



Stroke-Turn Applicator

4214

Made in Germany

Family	Type
Stroke-Turn Applicator	4214L-200
	4214L-300
	4214L-400
	4214R-200
	4214R-300
	4214R-400

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Topicality

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1 Introduction

1.1 Instructions

Important information and instructions in this documentation are designated as follows:



Danger!

Draws attention to an exceptionally great, imminent danger to your health or life due to hazardous voltages.



Danger!

Draws attention to a danger with high risk which, if not avoided, may result in death or serious injury.



Warning!

Draws attention to a danger with medium risk which, if not avoided, may result in death or serious injury.



Caution!

Draws attention to a danger with low risk which, if not avoided, may result in minor or moderate injury.



Attention!

Draws attention to potential risks of property damage or loss of quality.



Note!

Advice to make work routine easier or on important steps to be carried out.



Environment!

Gives you tips on protecting the environment.



Handling instruction



Reference to section, position, illustration number or document.



Option (accessories, peripheral equipment, special fittings).

Time Information in the display.

1.2 Intended Use

- The device is manufactured in accordance with the current technological status and the recognized safety rules. However, danger to life and limb of the user or third parties and/or damage to the device and other tangible assets can arise during use.
- The device may only be used for its intended purpose and if it is in perfect working order, and it must be used with regard to safety and dangers as stated in the operating manual.
- The device applicator mounted on a cab printer of the Hermes+ series is intended exclusively for applying suitable materials that have been approved by the manufacturer. Any other use or use going beyond this shall be regarded as improper use. The manufacturer/supplier shall not be liable for damage resulting from unauthorized use; the user shall bear the risk alone.
- Usage for the intended purpose also includes complying with the operating manual, including the manufacturer's maintenance recommendations and specifications.



Note!

The complete and current version of the documentation can be found in the Internet.

1.3 Safety Instructions



Attention!

Initiation, adjustments and changing of parts are to be performed by qualified service personnel only.

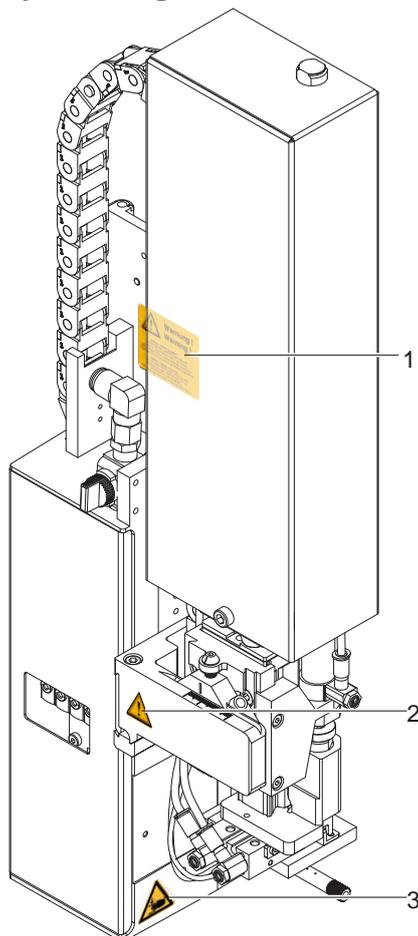


Warning!

This is a class A product. In a domestic environment this product may cause radio interference in which case the user may be required to take adequate measures.

- Before mounting the delivered components disconnect the printer from the power supply and close the shutoff valve of the applicator.
- Only connect the device to other devices which have a protective low voltage.
- Switch off all affected devices (computer, printer, accessories) before connecting or disconnecting.
- 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.
During operation do not reach into that zone and keep long hair, loose clothes, and jewelry away. Before any alterations are undertaken in those areas, close the compressed air shutoff valve.
- The device may only be used in a dry environment, do not expose it to moisture (water splashes, sprays and mist)
- Do not use the device in an explosive atmosphere.
- Do not use the device close to high-voltage power lines.
- Perform only those actions described in this service manual.
Work going beyond this may only be performed by trained personnel or service technicians.
- Unauthorized interference with electronic modules or their software can cause malfunctions.
- Other unauthorized work on, or modifications to the device can also endanger operational safety.
- Always have service work done by a qualified workshop, where the personnel have the technical knowledge and tools required to do the necessary work.
- There are various warning stickers on the device. They draw your attention to danger. Warning stickers may therefore not be removed.

1.4 Safety Marking



1:



Risk of injuries by moving parts!

2:



The cylinder is under pressure
also if the printer is switched off.
Possibility of residual energy!

3:



Danger of crushing hands and
fingers by the moving pad!



Attention!
Never remove or cover safety markings!
Replace it in case of damage!

Fig. 1 Safety marking

1.5 Environment



Obsolete devices contain valuable recyclable materials that should be sent for recycling.

- Send to suitable collection points, separately from residual waste.

The modular construction of the applicator enables it to be easily disassembled into its component parts.

- Send the parts for recycling.

2.1 Important Features

- 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.
- To avoid contamination within the vacuum channels they are cleaned by air pressure impulse at the end of each application.
- For operation in a system the I/O interface of the printer can be used.

2.2 Technical Data

Label transfer method		Tamp pad	Tamp pad with foam	Tamp pad with label stop	Blow pad
		4214 L/R 11 F	4214 L/R 12 F	4214 L/R 61 F	4214 L/R 2100
Label width in mm for Hermes+2		4 - 58	10 - 58	10 - 58	10 - 58
for Hermes+4		10 - 80	10 - 80	10 - 80	10 - 80
Label height in mm		4 - 40	4 - 40	4 - 40	10 - 40
Compressed air pressure		0,45 MPa (4,5 bar)			
Sound pressure level		unter 74 dB(A)			
Product during labeling	fixed	■	■	■	■
	in motion	-	-	-	■
Labeling onto the product	from the top	■	■	■	■
	from below	■	■	■	■
	sideways	■	■	■	■
Product height	fixed	-	-	-	■
	variable	■	■	■	-
Horizontal swing angle 90°, 180°, 0°		■	■	■	■
Product distance to lower edge at cylinder stroke	200 mm up to mm	135	135	135	140
	300 mm up to mm	235	235	235	240
	400 mm up to mm	335	335	335	340
Immersion depth pad F ²⁾	up to mm	65	65	65	-
Cycle time about frequency/min. ¹⁾		25	25	25	25

Table 1 Technical data

¹⁾ Determined at 100 mm stroke below device / smallest label height / print speed 100 mm/s.

²⁾ Immersion depth at applicator >25 mm, the cover of the Hermes+ must be modified.

2.3 Overview Without Cover

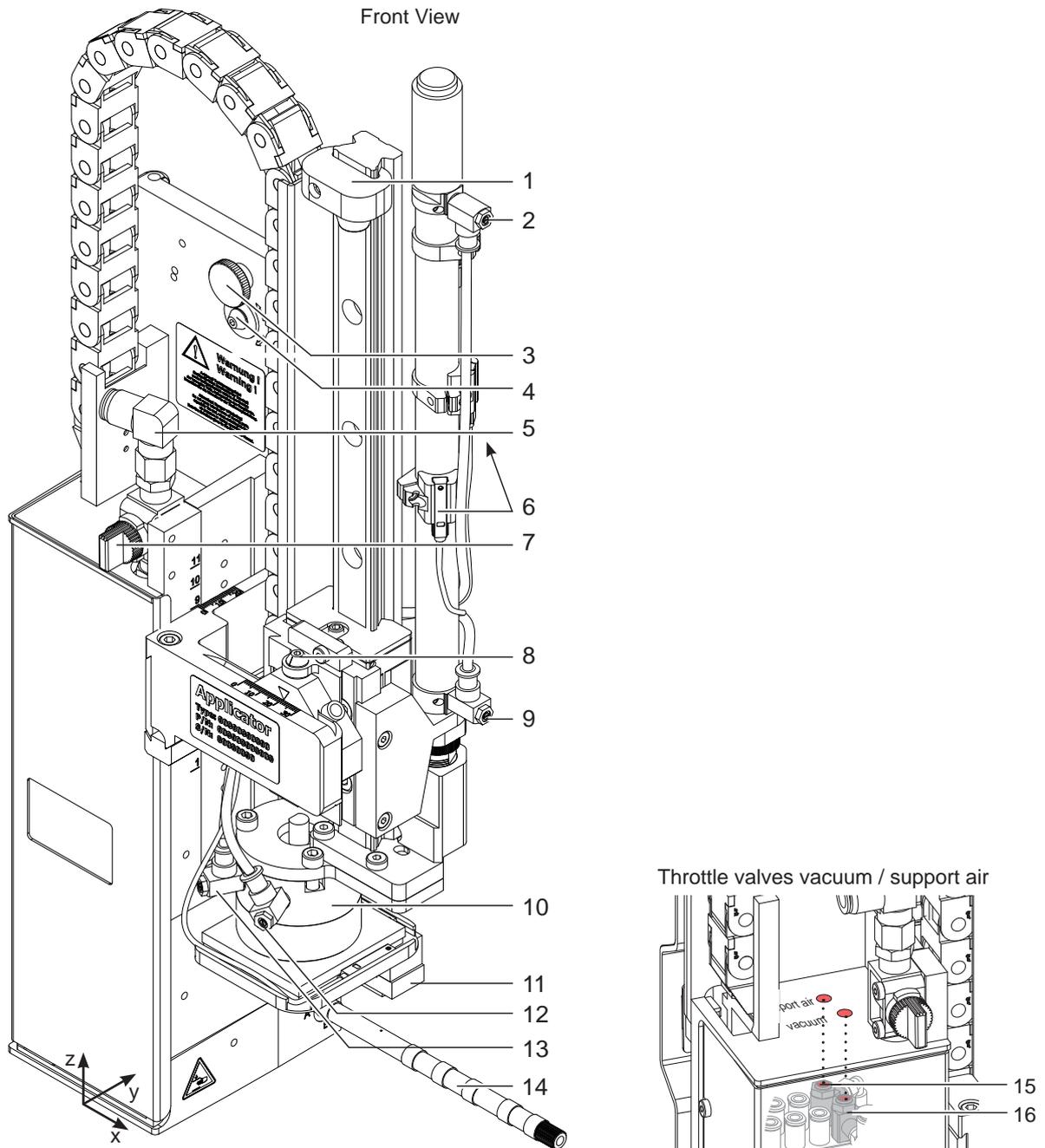


Fig. 2 Device overview - Front view

- | | |
|--|---|
| <ol style="list-style-type: none"> 1 Stopper for the operation mode "Blow on", transport lock 2 Throttle valve cylinder - move in Z-direction 3 Knurled screw for attaching the applicator to the printer 4 Setting screw to adjust the angle between applicator and printer 5 Compressed air connector 6 Sensors Middle Position Z-direction 7 Shutoff valve | <ol style="list-style-type: none"> 8 Setting screw for vertical adjustment cylinder assembly 9 Throttle valve cylinder - move out Z-direction 10 Cylinder R (Rotation) 11 Pad (customized) 12 Throttle valve cylinder R- move in 13 Throttle valve cylinder R- move out 14 Blow tube for supporting air 15 Support air throttle valve 16 Vacuum throttle valve |
|--|---|

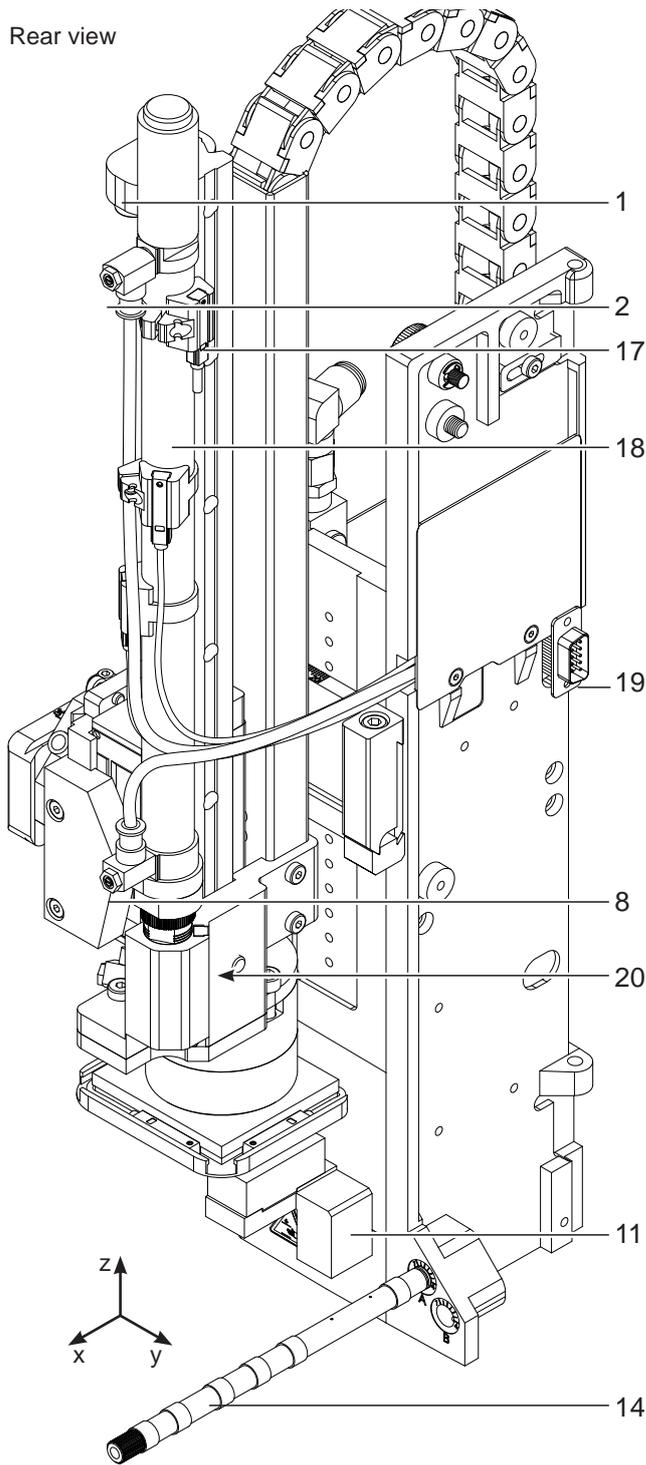


Fig. 3 Device overview - Rear view

- 1 Stopper for the operation mode "Blow on"/ transport lock
- 2 Throttle valve cylinder - move in Z-direction
- 8 Throttle valve cylinder - move out Z-direction
- 11 Pad (customized)
- 17 Sensor "start position" Cyl. Z
- 18 Cylinder Z
- 19 Interface to the printer
- 20 Sensor "end position" Cyl. Z

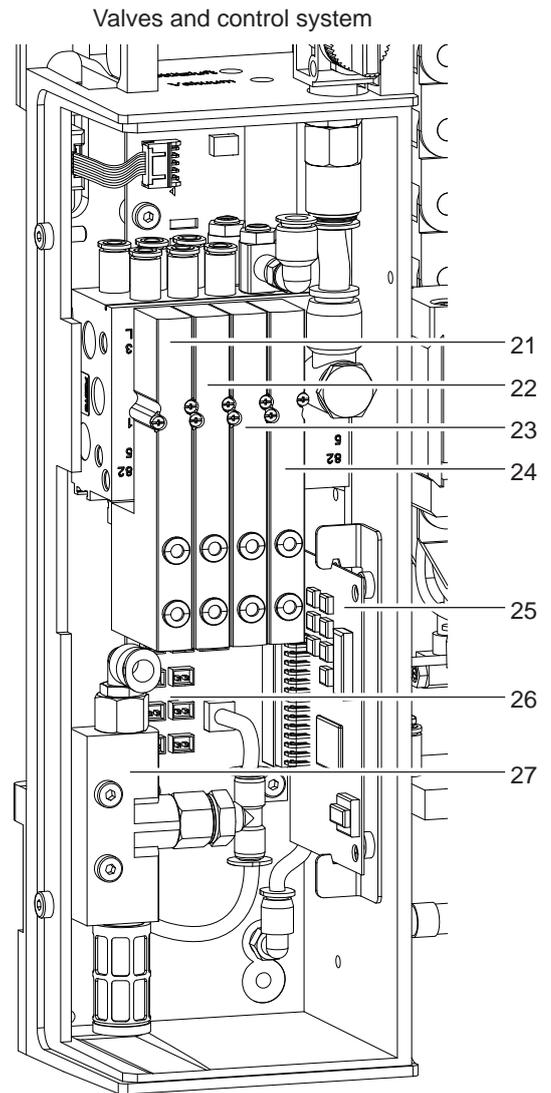
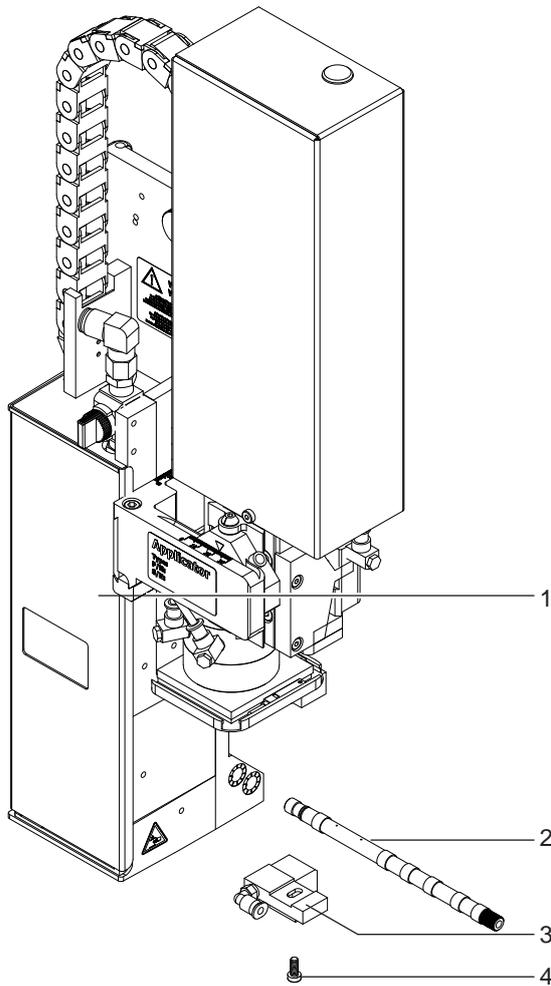


Fig. 4 Device overview - Control system

- 21 Valve Cylinder Z
- 22 Valve Cylinder R
- 23 Valve Blow air
- 24 Valve Vacuum and Support air
- 25 PCB Applicator Control
- 26 PCB Applicator Interfaces
- 27 Vacuum Generator

2.4 Contents of Delivery



- Applicator (1)
- Blow tube - as ordered (2)
- Pad - as ordered (3)
- Screws as part of the pad (4)
- Documentation

Fig. 5 Contents of delivery

**Note!**

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

**Attention!**

The device and printing materials will be damaged by moisture and wetness.

- ▶ Only set up label printer with applicator in dry locations protected from moisture and splashes.

3.1 Standard Operation

- ▶ Check all external connections.
- ▶ Load the material.
- ▶ Open the shutoff valve.



Attention!

- ▶ Ensure that the pad is not covered by a label when switching on the printer-applicator system. Otherwise the vacuum sensor may be calibrated incorrectly.

- ▶ Switch on the printer.



Note!

If the pad is not in the starting position when the printer is switched on an error message will appear on the display.

Press pause button on the printer.

The applicator will move into the start position and is ready for work.

- ▶ Press the **feed** button on the printer.
A synchronization feed is initiated. The processed labels have to be removed manually. After a few seconds the printer carries out a short backfeed to position the front edge of the next label at the printing line.



Note!

This synchronization also has to be carried out when the print job has been interrupted with the cancel button.

Synchronizing is not necessary when the print head was not lifted between print jobs. This also applies if the printer was powered off between print jobs.

- ▶ Start a print job.
- ▶ Start the labelling process via PLC interface.

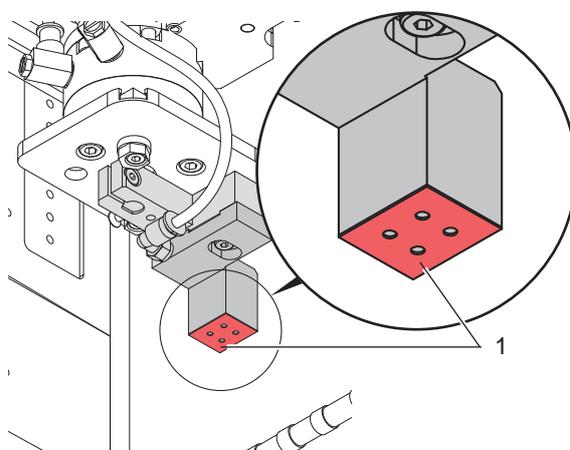
Error messages during labelling process are shown in the display of the printer ▷ Error Messages.

3.2 Cleaning



Attention!

Never use solvent and abrasive.



- ▶ Clean the outside surfaces with multi purpose cleaner.
- ▶ Remove dust particles and leftover label pieces with a soft brush and/or vacuum cleaner.
- ▶ The slide foil (1) requires regular cleaning as most of the dirt will accumulate here.

Fig. 6 Cleaning the pad

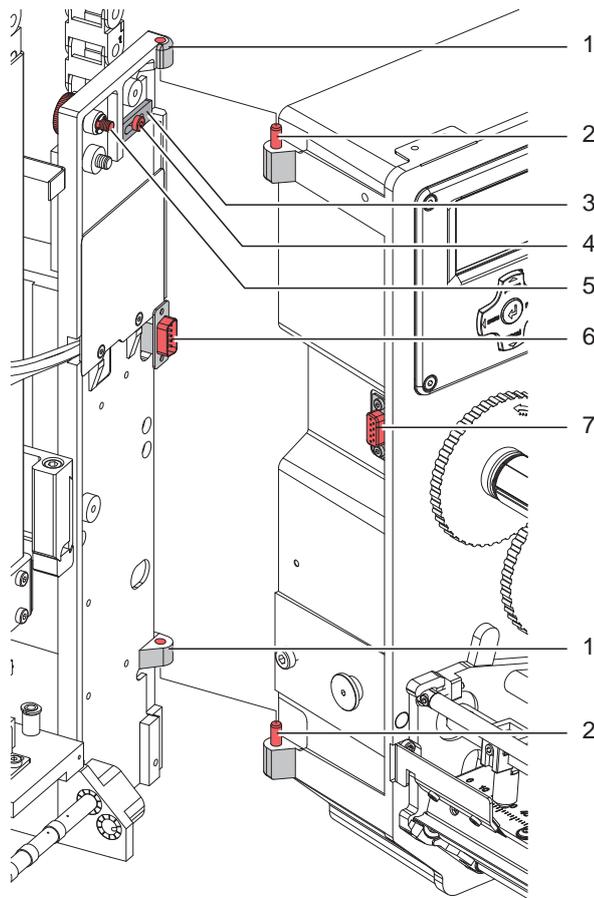


Fig. 7 Mounting the applicator to the printer



Attention!

- ▶ **Disconnect the printer from the power supply before mounting the applicator!**
- ▶ **Ensure a stable positioning of the printer!**
- ▶ **Connect the compressed air only after mounting the applicator to the printer!**

To clean the applicator and printer it is sometimes necessary to turn away or even dismount the applicator from the printer.

Take care not to adjust the setting screws, throttle valves or other alignment elements. This will enable use of the applicator directly after cleaning.

Turn Away / Dismount the applicator

1. Loosen thumbscrew (5) and swing the applicator away.
2. Disconnect SUB-D 15 male connector (6) from the female connector (7) of the printer.
3. Loosen screw (4) and remove the locking plate (3) from the hinges.
4. Lift the applicator from the hinges.

Mount the applicator

5. Hang on the applicator with the female parts (1) of hinges on the hinges parts (2) of the printer.
6. Connect the SUB-D 15 male connector (6) to the female connector (7) of the printer.
7. To secure the applicator against slipping out of hinges, loosen screw (4), move metal part (3) under the hinge and tighten screw (4).
8. Swing the applicator to the printer and tighten the thumbscrew (5).

3.3 Movement of the Pad

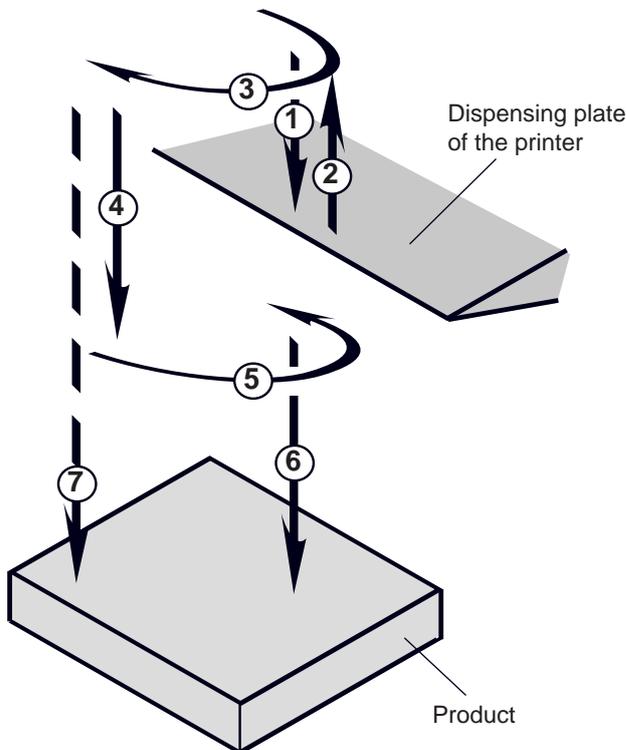
The applicator 4214 has different takeover modes. The position of the pad is also adjustable.

The base position of the pad will be described in > „7.1 Pad Adjustments“. The kind of takeover mode is dependant on the label size and material. The standard takeover procedure occurs without the intermediate steps of the "take over from above" application mode.

No	Movement of the pad	Label hand-over up, apply 0° swing	Label hand-over up, apply 90° swing	Label apply 0° swing *	Label apply 90° swing *
1	Pad moves to the dispensing plate of the printer (take up of the label)	X	X		
2	Pad departs from the dispensing plate of the printer	X	X		
3	Pad pivots out via the rotation cylinder	X	X	X	X
4	Pad moves to the intermediate position below the dispensing plate of the printer and stops	X		X	
5	Pad will pivot back via the rotation cylinder	X		X	
6	Pad moves to the product un-pivoted and applies the label	X		X	
7	Pad moves to the product pivoted and applies the label		X		X

* Takeover of the label via vacuum and support air with a set distance between the pad and dispensing plate.

Table 2 Phases of pad movement



Hand-over up switch on/off

Menu tree:

- Setup
 - > Machine param.
 - > Applicator
 - > Hand-over up
 - Off / On

Label swing out apply

This function will be controlled by the I/O interface of the printer.

The signal **EDR** on Pin 24 will be used to control this function.

> Operator's Manual of the printer

Fig. 8 Movement of the pad

4.1 Error Messages of the Printer

For detailed information about printer errors (e.g. 'Paper out', 'Ribbon out', etc.) ▷ Check the operator's manual of the printer.

Error treatment:

- ▶ Clearing the error results.
- ▶ Press the **feed** key to synchronize the label feed, remove the left over labels manually.
- ▶ Press the **pause** key to quit the error state.

After error correction, the label causing the error will be reprinted.

4.2 Error Messages of the Applicator

The following table contains an overview of applicator specific error messages and their possible causes. It also suggests methods to resolve the error states:

Error Message	Possible Cause
Air pressure ins.	Compressed air is switched off Pressure to low < 4 bar Pressure to high > 6 bar
Label not depos.	Label has not been placed onto the product; after the pad has moved back the label is still sticking to the pad.
Lower position	Pad has not reached the starting position within 2s after the pad has left the labelling position; or pad has left the starting position without authorization.
Process Error	Process of labeling was interrupted via the I/O interface of the printer with the STP signal.
Refl. sensor blk.	There has been no change of state of the upper sensor of the cylinder from the start of the labelling process and the signal of the labelling position sensor.
Upper position	Pad is not in the starting position when the printer was switched on. Pad has not reached the labelling position within 2s after the movement of the pad was started. Pad has left the printing position without authorization.
Vac. plate empty	Label has not been picked up properly by the pad; or label fell off the pad before it could be placed onto the product.

Table 3 Error messages of the applicator

Error treatment:

- ▶ Clear the error results.
- ▶ Press the **pause** key to quit the error state.



Note!

In the case of errors check the **Service Manual** for adjustments and settings.



Warning!

After the error has been resolved the pad will immediately move back to the starting position!

Danger of injury to hands and fingers by the moving pad!

- ▶ **Do not reach into the area of the moving pad and keep long hair, loose clothes, and jewelry away.**

After error correction, the printing of the label causing the error cannot be repeated without restarting the print job except the error "Vac. plate empty". In this case, the last label will be printed again after resolution via the **pause** key and then pressing the Enter button ↵.

- ▶ In the application mode "Apply/Print" sends the signal "Print first label" or press the button ↵ to send a printed label to the tamp.

5.1 Declaration of Incorporation



Declaration of Incorporation

We declare herewith that the following „partly completed machinery“ as a result of design, construction and the version put in circulation complies with the essential requirements of the **Directive 2006/42/EC on machinery**:

Annex I, Article 1.1.2, 1.1.3, 1.1.5, 1.1.6, 1.2.1, 1.3.2, 1.5.2, 1.5.8, 1.6.3, 1.7

In the event of any alteration which has not been approved by us being made to any device as designated below, this statement shall thereby be made invalid.

Device:	Stroke-Turn Applicator
Type:	4214
Applied EU Regulations:	Applied Standards:
Directive 2006/42/EC on machinery:	<ul style="list-style-type: none"> • EN ISO 12100:2010 • EN ISO 13849-1:2008 • EN 60950-1:2006 +A11:2009+A12:2011+A1:2010+A2:2013
Person authorised to compile the technical file:	Erwin Fascher Am Unterwege 18/20 99610 Sömmerda
Signed for, and on behalf of the Manufacturer:	Sömmerda, 01.03.2016
cab Produkttechnik Sömmerda Gesellschaft für Computer- und Automationsbausteine mbH 99610 Sömmerda	 Erwin Fascher Managing Director

The product must not be put into service until the final machinery into which it is to be incorporated has been declared in conformity with the provisions of the Directive on machinery.

The documents according annex VII part B from the incomplete machinery are created and will commit to state agencies on request in electronic kinds.

5.2 EU Declaration of Conformity



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Germany

EU Declaration of Conformity

We declare herewith that the following device as a result of design, construction and the version put in circulation complies with the relevant fundamental regulations of the EU Rules for Safety and Health. In the event of any alteration which has not been approved by us being made to any device as designated below, this statement shall thereby be made invalid.

Device:	Stroke-Turn Applicator
Type:	4214
Applied EU Regulations:	Applied Standards:
Directive 2014/30/EU relating to electromagnetic compatibility:	<ul style="list-style-type: none"> • EN 55022:2010 • EN 55024:2010 • EN 61000-6-2:2005
Directive 2011/65/EU on the restriction of the use of certain hazardous substances in electrical and electronic equipment	<ul style="list-style-type: none"> • EN 50581:2012
Signed for, and on behalf of the Manufacturer:	Sömmerda, 01.03.2016
cab Produkttechnik Sömmerda Gesellschaft für Computer- und Automationsbausteine mbH 99610 Sömmerda	 Erwin Fascher Managing Director

6.1 Factory default Settings



Note!

The applicator is adjusted in a standard configuration by the factory. Keeping these values guarantees a reliable operation with same within the same configuration. The values in the setup protocol are valid.

6.2 Tools

Screwdriver with parallel blade	2.5		<ul style="list-style-type: none"> To adjust the throttle valves and product sensor
Hexagon key L-wrench	0.8		<ul style="list-style-type: none"> To adjust the sensors (in contents of delivery)
	2.5		<ul style="list-style-type: none"> For matched norm parts (in contents of delivery)
	4		<ul style="list-style-type: none"> Pad adjustments Changing pad
Flat-round nose - straight - angled			<ul style="list-style-type: none"> To mount/dismount tubes
Open spanner	SW 8		<ul style="list-style-type: none"> To change the throttle valves
	SW 13		<ul style="list-style-type: none"> Setting the spring strength of the adapter bolt
	SW20		<ul style="list-style-type: none"> Changing the cylinder
Manometer	± 7 bar		<ul style="list-style-type: none"> Air pressure control

Table 4 Tools

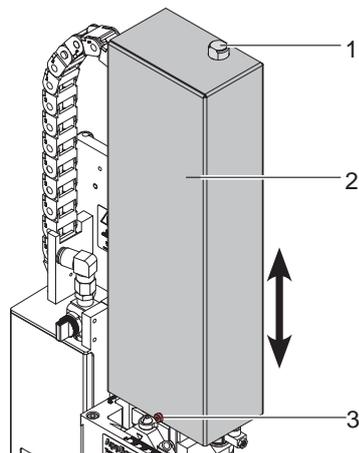
6.3 Mounting and Dismounting the Cover

To initiate the applicator or for adjustments it is necessary to dismount the cover (2). After these adjustments have been completed remount the cover.



Warning!

- ▶ Do not operate the applicator without cover (2).
- ▶ Dismount the cover only for service and/or adjustment purposes.



Dismount

1. Loosen screw (3).
2. Lift cover (2).

Mount

3. Move the cover (2) over the cylinder assembly.
4. Put in the cylinder (1) into the hole in the cover (2).
5. Tighten screw (3) to fix cover (2).

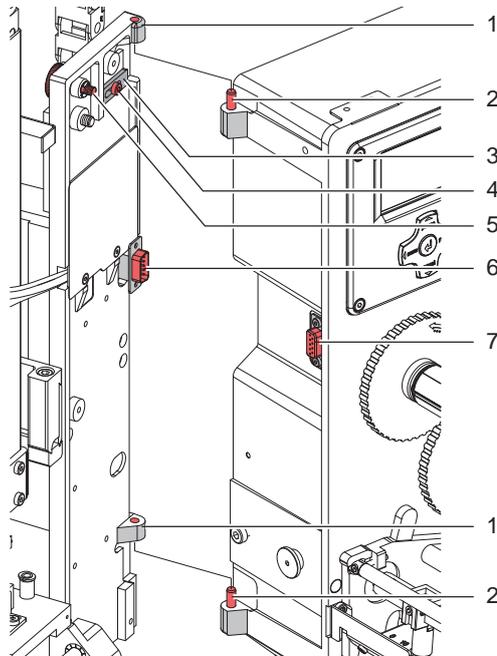
Fig. 9 Cover

6.4 Mounting the Applicator



Attention!

- ▶ Disconnect the printer from the power supply before mounting the applicator!
- ▶ Ensure the printer is standing in a stable position!
- ▶ Connect the compressed air only after mounting the applicator to the printer!



1. Hang the applicator to the printer via the female hinges (1) to the male hinges (2) of the printer.
2. Connect the SUB-D 15 male connector (6) to the female connector (7) of the printer.
3. To ensure the applicator does not slip out of the hinges, loosen screw (4), move the locking plate (3) to secure the applicator and tighten screw (4) again.
4. When pivoting the applicator onto the printer ensure that the cable is not caught between the two units.
5. Tighten the thumbscrew (5).
6. Raise the stopper on the rail to enable movement of the lifting cylinder. ▷ „6.5 Transportation Lock“

Fig. 10 Mounting the applicator on printer

6.5 Transportation Lock

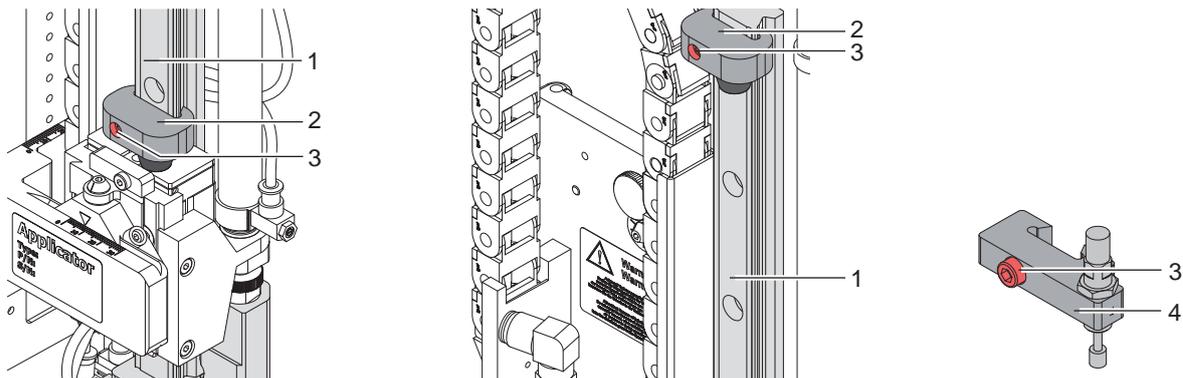


Fig. 11 Stopper as transportation lock

When the applicator is delivered, the stopper (2) is mounted on the rod (1). With this stopper (2) the labelling position for the operation mode "Blow on" can be adjusted. In delivery status the stopper (2) is used as transportation lock.



Note!

To reduce the impact energy it is possible to use a stopper with cushioning (4).

Releasing the transportation lock

1. Loosen screw (3) of the stopper (2).
2. Move the stopper (2) along the rod (1) into the position as in operation mode:
 - Operation mode "Blow on": ▷ „7.4 Adjustment of the Stopper for Blow Mode“
 - Operation mode "Stamp on" : Move the stopper (2) up to the end of the rod (1).
3. Tighten screw (3) to fix the stopper (2) in position.

6.6 Mounting the Pad

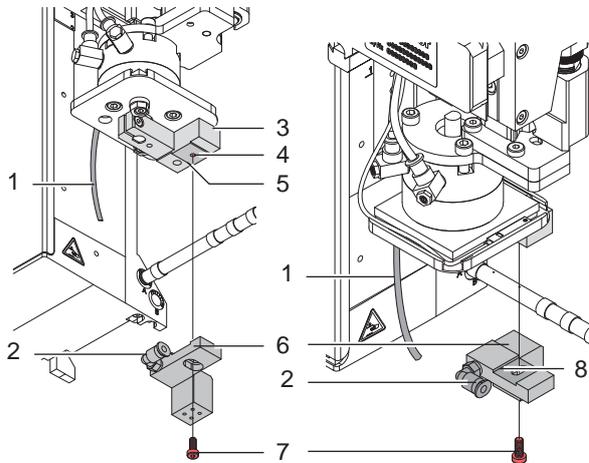


Fig. 12 Mounting the pad

1. Move the pad (6) with the cut-outs (8) along the guiding rail (5) to the bottom side of the pad holder (3).
2. Fix the pad with the screws (7) to the pad holder (3).
3. Insert the vacuum tube (1) into the appropriate connector (2) of the pad.

**Attention!**

- ▶ To avoid possible collisions of the pad with other parts of the printer-applicator system, please roughly align the pad in all directions (▶ „7 Adjustments“) before connecting the applicator to the compressed air supply!

6.7 Mounting the Blow Tube

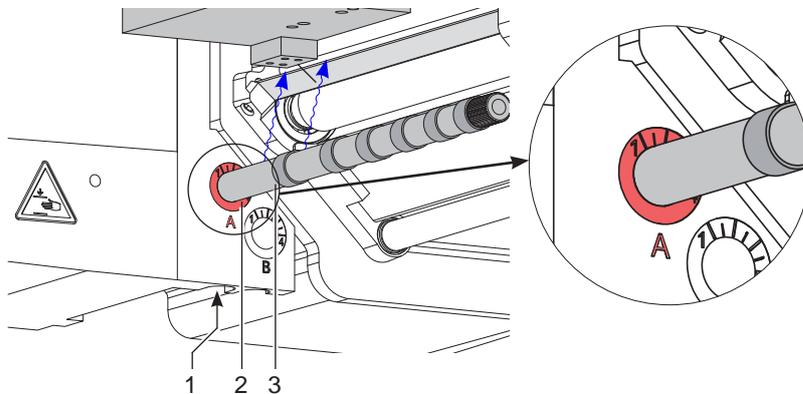


Fig. 13 Mounting the blow tube

It is possible to rotate the blow tube to optimize the direction of the support air for the take over procedure of the label from printer to applicator.

1. Loosen screw (1).
2. Put in the blow tube (3) into the hole A (2).
3. Tighten screw (1). ▶ „7.3 Adjusting the Blow Tube (Supporting Air)“

6.8 Connecting the Compressed Air



Attention!

Adjustments and functionality tests where done with a compressed air value of 4,5 bar. The applicator's operating range is between 4,0 and 6,0 bar.

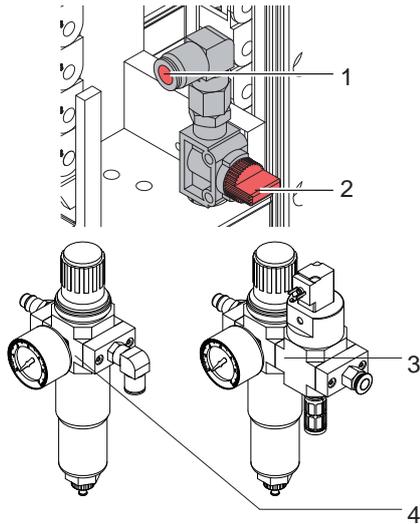


Warning!

Warning!

When connecting the applicator to compressed air it is considered "IN USE!" Cylinder motion is possible!

► Do not reach into the zone of the moving pad and keep long hair, loose clothes, and jewelry away.



1. Check that the stop valve (2) is closed as illustrated.
 2. Attach compressed air to connector (1).
 3. Open the stop valve (2) by turning it into the direction of air flow.
 4. Switch on the printer via the power switch.
- It is possible to use an air pressure regulation unit.

cab offers two versions of air pressure regulators.

- Air pressure regulation unit with included magnetic valve (3)
Controlling via printer
▷ Interface description of the printer
- Standard version (4)

Fig. 14 Compressed air connection



Note!

If the pad is not in the starting position when the printer is switched on an error message will appear on the display.

Press the pause button on the printer to cancel the error state. The applicator will move into the start position and is ready for work.



Note!

Only mount the air pressure regulation unit as illustrated otherwise the functionality of the air-water separator cannot be guaranteed.

7.1 Pad Adjustments

For optimal functionality it is necessary to place the pad exactly over the label for the takeover procedure.

Moving the Pad in X-, Y- and Z-Directions

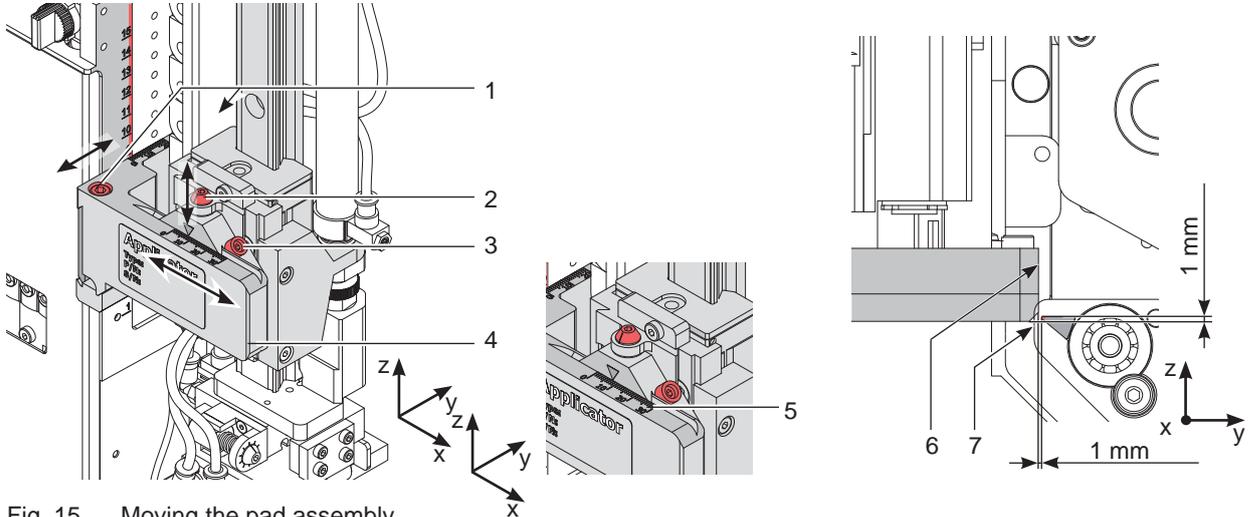


Fig. 15 Moving the pad assembly

Adjustment in the X-direction - Sideways Adjustment

1. Loosen screw (3).
2. Move the cylinder assembly group (4) including pad along the cross beam until the pad is over the middle of the label intended for application. For better orientation there is a graduation mark (5) depicted on the assembly group.
3. Tighten screw (3).

Adjustment in the Y-direction - Print Direction

1. Loosen screws (1).
2. Move cylinder assembly (4) including pad along the guide rail so that the distance between the edge of the pad (6) and the edge of the dispense plate (7) of the printer is approximately 1 mm.
3. Tighten screws (1).

Adjustment in Z-direction - Height Adjustment

1. Loosen screw (3).
2. Turn setting screw (2) so that the bottom of the pad is 1 mm over the top edge of the dispense plate (7).
3. Tighten screw (3).

Adjusting the Parallelism between Pad and Dispense Edge

The edge of the pad must be parallel to the dispense edge of the printer.

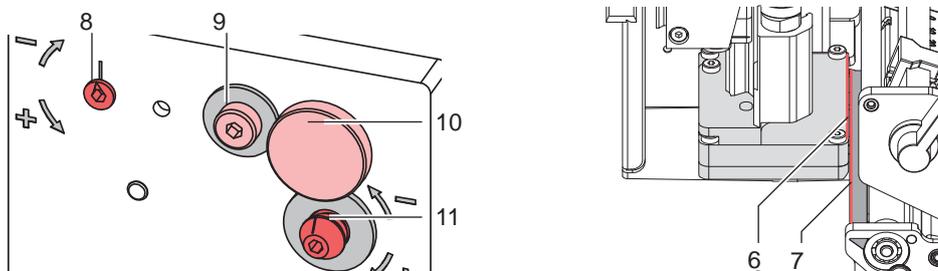


Fig. 16 Adjusting the pad to the dispense edge

1. Loosen knurled screw (10) and screw (9).
2. Press the applicator against the printer and adjust the angle between applicator pad edge (6) and printer dispensing plate (7) via the setting screw (11) and the eccentric (8).
3. Tighten screw (9) and fasten the applicator with knurled screw (10).

7.2 Vacuum Adjustments

The label will be held on the pad by a vacuum.

The vacuum needs to be set up in such a way that the label covers all the suction holes and is not hindered before it reaches its intended position on the pad.

The default Value of the Vacuum is -0.6 bar.

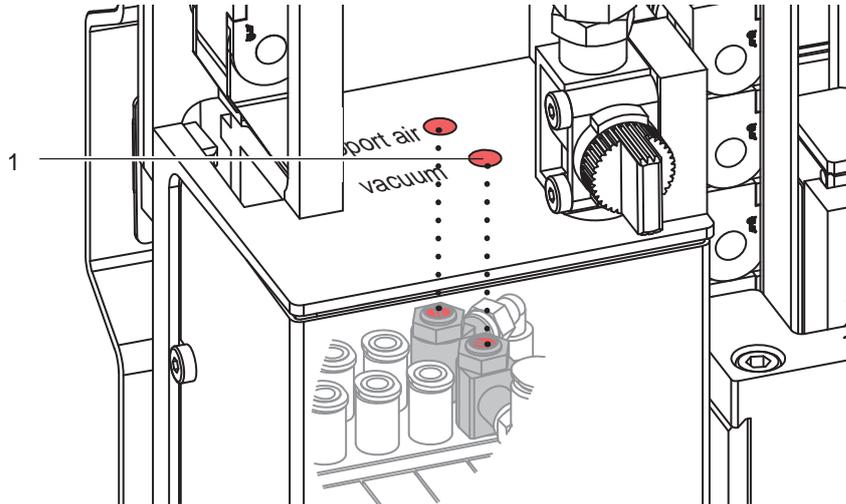


Fig. 17 Throttle valve "vacuum"

- ▶ Adjust the vacuum on the throttle valve "vacuum" (1) so that the label will be sucked up over its entire area.
- ▶ To increase the vacuum turn the setting screw on the throttle valve (1) counterclockwise.

Measuring Point Vacuum (MP V)

Use a manometer with a measurement range of -7 to 7 bar to control the pressure.

MP V : Vacuum - Reference Value (-0.6 bar)

1. Remove cover.
2. Cover the suction plate so it is airtight.
3. Attach manometer between tube (1) of the energy chain and fitting (2) of the pad.
4. Activate the magnetic valve manually by pressing the micro switch (3) to measure the pressure.
5. Mount cover.

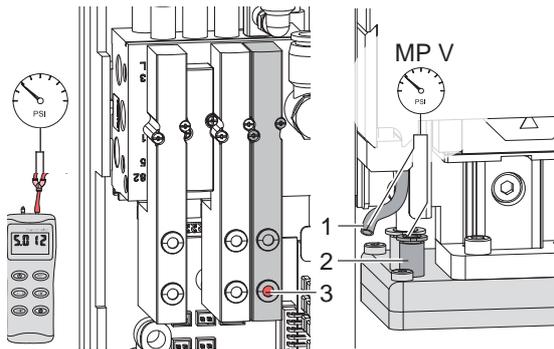


Fig. 18 Measuring points for the vacuum



Attention!

After pressure measurements, reconnect all components correctly.

7.3 Adjusting the Blow Tube (Supporting Air)

The blow tube must be adjusted in such a way that the label takeover is unhindered by turbulence and the supporting air blows the label evenly against the pad.

The default factory value is 2 bar.

**Note!**

When changing the label size (2", 4" or 6") the appropriate blow tube is to be used.

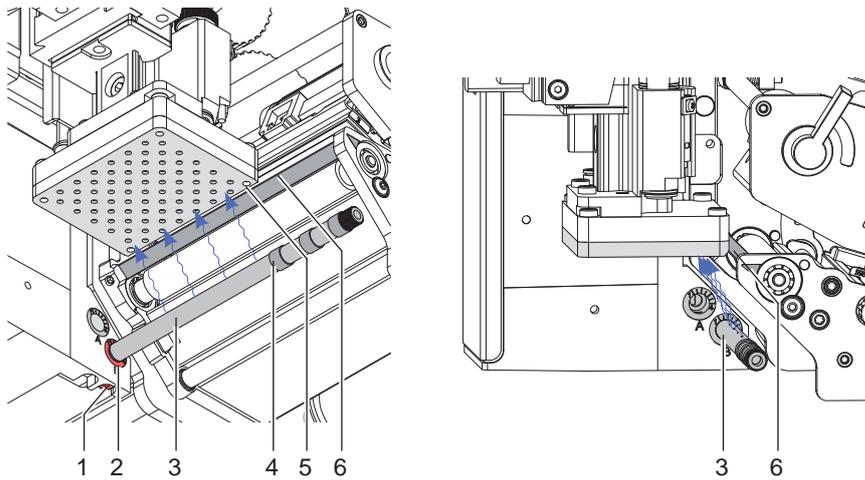


Fig. 19 Adjust the blow tube

The blow tube (4) for the supporting air can be rotated around its axis. That way the direction of the supporting air can be optimized.

1. Loosen screw (1).
2. Put the blow tube (3) into the tube adapter B (2).
Turn the blow tube (2) in the direction that the air current can support the take up of the label.
 - For small labels direct the air current more toward the dispensing edge (5) of the printer.
 - For larger labels direct the air current away from the dispense edge (6).
Use the graduation guide for orientation.
3. Open as many holes of the blow tube as are needed to cover the label width. Remove rings (4) if necessary. All holes outside the label width should be covered with the shrink tube rings provided. Once the unneeded holes have been covered the shrink tube should be shrunk.
4. Tighten screw (1).

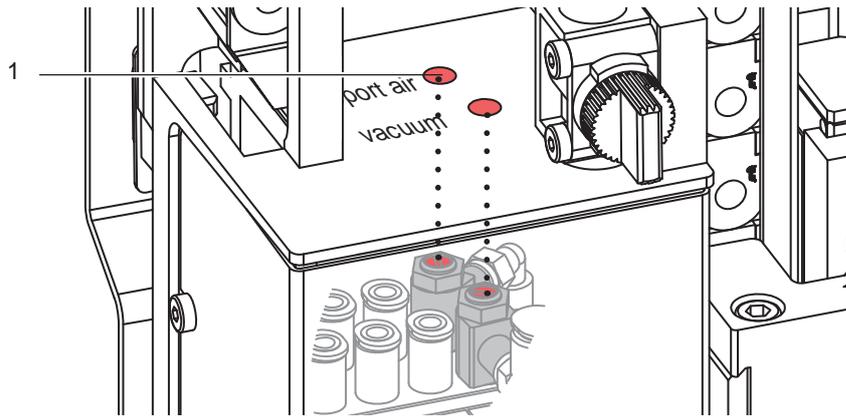
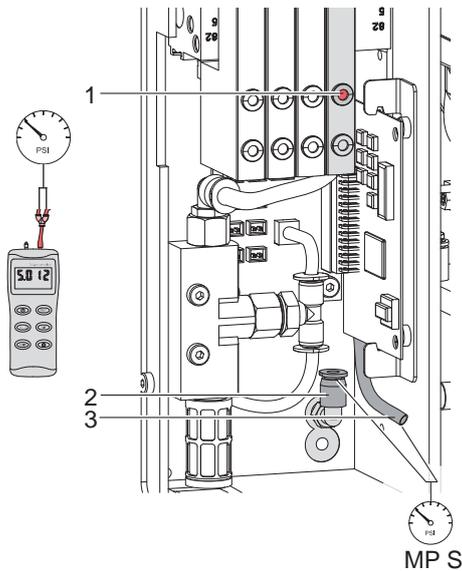


Fig. 20 Throttle valve "support air"

The strength of the supporting air can be varied via the provided throttle valve (1).

► To increase the strength of the supporting air turn the throttle valve (1) counterclockwise.

Measuring Point Support Air (MP S)



Use a manometer with a measuring range of -7 to 7 bar to measure the pressure.

MP S: Supporting Air (reference value 2 Bar)

1. Dismount cover and connect the manometer to the MP S.
2. Attach manometer between tube (2) and fitting (3).
3. Activate the valve manually by pressing the micro switch (1) to measure the pressure.
4. Mount cover.

Fig. 21 Measuring support air



Attention!

After pressure measurements, connect all components correctly.

7.4 Adjustment of the Stopper for Blow Mode



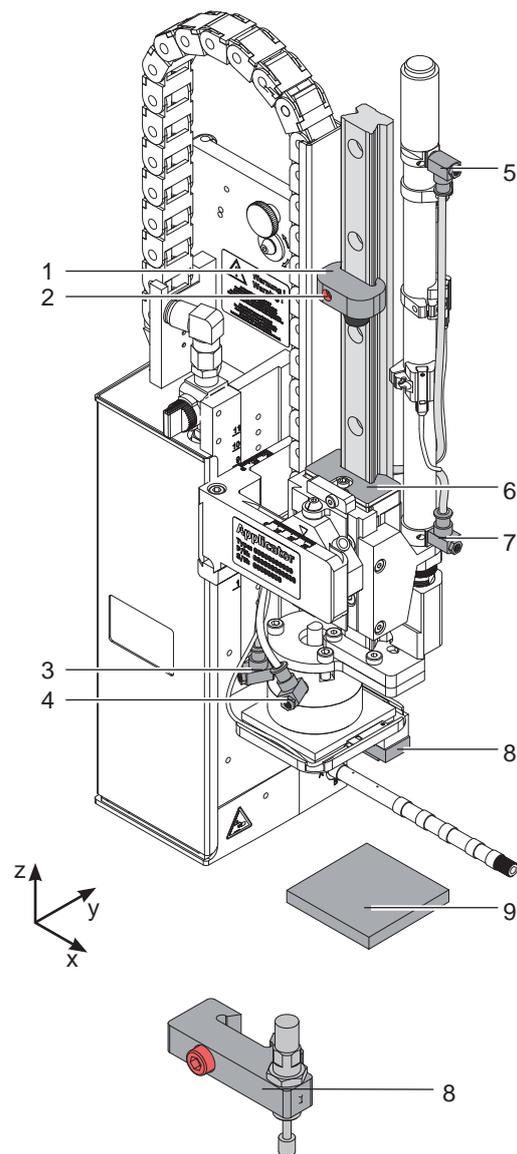
Note!
For operation mode "Blow on" only!

The operation mode "Blow on" allows a labelling without contact.

The pad does not press on the product. The label will be blown from the pad onto the product over a distance of up to 10 mm.

**Attention!**

► Switch off the printer and close the shutoff valve of the compressed air via the shut-off valve!



1. Place a product sample (9) on the labelling point.
2. Pull the tubes out of the push-in-fittings (5,7).
3. Loosen the screw (2) of the stopper (1).
4. Move the pad manually in the desired labelling position. The distance between the blow pad (8) in the labelling position and the product surface (9) must not exceed 10 mm.
5. Move the stopper (1) against the guide block (6) and tighten the screw (2)
6. Insert the tubes into the appropriate push-in-fittings (5,7).
7. Open the shutoff valve and switch on the printer.



Note!
To reduce the impact of the pad it is possible to use a stopper with cushioning as illustrated in option (8).

Fig. 22 Adjusting the stopper

7.5 Lift Speed of Cylinder Z

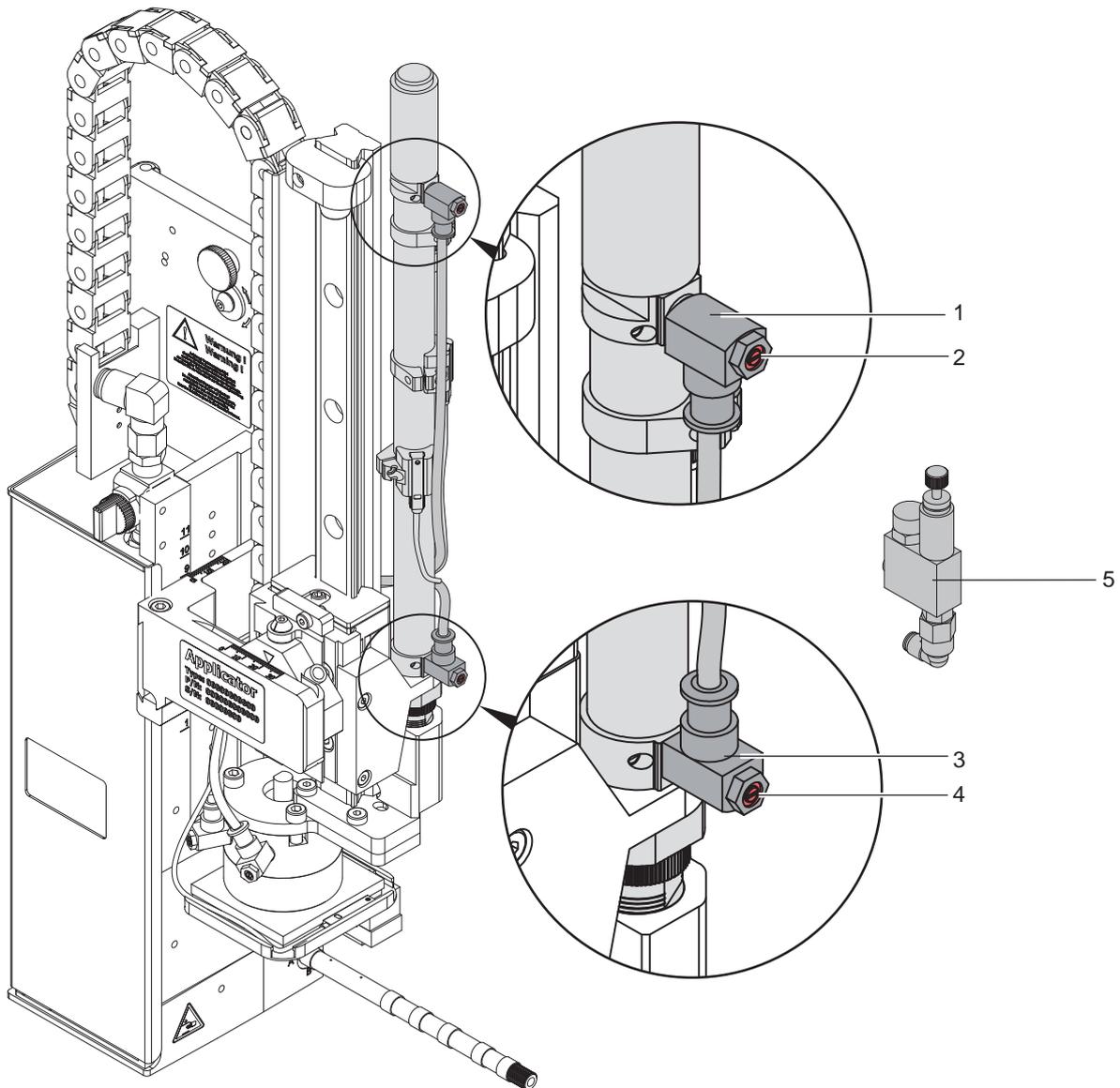


Fig. 23 Throttle valves on the cylinder Z

The speed of the pad movement can be regulated by two throttle valves (1, 3).

- ▶ Adjust the pad movement speed as necessary.
- ▶ To increase the downward speed turn screw (4) at the lower valve (3) counterclockwise.
- ▶ To increase the upward speed turn screw (2) at the upper valve (1) counterclockwise.



Note!

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

- ▶ In order to reduce the application pressure turn screw (4) clockwise.



Attention!

The time for the downward movement of the pad may not exceed 2 seconds otherwise the error message "Lower position" will appear.



Note!

To reduce the air pressure in Z-direction it is possible to use an optional pressure reduction valve (5).

- ▷ „7.8 Adjusting the Options for Z-Direction Movement“

7.6 Sensors on Cylinder Z

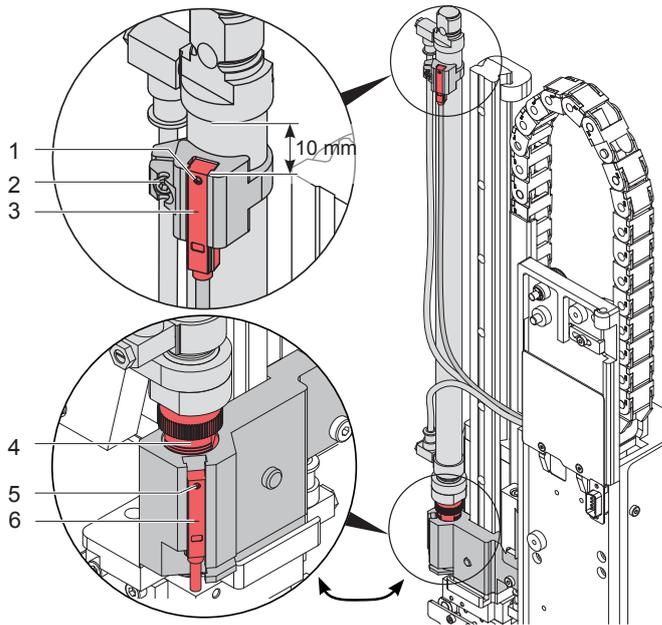


Fig. 24 Sensors on cylinder Z

Sensor 1 Start Position

1. Loosen screw (1) of the sensor "Start Position" (3) and move the sensor so that the top edge of the sensor is on the same level as the sensor holder.
2. Loosen screw (2) and move the sensor holder to a distance of 10 mm between top edge of the sensor and the lower edge of the connecting ring of the cylinder like shown in the illustration.
3. Tighten screw (2).
4. Check the sensor in the applicator operation.
 - Cylinder is moved in and the pad is in start position. - LED at the sensor glows
 - The pad is not in the start position. - LED at the sensor does not glow

Sensor 2 Labelling

The position of the labelling sensor (6) is dependant on the pad assembly's weight and the mounting position. The spring tension on the adapter bolt is dependant on these parameters and must be adjusted so that the sensor cannot trigger unintentionally. The triggering magnet is integrated in the adapter bolt and changes position with the tension spring.

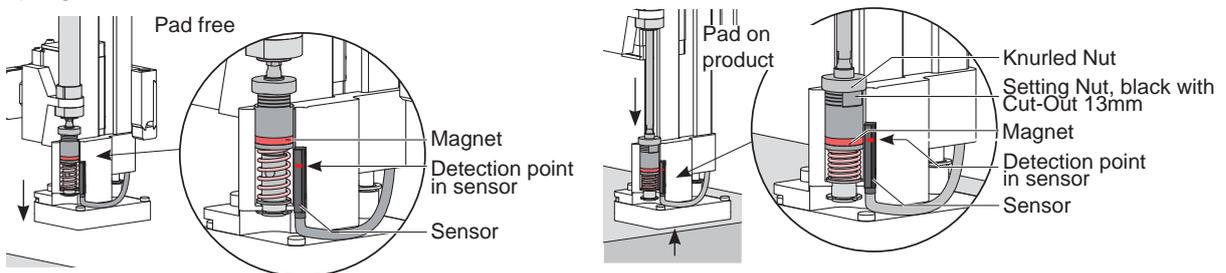


Fig. 25 Labelling sensor principle

1. Getting the printer and applicator into the final orientation.
2. Adjust the spring tension on the adapter bolt (4) via the black setting nut so that:
 - The adapter bolt is not pushed into the stamp assembly group during motion.
 - The sensor triggers when the pad has reached the labeling position.
3. Turn the setting nut with an open spanner 13 mm and fix the knurled nut by holding it.
 - Turning the setting nut clockwise will increase the spring tension.
 - Turning the setting nut counterclockwise will decrease the spring tension.
4. Loosen screw (5) and move the sensor (6) so that the LED lights up when the adapter bold is pushed into the pad assembly.
5. Tighten screw (5).

7.7 End Position Cushioning



Note!

The end position cushioning of the cylinder is set up to client specifications and does usually not need to be adjusted.

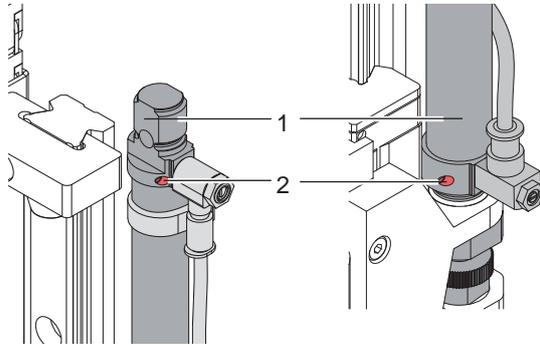


Fig. 26 End position cushioning

The end position cushioning of the main cylinder reduces the impact energy when the applicator is operating at high speeds and/or masses.

Adjust the end position cushioning so that the piston arrives the end position definitively but does not strike it too hard.

A higher level of end position cushioning will reduce the lift speed.

- ▶ To increase the value of the end position cushioning turn the setting screw (2) clockwise on cylinder (1).
- ▶ To reduce the value of the end position cushioning turn the setting screw (2) counterclockwise on cylinder (1).

7.8 Adjusting the Options for Z-Direction Movement

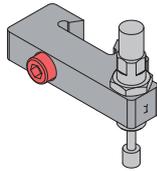


Fig. 27 Stopper with cushioning (Guide Rail)

The stopper with cushioning (guide rail) reduces the speed of the cylinder Z shortly before impact when the applicator is operated at higher speeds and/or with larger pads.

Adjustments like chapter ▶ „7.4 Adjustment of the Stopper for Blow on Mode“

Adjust the stopper with maximum compressed spring.

- ▶ „6.5 Transportation Lock“

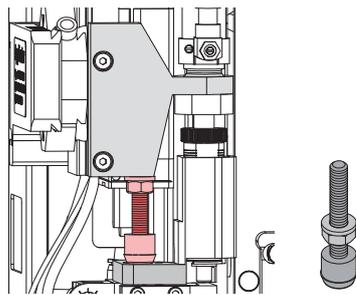


Fig. 28 Stopper (pad assembly)

The stopper avoids the triggering of the labelling sensor by the weight of the pad assembly during the inward motion of an installation turned 90° or 180°.

The setting occurs during the take-up of the label from the printer.

1. Loosen the counter nut of the stopper.
2. Turn the stopper until it touches the pad retainer lightly. Do not change the take over position of the pad by via stopper.
3. Tighten the counter nut to fix the stopper.

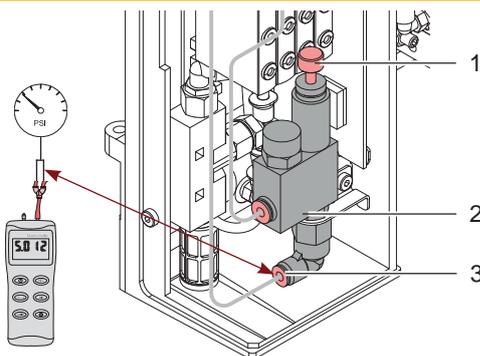


Fig. 29 Pressure reduction valve cylinder Z

The pressure reduction valve (2) can be used when labelling pressure-sensitive products or considering general safety aspects to reduce the pressure of the cylinder in Z-direction. The standard value is 2.5 bar.

- ▶ Connect the manometer between tube and exit (3) and adjust the pressure to 2.5 bar with the knurled screw (1).

It is possible to order an upgraded set with a pressure reduction valve.

Instructions are provided with the upgraded set.

7.9 Lift Speed of Cylinder R

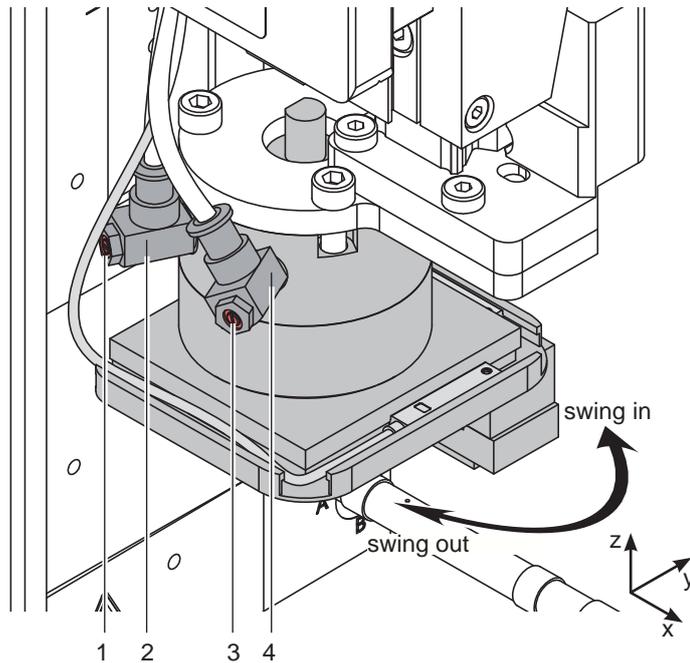


Fig. 30 One-way flow control valve of cylinder R

- ▶ Adjust speed as necessary.
- ▶ To increase the outward movement speed of cylinder R in the direction of the labeling position turn the screw (1) of valve (2) counterclockwise.
- ▶ To increase the inward movement speed of cylinder R in the direction of the labeling position turn screw (3) of valve (4) counterclockwise.

7.10 Sensors on Cylinder R

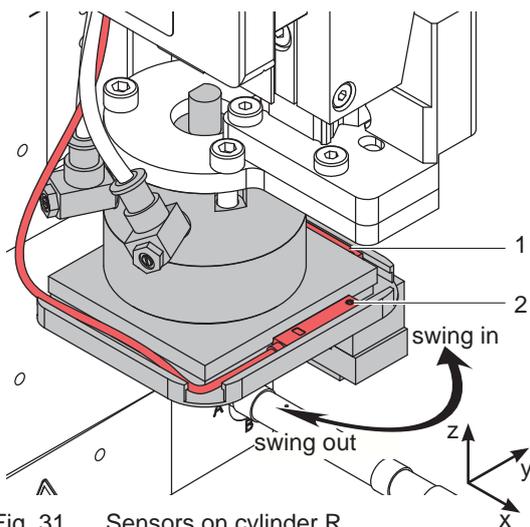


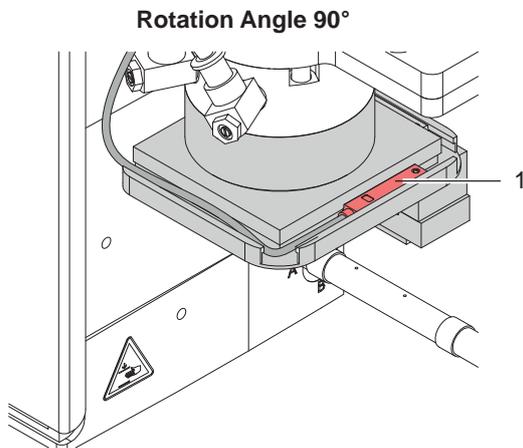
Fig. 31 Sensors on cylinder R

The sensors of cylinder R show the position of the cylinder in the state of label take-up and labeling position.

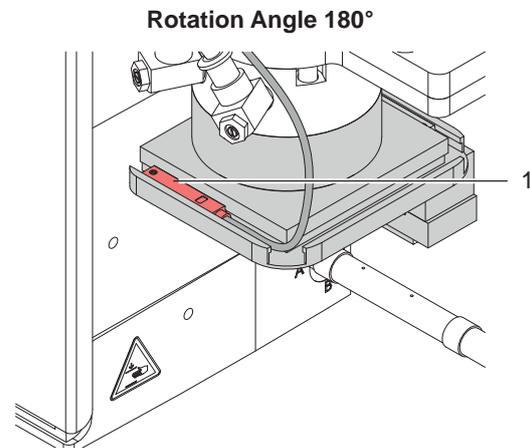
- Place the sensor start position (1) so that it is triggered if the cylinder is completely swiveled in and releases as soon as the cylinder moves from the start position.
- Place the sensor end position (2) so that it is triggered if the cylinder is completely swiveled out and releases as soon as the cylinder leaves the end position.

7.11 Settings of the Rotation Angle of the Cylinder R

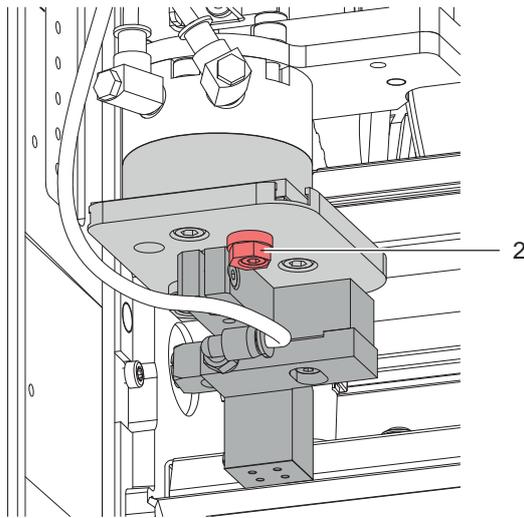
To change the rotation angle from 90° to 180° and vice versa it is necessary to change the position of the sensor "End Position" and the stopper of cylinder R.



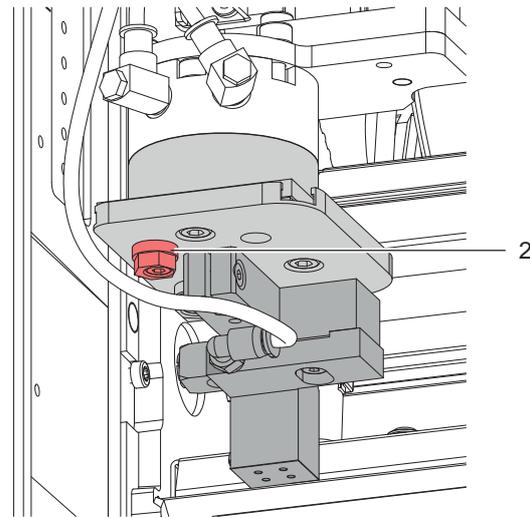
Sensor (1) must be at an offset of 90° in the direction of rotation to the start sensor.



Sensor (1) must be at an offset of 180° to the start sensor.



Mount the stopper (2) underneath the plate on the cylinder R the right side (view direction toward the printer)



Mount the stopper (2) underneath the plate on the cylinder R the left side (view direction toward the printer)

The pictures shown an applicator 4214 L. The components for the applicator 4214 R are the mirror opposite.

Fig. 32 Changing the rotation angle

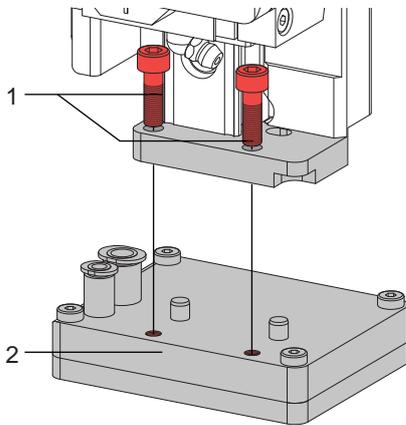


Note!

Stopper (2) is designed as an eccentric. It is possible to fine tune the end position by turning the stopper.

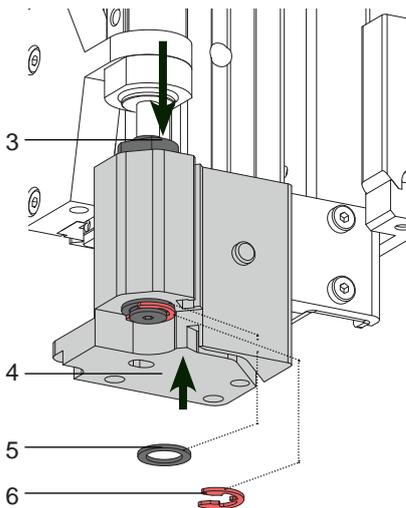
7.12 Labeling from Below - Changing the Spring of the Impact Sensor

For fault free labeling in a side- or upward-motion it is necessary to change the spring of the impact sensor. The stronger spring prevents the unwanted triggering of the impact sensor due to the inertia of the cylinder and stamp assembly group.



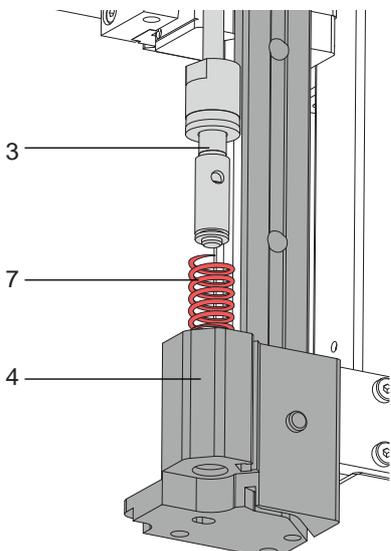
- ▶ Loosen screw (1) and dismount the stamp (2) to get to the locking washer (6).

Fig. 33 Demounting the stamp



- ▶ Push the adapter bolt (3) into the stamp uptake (4) to ensure that the bottom of the bolt is pushed out. Demount locking plate (6).
- ▶ Remove washer (5).

Fig. 34 Loosening the adapter bolt



- ▶ Hold onto the adapter bolt (3) and pull off the stamp uptake (4).
- ▶ Pull out the pressure spring (6) and replace it with the alternative.
- ▶ Push together the stamp uptake (4) and the adapter bolt (3).
- ▶ Replace the washer (5).
- ▶ Place the locking washer (6) back into it's position.

Fig. 35 Changing the spring

The applicator can be operated in different ways. While the original process stays the same, the operation mode can be chosen from the printer setup.

The most important setting is the selection between the operation modes "Stamp on" and "Blow on".

Additionally the applicator has different application modes concerning the order of printing and applying within one labelling cycle.

	Stamp on	Blow on
Print/Apply	x	x
Apply/Print Waiting position top	x	x
Apply/Print Waiting position bottom	-	x

Table 5 Operation and application modes

Additionally all operating modes can be adjusted by setting different time delays.



Note!

For more information about the printer configuration and the function of the keys in the navigator pad
 ▷ Configuration manual of the printer or ▷ Operator's manual of the printer.

8.1 Method for Changing the Printer Setup

1. Press **menu** button.
2. Select Setup > Machine param. > Applicator.
3. Select and adjust the needed parameters.
4. Return to the "Ready" mode.

8.2 Quick Mode for Setting the Delay Times

Beside the standard method for the printer configuration there is a quick mode to adjust the delay times.



Note!

The quick mode settings can be made during operation. The changes directly affect the current print job.

1. Press the **menu** button for at least 2 seconds.
The first delay time appears on the display.
2. Adjust the delay time by pressing the ▲ button and ▼ button.
3. To switch between the different delay times press the ▶ button.
4. To leave the quick setup mode press the ◀ button.
The selected delay times are stored in the printer.

8.3 Configuration Parameters of the Applicator

The configuration parameters of the applicator can be found in the menu Setup > Machine param.

Parameter	Meaning	Default
 Applicator	Configuration parameters of the applicator	
 > Mode of oper.	Setting the operation mode Stamp on, Roll on, Blow on	Stamp on
 > Mode of appl.	Setting the application mode Print-Apply / Apply-Print Print-Apply: An external start signal releases the print of a label and following the application of the label. After a cycle is complete, the pad without label waits in the start position. Apply-Print: An extra signal starts the print of the first label and the transfer of the label to the pad. The external start signal releases the application of the label and following the print and transfer of the next label. After a cycle is complete, the pad with a label is in the waiting position.	Print-Apply
 > Waiting position	only at Mode of oper. Blow on and Mode of appl. Apply-Print up : Pad waits in the start position for the start signal down : Pad waits in the labelling position for the start signal	up
 > Blow time	only at Mode of oper. Blow on Switch-on time (max. 2.5 s) of the blowing air for the label transfer	0 ms
 > Support delay on	Setting the switch-on delay (max. 2.5 s) for the supporting air between print start and switching on the supporting air. The delay prevents swirling at the front of the label and, consequently, avoids faults when the label is being picked up from the printer.	0 ms
 > Support del. off	Setting the switch-off delay (max. 2.5 s) for the supporting air between the end of label forwarding and switching on the supporting air. The delay can be useful to separate the rear edge of the label from the carrier to avoid errors and to improve the accuracy of label positioning	270 ms
 > Delay time	Delay (max. 2.5 s) between start signal and the start of an labelling cycle. Allows e.g. the use of product sensors at conveyors.	0 ms
 > Lock time	All start signals coming in following the first start signal are ignored when they arrive within the lock time.	0 ms
 > Peel position	Shift the position of the dispensed label relatively to the dispense edge. In the software an extra peel offset value is available. The offset values from "Peel position" and from software are added together for execution. ▷ "Setting the Peel Position".	0.0 mm
 > Vacuum control	Setting the label transfer check from printer to pad and from pad to product by the vacuum sensor	On
 > Hand-over up	Take over the label direct from the dispense edge via contact between pad and dispense edge.	Off
 > Cleaning blow	Activate / Deactivate - air pressure impulse to clean the pad	On
 > Vacuum delay	On - The vacuum will switched on after end of the label transport. Off - The vacuum will switched on with start of the label transport.	Off

Table 6 Applicator parameters

8.4 Setting the Peel Position

To optimize the transfer of the labels from the printer to the pad there two different parameters are available for adjusting the peel position.



Attention!

- ▶ First adjust the parameter "Peel Position" in the printer configuration.
- ▶ Following adjust the additional peel-off offset in the software.

It is very important to follow that procedure for a certain start after label loading and for the re-start after error treatment.

Parameter "Peel Position" in the printer configuration

- ▶ Check the basic setting in the printer setup. Perform labelling cycles by alternately pressing the **feed** button and the Enter button ↵ ▷ „9.1 Test Mode without a Print Job“
- ▶ Adjust the "Peel Position" in such a way, that the blank labels are peeled-off completely from the liner ▷ „8.3 Configuration Parameters of the Applicator“

Peel-off offset in the software

- ▶ Check the setting in the software. Perform labelling cycles by repeatedly pressing the the pre-dispense key ▷ „9.2 Test Mode with Print Job“
- ▶ Adjust the peel-off offset in such a way, that the printed labels are peeled-off completely from the liner ▷ Programming manual or software documentation.

8.5 Activation of Peel-off Mode



Note!

- ▶ For labelling operation activate the peel-off mode in the software.
- ▶ For direct programming use the P-command ▷ Programming manual.

9.1 Test Mode without a Print Job

**Warning!**

The pad will be moved to the starting position immediately!
 Danger of injury to hands and fingers by the moving pad!

- ▶ Do not reach into the zone of the moving pad and keep long hair, loose clothes, and jewelry away.

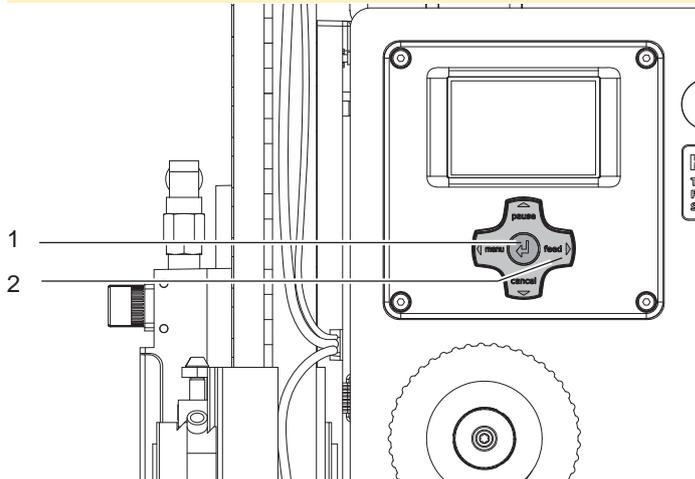


Fig. 36 Test mode with enter button ↵ (1)

**Note!**

- ▶ Please use this test mode to adjust the parameter "Peel position" in the printer configuration.

The whole labelling process can be simulated without the need of a print job or a connection to a computer by alternately pressing the **feed** (2) button and the Enter button ↵ (1) :

- ▶ Press the **feed** button (2).
 A blank label is fed. The vacuum at the pad as well as the supporting air (blow tube) are switched on. After the label has been picked up by the pad, the supporting air is switched off.
- ▶ Press the Enter button ↵ (1).
 The pad is moved to the labelling position. A sensor signals when the labelling position is reached. The vacuum is switched off and the label is placed onto the product. Then, the pad is moved back into the starting position.

9.2 Test Mode with Print Job

**Note!**

- ▶ Please use that test mode to adjust the peel-off offset in the software.

This method allows to check labelling processes with the real print data using the Enter button ↵ (1).

- ▶ Send a print job.

The test mode is executed in two half cycles:

- ▶ Press the Enter button ↵ (1).

Half cycle 1

A label is printed. The vacuum of the pad as well as the supporting air (blow tube) are switched on. After the label has been picked up by the pad, the supporting air is switched off.

- ▶ Press the Enter button ↵ (1) again.

Half cycle 2

The pad is moved to the labelling position. A sensor signals when the labelling position is reached. The vacuum is switched off and the label is placed onto the product. Then, the pad is moved back into the starting position.

If the label is manually removed from the pad after the first half cycle, the half cycle 1 will be repeated when the pre-dispense button is pressed again.

10.1 Retainer Assembly

No.	Part-No.	Description	PU	Serial No.	
				from	to
1	5902489.001	Screw DIN7984-M4x8	10		
2.1	5964129.001	Cover L	1		
2.2	5964260.001	Cover R	1		
3	5964367.001	Knurled Screw	1		
4	5965963.001	Set Screw	1		
5	5904544.001	Spring	10		
6	5964090.001	Bar	1		
7.1	5964429.001	Plate L	1		
7.2	5964438.001	Plate R	1		
8	5902021.001	Screw DIN7991-M3x6	10		
9	5903525.001	E-Ring DIN6799-4	10		
10.1	5964036.001	Base Plate L	1		
10.2	5964185.001	Base Plate R	1		

No.	Part-No.	Description	PU	Serial No.	
				from	to
11.1	5964318.001	Adapter Profile L/R 200/300H	1		
11.2	5970013.001	Adapter Profile L 400H	1		
11.3	5970014.001	Adapter Profile R 400H	1		
12	5902167.001	Screw DIN912 M5x50	10		
13.1	5964312.001	Crossbeam L	1		
13.2	5964331.001	Crossbeam R	1		
14.1	5964310.001	Clamping Element L	1		
14.2	5964328.001	Clamping Element R	1		
15	5964062.001	Binder	1		
98	5966530.001	Eccentric	1		
99	5966529.001	Hinges	1		

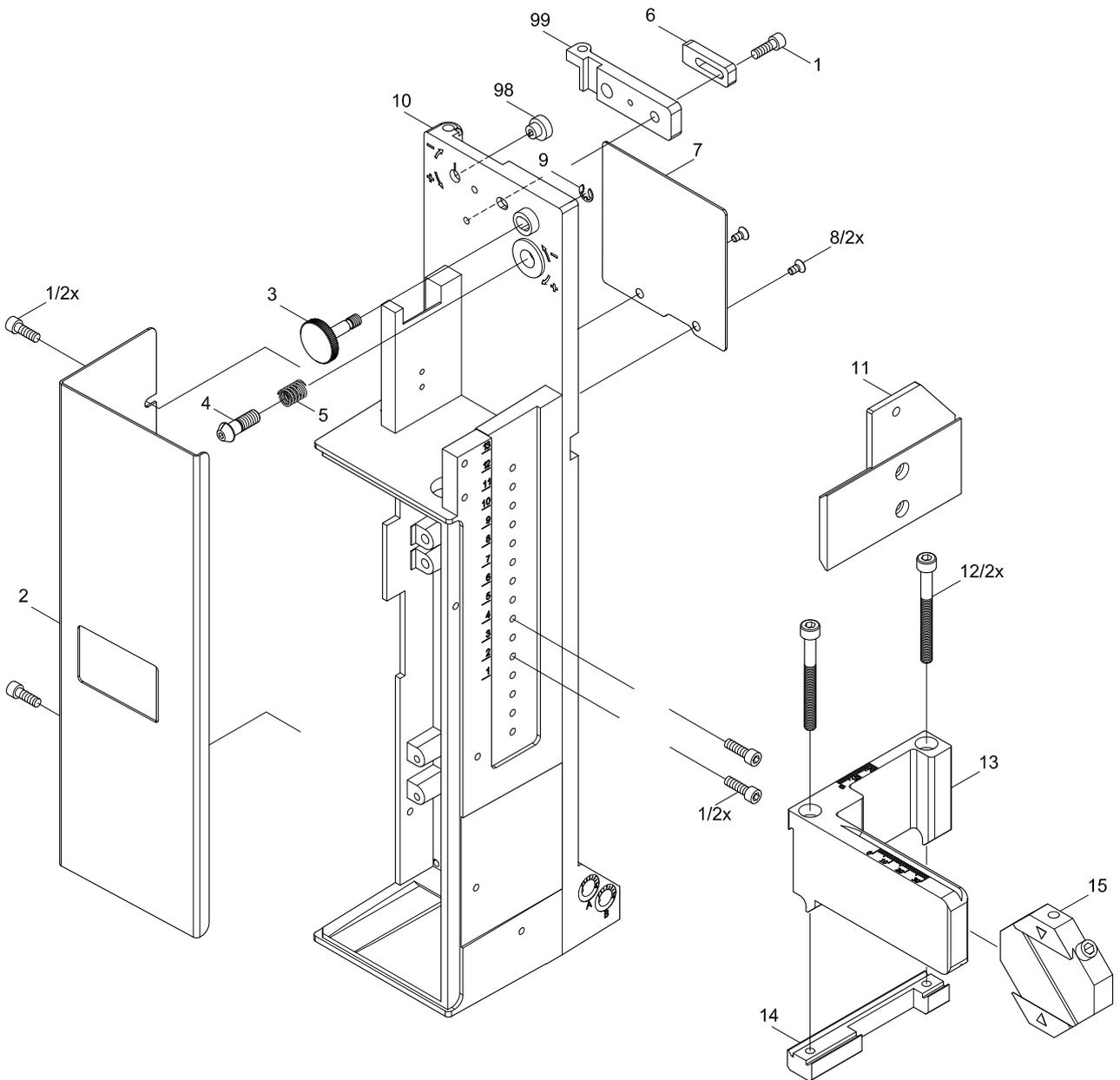


Fig. 37 Retainer assembly - spare parts

10.2 Pneumatics Retainer Assembly

No.	Part-No.	Description	PU	Serial No.	
				from	to
1	5902489.001	Screw DIN7984-M4x8	10		
16	5902863.001	Screw DIN7984 M4x25	10		
17	5905285.001	Push-in L-Connector	1		
	FESTO 153276				
18	5905284.001	Block Valve	1		
	FESTO 153296				
19	5906656.001	Push-in/threaded Fitting	1		
	FESTO 153023				
20	5966460.001	Tube Ø 4	1		
	FESTO 152584				
21	5966463.001	Tube Ø 4	1		
	FESTO 159663				
22	5966464.001	Tube Ø 6	1		
	FESTO 159665				
23	5966465.001	Tube Ø 8	1		
	FESTO 159667				
24	5966466.001	Tube 2x Ø 4	1		
	FESTO 152822				
25	5905972.001	Push-in Y-Fitting	1		
	FESTO 153371				

No.	Part-No.	Description	PU	Serial No.	
				from	to
27.1	5966651.001	Valve Block	L	1	
27.2	5966655.001	Valve Block	R	1	
28	5906021.001	Valve	1		
29	5906022.001	Valve	1		
32	5905317.001	Push-in L-Connector	1		
	FESTO 153336				
33	5906844.001	Vacuum Generator	1		
	FESTO 193509				
34	5905257.001	Silencer	1		
	FESTO 2307				
35	5966414.001	Pressure Reduce Valve	1		
36	5905338.001	Push-in T-Connector	1		
	FESTO 153355				
38	5905283.001	Push-in/threaded Fitting	1		
	FESTO 153315				
39.1	5964277.001	Blow Tube	2"	1	
39.2	5964095.001	Blow Tube	4"	1	

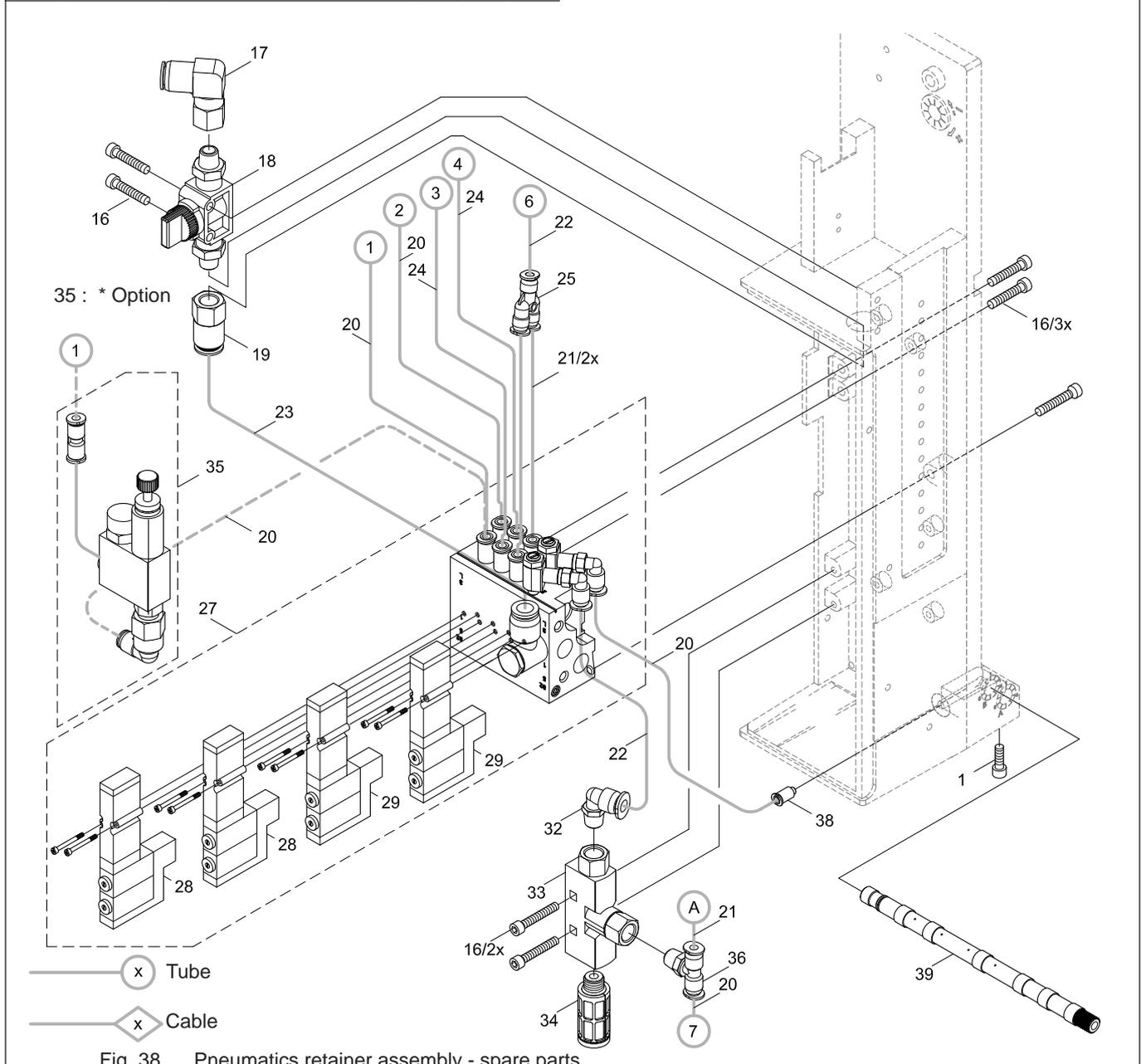


Fig. 38 Pneumatics retainer assembly - spare parts

10.3 Electronics Retainer Assembly

No.	Part-No.	Description	PU	Serial No.	
				from	to
21	5966463.001	Tube Ø 4	1		
40	5902144.001	Screw DIN7984-M3x5	10		
41	5964045.001	Bracket	1		
42	5955586.001	Cable	1		
43.1	5964590.001	Cable	200H	1	
43.2	5964591.001	Cable	300H	1	
43.3	5964592.001	Cable	400H	1	
44	5902571.001	Screw DIN7984-M4x6	10		
45.1	5955579.001	PCB Applicator Interfaces	L	1	6123
45.1	5971416.001	PCB Applicator Interfaces	L	1	6124
45.2	5964188.001	PCB Applicator Interfaces	R	1	6123
45.2	5971417.001	PCB Applicator Interfaces	R	1	6124
46	5955585.001	PCB Valve Block	1		
47.1	5964454.001	Sensor	200H	1	
47.2	5966439.001	Sensor	300H	1	
47.3	5964495.001	Sensor	400H	1	

No.	Part-No.	Description	PU	Serial No.	
				from	to
48.1	5964490.001	Sensor End Position Cyl.Z	200H	1	
48.2	5966440.001	Sensor End Position Cyl.Z	300H	1	
48.3	5966447.001	Sensor End Position Cyl.Z	400H	1	
49.1	5966438.001	Sensor Middle Pos. Cyl.Z	200H	1	
49.2	5966443.001	Sensor Middle Pos. Cyl.Z	300H	1	
49.3	5966450.001	Sensor Middle Pos. Cyl.Z	400H	1	
50.1	5966436.001	Sensor Start Position Cyl.R	200H	1	
50.2	5966441.001	Sensor Start Position Cyl.R	300H	1	
50.3	5966448.001	Sensor Start Position Cyl.R	400H	1	
51.1	5966437.001	Sensor End Position Cyl.R	200H	1	
51.2	5966442.001	Sensor End Position Cyl.R	300H	1	
51.3	5966449.001	Sensor End Position Cyl.R	400H	1	
52	5964611.001	EEPROM	1		
53	5955575.001	Applicator Control	1		
54	5964041.001	Holder	1		
97	5906943.001	Sealing Ring	10		

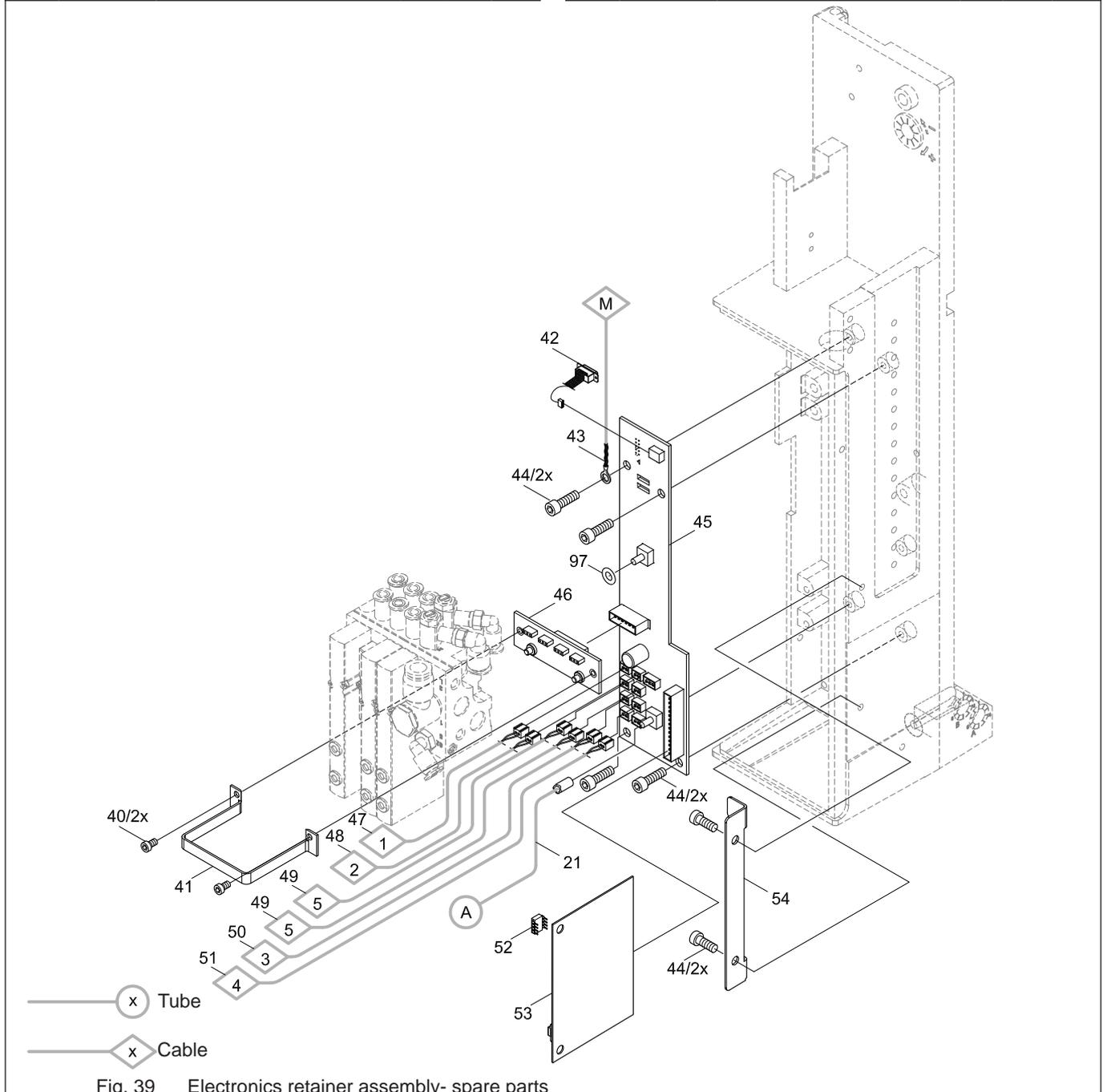


Fig. 39 Electronics retainer assembly- spare parts

10.4 Cylinder Assembly R

No.	Part-No.	Description	PU	Serial No.	
				from	to
24	5966466.001 FESTO 152822	Tube 2x Ø 4	1		
48.1	5964490.001	Sensor 200H	1		
48.2	5966440.001	Sensor 300H	1		
48.3	5966447.001	Sensor 400H	1		
50.1	5966436.001	Sensor 200H	1		
50.2	5966441.001	Sensor 300H	1		
50.3	5966448.001	Sensor 400H	1		
51.1	5966437.001	Sensor 200H	1		
51.2	5966442.001	Sensor 300H	1		
51.3	5966449.001	Sensor 400H	1		
55	5964343.001	Stopper	1		
56	5964364.001	Stopper	1		
57	5964061.001	Setting Screw	1		
58	5965966.001	Sliding Carriage	1		
59.1	5964302.001	Plate	1		
59.2	5964337.001	Plate	1		
60	5903505.001	E-Ring DIN6799-5	10		
61.1	5964301.001	Holder L	1		
61.2	5964336.001	Holder R	1		
62	5902562.001	Screw DIN7984-M4x14	10		
63	5521159.001	Nut	1		
64.1	5964387.001	Tamp Retainer	1		
64.2	5964387.001	Tamp Retainer	1		

No.	Part-No.	Description	PU	Serial No.	
				from	to
65	5964311.001	Adapter Bolt	1		
66.1	5905069.001	Spring	1		
66.2	5905049.001	Spring	1		
67	5521157.001	Washer	1		
68	5521158.001	Washer	1		
69	5903501.001	E-Ring DIN6799-7	10		
70	5902290.001	Screw DIN912-M5x35	10		
71.1	5966405.001	Retainer L	1		
71.2	5966407.001	Retainer R	1		
72	5905395.001	Swing Drive	1		
SMC					
73	5906636.001	One-way Flow Control Valve	1		
74	5964391.001	Plate	1		
75	5902138.001	Screw DIN912-M5x10	10		
76	5941964.001	Exenter	1		
77	5902002.001	Screw DIN912-M4x10	10		
78	5964393.001	Swing Bracket	1		
79	5905255.001	Push-in L-Connector	1		
80		pad (customized)	1		
90	5964238.001	Plate	1		
91	5902281.001	Screw DIN7984-M5x12	10		
92	5964351.001	Stopper	1		

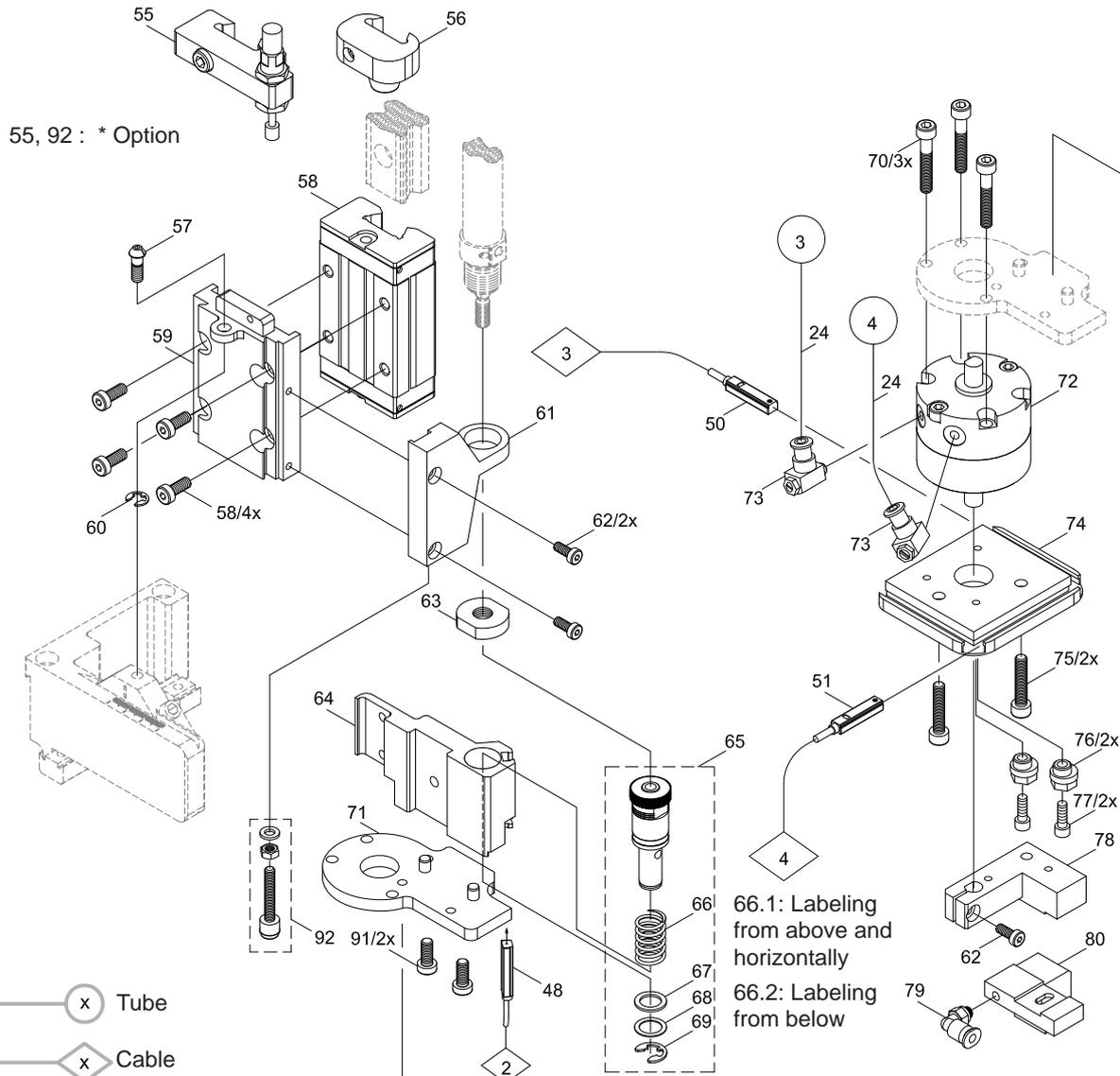
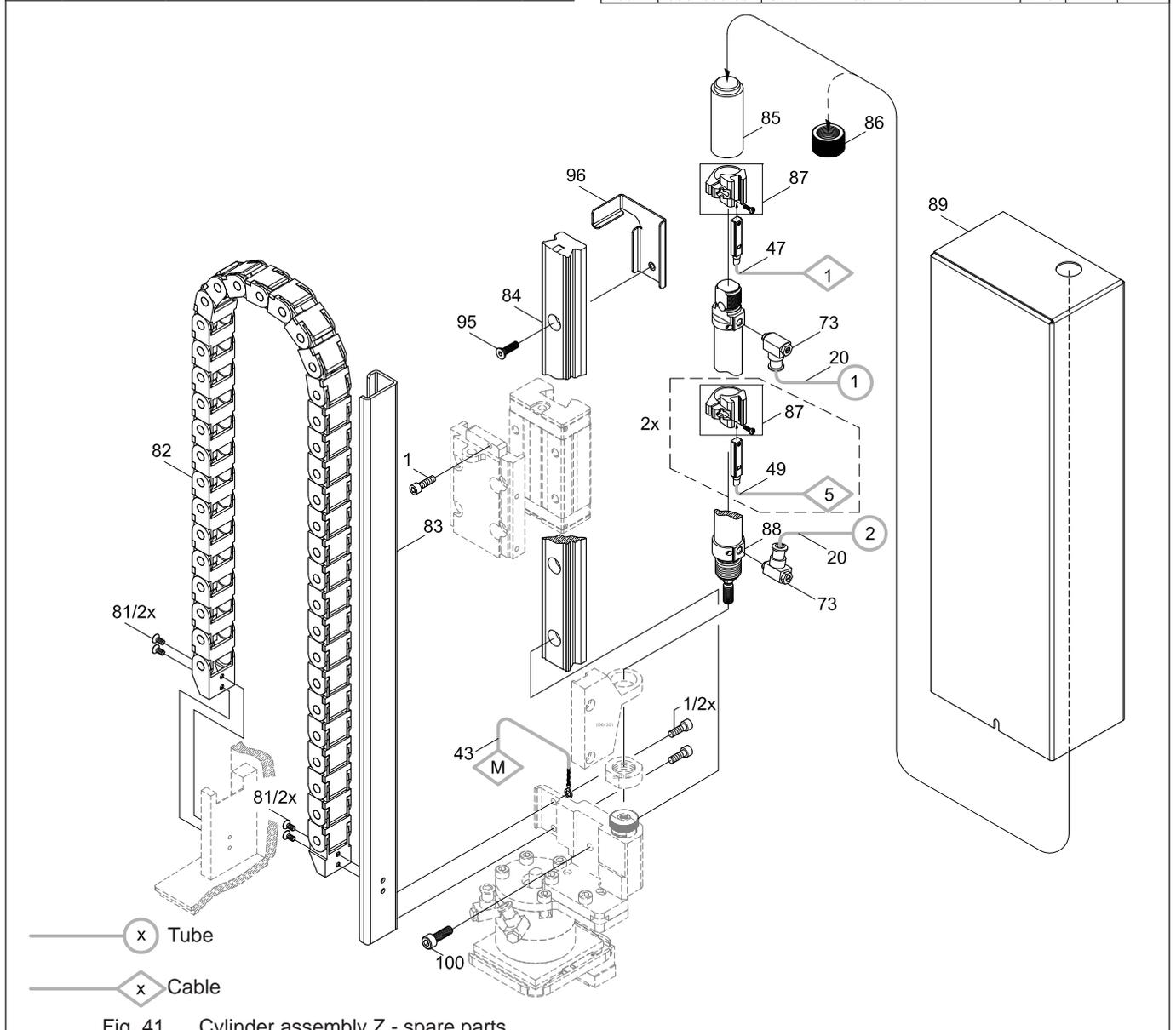


Fig. 40 Cylinder assembly R - spare parts

10.5 Cylinder Assembly Z

No.	Part-No.	Description	PU	Serial No.	
				from	to
20	5966460.001 FESTO 152584	Tube Ø 4	1		
43.1	5964590.001	Cable 200H	1		
43.2	5964591.001	Cable 300H	1		
43.3	5964592.001	Cable 400H	1		
47.1	5964454.001	Sensor 200H	1		
47.2	5966439.001	Sensor 300H	1		
47.3	5964495.001	Sensor 400H	1		
49.1	5966438.001	Sensor 200H	1		
49.2	5966443.001	Sensor 300H	1		
49.3	5966450.001	Sensor 400H	1		
73	5906636.001 FESTO 175056	One-way Flow Control Valve	1		
81	5902047.001	Screw DIN7991-M3x5	10		
82.1	5964373.001	Energy Track 200H	1		
82.2	5964374.001	Energy Track 300H	1		
82.3	5964375.001	Energy Track 400H	1		
83.1	5964347.001	Bracket L200H	1		
83.2	5964357.001	Bracket L300H	1		
83.3	5964358.001	Bracket L400H	1		
84.4	5964396.001	Bracket R200H	1		
84.5	5964398.001	Bracket R300H	1		
84.6	5964402.001	Bracket R400H	1		

No.	Part-No.	Description	PU	Serial No.	
				from	to
84.1	5964306.001	Guide Rail 200H	1		
84.2	5964307.001	Guide Rail 300H	1		
84.3	5964308.001	Guide Rail 400H	1		
85	5964443.001	Bolt	1		
86	5964489.001	Knurled Nut	1		
87	5905593.001 FESTO 175094	Mounting Clip	1		
88.1	5906938.001 FESTO 19235	Cylinder Z 200H	1		
88.2	5905973.001 FESTO 14320	Cylinder Z 300H	1		
88.3	5906117.001 FESTO 14320	Cylinder Z 400H	1		
89.1	5964440.001	Cover L200H	1		
89.2	5964483.001	Cover L300H	1		
89.3	5964484.001	Cover L400H	1		
89.4	5964451.001	Cover R200H	1		
89.5	5964453.001	Cover R300H	1		
89.6	5964485.001	Cover R400H	1		
95	5902224.001	Screw DIN7991-M4x12	10		
96.1	5966524.001	Support L 400H	1		
96.2	5966528.001	Support R 400H	1		
100	5902335.001	Screw DIN7984-M6x25	10		



11.1 Block Diagram

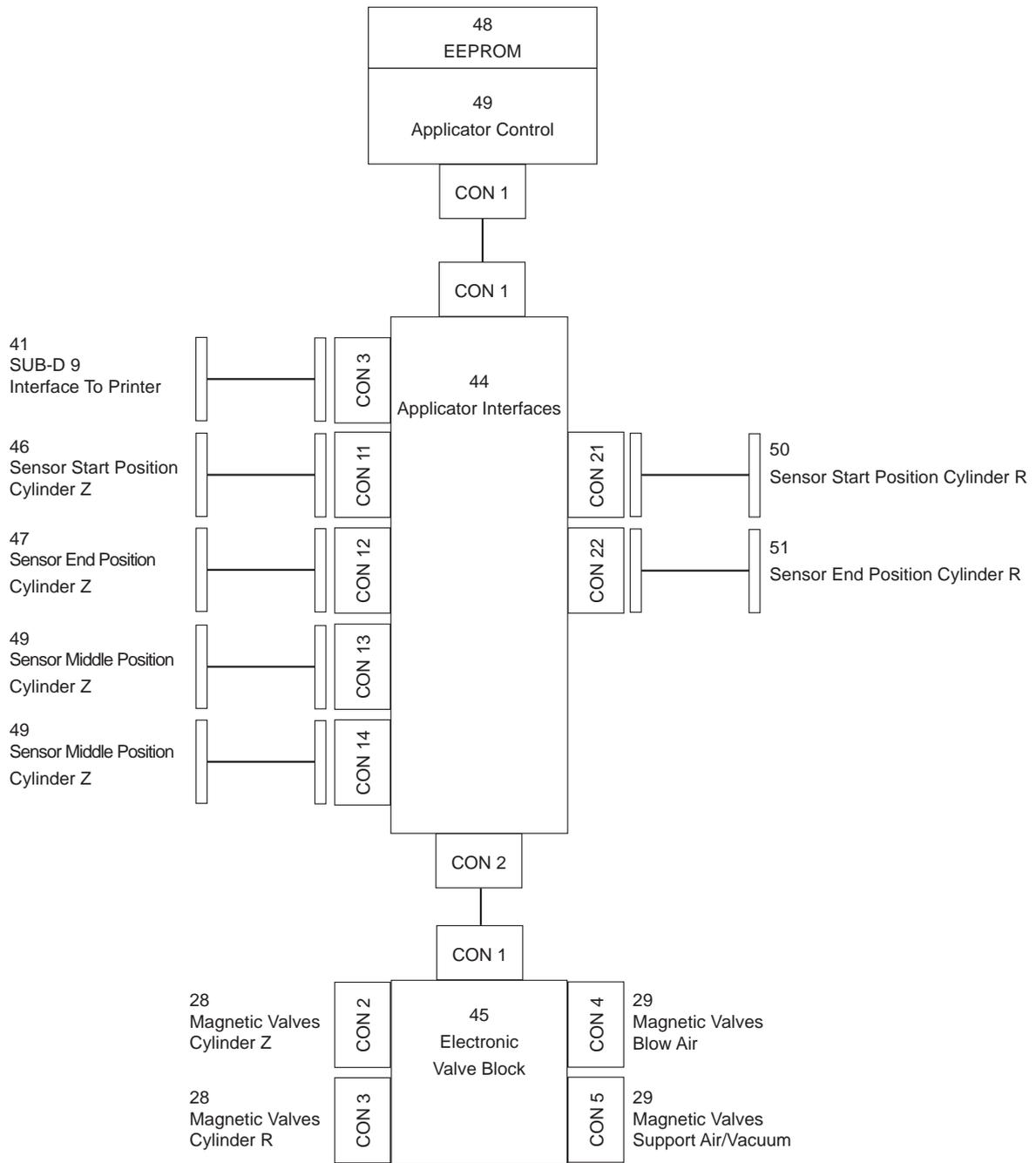


Fig. 42 Block diagram

B		S	
Block diagram.....	40	Sensor Start Position.....	27
Blow on.....	31	Speed	
Blow Tube		Cylinder Y	29
Mounting.....	19	Cylinder Z	26
C		Stamp on	31
Compressed Air.....	20	Standard.....	17
Configuration	32	Stopper	28
Connect	20	Support Air.....	23
Cover	17	Reading Points	24
Cylinder Assembly Y		T	
Spare Parts.....	38	Tamp Adjustments	21
Cylinder Assembly Z		Test Mode.....	34
Spare Parts.....	39	Tools	17
D		Transport Lock.....	18
Default	32	V	
Delay Times.....	31	Vacuum.....	22
E			
Electronics			
Spare Parts.....	37		
End Position Cushioning	28		
L			
Labelling Sensor.....	27		
Label position 4314R.....	42, 43		
O			
Option.....	28		
Options	26		
P			
Pad			
Mounting.....	19		
Parameter.....	32		
Peel-off Mode	33		
Peel-off offset	34		
Peel Position.....	33		
Pneumatics.....	41		
Spare Parts.....	36		
Pressure reduction	28		
Pressure reduction valve.....	28		
Printer Setup.....	31		
Print Job	34		
R			
Retainer			
Spare Parts.....	35		