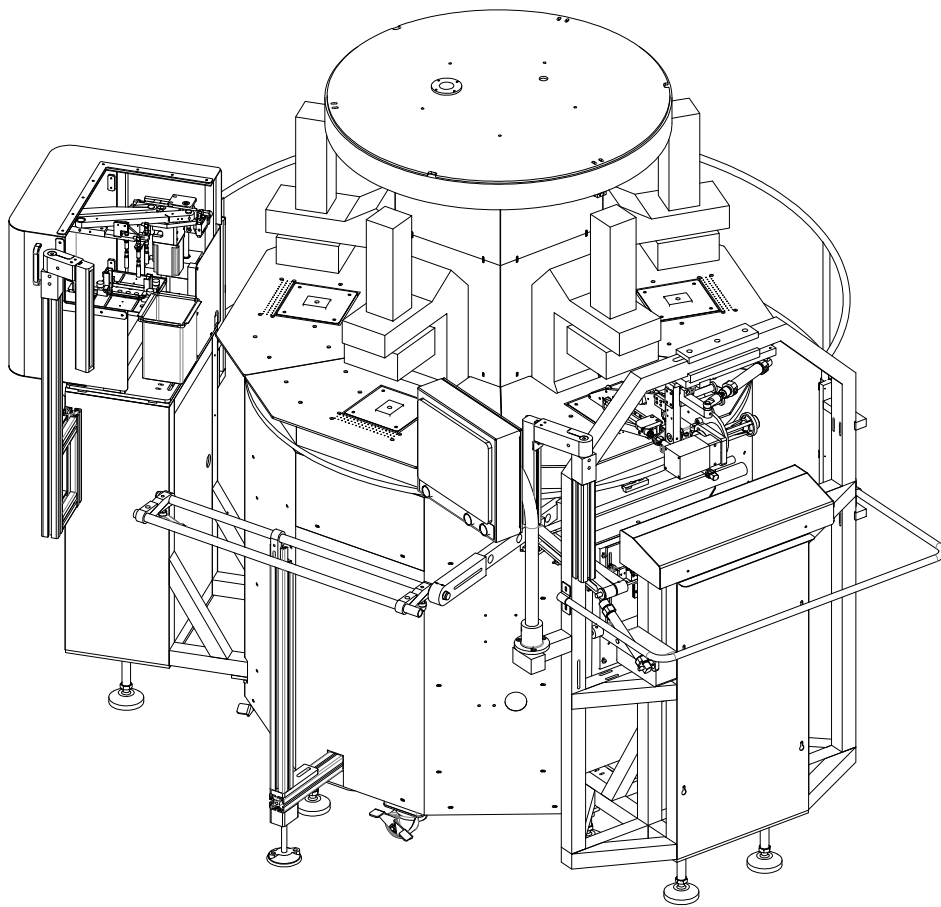


F1015

INSTRUCTION MANUAL

Please read this Instruction Manual before you use the machine.
Please keep this Manual within easy reach for quick reference.

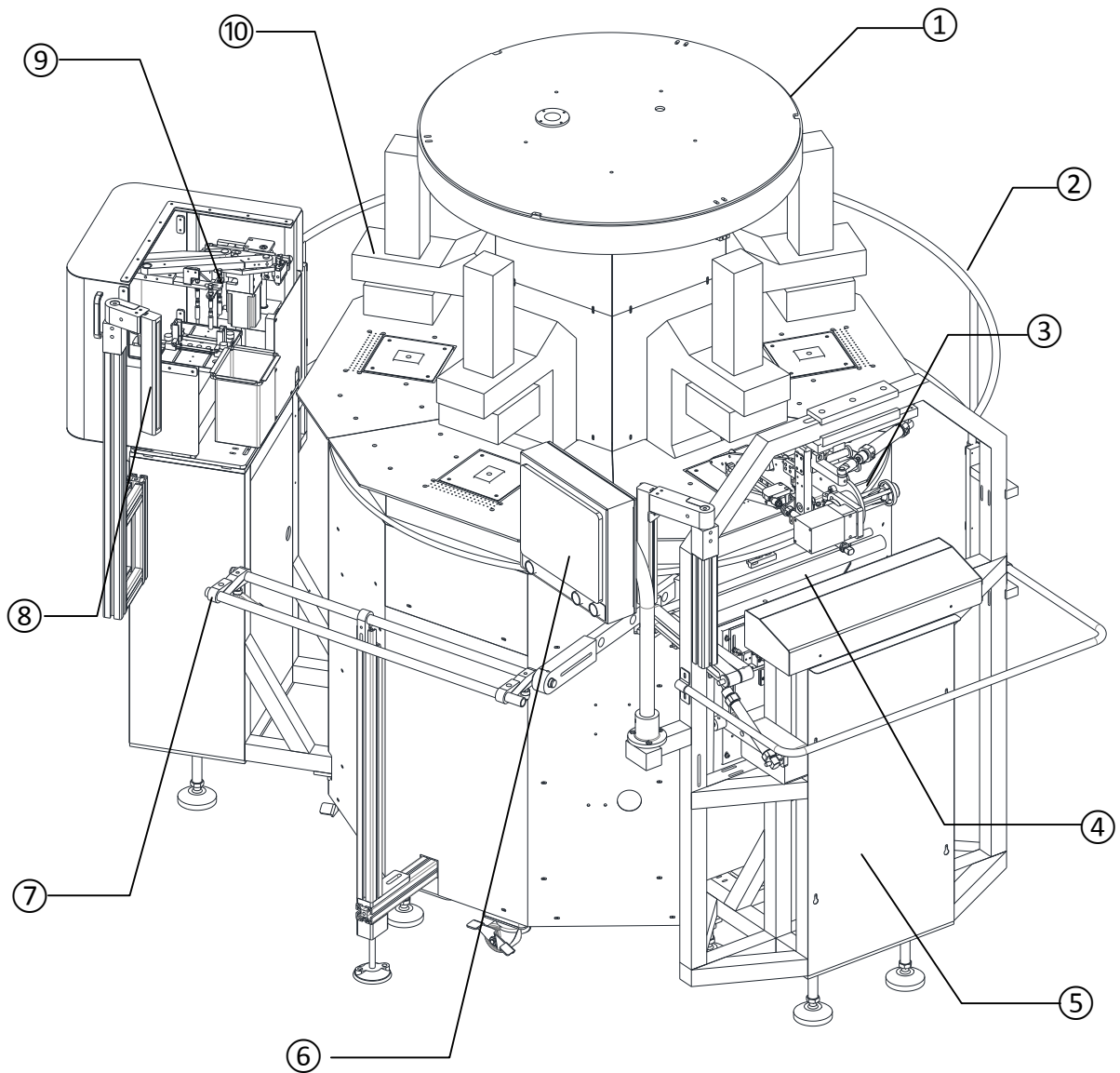
Five-Station Automatic Label Printing Machine



Contents

| | | |
|------|--|---|
| I. | Names of Major Parts | 1 |
| II. | Debugging of Label Printing Machine..... | 2 |
| III. | Settings of Label Printing Machine | 3 |
| IV. | Running of Label Printing Machine | 5 |
| V. | Table of Error Codes..... | 7 |

I. Names of Major Parts



① LED ring lamp

② Safety guard

③ Label tear-off device

④ Receiving device

⑤ Electric cabinet

⑥ Touch screen

⑦ Start switch

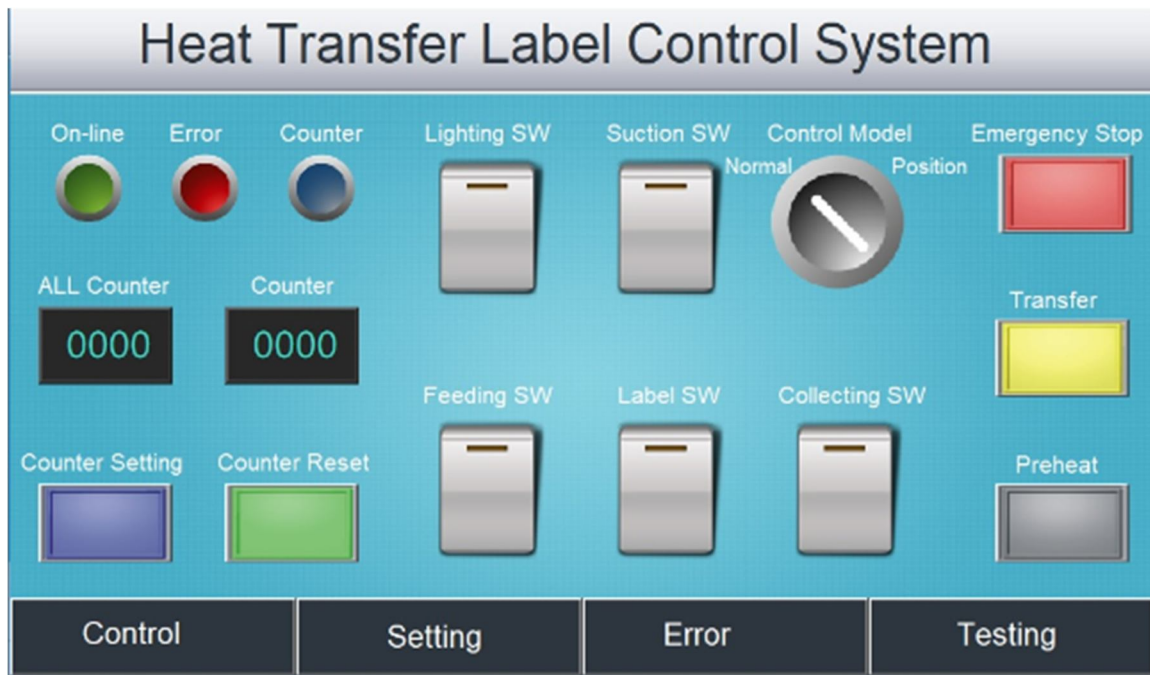
⑧ Grating starter


⑨ Label feeding device

⑩ Pressing and ironing device

II. Debugging of Label Printing Machine

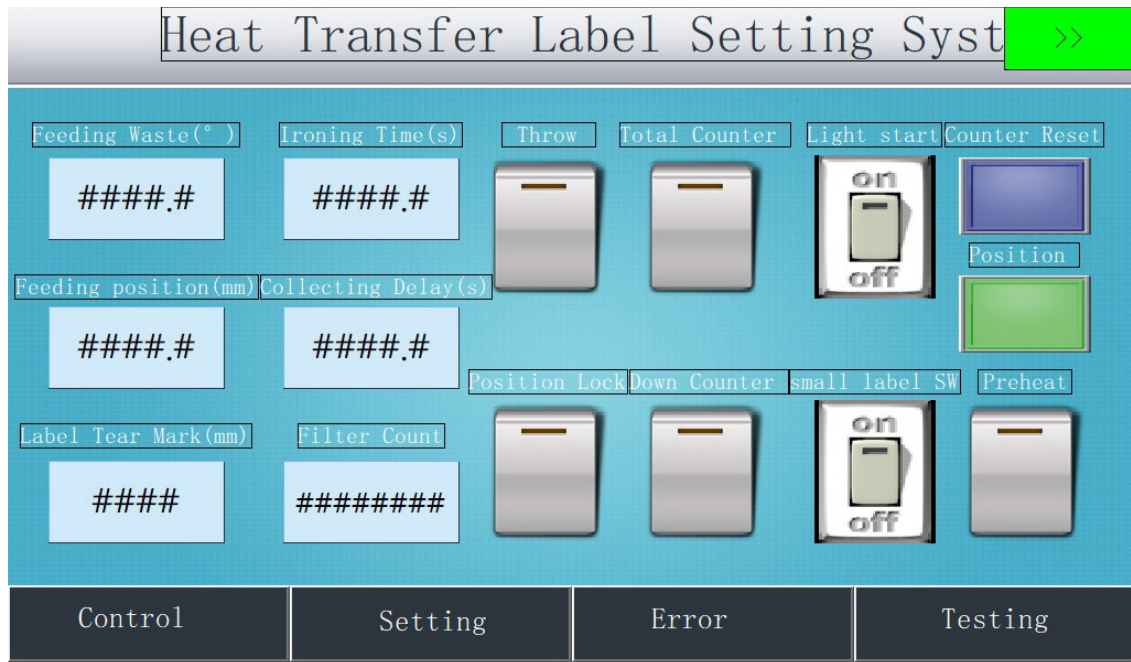
1. After connecting power supply and air supply, turn on the power switch. Start the machine and the following interface will be displayed on the screen.




2. Click Icon button  and switch to “Align” mode.
3. Press “On-line” button below the touch screen. The equipment will connect with each other on line.
4. Debugging method:
 - 4.1 Press “On-line” button below the touch screen. The label-feeding mechanical arm will deliver the label forward.
 - 4.2 Press “On-line” button below the touch screen again. The label-feeding mechanical arm will drop. (Dropping distance is controlled by “Positioning in Label Feeding” as indicated on the setup window. Larger number indicates longer distance.)
 - 4.3 Adjust the position of template on the ironing table.
 - 4.4 Press “On-line” button below the touch screen. The label-feeding mechanical arm will rise.
 - 4.5 Press “On-line” button below the touch screen again. The label-feeding mechanical arm will move backwards.
 - 4.6 Press simultaneously the start-up buttons on both sides of feeding rod, and the equipment will rotate to the next position. Repeat the Step 1 until positions of 5 templates on the ironing table have been adjusted.


III. Settings of Label Printing Machine

1. Click “Setup Window” button. The following interface will be displayed on the screen.





2. Click the window below “Pressing and Ironing Time” icon. Enter the pressing and ironing time of the ironing table.
3. Click the window below “Label Tear-off Code” icon. Enter relative value of label tear-off rotation. (Larger value indicates more tape rotation)



4. If paper remains between labels, click icon  to enable paper throwing.

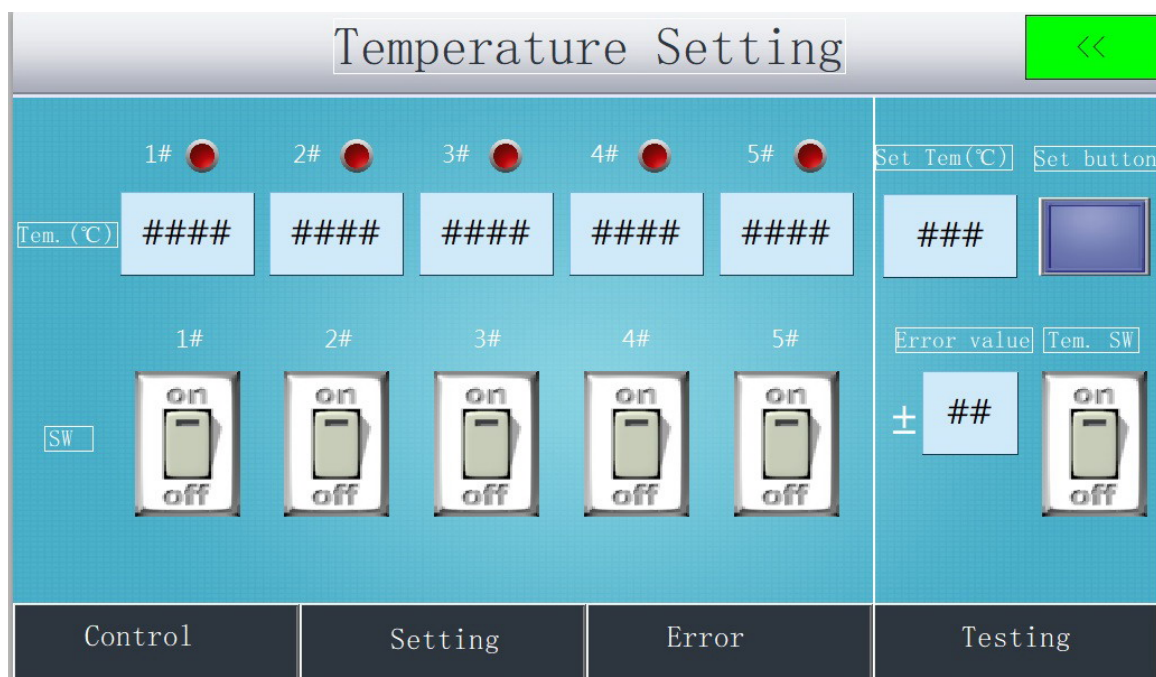
5. If total count is required, click icon  to enable total counting, and it will be displayed on the “Total Counter” window on the control interface.

6. If the count needs to be cleared, click icon  to reset the total count.

7. If a sub-total is required, click icon  to enable down-counting, and it will be displayed on the “Countdown Setup” window under control interface. The sub-total value can be set in the “Countdown Setup” on the control interface. When the sub-total value is satisfied, the countdown indicator light on the control interface will blink and the equipment will automatically stop.

8. Preheat the ironing table before running the machine. Turn on "Preheat Switch"  in the setup window to perform the preheating on the control interface.

9. If the cloth is too small and the material collection swing bar cannot collect the pressed and ironed cloth, click the icon  to open the function of collecting small pieces. If the cloth is long enough, please turn off the function in time.
10. In the process of using, the default of the system is to press down the start switch on both sides of the feeding rod to run the device. Click the icon  to open the start function of the light curtain.



Temperature setting:


1. Turn ON the temperature switch "ON" and enter the corresponding error value.
 Note: when the difference between the set temperature value and the actual value exceeds the error value, the corresponding alarm light will alarm and the equipment will stop running.
2. Enter the required temperature value in the column of setting value and press the setting key to confirm. After 5 seconds, all thermostat Settings on the hot table will be set. (the set value is only valid when the temperature switch is turned on)
3. SW: control the switch of the station, and close the corresponding station with hot head under the "ON" state; "OFF" position hot head open.
4. Temperature: display the real-time temperature value of the corresponding station.

IV. Running of Label Printing Machine

1. Basic Operations of the Label Printing Machine:

- 1) Start the machine and the following interface will be displayed on the screen.



- 2) Click "Control Mode" button and switch to "Normal".
- 3) If air suction system is not required, click "Suction Switch" button to close the air suction system. Click "Feed Label Switch" button to open the label feeding system. If label receiving system is required, click "Receive Label Switch" button to open the label receiving system. If material receiving system is required, click "Receive Material Switch" button to open the material receiving system.
- 4) Press "On-line" button below the touch screen. The equipment will connect with each other on line.
- 5) Preheat the ironing table before working. Turn on "Preheat Switch" on the setup interface. Return to the control interface, and press "Preheat" button . The ironing head will drop to heat the ironing table. The ironing head will retract automatically after the ironing table reaches a certain degree, and the preheating is completed.
- 6) After placing the cloth on the ironing table properly, press the start-up switches on both sides of the feeding rod. The equipment will start to run. When the equipment rotates to the next position, repeat the loading step.

- 7) When problem occurs in label feeding, press the Emergency Stop button below the touch screen. The current ironing table will be reset upward, and the positions of cloth and labels could be adjusted manually. In case no labels or bad labels are fed, press the Replace Label button, the label-feeding mechanical arm will feed the label again. Finally, press the start-up switches on both sides of the feeding rod, the equipment will continue to run.
- 8) When the work is about to be finished, the last piece of cloth is placed. Click the “Transposition Key” on the screen, the equipment will run automatically and stop running upon the completion of work.

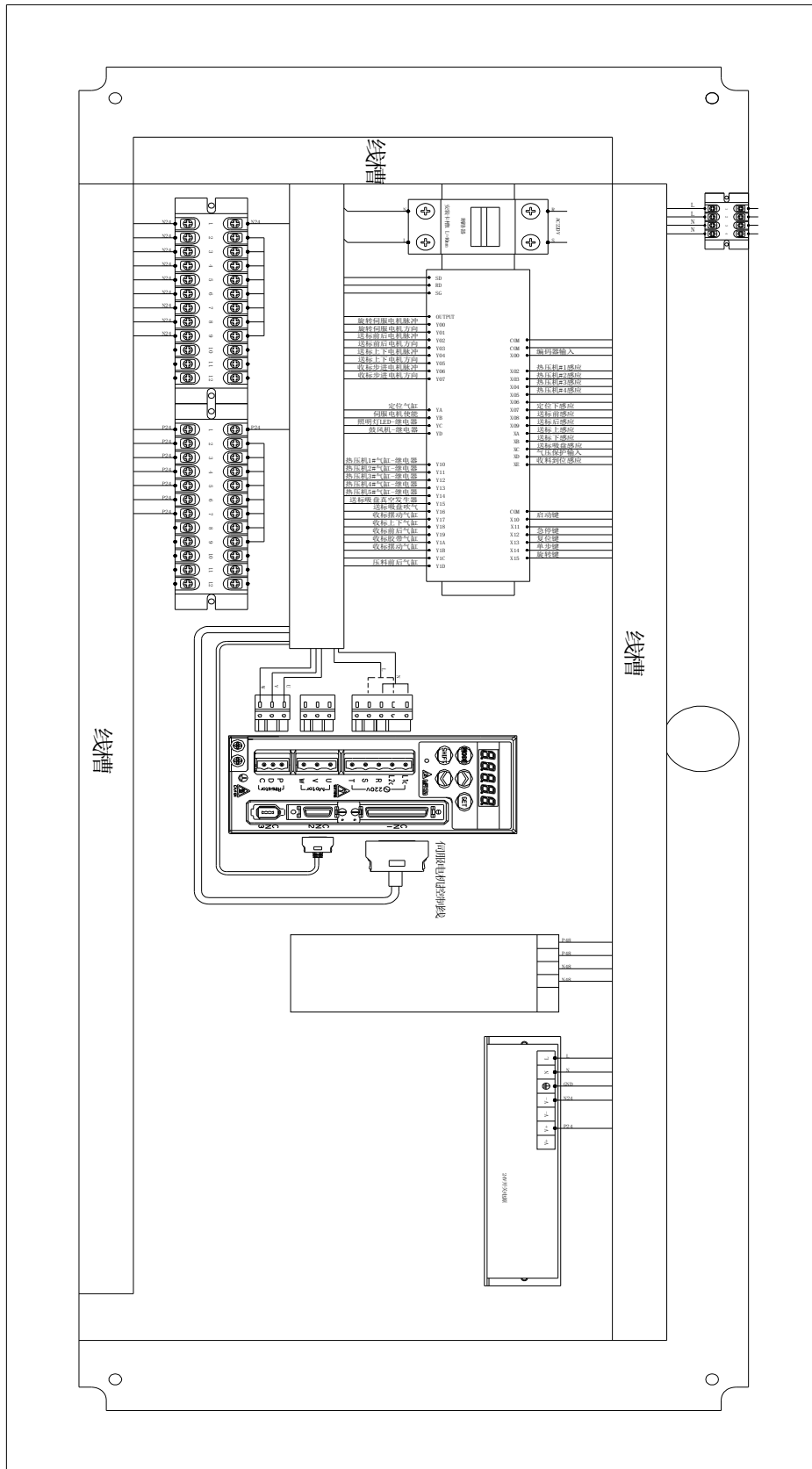
Note: For the avoidance of burns, touching the ironing head and table is strictly prohibited.

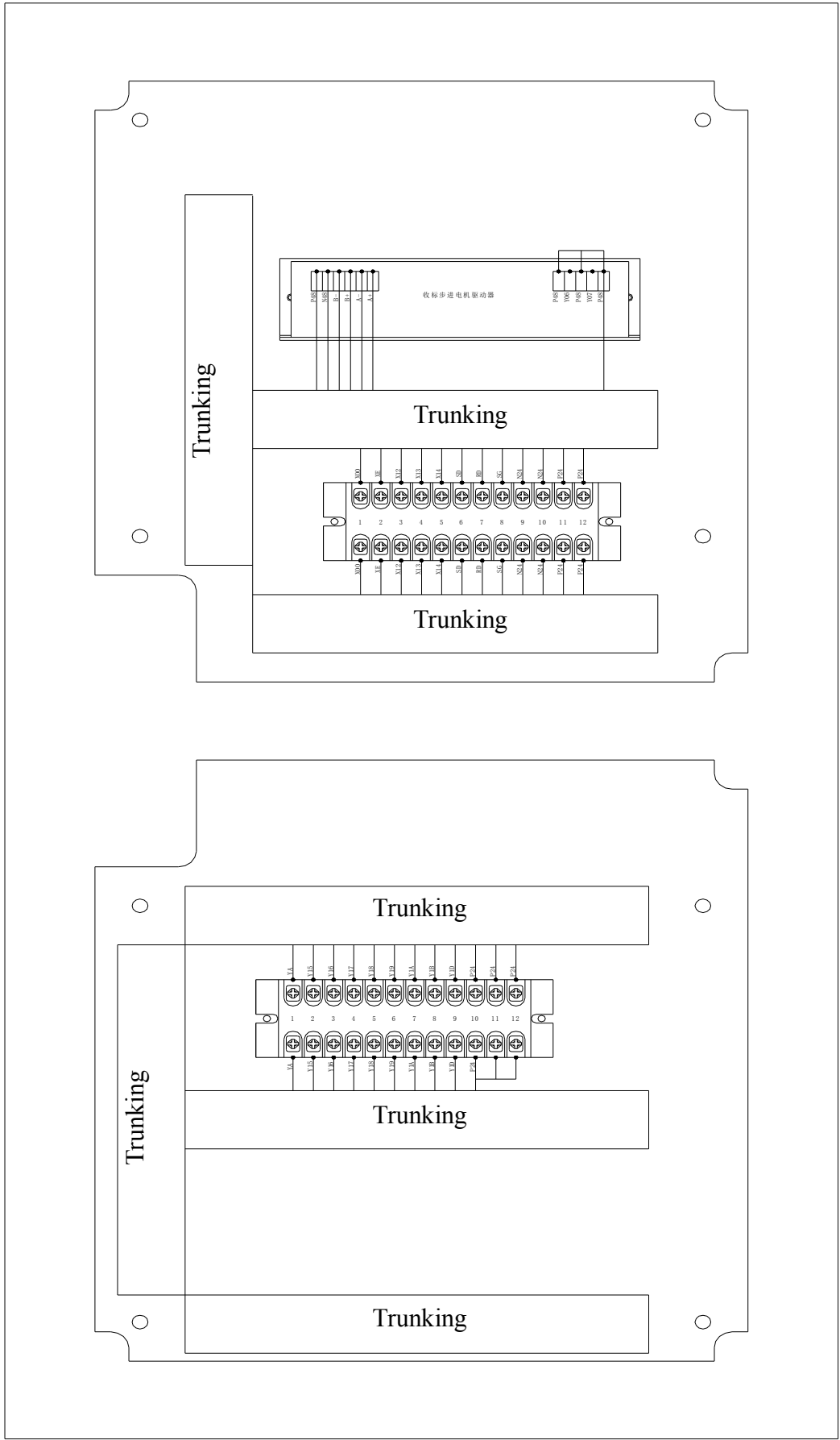
2. Failure of power and gas supply during the operation
 - 1) Turn off the power switch of the machine;
 - 2) Move the label feeding and label tear-off devices to the initial positions;
 - 3) After the ironing table and ironing head are cooled down, the operator shall collect the unironed cloth on the table. The unironed or unpressed cloth shall be subject to hand ironing, and the labels on the ironed or pressed cloth shall be removed manually.

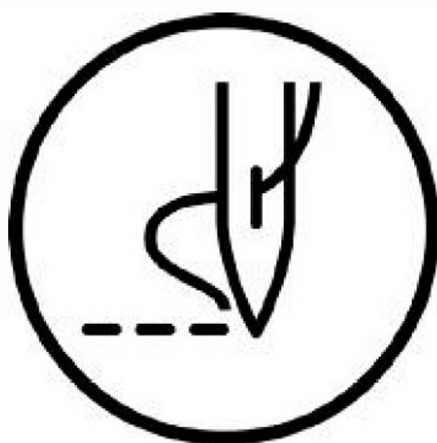
V. Tables of Error Codes

| Error Code | Fault Display | Fault Cause | Remedy |
|-------------------|--|--|---|
| E-01 | The fault indicator flashes in the touch screen, and the fault cause is displayed in a rolling fashion | Low air pressure | Test the air pressure input |
| E-02 | The fault indicator flashes in the touch screen, and the fault cause is displayed in a rolling fashion | Starved label feeding device | Load the labels |
| E-03 | The fault indicator flashes in the touch screen, and the fault cause is displayed in a rolling fashion | Shortage of tapes in the material receiving device | Load the tapes |
| E-04 | The fault indicator flashes in the touch screen, and the fault cause is displayed in a rolling fashion | Sensor fault of pressing and ironing device | Check the sensor signals of pressing and ironing device |
| E-05 | The fault indicator flashes in the touch screen, and the fault cause is displayed in a rolling fashion | Front label-feeding sensor fault | Check the front label-feeding sensor signals |
| E-06 | The fault indicator flashes in the touch screen, and the fault cause is displayed in a rolling fashion | Rear label-feeding sensor fault | Check the rear label-feeding sensor signals |
| E-07 | The fault indicator flashes in the touch screen, and the fault cause is displayed in a rolling fashion | Label-feeding upper/lower origin fault | Check the label-feeding upper/lower origin sensor signals |

Wiring Diagram:







使用说明书

INSTRUCTION MANUAL