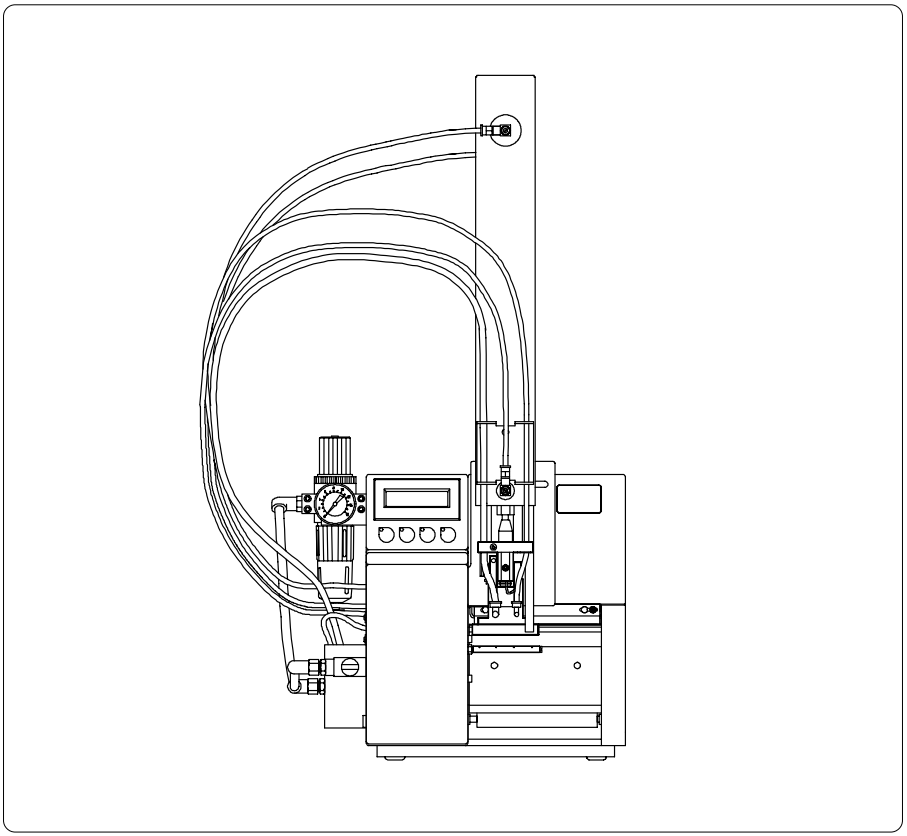
Tamp-Blow Applicator with Lift Cylinder
Version 2100

Operating Instructions

Edition 7/03



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EC-Conformity Declaration

1. Product Description

Function

The Tamp-Blow Applicator with Lift Cylinder is an extra device to use with the **Apollo** label printer for automatically applying the printed label onto the product.
The labels are transferred with a pad, which is moved 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 printer by the vacuum plate of the pad.
A sensor at the cylinder signals when the pad is in the starting position. The label is removed from the silicon liner directly at the dispense edge of the printer. 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 by 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, which is confirmed by another sensor (labelling position sensor). Here, the label is blown onto the product by blow air from the pad.
While the pad is moving back into the starting position, the vacuum sensor controls whether the label has been removed from the pad.
Specially adapted pads may be used for different label sizes.

The control unit of the applicator is connected with the **Apollo** on its SPI interface using the peripheral connector of the printer.

For operation in a networked system the applicator's PLC (programmable logic control) interface with potential free inputs and outputs may be used.

Technical Data

Label width :	.5 to 4.45 in (12 to 116 mm)
Label height :	.2 to 3.2 in (5 to 80 mm)
Air pressure :	4 to 6 bar
Labelling speed :	approx. 20 labels per minute for labels with a length of 3.2 in (80 mm)
Lift cylinder :	lift height max. 12 in (300 mm) incl. 6 in (150 mm) underneath the standing position of the printer

2. Equipment Supplied

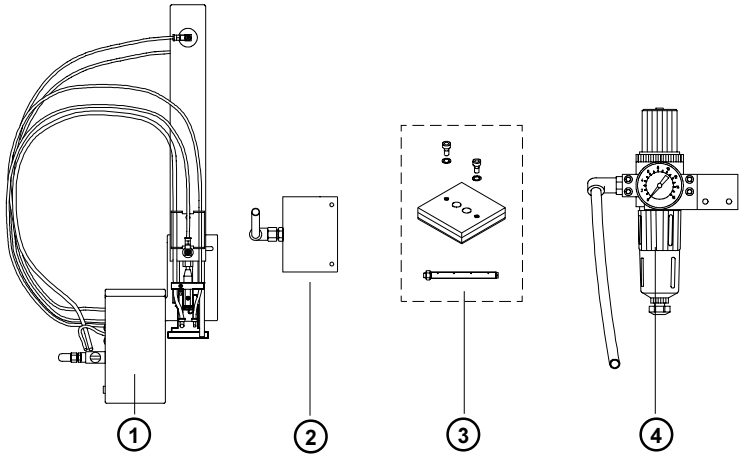

Fig. 2 Equipment supplied

1 - Tamp-Blow Applicator with Lift Cylinder
Tamp-Blow Applicator
4 cylinder-head screws
4 washers
4 spring washers

2 - External Blow Valve
Blow valve with retaining and connectors
2 counter-sunk screw

3 - Pad Unit (as required)
2 cylinder-head screws
2 spring washers
Pad
Blow Tube

4 - Service Unit (optional)
Service Unit
2 oval-headed screws
2 washers

Other options on request.

3. Safety Instructions

Make sure that the **Apollo** is disconnected from the power supply and the valve at the service unit as well as the shutoff valve at the applicator are closed, while installing the delivered components.

In operation, moving parts are easily accessible. Therefore, keep long hair, loose clothes, and jewelry away. Before any manipulations in those areas, close the shutoff valve.

Do not try to manipulate or repair any parts that are not described in the manuals of the Tamp-Blow Applicator or the **Apollo.**

4. Installation

Installing the External Blow Valve

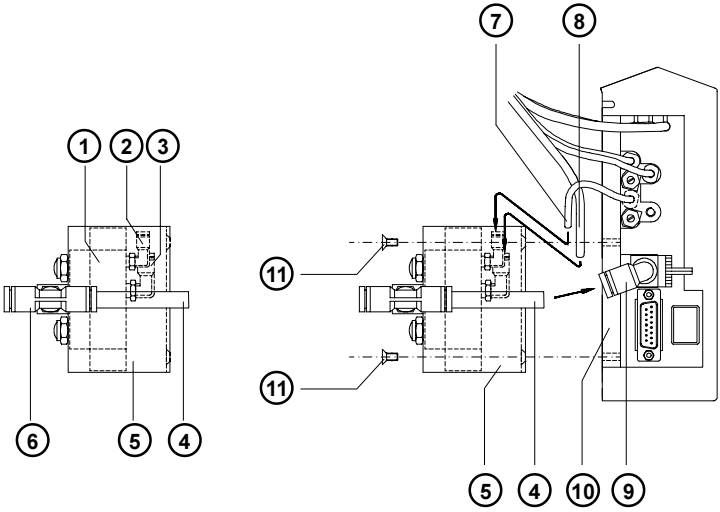

Fig. 4a Installation of the external blow valve

In order to produce the correct amount of air pressure to blow the label onto the product, a valve (**1**) is used which has a higher throughput rate than the standard control valves of the applicator.

1. Fasten the retaining (**5**) of the valve (**1**) at the rear of the base plate (**10**) of the applicator with 2 counter-sunk screws (**11**).

2. Insert the control tube (**7**) and the blow tube (**8**) into the L-fittings (**2** and **3** respectively) at the blow valve.
   Insert tubes firmly.

3. Insert the small tube (**4**) which is fixed at the T-fitting (**6**) into the L-fitting (**9**).
   Insert tube firmly.

Installing the Tamp-Blow Applicator

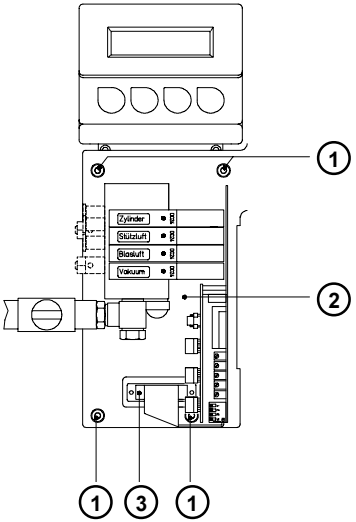

Fig. 4b Installation of the Tamp-Blow Applicator

1. Dismantle the casing of the manifold (**2**) by loosening the screws, two on the left and one on the right.
2. Fasten the applicator at the front of the **Apollo** using the 4 screws supplied (**1**) including the washers.
3. Plug the connector of the applicator's electronic system (**3**) in the peripheral port of the **Apollo**.
4. Reassemble the casing of the manifold.

Unlocking the Securing Device

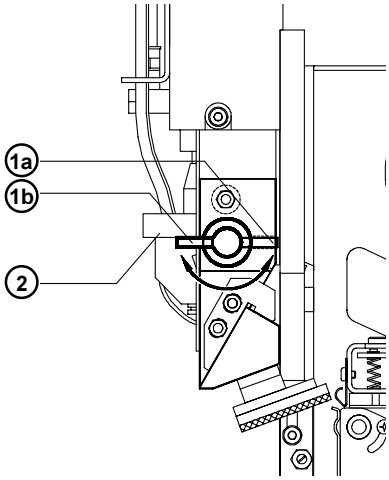

Fig. 4c Unlocking the securing device

When delivered, the lever (**1**) is in position **b** supporting the carrier (**2**). This keeps the pad in the upper position.

To unlock, slightly pull lever (**1**) and rotate counter-clockwise by 180° until the lever clicks into place (position **a**).

NOTICE !
In the event of a long working break, and especially when the compressed air is switched off, lock the securing device.

Installation of the Pad Unit and the Blow Tube

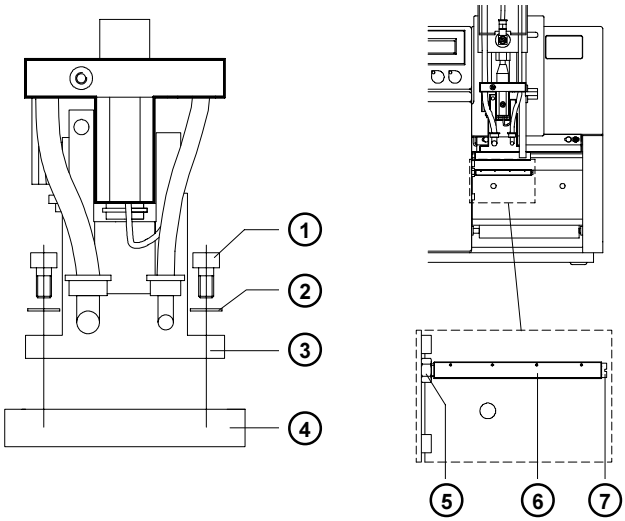

Fig. 4d Installation of the pad and the blow tube

1. Fasten the pad (**4**) with the washers (**2**) and the screws (**1**) at the pad holder (**3**).

2. Screw the blow tube (**6**) into the pneumatic module.

3. Turn the drillings of the tube towards the dispense edge of the printer. Next, hold the slotted screw (**7**) with a screwdriver and fix the tube by fastening the counter nut (**5**).

Installation of the Service Unit

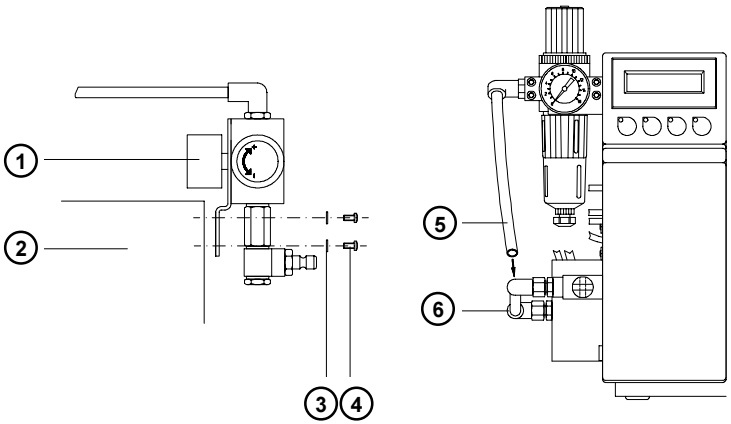

Fig. 4e Installation of the service unit

1. Fasten the service unit (**1**) at the back of the **Apollo** (**2**) using the washers (**3**) and the screws (**4**).

2. Insert the tube of the service unit (**5**) into the push-in L-fitting (**6**) of the external blow valve.
   Insert tube firmly.

Connections

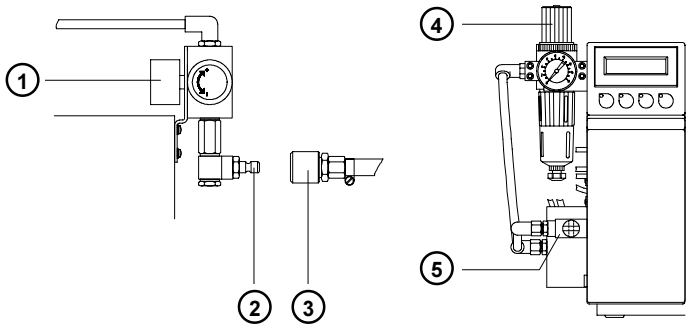

Fig. 4f Connections

1. Prepare the connections to power supply and to the computer as described in the manual of the **Apollo**.

2. To contact the PLC interface use the 15 pin connector (for details see appendix A).

3. Make sure that the shutoff valve (**5**) is closed (lever at the valve is turned vertical).

4. The connector (**2**) for the compressed air supply is located at the service unit (**1**) at the rear of the printer. The connector is suitable for a 1/4" coupling plug (**3**).

5. The air pressure for operating the applicator has to be adjusted at the service unit (**1**).
   - Pull knurled knob (**4**) upwards.
   - Turn knob to tune required operating pressure (4-6 bar). By turning knob clockwise the pressure rises.
   - Push knob down.

6. Switch on the power supply of the **Apollo**.

7. Open the shutoff valve (**5** / lever is turned horizontal).

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5. Adjustments

All supplied applicators have passed a previous running at the factory. It may be useful to perform some more fine tuning when the applicator is installed. This refers mainly to those parameters, which are significant when using the applicator as part of a networked system as well as pneumatic settings, which have an influence on the application rate.

5.1. Mechanical Adjustments

Swing Path of the Pad

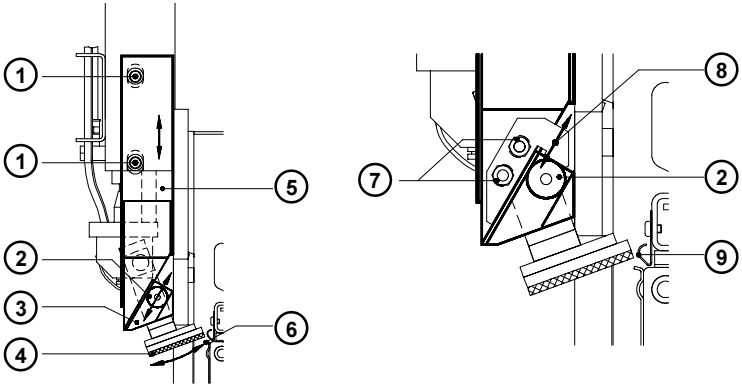

Fig. 5.1a Adjustment of the swing path of the pad

In its upper (starting) position, the pad (**4**) faces the printer. The swing movement of the pad is caused by a guiding system with a pilot bearing (**2**) in the curve (**3**). The swing path and the end position of the pad can be adjusted by shifting the guide rail (**5**).

1. Switch the applicator on.
2. Switch the compressed air on.
3. Loosen the screws (**1**).
4. Loosen the hexagonal nuts (**7**).

5. Move the guide rail (**5**) straight up until the rear edge of the pad (**10**) in its upper (starting) position is located vertically above the dispense edge (**6**) of the printer.
   Do not touch the ribbon shield (**9**).
   By shifting the guide rail downwards, the pad moves closer to the ribbon shield.

6. Tighten the screws (**1**).

A stud (**8**) is fixed at the guide rail to avoid the pad swinging too far and, thus, to avoid it beating against the ribbon shield (**9**), when the applicator moves back.

7. Move the stud (**8**).
   The stud is adjusted correctly if it is possible to push a piece of normal paper between the stud (8) and the bearing (2) while the compressed air is switched on.

8. Tighten the hexagonal nuts (**7**).

Adjusting the Level and the Sides of the Cylinder Unit

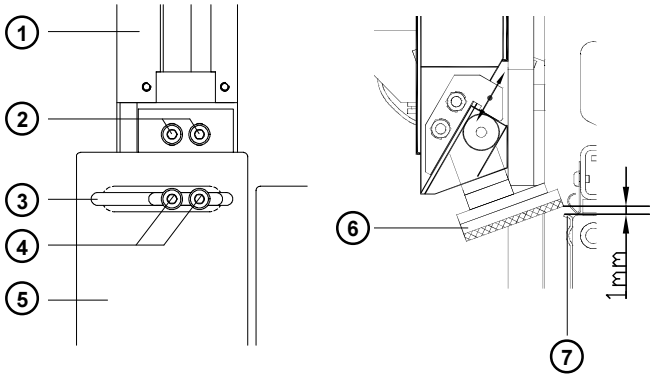

Fig. 5.1b Level adjustment / side adjustment

At the rear of the carrier plate (**5**) of the applicator there are four screws (**2, 4**).

1. For side adjustment of the cylinder unit (**1**), loosen the bottom screws (**4**). The unit can be moved within the longish hole (**3**). Adjust until the pad is aligned centrally to the dispensed label. Tighten screws (**3**).

2. For level adjustment, loosen the upper screws (**2**). Move the whole unit until in its upper (starting) position the pad (**6**) is located slightly above the dispense edge (**7**) of the **Apollo**. The distance between the pad and the dispense edge of the **Apollo** is recommended to be around 1 mm.
   Tighten screws (**2**).

Adjusting the Labelling Position

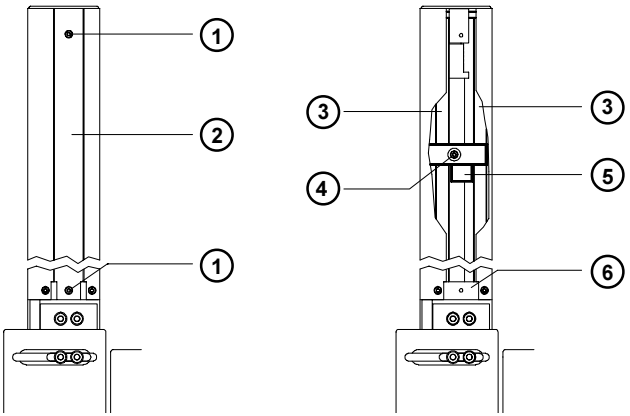

Fig. 5.1c Adjustment of the labelling position

After setting up the applicator, the labelling position (i.e. the lower end position of the pad) needs to be adjusted depending on the height of the products to be labelled.

1. Place a product sample at the labelling point.
2. Close the shutoff valve for the compressed air.
3. Loosen the set screws (**1**) and dismount the central covering (**2**) at the back of the cylinder casing.
4. Loosen the stop collar set screw (**4**) **enough** so that you can move the collar with rubber block (**5**) along the guide bars (**3**).
5. Unlock the securing device and move the pad manually into the required labelling position (max .8 in/ 20 mm above the product).
6. Move the stop collar (**5**) against the stop block (**6**) and tighten the set screw (**4**).
7. Reassemble the covering (**2**).
8. Open the shutoff valve.

Tuning of the Blow Tube

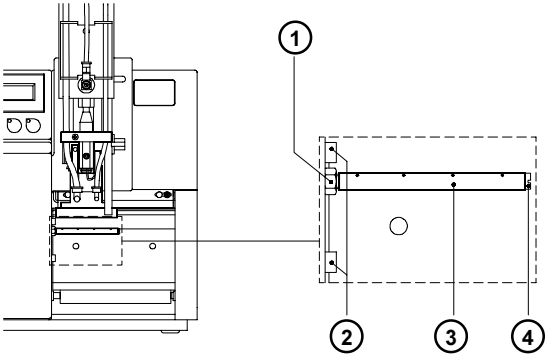

Fig. 5.1d Tuning of the blow tube

The blow tube (**3**) for the supporting air may be adjusted vertically and also be rotated around its longitudinal axis.

1. For vertical adjustment, loosen the two screws (**2**) and move the tube (**3**) as required.
   Tighten screws (**2**).

2. To rotate the blow tube and, consequently, change the direction of the air current, hold slotted screw (**4**) with a screwdriver while loosening counter nut (**1**). Adjust the tube until the air current is aligned to the dispense edge of the printer.
   Tighten counter nut.

Adjustment of the Blow-on Angle of the Pad

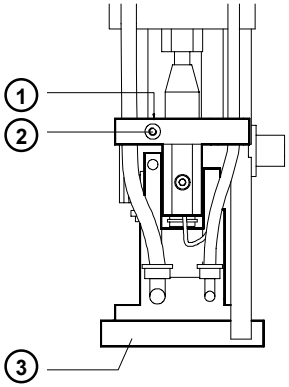

Fig. 5.1e Adjustment of the blow-on angle of the pad

The pad has to be adjusted in such a way that the pad (**3**) is in a horizontal position when it applies the label.

1. Close the shutoff valve (pad moves downwards).
2. Loosen the securing screw (**2**).
3. Turn the adjusting screw (**1**) until the pad is horizontal. Turning clockwise swings the pad (**3**) towards the printer.
4. Tighten securing screw (**2**).
5. Open the shutoff valve.

5.2. Pneumatic Adjustments

Control Valves

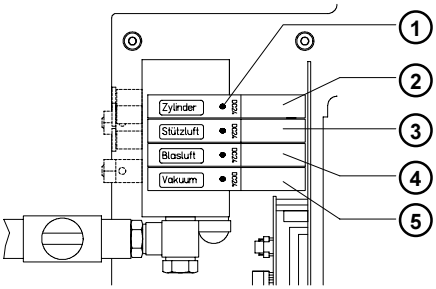

Fig. 5.2a Control valves

To reach the control valves, the casing of the manifold has to be removed. Therefore, loosen the screws at the cover, two on the left and one on the right.
That way, four electric switchable control valves for compressed air become accessible. For manual tuning, the valves may also be operated by integrated keys (**1**).

The functions of the valves are as explained below.

'Zylinder' (**2**/ lift cylinder) :
Two-way valve to control the lift cylinder.
When the valve is switched off the pad is kept in the starting position. Switching the valve on will move down the pad into the labelling (stamp) position. Normally the disconnection of the valve is controlled by the signal of the labelling position sensor. When operated manually, there is no controlling by the labelling position sensor. The pad moves to the bottom as far as possible and stays in that position until the key is released.

'Stützluft' (**3**/ supporting air) :
This valve controls the switch-on of the supporting air at the blow tube.

'Blasluft' (**4**/ blow air) :
This valve controls the external blow valve and, thus, operates the switch-on of the blow air on the pad.

'Vakuum' (**5**/ vacuum nozzle) :
This valve operates the vacuum nozzle and, consequently, controls the vacuum on the pad for picking-up the label.

Throttle Valves at the Lift Cylinder

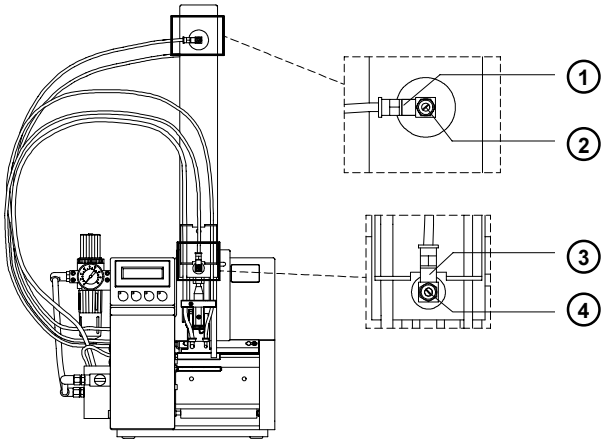

Fig. 5.2b Throttle valves at the lift cylinder

The setting of the lift cylinder may be regulated via two throttle valves (**1, 3**). Those valves regulate the speed at which the compressed air escapes the two air containers.
The valves are adjustable by turning the throttle screws (**2, 4**). Turning clockwise will close the valves.

A wider opening of the bottom valve (**3**) speeds up the pad moving down, a wider opening of the top valve (**1**) accelerates the upward movement.

Throttle Valves at the Manifold

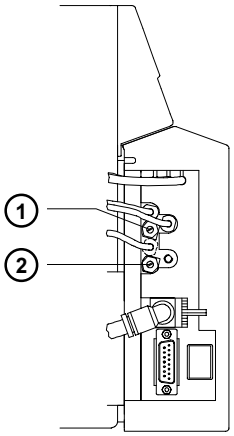

Fig. 5.2c Throttle valves at the manifold

Throttle valve to regulate the supporting air (1)

With this valve the supporting air to blow the label onto the pad can be adjusted.
Turn the throttle screw to adjust the valve. Turning clockwise will close the valve.
The valve has to be tuned in such a way, that the label is blown onto the pad without turning or swinging.

Throttle valve to regulate the vacuum (2)

With this valve the vacuum to suck the label onto the pad can be adjusted.
Turn the throttle screw to adjust the valve. Turning clockwise will close the valve.
The vacuum may be adjusted until the label totally sticks on the vacuum plate.

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5.3. Selection of the Operation Mode

The Tamp-Blow Applicator, with its standard components, can be operated in three different ways. While the original process stays the same, the operation mode can be chosen within the control electronics.
The three operation modes differ in the order of labelling and printing within one labelling cycle. A mode can be selected through actuating a DIP switch. The operating modes can be adjusted by setting different time delays.
Furthermore, there is a special function using the pre-dispense key for adjusting, etc.

Operation Mode 'Printing / Labelling'

The print of a label is released by an external start signal (via PLC interface). At the same moment the vacuum on the pad as well as the supporting air from the blow tube are switched on. When the label is printed and picked up from the carrier ribbon, the supporting air is switched off. Then the lift cylinder is driven 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 blow air is switched on briefly through which the label is placed onto the product.
Next, the lift cylinder is driven to move the pad back into the starting position. Thus, the labelling cycle is finished.

Operation Mode 'Labelling / Printing - Upper Stand-By Position'

Before starting the mode 'Labelling / Printing', the printing and picking up of the first label has to be released separately by a special signal (via PLC interface).
The pad with the printed label is in the starting position. The vacuum on the plate is switched on.
By an external start signal, the lift cylinder is driven to move the pad down into the labelling position. The sensor signals when the labelling position is reached. In the following, the vacuum is switched off and the blow air is switched on briefly through which the label is placed onto the product.
Next, the lift cylinder is driven to move the pad back into the starting position. The print of the next label is released. At the same moment, the vacuum on the plate as well as the supporting air are switched on. When the label is printed and completely picked up, the supporting air is switched off. Thus, the labelling cycle is finished.

Operation Mode 'Labelling / Printing - Lower Stand-By Position'

This operation mode differs from the above described mode 'Labelling / Printing - Upper Stand-By Position' in so far as the printed label is immediately moved into the labelling position and is being held there. Consequently, the next cycle begins by blowing the label onto the product.

Function of the Pre-Dispense Key

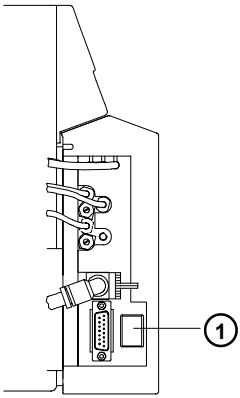

Fig. 5.3a Pre-dispense key

By pressing the pre-dispense key (**1**), half cycles of the labelling process may alternately be released, provided that there is a current print job.

1(st) half cycle

Pressing the key will release the print of one label. At the same moment the vacuum at the pad as well as the supporting air (blow tube) are switched on. After the label has been printed and picked up by the pad, the supporting air is switched off.

2(nd) half cycle

Pressing the key will drive the lift cylinder to move the pad down into the labelling position. The sensor signals when the labelling position is reached.
Following, the vacuum is switched off and the blow air is switched on briefly through which the label is placed onto the product.
Then, the lift cylinder is driven to move the pad back into the starting position.

If the label is removed from the pad manually after the first half cycle of the labelling process, this half cycle will be repeated when the pre-dispense key is pressed again.

If there is no current print job, only the movements of the pad as described for the second part of the labelling cycle are carried out, when pressing the key.

The first half cycle of the labelling process may also be released by pressing the  key on the control panel of the printer. In that case, a blank label is picked up by the pad. That way, the whole labelling process may be simulated by alternately pressing the  key and the pre-dispense key without a current print job or a connection to a computer.

Setting the Operation Mode and Delay Times

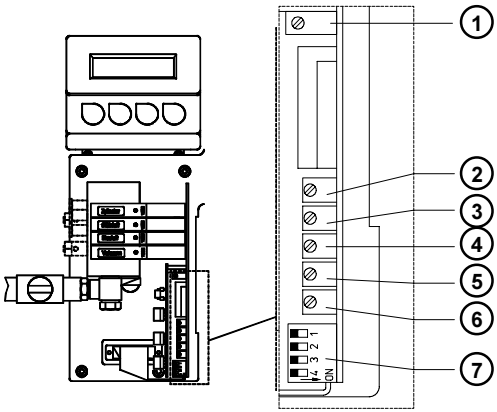

Fig. 5.3b Potentiometers and DIP switches

For best adaptation, the applicator offers several methods to adjust it to the whole system and, therefore, to the required needs. After removing the cover of the manifold, 6 potentiometers as well as 4 DIP switches become accessible by which the parameters can be set.

Potentiometers

Potentiometer 1 is sealed. Certain voltage settings are pre-adjusted from the factory and not to be changed by the user.
The potentiometers offer the adjustment of the labelling process by changing certain time delays. If any of the settings is changed, the actual value is briefly shown in the printer display.

Potentiometer (**2**) : t_B - blowing time 0 ... 2.5 s

This potentiometer is used to set the time period of the blow air for the transfer of the label onto the product.

Potentiometer (**3**) : t_{SA} - switch-off delay supporting air 0 ... 2.5 s

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 silicon liner. This may affect the accuracy of the label positioning or even cause labelling faults. Therefore, switching off the supporting air delayed may be useful to separate the label from the carrier ribbon and place it neatly on the surface of the pad.

Potentiometer (**4**) : s_{SE} - switch-on delay supporting air 0 ... .8in/20mm

The supporting air from the blow tube is not immediately switched on when the print of the label is released but delayed, when the label has covered a certain distance s_{SE}.
This delay helps to prevent a turning or swinging at the front of the label and, consequently, avoids faults when the label is picked up from the printer.
The parameter measures the distance covered by the label before the supporting air is switched on, and does not depend on the print speed. This way, the position of the label may be determined until the air is switched on.

Potentiometer (**5**) : t_{SP} - locking time 0 ... 2.5 s

All start signals coming in following the first start signal are ignored when they arrive within the locking time t_{SP}.

Potentiometer (**6**) : t_{VS} - start delay 0 ... 2.5 s

The parameter t_{VS} determines the time period between the start signal and the start of the labelling process. This delay makes it possible to release the start of the process controlled by a sensor, for instance, when a sensor is located within an assembly line in front of the labelling place.

DIP Switches

Using the DIP switches (**7**), the operation mode as well as the firmware of the applicator may be altered.

DIP Switch	Parameter	ON	OFF
1	Stand-by position (only if DIP2 is OFF and DIP3 is OFF)	upper position	lower position
2	Applicator	Tamp Applicator	Tamp-Blow Applicator
3	Operation mode	printing / labelling	labelling / printing
4	Saving potentiometer settings	no	yes

If switch No. 4 is OFF the setting of the potentiometers is automatically stored in the printer when switched on. Therefore, in case the applicator has been changed (e.g. in case of an accident) the settings are still saved and may be transferred to a replacement. (see also section about Print Info Display).

Print Info Display

Apollo offers a convenient option for recalling information about the configuration and hardware problems in the printer info display (see also Operator's Manual of the **Apollo** / section 11).

First, press the 

key to switch from ONLINE mode into OFFLINE mode. Next, to recall the desired printer information, press the 

key to see the first of the five display pages available. Press key repeatedly to view the other pages. When an applicator is installed, this display is extended by another five pages. After the standard pages, the following parameters are shown :

- start delay
- locking time
- switch-off delay supporting air
- blowing time
- switch-on delay supporting air.

When the reviewing is completed, switch back into ONLINE mode by pressing the 

key.

In case the applicator has been changed (e.g. in case of an accident) the stored parameters can be viewed as described above and the new device can be adjusted accordingly. For that purpose the DIP-switch 4 at the new applicator has to be 'ON' during switching on the device the first time.

6. Operation

1. **Check all external connections before starting to print.**
2. Make sure that the media is loaded corresponding to the instructions in the chapter 'Present Sensor / Inserting the Labels for Peel-off' of the Operator's Manual **Apollo**.
3. Check that the transfer ribbon is loaded properly before starting to print (see section 6 Operator's Manual **Apollo**).
4. Make sure that the pad is not covered by a label when switching on the device.
5. Open the shutoff valve.
6. Make sure that the securing device has been unlocked (see also section 4).
7. Switch into the present mode of the Apollo during programming and set the peel position to remove the labels from the carrier ribbon corresponding to the size of the label.
8. **Before starting the first print job, press the FF key on the printer.**

   This generates a synchronous running. Remove the processed labels manually. After a few seconds the printer carries out a brief reverse feed and the edge of the next label is positioned at the print line.
   This synchronizing also has to be carried out when the print job has been interrupted with the CAN key.
9. Start the print job.
10. Start the labelling process via PLC interface.

If an error occurs while the applicator is operating, this is shown in the display of the **Apollo** (for types of errors and how to treat them see appendix B).

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Appendix A - PLC Interface

For use in a networked system the applicator is equipped with a PLC interface to start and interrupt the labelling process. It also passes on state information as well as error messages of the applicator to the system control.
The interface has a 15 pin SUB-D connector.

Pin Assignment of the PLC Interface

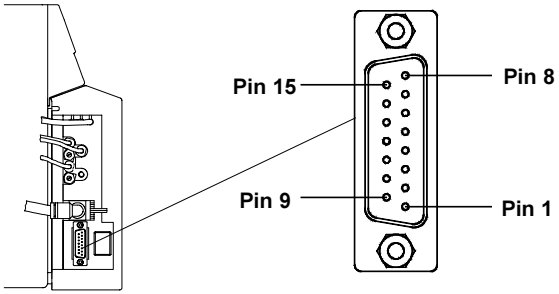


Fig. A-1 Connector of the PLC Interface

PIN	Signal	Direction	Function
1	XSTRT	input	start signal
2	XSTP	input	stop signal
3	XDREE	input	print first label
4	XDNB	output	printer not ready
5	XEDG	output	no existing print job
6	XSAA	output	general error message
7	XSOE	output	pad in starting position
8	GND	output	grounding (0V)
9	XSTRTR	(input)	start signal (reverse line)
10	XSTPR	(input)	stop signal (reverse line)
11	XDREER	(input)	print first label (reverse line)
12	XSUE	output	pad in labelling position
13	XETF	output	applicator fault
14	RÜL	output	reverse line (for all output signals)
15	24P	output	operating voltage +24V, Si T 100mA

Table A-1 Pin Assignment of the PLC Interface

Circuit Diagrams of Inputs and Outputs

The **inputs** are optocouplers with a current limiting resistor of 2.4kΩ in the input circuit.
For each signal X[IN] there is a separate reverse line X[IN]R via the plug connector. From that, the following matching pairs of signals result :

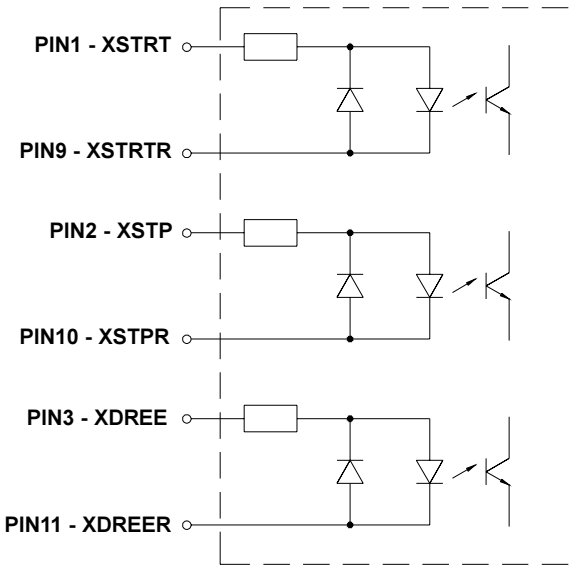


Fig. A-2 Circuit of the Inputs

All **outputs** are realized through solid state relays which outputs are connected among one another one-sided. The joint line is lead to the plug connector as RÜL signal.
The switch function of the outputs is to open or close the contact between the joint line RÜL and the respective output.

Electrical requirements : U_{max} = 42V
I_{max} = 100mA

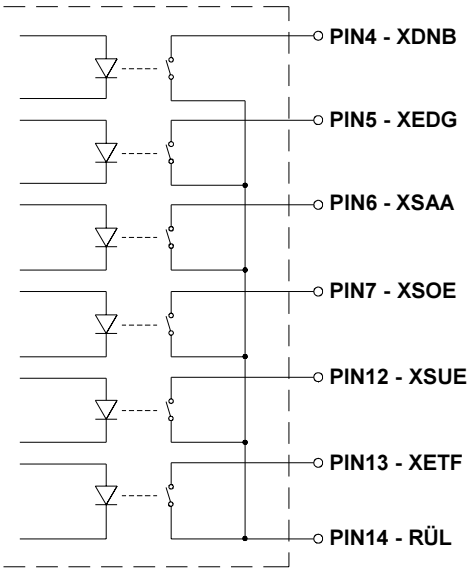


Fig. A-3 Circuit of the Outputs

Comments on the Signals

PIN1 - XSTRT - Start signal

This signal will release the start of the labelling process. It is active when a current flows between PIN1 and PIN9.

PIN2 - XSTP - Stop signal

The signal is active when a current flows between PIN2 and PIN10.
It releases following functions :
- to finish the print of a label and its picking-up by the pad
- to interrupt or to stop the beginning of the labelling process
- to make the pad moving back into the starting position
- to command the disregard of all following signals
- if the stop signal has been activated during the labelling phase, the display will show the message 'Host stop/ error'. (does not show message during print process)

PIN3 - XDREE - Print first label

When current flows between PIN3 and PIN11 the print of the first label and its picking-up by the pad is released within the operation mode 'Labelling / Printing'.
When the labelling process is started by the XSTRT signal within the operation mode 'Labelling / Printing', the cylinder will start to place the label onto the product at once. Only after that, a new label is printed. Therefore, the provision of the first label has to be assigned by a separate signal.
In the 'Printing / Labelling' mode this signal has no function.

PIN4 - XDNB - Printer not ready

This is an error message of the printer.
The details and type of error can be learnt from the printer display. ('Ribbon out'; 'Paper out'; 'No label')
In this state the contact between PIN4 and PIN14 is opened.
After error correction, the print of the last label will be repeated.

PIN5 - XEDG - No existing print job

State message.
There is no print job currently available.
In this state the contact between PIN5 and PIN14 is opened.

PIN6 - XSAA - General error message

General error message of both, printer and applicator.
This message is shown when one of the two errors either XDNB or XETF occurs. This signal is important in case that only one error signal of the applicator can be analysed from the system control.
In this state the contact between PIN6 and PIN14 is opened.

PIN7 - XSOE - Pad in starting position

The signal is active when the pad is in the starting position where it picks up the label from the printer.
In this state the contact between PIN7 and PIN14 is opened.

PIN8 - GND - Grounding (0V)

PIN9 - XSTRTR - Reverse line of the start signal XSTRT

PIN10 - XSTPR - Reverse line of the stop signal XSTP

PIN11 - XDREER - Reverse line of the print first label signal XDREE

PIN12 - XSUE - Pad in labelling position

The signal is active when the pad is in its labelling position where the label is removed from the vacuum plate and positioned onto the product.
In this state the contact between PIN12 and PIN14 is opened.

PIN13 - XETF - Applicator fault

This is an error message of the applicator.
This message is shown when one of the following errors occurs at the applicator :

- pad has not reached the labelling position within 2s after the movement of the cylinder
- pad has not reached the starting position within 2s after the movement of the cylinder
- a printed label has not been picked up by the pad properly or it fell down during the movement of the cylinder (message of the vacuum sensor)
- the label is still on the vacuum plate of the pad when the cylinder moves back up (message of the vacuum sensor)

The type of fault is shown in the display of the printer.
In this state the contact between PIN13 and PIN14 is opened.
After fault correction, the print of the last label printed before the fault occured will not be repeated.

PIN14 - RÜL - Reverse line (for all output signals)

PIN15 - 24P - Operating voltage +24V, Si T 100mA

There is an operating voltage of 24V available on PIN15 provided from the applicator system.

CAUTION !
You must not apply any external voltage on PIN15 !

The operating voltage on the plug connector allows the use of the applicator without being part of a networked system. The start signal which is required for releasing the labelling process may be caused, for instance, by a suitable foot controlled switch with a 15 pin SUB-D plug.

Examples for Circuits to Creating a Start Signal

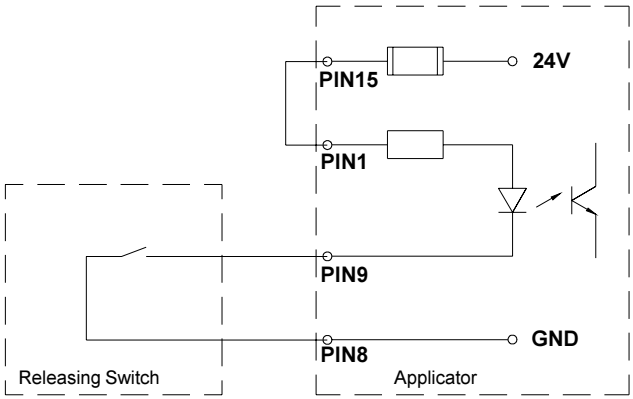
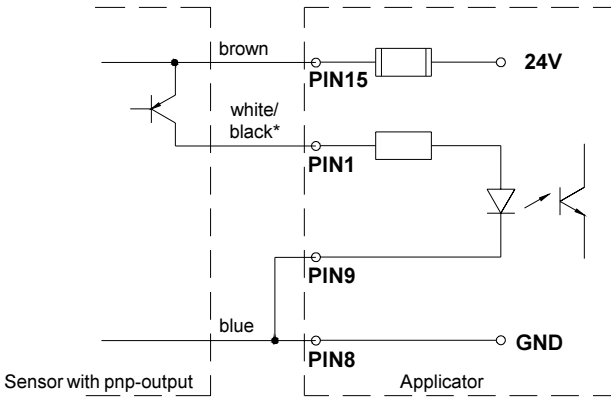
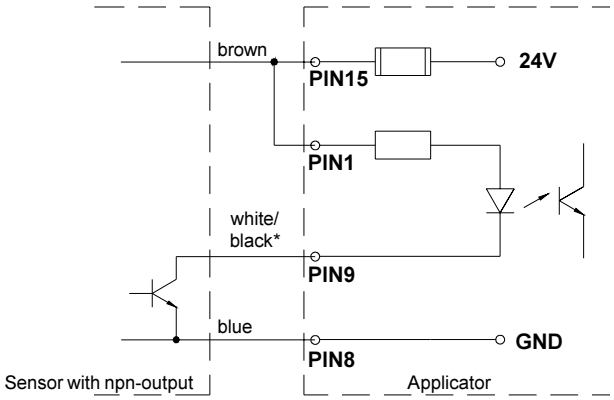


Fig. A-4 Example with releasing switch



* dependent on the used sensor

Fig. A-5 Example for an optical sensor with pnp-output



* dependent on the used sensor

Fig. A-6 Example for an optical sensor with npn-output

Appendix B - Error Messages

Error Messages of the Printer

Detailed information about printer errors (e.g. 'Paper out', 'Ribbon out', etc.), their causes and correction methods can be found in the Operator's manual for the **Apollo** (Appendix C).

With the installation of an applicator the error treatment expands. This means in particular, that after correcting the error and **before** the correction is quit with the PSE key, an additional label feed has to be released using the FF key. This synchronizes the process of printing and labelling. Possibly dispensed blank labels have to be removed manually.
After quitting the error message the label caused the error will be printed once more.

Error Messages of the Applicator

The following table gives an overview of error messages and their possible cause. It also suggests methods to resolve the problem. After error correction, always quit the error message of the applicator with the PSE key.

To reprint the label where the applicator error occurred, a new print job has to be released.

Error message	Possible cause	Solution
Label not depos.	Label has not been placed onto the product; after the lift has moved back the label still sticks on the vacuum plate of the pad	Label the product manually
Upper position	Pad has not reached the starting position within 2s after the lift has moved back; or Pad has left the starting position unauthorized	Check the pneumatic adjustments (esp. the upper throttle valve of the cylinder); Label the product manually
Host stop/ error	Labelling process has been interrupted by an XSTP stop signal via PLC interface	Label the product manually if necessary
Refl. sensor blk.	There has been no change of the switch state at the upper control sensor (at the cylinder) between the start of the labelling process and the signal from the labelling position sensor	Check the sensor (service)
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	If possible, place the 'lost' label onto the product manually; Otherwise stop print job and start again with adapted parameters (e.g. count)
Lower position	Pad has not reached the labelling position within 2s after the movement of the cylinder	Check the pneumatic adjustments (esp. the lower throttle valve of the cylinder); Make sure that the securing device has been unlocked; Check the applicator for heaviness of its mechanics; Check the labelling position sensor (service); Label the product manually

Table B-1 Error messages of the applicator

Appendix C - Function of the LEDs of the Electronics

PLC Port PCB

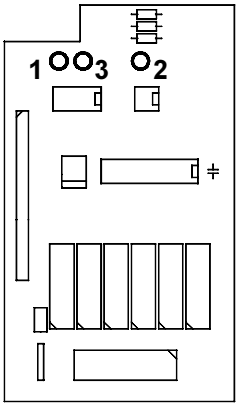


Fig. C-1 LED on the PLC port PCB

LED No.	Colour	Function	Active state
1	green	PLC signal XSTRT	ON
2	green	PLC signal XSTP	ON
3	green	PLC signal XDREE	ON

Table C-1 LED on the PLC port PCB

PCB Applicator Control

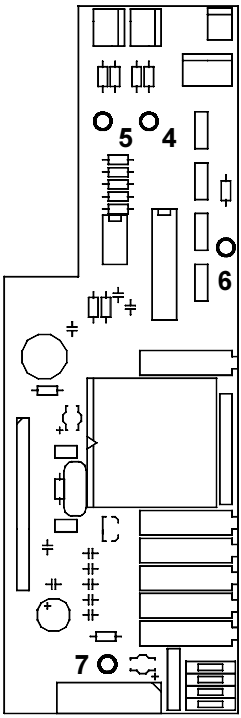


Fig. C-2 LED on the applicator control PCB

LED No.	Colour	Function	Active state
4	red	Labelling position sensor	OFF
5	red	Sensor signals that pad is in starting position	ON
6	yellow	Label on the pad	ON
7	yellow	Operating voltage 5V	ON

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Herewith we declare that the following described machine, from the design and style and as we sell it, complies with the relevant EC Safety and Health Requirements. This declaration will lose the validity if there are any changes of the machine or the purpose without our consent.

Description:	Type:
Applicator	**Tamp-Blow Applicator with Lift Cylinder**

Applied EC Regulations and Norms:

- **EC Machinery Regulations**	**98/37/EU**
- Machine Safety	EN 292-2:1991 + A1:1995
- **EC Low Voltage Regulations**	**73/23/EEC**
- Data and Office Machine Safety	EN 60950:1992 + A1:1993 EN 60950/A2:1993 + A3:1995 + A4:1997
- **EC Electromagnetic Compatibility Regulations**	**89/336/EEC**
- Threshold values for the Interference of Data Machines	EN 55022:1998
- Limits for harmonic current emission	EN 61000-3-2:1995 + A1:1998 + A2:1998 + A14:2000
- Limits of voltage fluctuation and flicker	EN 61000-3-3:1995
- Immunity characteristics- Limits and methods of measurement	EN 55024:1998

Signature for the producer:

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Sömmerda, 01.10.01

Erwin Fascher
Managing Director