving parts are accessible when using the applicator. Especially in the area in which the pad is moved between the basic and the labelling position.

There is a risk of injury due to the movement of the pad downwards and back up again.

- ⇒ Before accessing this area, switch off the power supply and the compressed air supply.
- ⇒ Keep hair, loose clothing, and items of jewellery out of this area.
- ⇒ Turn off the compressed air supply before accessing this area.

**NOTICE!**

When delivered, a stopper (B) is attached to the guiding rods (C).

Operating mode***Blow on***

In the "*blow on*" operating mode, the stopper is used to limit the downward movement of the pad to set a fixed labelling position.

1. Place sample (G) of the product to be labelled at the labelling position.
2. Measure the distance between the pad bottom edge (F) and the product top edge (G) (distance = L).
3. Loosen the cylinder screw (A) in the stopper (B).
4. Push the stopper (B) against the housing (E) and set a distance between the underside of the stopper (B) and the rubber buffer (D) of L-10 mm.
5. Push the stopper (B) against the housing (E) and tighten the cylinder screw (A).

Operating modes***Stamp on and******Roll on***

The stopper is not needed in the operating modes "*stamp on*" and "*roll on*". The stopper may not limit the pad movement.

1. Loosen the screw (A) in the stopper (B).
2. Push the stopper (B) upwards as far as possible and tighten the screw (A).

10 Pneumatic Adjustments

10.1 Control Valves



NOTICE!

For adjustments of certain applicator functions, release the control valves in the pneumatic system.
The control valves are accessible only with dismounted protective covers for the electronics and cylinder.

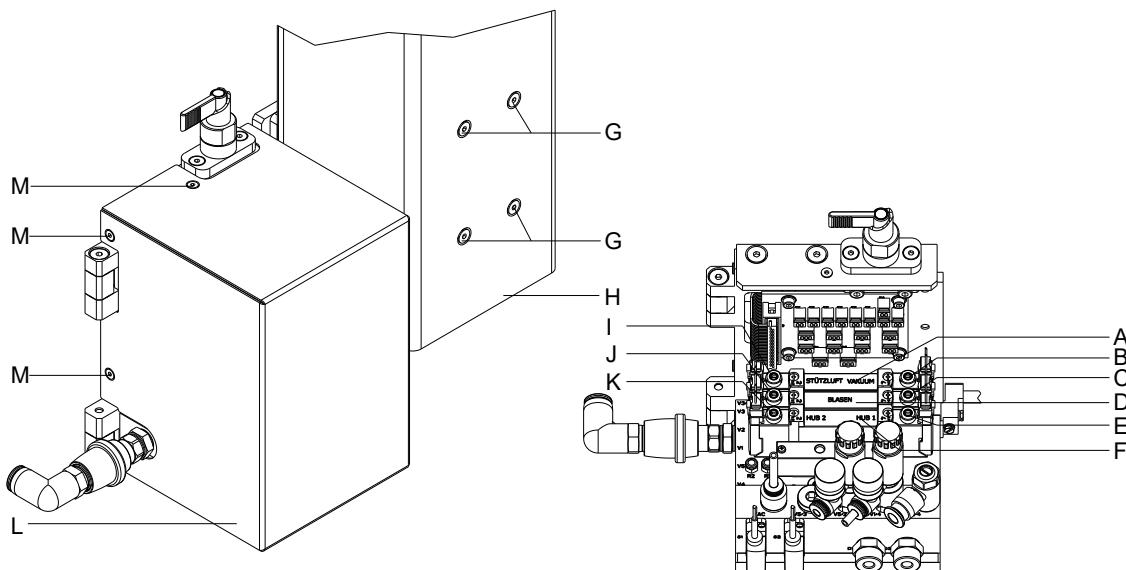


Figure 37

1. Loosen the screws (M) and remove the cover (L) of the pneumatic unit.
2. The compressed air control valves can be controlled manually with the integrated switch.

3-way valve (F) to control the lift cylinder

If the printing system is switched on the valve will be controlled by electronics and the tamp will hold in the upper end position (home position). If the valve switched the tamp will move in the lower end position (labelling position).

In normal labelling operation the movement back in the upper end position will start by a signal from labelling sensor.



NOTICE!

The switching by hand of this valve has only a result in case of a switched off printing system.

Switching the valve by hand over switch (E) the tamp will move down up to the lowest possible position because no control is made by the sensor.

Switching the valve by hand over switch (K) the tamp will move up.

Double 2-way valve (D) for blow air	<p>In the operation mode "blow on" the label will blow up to the product.</p> <p>In the operating modes "stamp on" and "roll on" the blow air is switched on for a short time after each application to avoid contaminations within the vacuum channels.</p> <p>For all described functions both valves will be controlled parallel.</p> <p>By pressing the switch (C or J), the blowing air is only switched on by one of both internal valves.</p>
Double 2-way valve (A) for vacuum / supporting air	<p>The two internal valves serve the vacuum nozzle for connecting an in this way for creating the negative pressure at the tamp and independent of this for connecting the support air at the blow tube for the label transfer.</p> <p>The vacuum can be set with the throttling back valve (H, see chapter 10.3).</p> <p>By pressing the switch (I) the supporting air is switched on and by pressing the switch (B) the vacuum is switched on.</p>

2-way valve (A) for option 'Quick Apply'

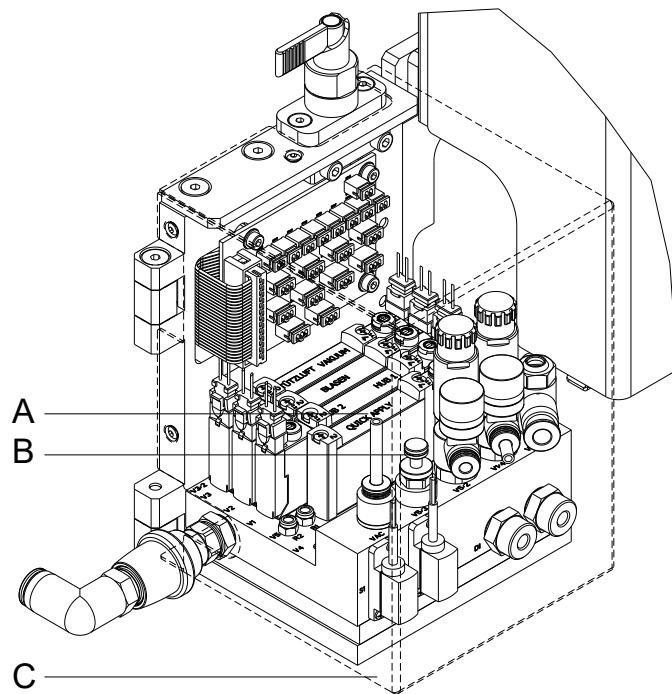


Figure 38

Turn the adjusting screw (B) to set the absorption of solenoid valve (A).

In the "quick apply" menu of the printing system, set the desired delay for valve activation in ms.

10.2 Adjust the Pad Movement Speed

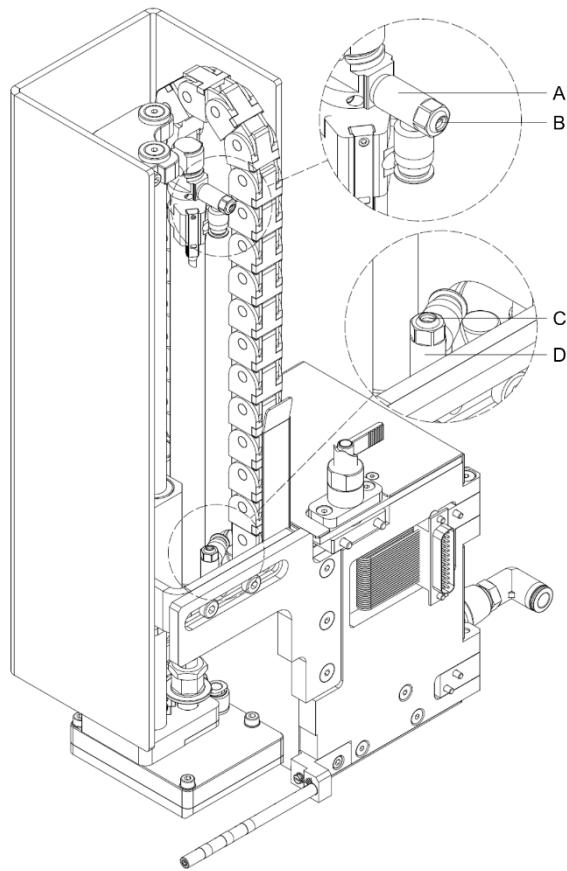


Figure 39

The adjustment of pad movement speed can be regulated with two throttle valves (A, D).

- ⇒ Adjust the pad movement speed as necessary.
- ⇒ To increase the downward speed, turn the screw (C) at the lower valve (D) anticlockwise.
- ⇒ To increase the upward speed, turn the screw (B) at the upper valve (A) anticlockwise.



NOTICE!

The application pressure of the pad is mainly dependent on the downward speed of the pad.

- ⇒ To reduce the application pressure, turn screw (C) in clockwise direction.



CAUTION!

A too high decrease of the downward speed leads to an error message (Error 101 - Lower position).

- ⇒ The downward movement may not need more time as specified in the menu *Timeout Hub* (see page 42).

10.3 Adjust the Vacuum and Supporting Air

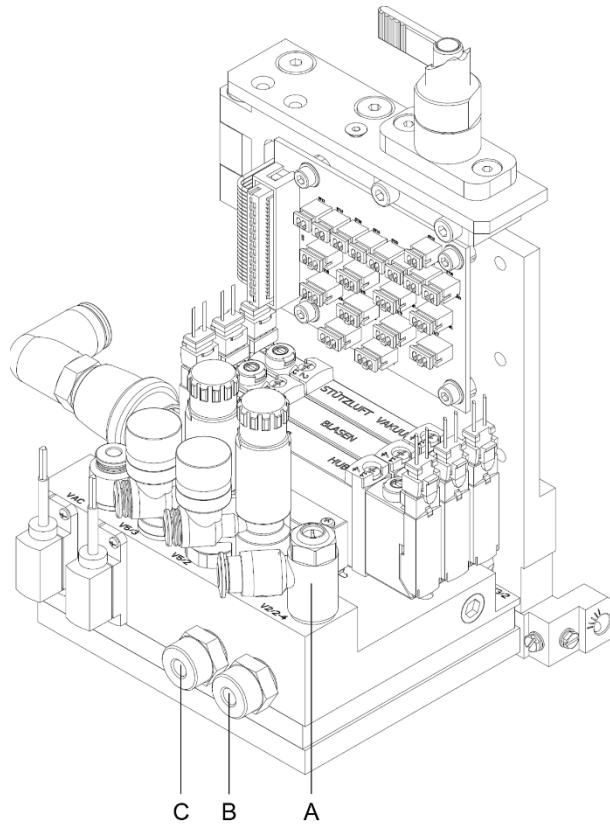


Figure 40

Adjust the supporting air

With the valve (C) the supporting air for blowing the label to the pad can be varied.

- ⇒ Adjust the supporting air in such way that the label is blown on the pad without swirling.
- ⇒ To increase the supporting air, turn the screw at the valve (C) anticlockwise.
- ⇒ If necessary adjust the direction of the air current (see chapter 9.4, page 52).

Adjust the vacuum



NOTICE!

With the vacuum setting the final position of the label on the pad can be adjusted. If the vacuum is too high the label feeding may early be stopped.

With the valve (B) the vacuum for sucking the label to the pad can be varied.

- ⇒ Adjust the vacuum in such way that the label is correctly sucked.
- ⇒ To increase the vacuum, turn the screw at the valve (B) anticlockwise.

Adjusting the blowing air

With the valve (A) the blowing air for blowing off the label from pad can be varied.

- ⇒ Adjust the blowing air in such way that the label is safely blown off and adheres at the product.
- ⇒ To increase the blowing air, turn the screw at the valve (A) anticlockwise.

11 Operation

11.1 Load Labels and Transfer Ribbon



NOTICE!

In dispensing mode, the labels are removed after printing, and only the liner is wound up internally.
For detailed information about inserting the material please read the operating manual of the printing system.

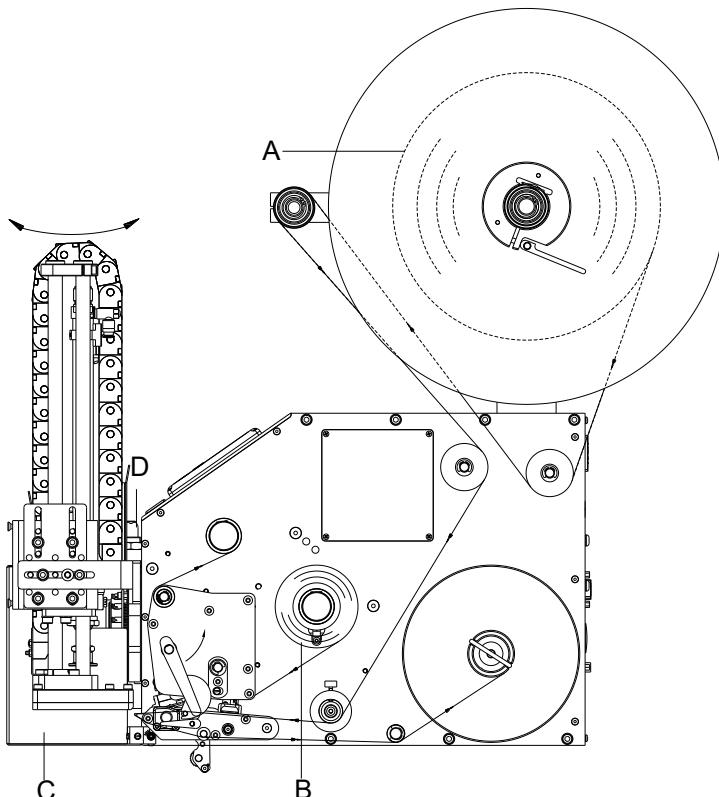


Figure 41



NOTICE!

For better accessibility, the applicator must be pivoted before inserting the labels and the transfer ribbon.

1. Turn the locking pin (D) by 180° and swing out the applicator.
2. Insert the transfer ribbon (B) in the printing system.
3. Insert the label material (A) in the printing system.
4. Swing in the applicator and turn back the locking pin (D) by 180°.



CAUTION!

Collision between the pad and the locking system during the labelling procedure.

⇒ Swivel the locking system on the rewind assistant roller.

11.2 Set the Dispenser Mode



NOTICE!

To operate the printing system in dispenser mode a print order must be started, and the printing system is to be in 'waiting' mode.

Switch on the printing system and the display shows the main menu.

Press the key to access the function menu.

Press the key until the menu *Dispenser I/O* is displayed.

Press the key to select the menu.

In the upper line of display, the operating mode can be selected.

In the line below, the dispenser I/O offset (approx. 24 mm) can be set.

Press the key to move to the next operating mode.

Operating modes

Off:

It is printed without the labels are dispensed.

I/O static:

The input signal evaluated, i.e. it is printed as long as the signal exists. The number of labels which was entered at the print start is printed.

The set dispenser offset is not taken into consideration.

I/O static continuous:

For description of this operating mode, see I/O static.

Continuous means that it is printed as long as new data is transferred via interface

The set dispenser offset is not taken into consideration.

I/O dynamic:

The external signal is evaluated dynamically, i.e. is the printing system in 'waiting' mode a single label is printed at each signal changing.

After the print the set dispenser offset is executed, i.e. a backfeed is effected.

I/O dynamic continuous:

For description of this operating mode, see I/O dynamic.

Continuous means that it is printed as long as new data is transferred via interface.

Photocell:

The printing system is controlled via photocell. The printing system prints automatically a label if the user takes away the label at the dispensing ledge. The print order is finished when the target number of labels is reached.

Photocell continuous:

For description of this operating mode, see Photocell.

Continuous means that it is printed as long as new data is transferred via interface.

11.3 Standard Operation

1. Check all external connections (see chapter 0, page 31).
2. Load the transfer ribbon and the label material (see chapter 11.1, page 61).

**NOTICE!**

Ensure that the locking system (4, Figure 41) is closed.

3. Open the shutoff valve.

**CAUTION!**

If the pad is covered the vacuum sensor may be calibrated faultily.

⇒ Before switching on the printing system-applicator system ensure that the pad is not covered.

4. Switch on the printing system.

**CAUTION!**

The printing system is factory-adjusted so that the applicator (during the printer switch On process) only moves to its home position when this process has been confirmed on the display.

⇒ Do not reach into the working area of the pad.

⇒ Keep hair, loose clothing, and items of jewellery out of this area.

⇒ Danger of striking by the moving rods. Do not reach or bend into the zone of the moving rods.

5. Press the key  at the printing system.

A synchronization feed is released. The processed labels must be removed manually. After a few seconds the printing system carries out a short backfeed to position the front edge of the next label at the printing line.

**NOTICE!**

This synchronizing also has to be carried out when the print job has been interrupted with the key .

Synchronizing is not necessary when the printhead was not lifted between print jobs. This also applies if the printing system was powered off between print jobs.

6. Start a print job.

12 Applicator Interface

Valves may be controlled, and limit position sensors may be prompted via different control inputs and outputs.

The control inputs and outputs are made available via a D-sub bushing (25 pins, female) on the front plate of the printing system and are NOT GALVANICALLY ISOLATED.

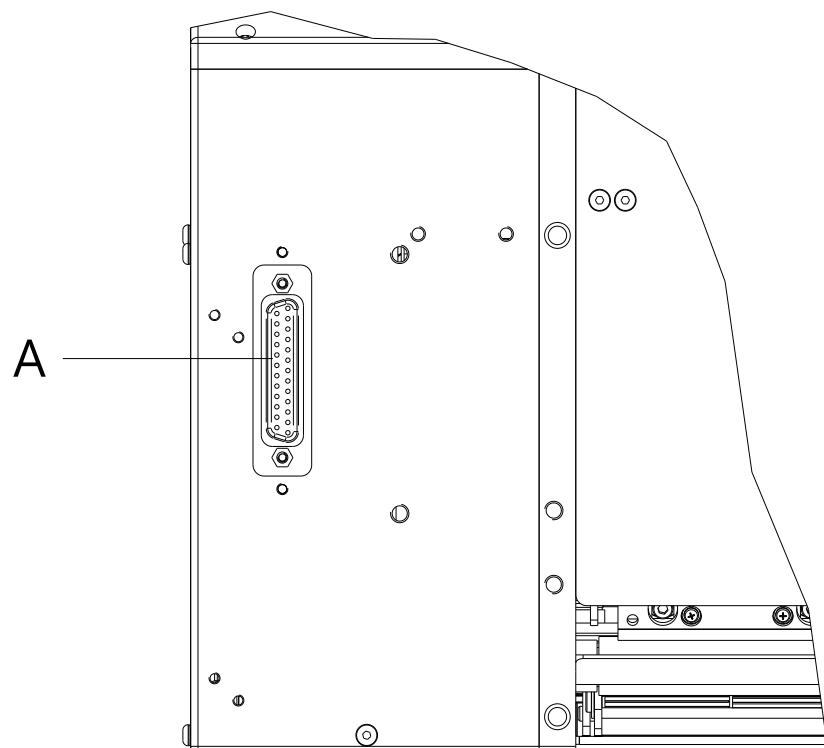


Figure 42

12.1 Printer internal circuitry

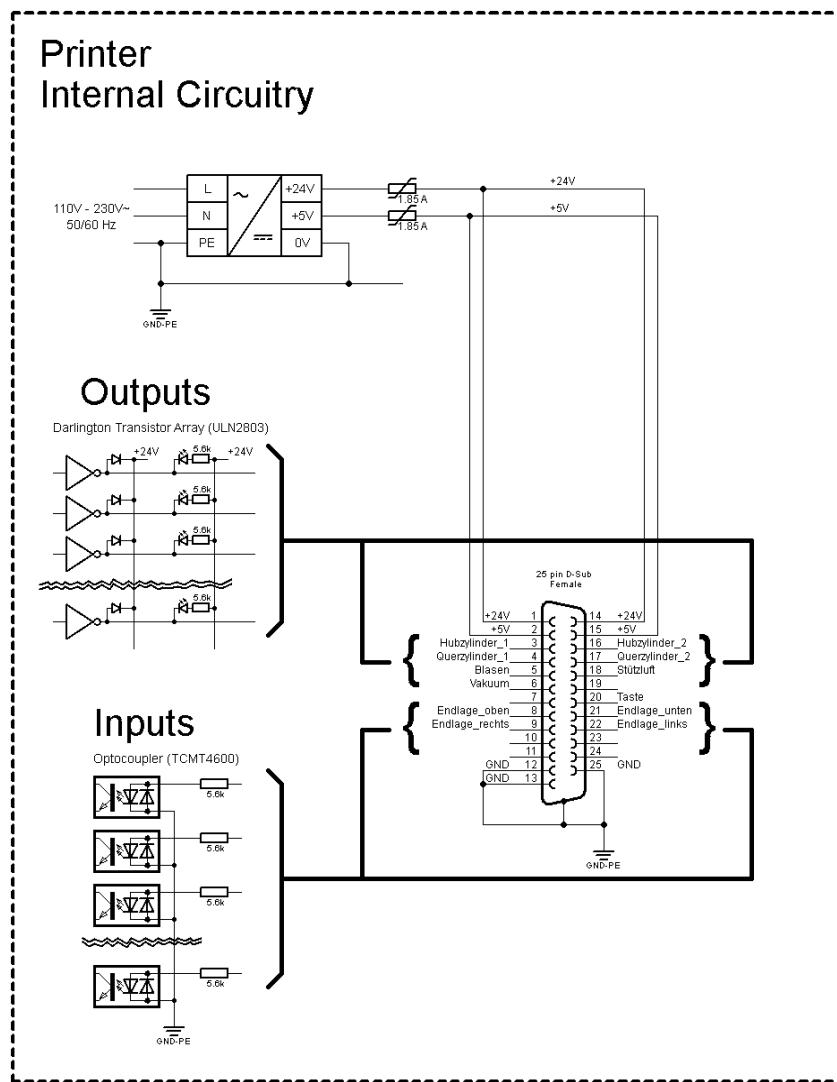


Figure 43

12.2 Pin assignment D-Sub bushing

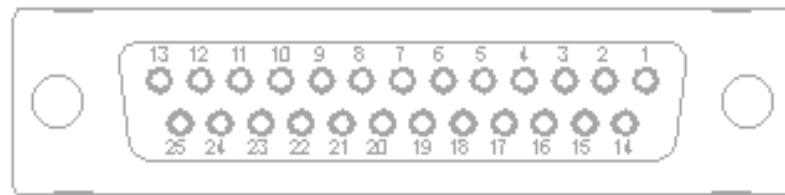


Figure 44

Signal assignment

Pin	Signal	Pin	Signal	Description / Function
1	24V	14	24V	24 Volt DC output for external use max 1 A.
2	5V	15	5V	5 Volt DC output for external use max 1 A.
3	Stroke cylinder 1	16	Stroke cylinder 2	Outputs (open Collector) 24 V / 0,1 A
4	Lateral cylinder 1*	17	Lateral cylinder 2*	
5	Blow on	18	Supporting air	
6	Vacuum	19		
7		20	Switch	Digital inputs 24 V
8	Top end position	21	Bottom end position	
9	Right end position	22	Left end position	
10		23	Vacuum control	
11	Pressure control	24		
12	GND	25	GND	GND-PE
13	GND			

* Option, on demand only

Technical data

Connection plug	
Type	D-Sub connector 25 pin / connector
Producer/distributor	MPE Garry / Schukat
Order no.	LPBL25RZM
Output voltage (connected with GND-PE)	
+ 24 V / 0.5 A*	Fuse: Polyswitch / 30 V / 1.85 A
+ 5 V / 0.5 A*	Fuse: Polyswitch / 30 V / 1.85 A
Digital outputs	
Driver	ULN2803A (open Collector)
Voltage	24 VDC
Current max	-0,1A
Impedance	Pull up 5,6 kΩ
Digital inputs	
Optocoupler	TCMT4600, CTR 80 % - 300 %
Voltage	24 VDC
Impedance	5,6 kΩ
Analogue inputs (optional, on demand only)	
OP	LMV393
Voltage	0.5 VDC
Impedance	>100 kΩ

* max. sum for all connected electric loads

12.3 Examples

Example 1

Device connection to a machine with S7-300 SPS.

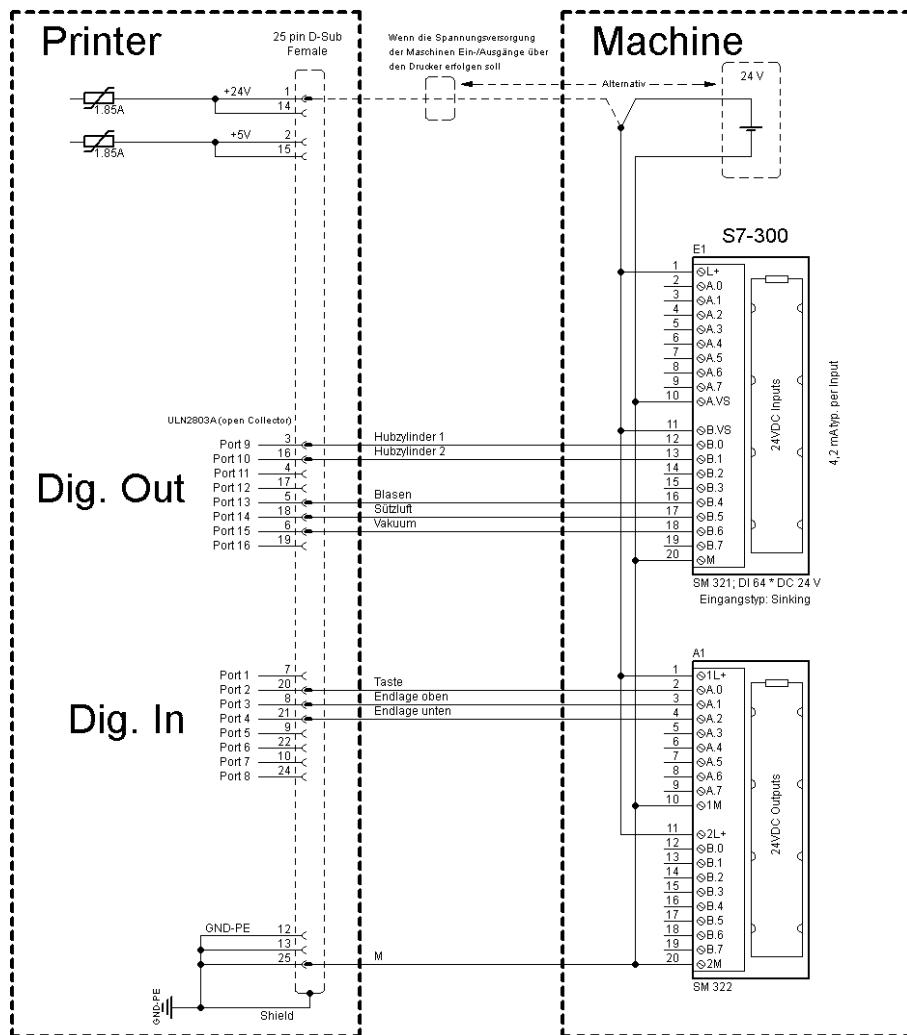
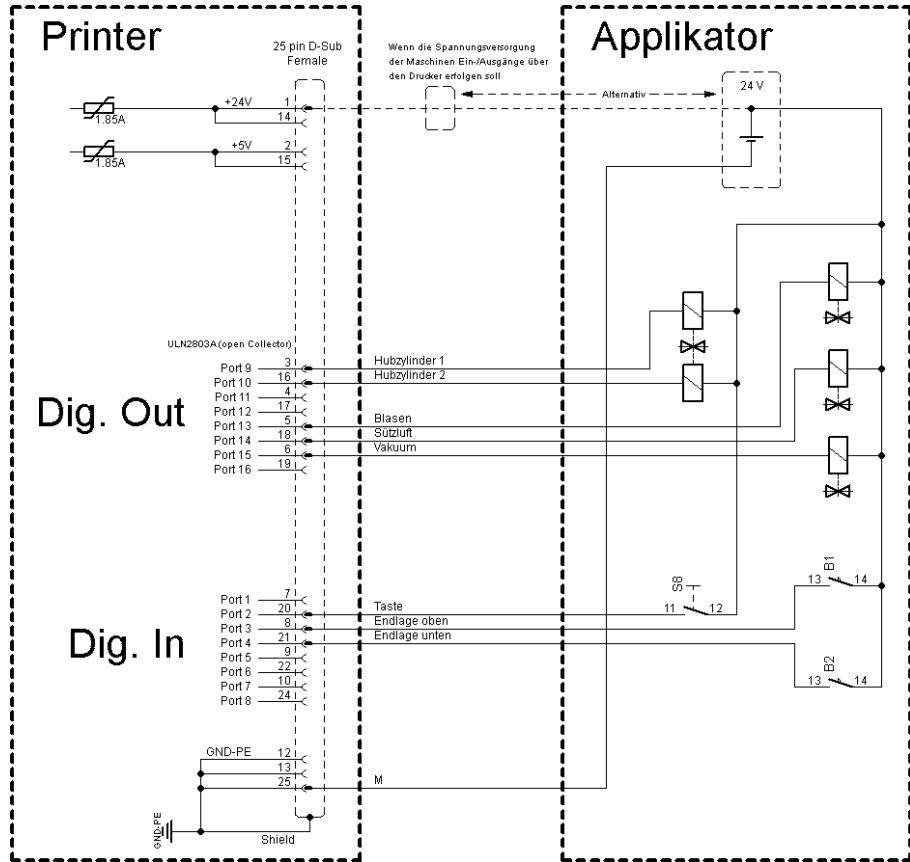


Figure 45

Example 2

Device connection to an applicator.

**Figure 46****12.4 Precautions**

When connecting a reed contact with a control input, the contact must have a switching capacity of min. 1 A to prevent the contact from sticking due to the inrush current. As an alternative, a suitable resistor can be connected in series.

If one of the printing system's internal voltages '+5 VDC EXT' or '+24 VDC EXT' is used, an external fuse e.g. 0.5 AF, should be additionally installed to protect the printing system electronics.

In case of an inductive load, an antiparallel connected diode, for instance, must be used to discharge the induction energy.

To minimise the influence of leakage currents at control outputs, a resistor must, depending on what is connected, be installed in parallel with the load.

To avoid any damages to the printing system, the max. output currents must not be exceeded, or outputs shorted.

13 Maintenance and Cleaning



CAUTION!

Risk of injury when cleaning.

⇒ Pay attention to sharp edges.

13.1 Tools

For Assemblies	Tools	Size
Cylinder plunger	Spanner wrench	5,0 mm
Throttling valves cylinder		8,0 mm
Throttling valve vacuum, blowing air		14,0 mm
L-connector, cam disk (valve block in service unit)		14,0 mm
Lift cylinder		24,0 mm
Valve block, energy track	Hexagon wrench	2,0 mm
PCB		2,5 mm
Adjustment guiding block		4,0 mm
Throttle valves	Screwdriver for slotted screws	2,5 mm
Valves on the valve block	Cross tip screwdriver	PH 0
Sensors (labelling sensor + sensor start position)		PH 2
Works at PCB	Wrist grounding	
Pressure measurement	Manometer	to approx. 5 bar
Cloth soft brush, multi-purpose cleaner (without solvent)		

13.2 Cleaning



CAUTION!

Abrasive cleaning agents can damage the applicator!

⇒ Do not use abrasives or solvents to clean the outer surface of the label printer.

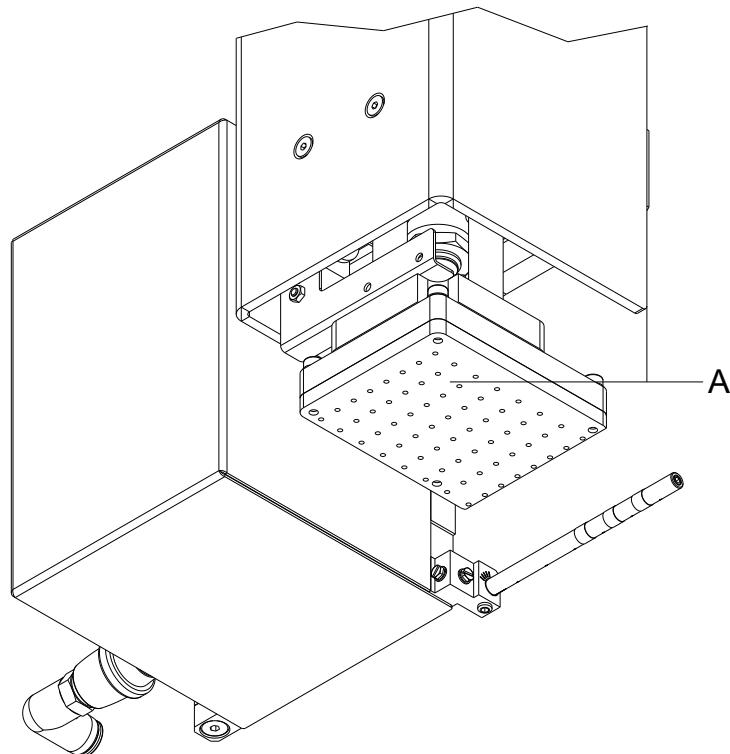


Figure 47

Clean the outside surfaces with multipurpose cleaner.

Remove dust particles and label splits with a soft brush or a vacuum cleaner.

The ideal takeover and handling of the label can be achieved by cleaning the surface of slide foil (A) at regular intervals.

14 Error Messages

14.1 Error Messages of the Printing System

In case an error occurred, the printing system stops and the print order is interrupted. Information to causes and remedies of printing system errors e.g. *no label found* are to be taken from the printing system manual.

1. Clear the error.
2. Press the key  to synchronize the label feed.
3. Remove the peeled labels manually.
4. Press the key  to quit the error state.
5. Press the key  to continue the print order or press the key  to cancel the print order.

14.2 Error Messages of the Applicator

Error message	Cause	Remedy
Upper position	The upper position (start position) was not reached.	Check the final position switch for the start position and the compressed-air supply. Adjust the stroke timeout.
Lower position	The lower position (labelling position) was not reached.	Check the final position switch for the labelling position and the compressed-air supply. Adjust the stroke timeout.
Empty vacuum plate	The sensor does not recognize a label at the vacuum plate.	Check if all holes of the pad plate are covered from the label. Check the compressed-air supply. Check if the switching threshold of the vacuum sensor is correctly adjusted (see chapter 14.3, page 74).
Compressed air	No compressed air is available.	Check the compressed air supply. Check if the switching threshold of the pressure sensor is correctly adjusted (see chapter 14.3, page 74).
Print position	At print start the pad is not in printing position (upper pad position).	Check the correct function and position of the final position switch for the upper position (start position). Check the pneumatic function.



CAUTION!

The printing system is factory-adjusted so that the applicator (during the printer switch On process) only moves to its home position when this process has been confirmed on the display.

- ⇒ Do not reach into the working area of the pad.
- ⇒ Keep hair, loose clothing, and items of jewellery out of this area.
- ⇒ Danger of striking by the moving rods. Do not reach or bend into the zone of the moving rods.

After error correction, the print of the label causing the error cannot be repeated without re-start of the print order.

Switch on the printing system and the display shows the main menu.

14.3 Troubleshooting pressure /vacuum control

Error: Empty vacuum plate

After verification that all holes in the pad plate are covered by the label and the pressure supply functions correctly, the switching threshold of vacuum sensor is to be set anew.

Press the key **F** to access the function menu.

Press the key **→** until the menu *Label applicator* is displayed.

Press the key **●** to select the menu.

Press the key **→** until the menu item shown below is reached.

ILX V 54/12		
Vac	V	InputV
Off	145	0

With the keys **▲** or **▼** set the the vacuum valve to On.

Place the label which is to be printed below the pad so that all suction holes are covered by the label. By the applied vacuum the label remains under the pad.

In case of correct operation, the *InputV* should stand for the value 1 (see display).

ILX V 54/12		
Vac	V	InputV
On	145	1

Otherwise, the switching threshold of the vacuum sensor must be set by the setting range of *VacuumV* so that the switching threshold changes from 0 to 1. For this, use the keys **◀** or **▶** to switch to the setting range of *VacuumV*. Use the keys **▲** and **▼** to increase or decrease the value.

Remove the label from the pad. The input value *InputV* should indicate the value 0. If a label is sucked again to the pad, the value should change to 1.

ILX V 54/12		
Vac	V	InputV
On	145	0

Switching limit InputV = 0

Vacuum is switched On
(Vac = 1)

The system recognizes that no
label is under the pad

ILX V 54/12		
Vac	V	InputV
On	145	1

Switching limit InputV = 1

Vacuum is switched On
(Vac = 1)

The system recognizes that a
label is under the pad

Error: Compressed air

After verification that the compressed air supply functions correctly, the switching threshold of the pressure sensor must be set.

Press the key  to access the function menu.

Press the key  until the menu *Label applicator* is displayed.

Press the key  to select the menu.

Press the key  until the menu item shown below is reached.

ILX V 54/12		
P	InputP	
100	0	

The air pressure is set to a minimum pressure of 2.5 bar. The input value *InputP* should now represent value 1 (see display).

ILX V 54/12		
P	InputP	
100	1	

Otherwise, the switching threshold of the pressure sensor must be set using the setting range *InputP* so that the switching threshold changes from 0 to 1. Use the keys  and  to increase or decrease the value.

The air pressure is set to < 2.5 bar. The input value *InputP* should now represent the value 0. If the air pressure is set to > 2.5 bar, the value should again change to 1.

ILX V 54/12

P	InputP
100	0

ILX V 54/12

P	InputP
100	1

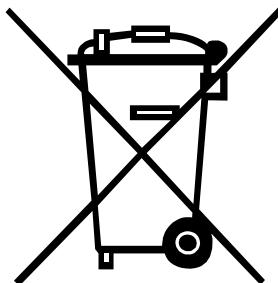
Switching limit pressure sensor
InputP = 0

The system recognizes that the minimum pressure of 2.5 bar is not set

Switching limit pressure sensor
InputP = 1

The system recognizes that the working pressure is \geq 2.5 bar

15 Environmentally Friendly Disposal



Manufacturers of B2B equipment are obliged to take back and dispose of old equipment that was manufactured after 13 August 2005. As a principle, this old equipment may not be delivered to communal collecting points. It may only be organised, used and disposed of by the manufacturer. Valentin products accordingly labelled can therefore be returned to Carl Valentin GmbH.

This way, you can be sure your old equipment will be disposed of correctly.

Carl Valentin GmbH thereby fulfils all obligations about prompt disposal of old equipment and facilitates the smooth reselling of these products. Please understand that we can only take back equipment that is sent free of carriage charges.

The electronics board of the printing system is equipped with a battery. This must only be discarded in battery collection containers or by public waste management authorities.

Further information on the WEEE directive is available on our website www.carl-valentin.de.

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