

Full-Automatic Desktop Rolling Labeling Machine Instructions

ST-530



— 、 Machine control instructions



Emergency stop: Press it in an emergency, the machine will stop running. (Note: The machine can't work when the emergency stop button is pressed); Emergency stop button recovery: Turn the button in clockwise direction to pop out and the machine returns to normal.



Speed control knob: the left one is to control the conveyor speed, the right one is to control labeling speed; below the speed control knob is the power switch, " | " means power on, "O" means power off; generally, the left knob adjust to the value 20-40, the right side knob adjust to 100



Digital display fiber amplifier: The green value is setted manually, the red value is the real-time value detected; the value can be adjusted through the "+" "-" button; You can increase the green value appropriately when the real-time value is misread when the product is not detected while the machine is running, (note: may be affected by dust or label reflection)



Fiber sensor: The detection position can be adjusted appropriately according to the principle of labeling immediately when the fiber sensor detects the product



Label sensor setting: if sensor can' t detect label and here is the re-setting way.

hold the "+" "-" buttons at the same time for one second then release, the indicator light flashing, and then move the label back and forward several time and then press "-" button, the label sensor re-setting finished.

How to make adjustment if label on metal peeling plate too long or too short.

①The label is short: adjust the position of the label sensor to back or forward on label after loosening the knob screw on label sensor, meanwhile go to touch screen-**manual page**- click the **label calibration** to make the label is only higher 1-2mm than metal peeling plate edge, then adjustment is completed, like below picture.

②label is longer: firstly move the label sensor position to the leftmost of one label, then go to touch screen-**parameter page**- **label stop delay** to change value, and then go back **maunal page** to click **label calibration** to check how label on metal peeling plate, repeat above step until the label is only higher 1-2mm than metal peeling plate, then adjustment is completed,like below picture.



6.



Parameter page: Traction manual frequency: it refers to the speed of label peeling during manual operation of the page;

Traction automatic frequency: it refers to the speed of label peeling during automatic page (Note: When the machine is running automatically, the label or backing paper is pulled during the product labeling process, it indicates that the label peeling speed is slow, and the value in traction automatic frequency need to be increased; If the label peeling faster than the product labeling which indicates that the label peeling speed is faster and the value in traction automatic frequency needs to be reduced appropriately;

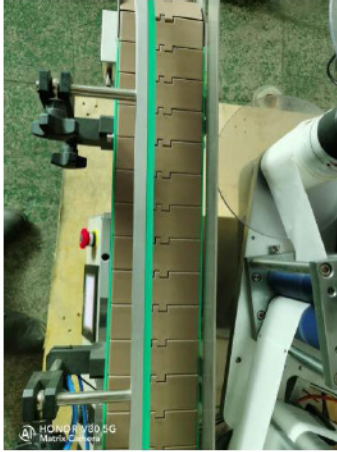
Detector filtration: It means that if there are multiple signals when detecting a product, in order to take only the first signal, the extra signals are filtered out by the method of setting time. Normally, the parameter is set to: 0.3;

Post delay : It means to delay the time point of labeling on the principle of peeling off the label when it is detected;

Standard stop delay: It means that the label is detected by label sensor and then stops within the specified time.

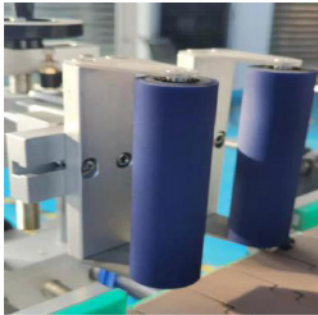
二、 Mechanical adjustment part

1.



Conveyor guide: adjust conveyor guide back or forward to fit well product size.

2.



(1)



(2)

Labeling wheel: place the product between the roller and labeling wheel first, and shake the handwheel to make the labeling wheel touch product to finish adjustment like (2) picture

3.



Over-label power wheel: According to the up and down position of the product label, loosen the fixing screws in the picture, and the position of the power wheel can be adjusted up and down.

4.



(1)



(2)

Bottle pressing wheel adjustment base: After the machine is connected to the air source, while pressing the positioning cylinder button on the manual page of the touch screen, shake (1) adjust the front and rear hand wheels to make the bottle pressing wheel press the product and the product cannot be turned by hand That's finish. Such as (2) picture.

5.



Angle adjustment base: If the one label end is higher or lower than another ending when labeling, then need to loosen the screw and turn the handwheel to adjust until the label two ends are in same level, then tighten the screw

≡ . Machine operation and debugging process

①First turn on the power and air source, and turn on the machine; ② Place the label and click the label calibration button on the touch screen manual interface to adjust the label peeling position 0-2mm; ③Adjust the width of the conveyor fence according to the size of the product;④The conveying speed is fixed (20-40 under normal conditions), and the position of the product object sensor is fixed; ⑤In the automatic interface of the touch screen, click Run, turn off the traction motor button, and put the product on the parameter page to adjust the positioning delay parameter and debug The time when the bottle-pressing wheel just presses the product after the product passes the sensor. ⑥The touch screen automatic interface, turn on the traction motor button, and put the product to try the label effect.