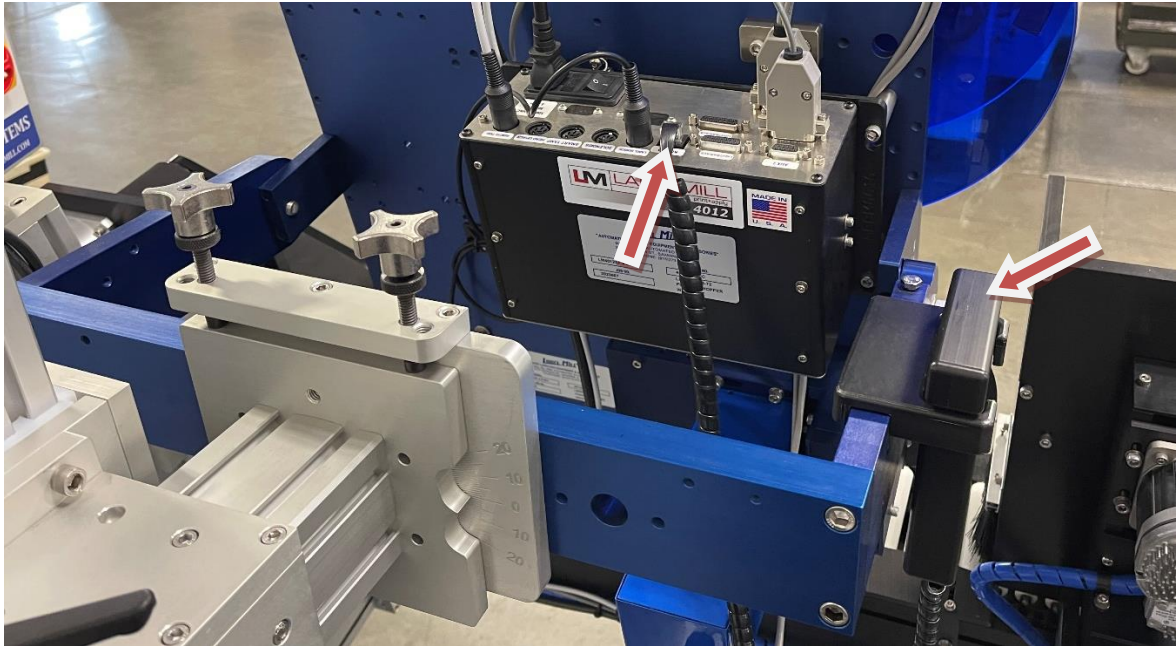


LM5000RB / LM4012SF Setup Guide - Job # 2023667

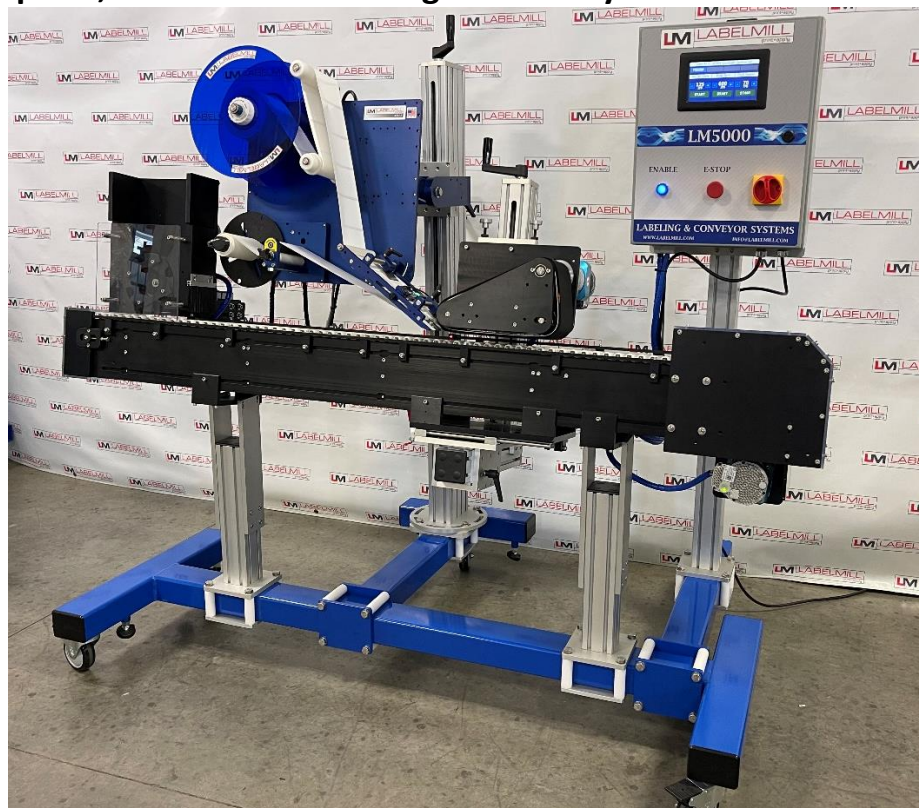
1. Position the system as needed, and lock the casters on all wheels. Remove any shipping stretch wrap & foam padding from the system components. Plug in the power to the main system control. Turn on the power to the system using the main shutoff on the front panel of the main control.



2. Open the carton containing the HLI-200 touch screen input device, and connect it to the label applicator control box using the communication cable. Place the HLI-200 into the holster, mounted onto the system U-Arm.



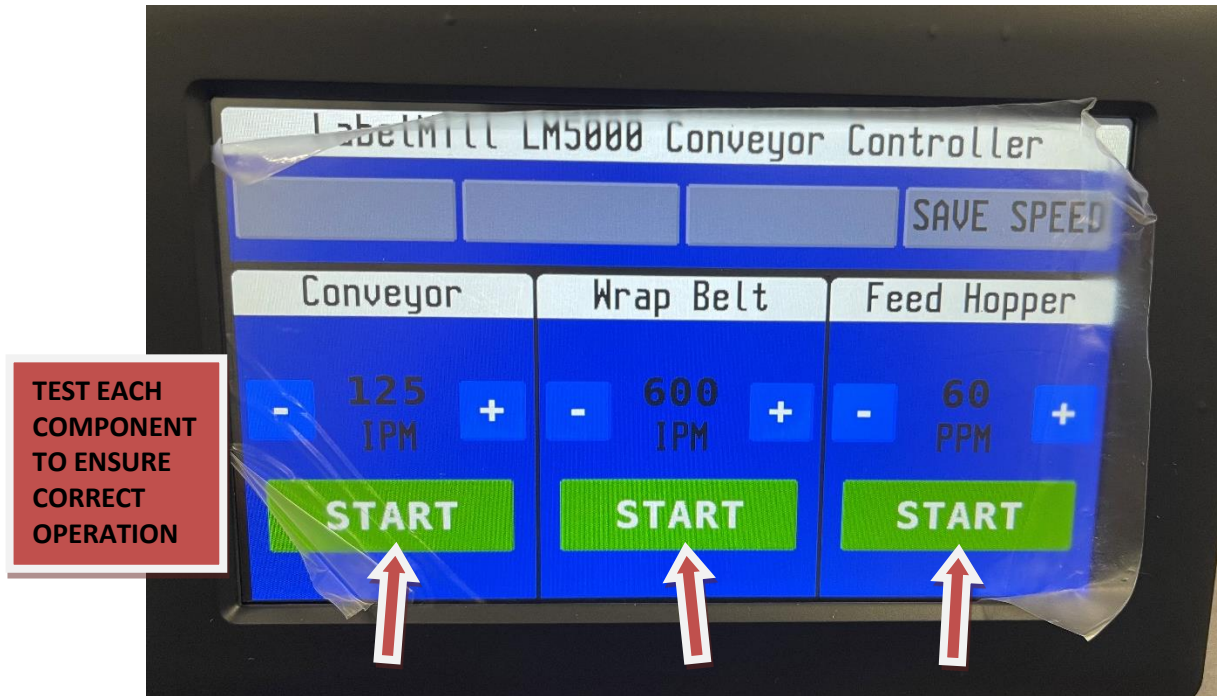
3. Inspect the system to ensure that product hopper, label applicator, and wrap belt assembly are not contacting the any part of the conveyor rollers. Ensure the system guarding is in place, and is not contacting the conveyor rollers.



4. Ensure that the label applicator is receiving power and that the HLI-200 input device has booted the applicator system to the main screen.
5. Remove all tubes from the product hopper and conveyor rollers.
6. Twist the E-Stop button on the main control to release it, and press the blue Enable button to supply power to the conveyor components.

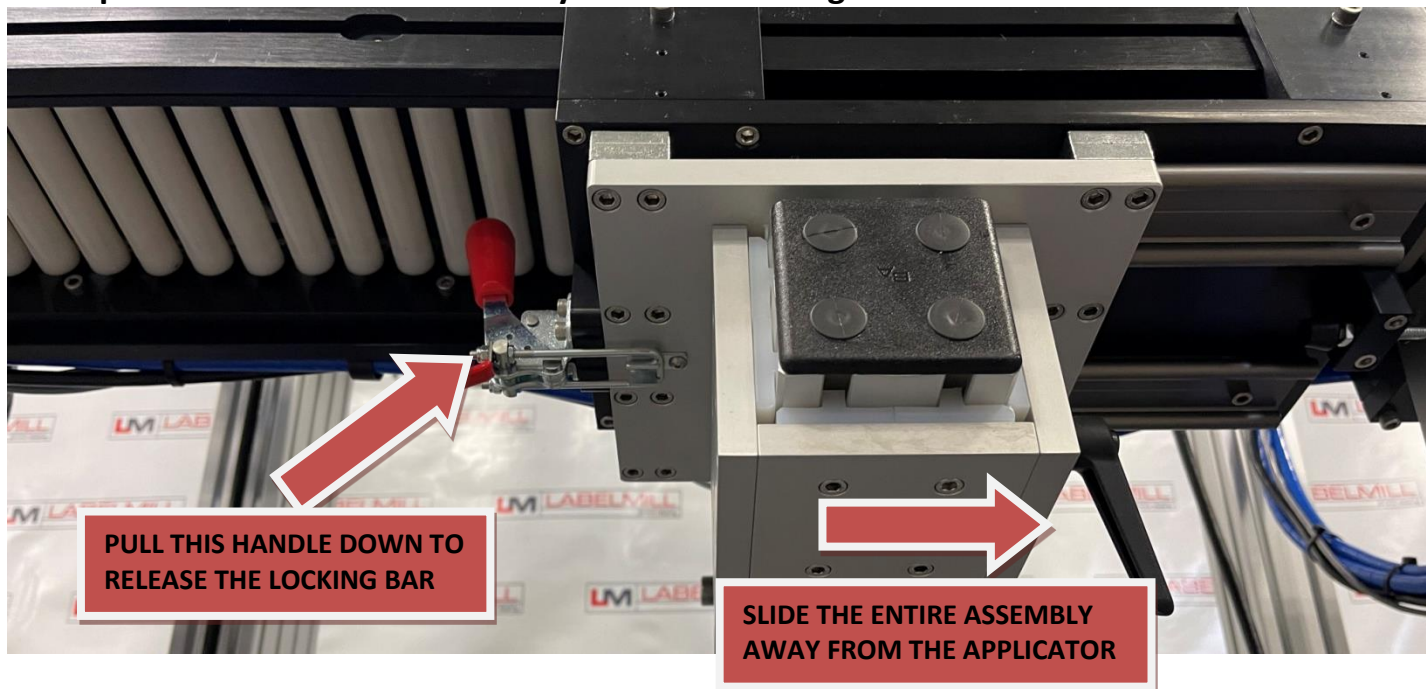


7. Test the Conveyor, Wrap Belt, and Feeder components by pressing the corresponding green “Start” button on the touchscreen display.

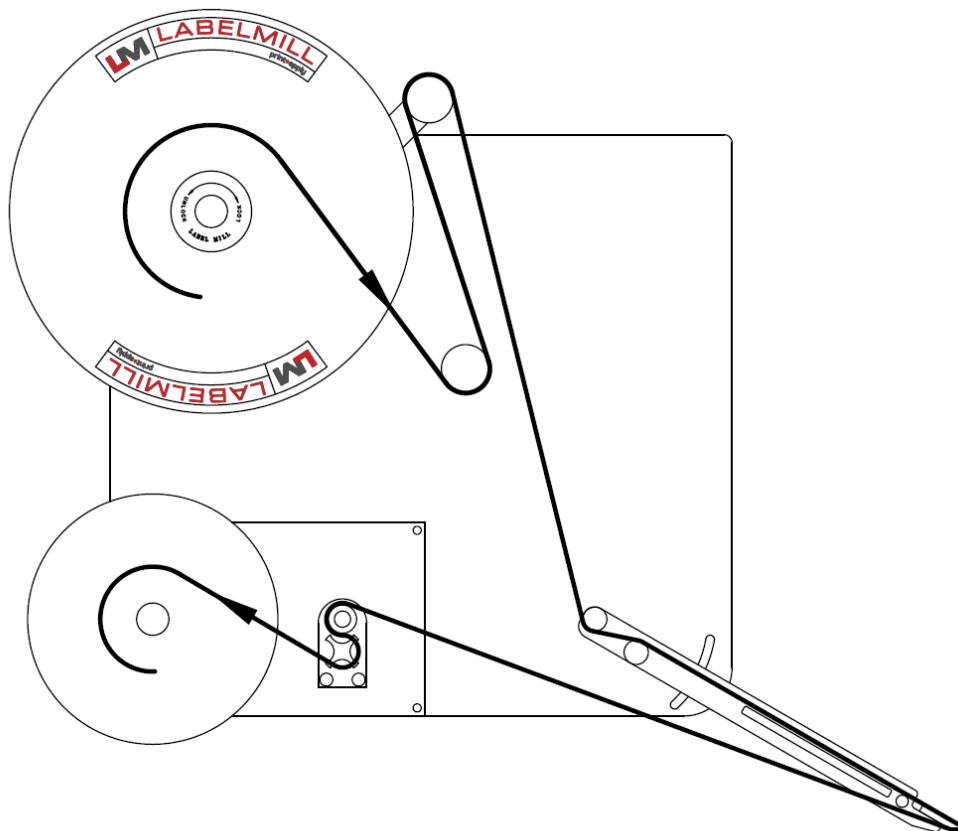


8. Check each display for correct setting values (baseline settings from factory are listed later in this document).
9. Once inspected, press the E-Stop button to turn off power to all conveyor components.
10. Remove the outer supply spool and load a roll of labels, ensuring that the roll is fully seated on the core support. Add the outer spool and lock it in place to secure.

11. Unlock and slide the wrap belt assembly away from the label applicator system to provide better access to the system for webbing the labels.



12. Follow the webbing diagram below to web the labels through the system.



- 13. Ensure that the labels are webbed correctly through the label sensor, the pinch roller assembly is closed, and the wipers are locked in the correct position.**
- 14. Using the HLI-200 interface, clear any fault displayed on the screen.**
- 15. Press the green Start button on the HLI-200 to feed a single label. Catch this label as it is peeled off of the plate, ensuring it does not get attached to the rollers of the conveyor. If it does, remove the label and clean the rollers with isopropyl alcohol. Do not use anything sharp or abrasive to clean any components!**
- 16. Feed several labels, and ensure that the label is consistently stopping at the correct position, with the leading edge of the label at the end of the peel plate. If necessary, adjust the label sensor position or the electronic offset setting to stop the label at the correct position.**
- 17. Slide the wrap belt assembly back into position, locking it in place with bar clamp and lock handle.**
- 18. Inspect the vertical and horizontal positions of the label applicator and wrap assembly by checking the ruler guides on the mount posts.**
- 19. Twist the E-Stop button to release it, and press the enable button to ready the system.**
- 20. Place a single tube into the hopper or directly onto the conveyor rollers.**
- 21. Turn on the wrap assembly, conveyor & product hopper to apply a label and inspect the application to the tube. Adjust the parameters or position as needed.**

- 22. Setup complete.**

System Baseline Settings

Main Control Enclosure		
	Conveyor Display Value	125 IPM
	Wrap Belt Display Value	600 IPM
	Feeder Display Value	70 PPM

LM4012 Synchronous Feed Label Applicator (Critical Settings Shown Below)

Product Sensor		
	Product Delay	0.150
	Sensor Trigger	Leading Edge
Label Speed		
	Label Speed	590
	Acceleration	3%
Label Sensor		
	Label Length	2.0
	Label Gap Length	0.125
	Label Stop Position	1.5
	Missing Label Detection	Off
Cycle Type		Set to "Feed Only"

Settings above saved as Job #6 in Job Storage Menu (Use Job Storage -> Restore Job to recall)