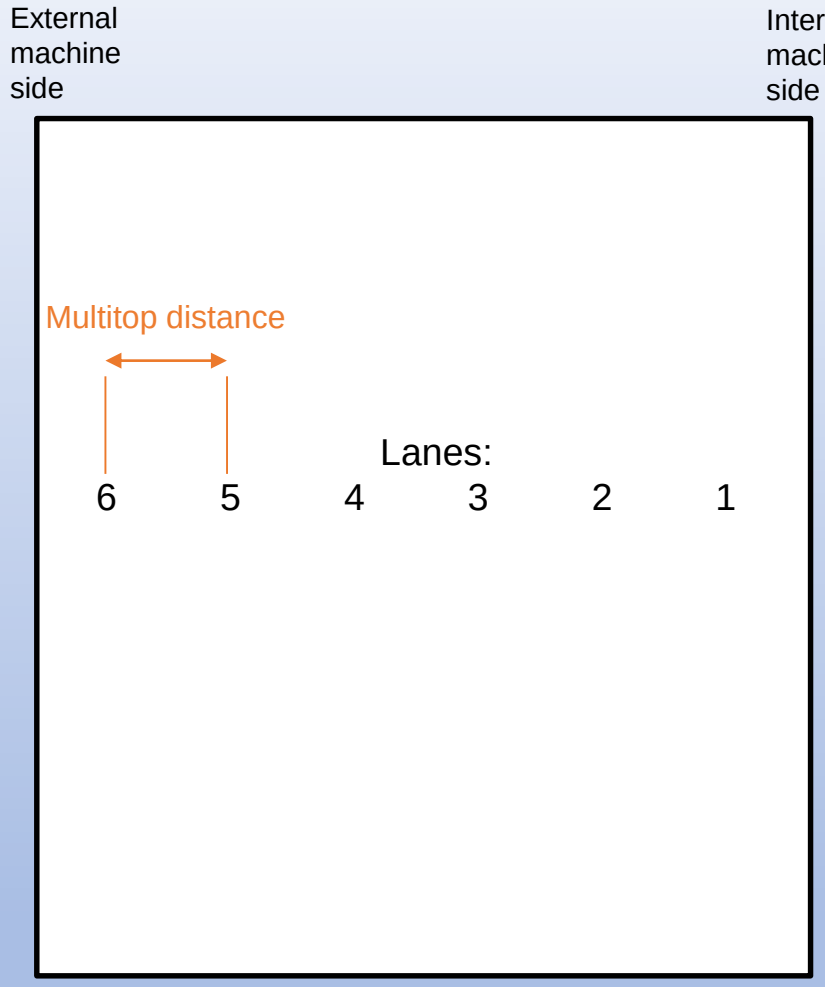
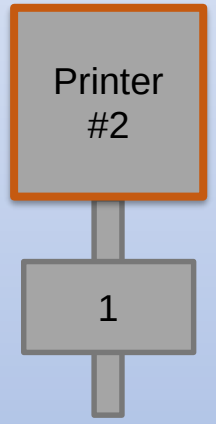
Operative Course for Elea Machine

Description of main part of machine and operative tips

InkJet Printers





Printer label setup:

For selecting a new production label, access to the printer controller.
Is possible to modify the actual label or select from the database.
For changing the pitch and repetitions number of labels:
Job/Modify/Job Setting then find the setting «Multitop». Inside this setting is possible to change the number and the distance between each print.

Printers height adjustment

For adjusting the position of the prints is possible to use the screw for moving up or down the printhead.

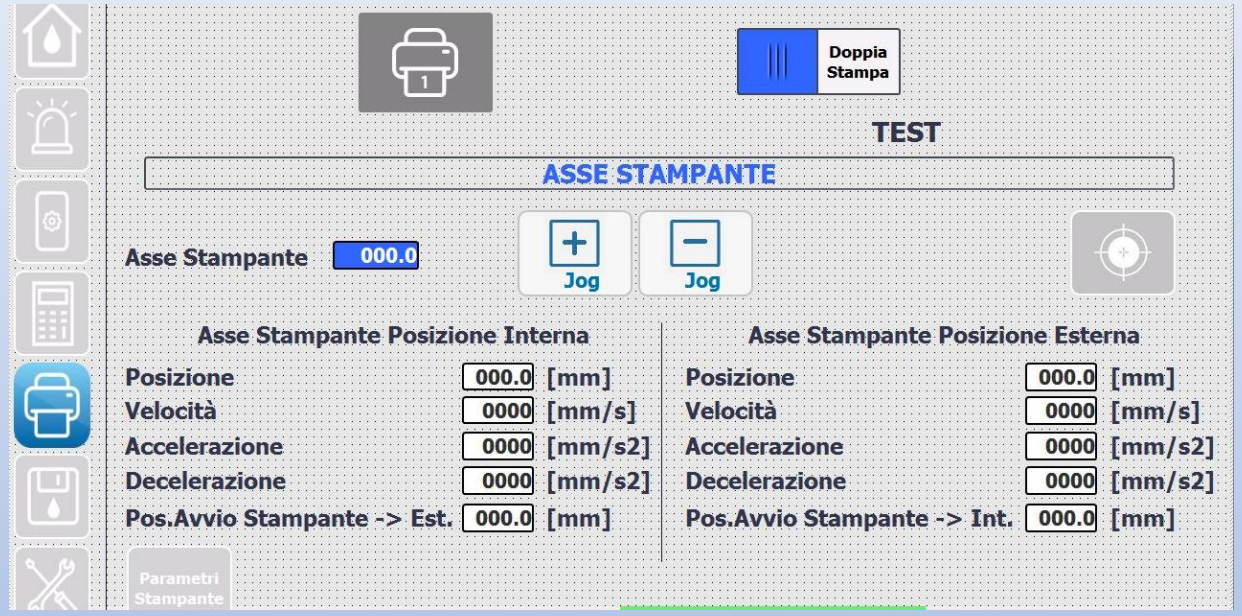
Printers settings

Printer parameters:

Toggle on top of the page must be in Single print mode.

Position, speed, acceleration and deceleration are parameters that must not be modified.

The value ‘Start print pos’ is used for moving all prints together internally (decreasing the value) or externally (increasing the value).



Pre-cut Area

Change pre-cut blades:

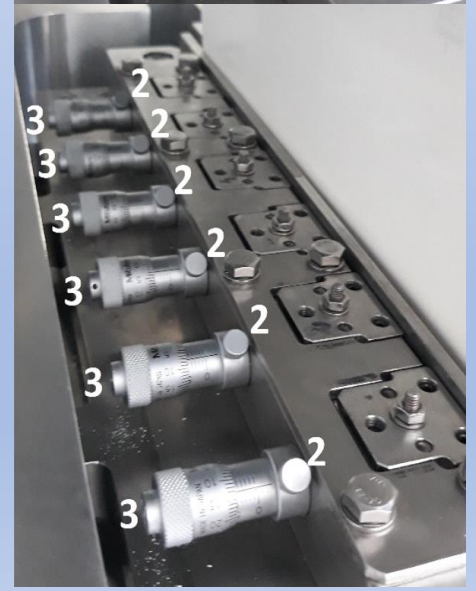
1. Remove the 2 screws that lock the front plate
2. Loosen the 2 grains that lock the blade.
3. Replace the blade and make sure to place it centered and flat into the groove.

Regulation pre-cut blades:

To adjust the depth of each blade:

1. Unscrew the locking screw of the micrometer.
2. Turn the graduated drum to make the adjustment. Screwing increase the depth.
3. Once finished, thight again the locking screw.

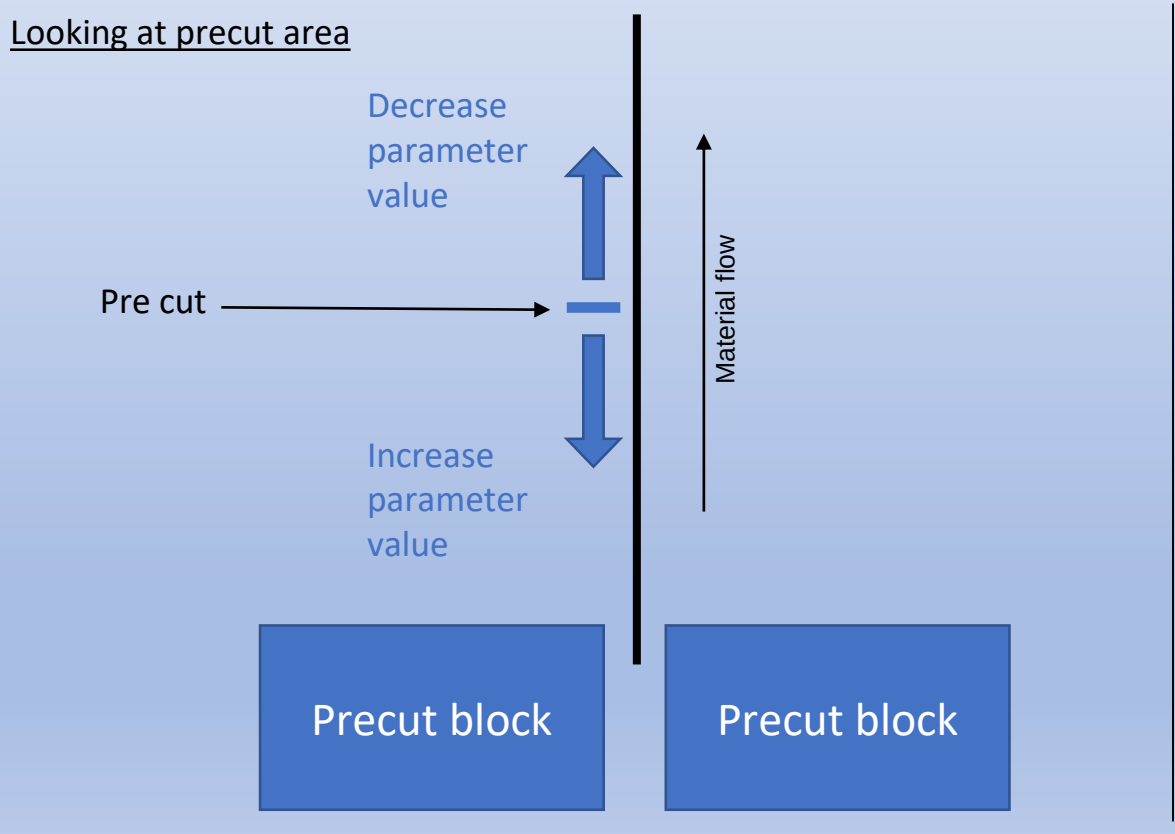
WARNING: act on the micrometer adjustment carefully. Excessive depth can damage the blades and the contrast plate.

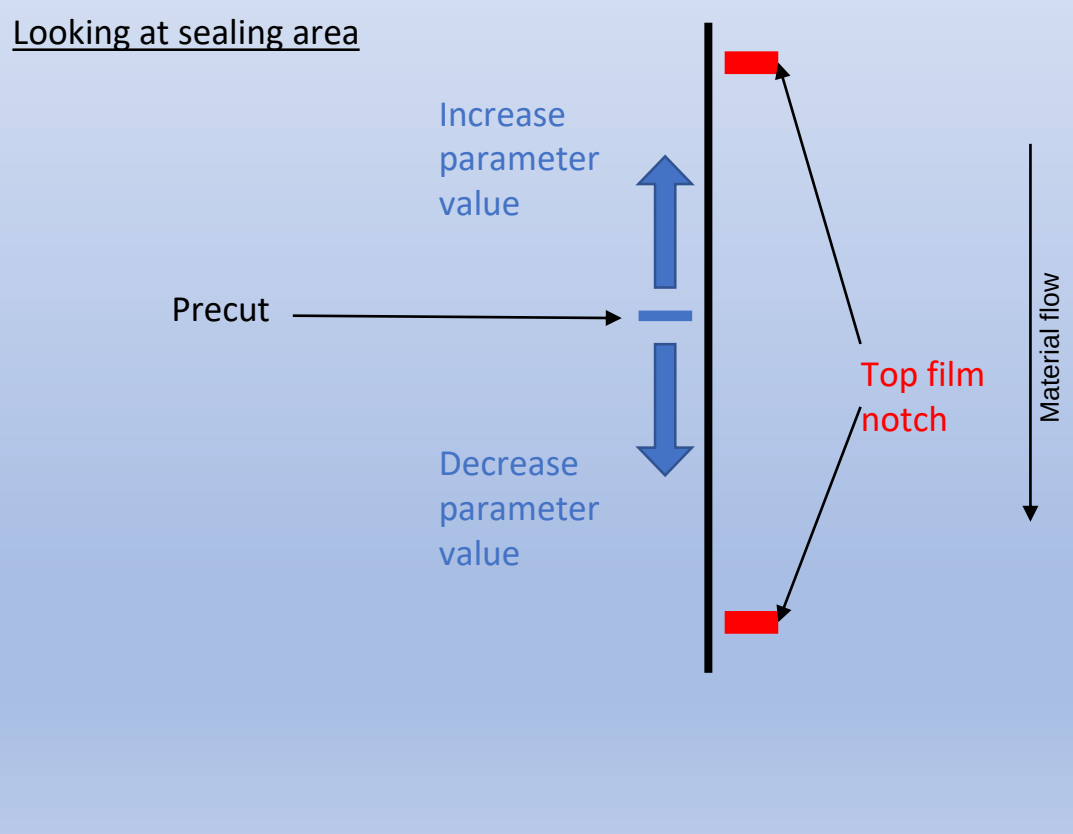


Pre-cut Area

Setting parameter “pre-cut position” in sachet

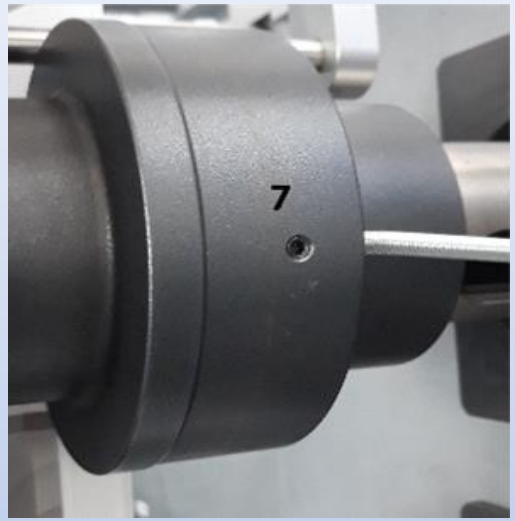
To modify the pre-cut position use the parameter “Pre-cut Position”





Sealing Area

Changing format Welding Rollers



Warning: Before operate on the welding parts check the temperature.

1. Remove the thermocouple from the first roller(7).
2. Use the template provided with the format to center each roller.
3. Lock again the roller with the screw.
4. Install the thermocouple and tight the screw.

Change format lenght

To change the pouch lengh, use the parameter ‘’Sachet Lenght’’. For the correctsetup is needed to calculate also the waste lenght (if monodose is 80mm the parameter should be 85mm).
To apply the setting put machine in emergency and then reset.

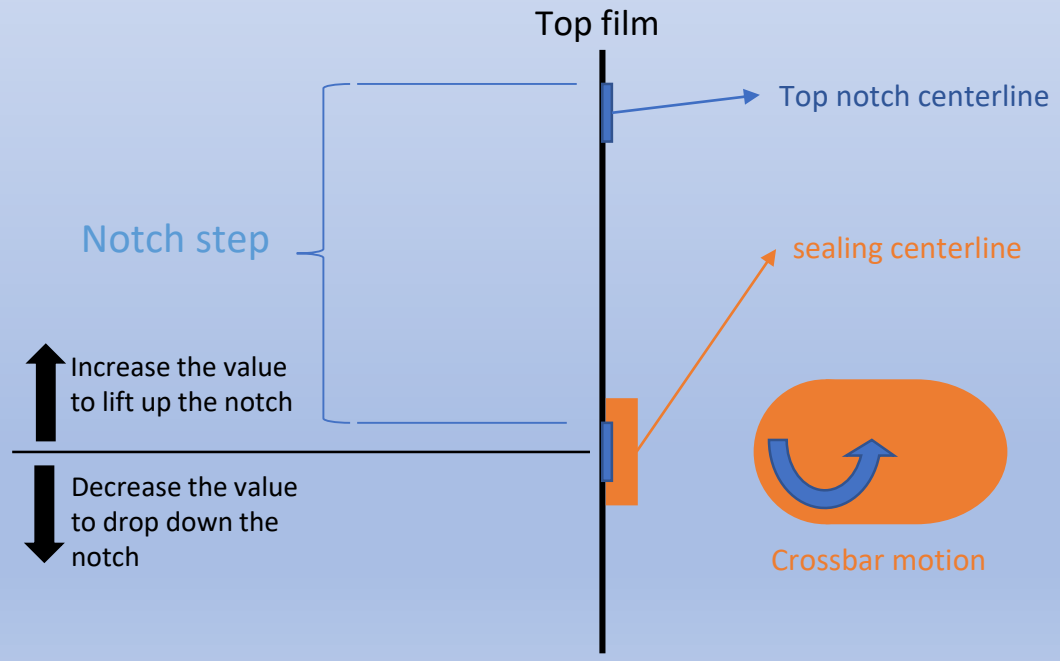
Change format

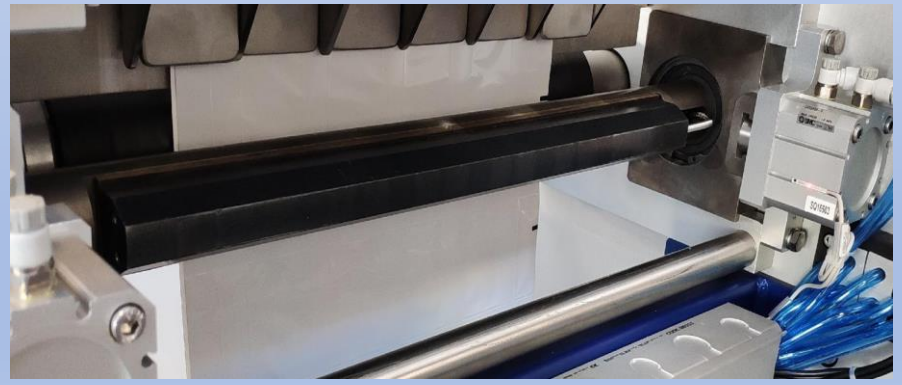
If machine is in emergency, is possible to rotate the shaft freely.
Is also possible to move the shafts in manual mode: turn the switch (6) to the left and use the manual jog back and forward in the relative HMI page.

Sealing Area

Set Top notch with the crossbar:

To modify the top notch position use the parameter “Top Notch position”.
The aim is to align the center line of the notch with the center line of the crossbar sealing area:

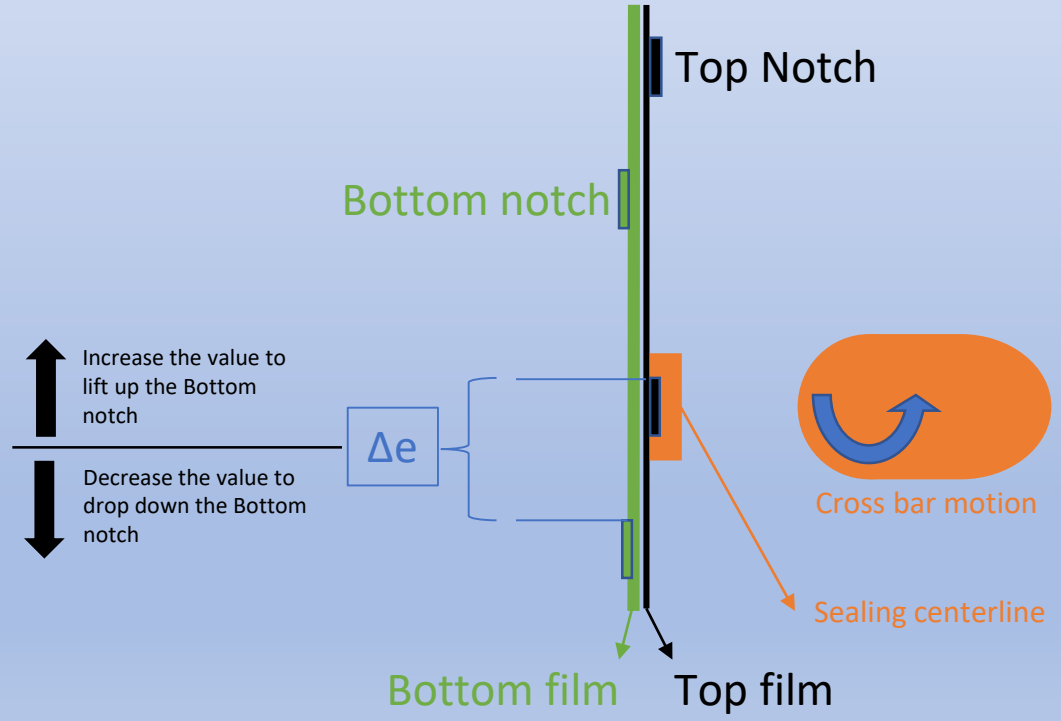




Sealing Area

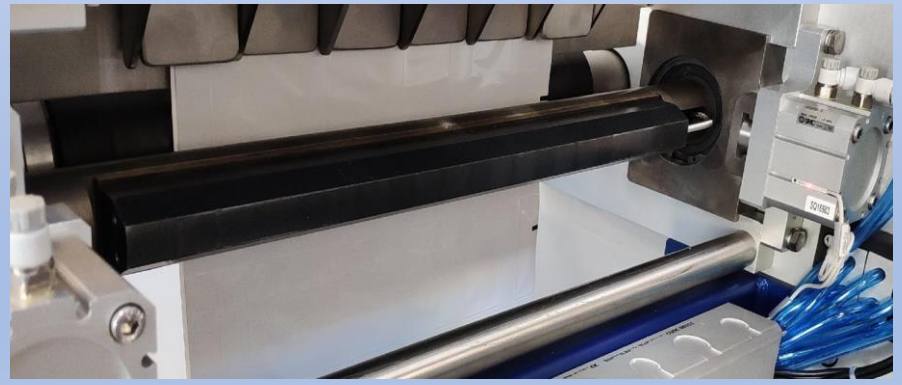
Set Synchro Motion (Top Notch with Bottom Notch):

To modify the Bottom notch compared to Top notch position use the parameter “Phasing Notches” in Sachet Production Page.
The parameter will move the center line of the Bottom notch respect to the Top notch.
Once aligned the 2 notches together use the “Bottom notch position” to center it with the crossbar centerline
Attention: Remember that Bottom notch is your reference in relation with the crossbar seal.



Bottom Sensor

Top Sensor



Towing Area

Towing unit is responsible for transporting the material under die-cut. There are 2 knobs to the side: upper one allows to adjust the width of the side rail for material guide; the lower one move laterally all the towing system.

Change format of towing group

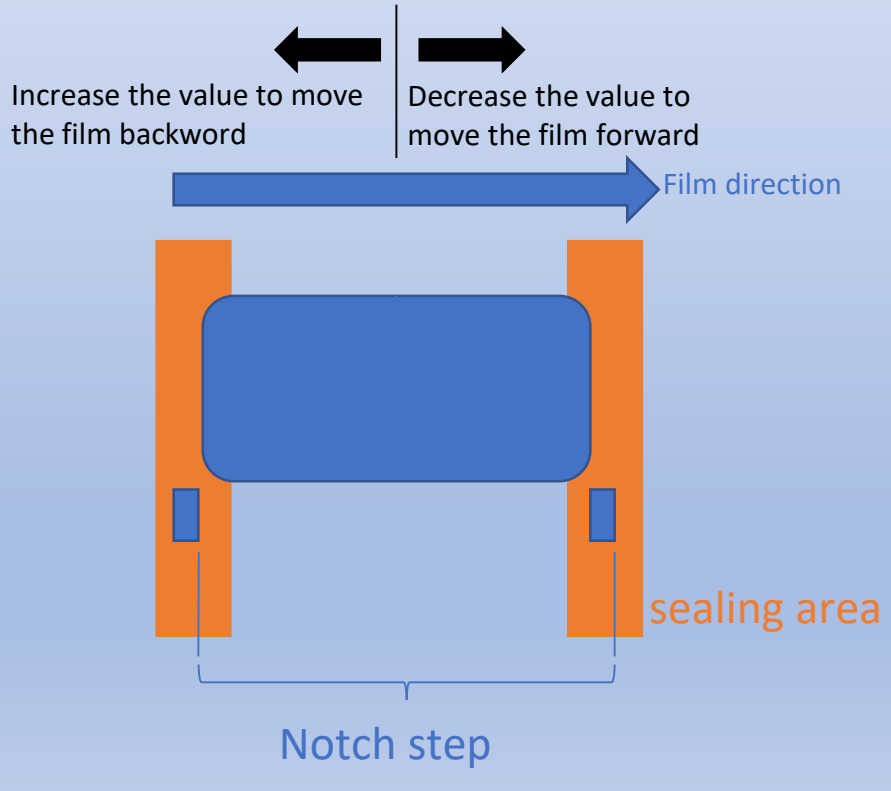
In the group there are also individual rubber rollers.
To change the width:

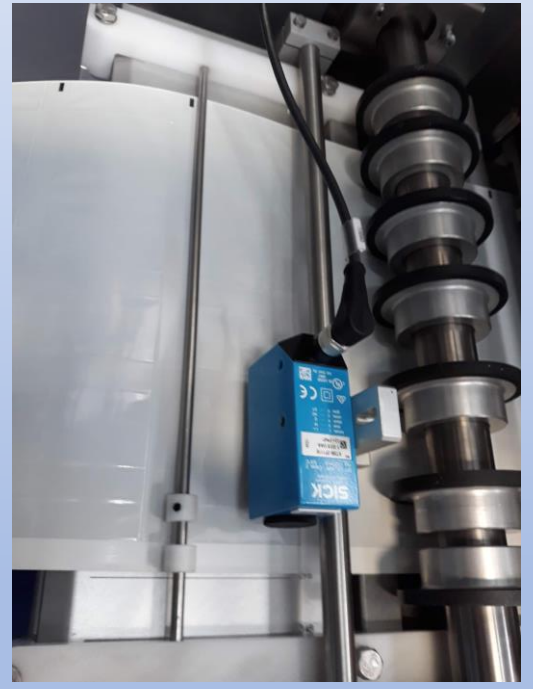
1. Lift the axis using the levers (2)
2. Move the film under the die-cut and lift down the levers.
3. Using the lower knob, center the material under the die-cut.
4. Stop the machine and check the rubber roller position on the vertical sealing areas. If not aligned, unscrew the grain (4) and move the roller on the sealing areas.
5. If top material color changed, set again the notch sensor for a correct reading.
6. Adjust the position of white roller for a correct notch reading.

Towing Area

Set Towing notch position:

To set the correct material positioning under die cut, use the parameter «pulling notch position».

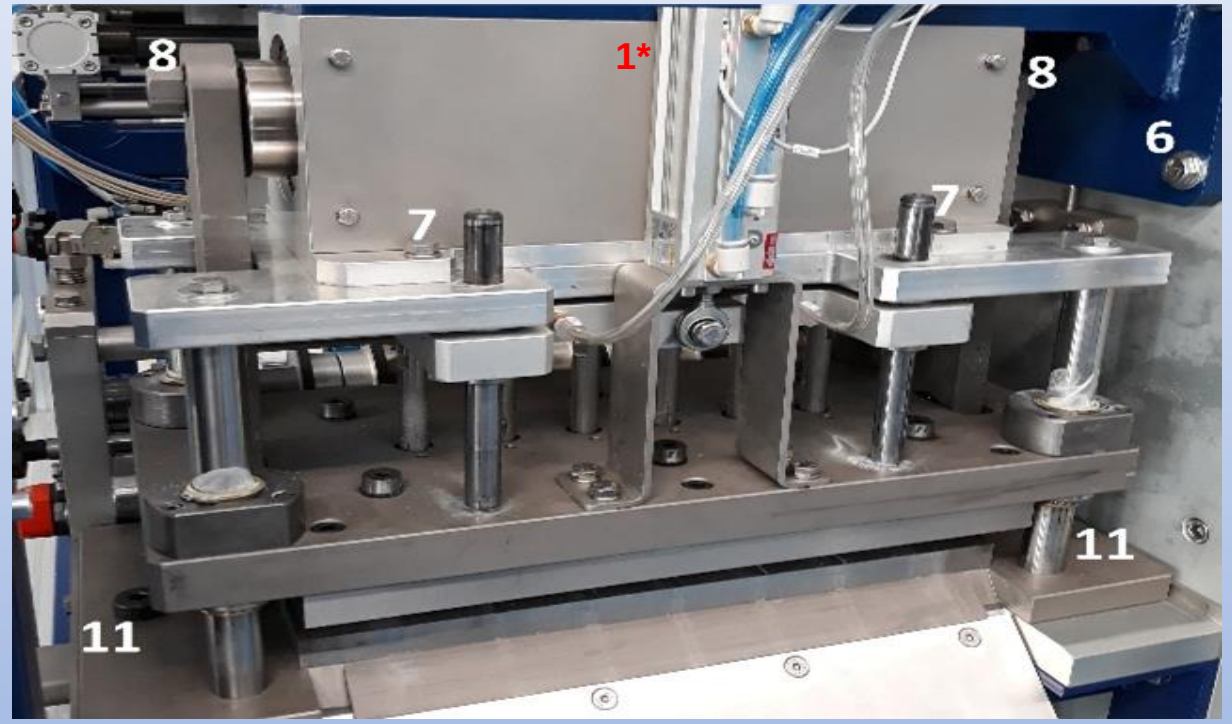




Diecut Area

Change Die Cut

1. Using operator panel, switch to manual mode. On die cut page, using jog buttons, move the material away from die cut. As an alternative way, is possible to use the lift the levers in the towing area.
2. Disconnect pneumatic tubes and sensor cables(4).
3. Loosen the screws(6) of the upper motor support (6x screws).
4. Remove the locking screws(7) of the upper shear plate (4x screws)
5. Loosen the 2 connecting screws(8) of the main shaft. Then in HMI Die Cut page, use the emergency brake button to release the die cut. **ATTENTION: check carefully that nothing is under the die cut. INJURY MAY OCCUR.** Now is possible to remove completely the 2 screws.
6. Use the manual bolt to lift up the engine support and tight again the motor support screws.
7. Remove the 2 lower clamping screws(11).
8. Use trolley supplied to move out the die cut.

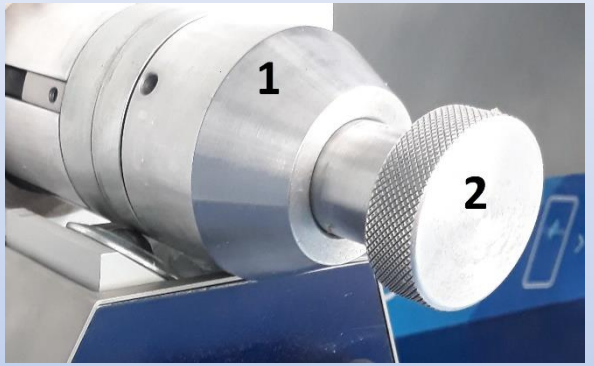


1*. Ejector system not present

Reels

Reels change

1. Remove finished reels switching the air valve(2) and moving apart the shaft support (only bottom shaft)
2. Place new reel on shaft.
   WARNING: for all bottom reels limit as minimum as possible the exposition of the reel shaft to full wheight without the support. Otherwise it will damage the shaft.
3. Use the 2 knob (1 & 2) to fine adjustment of the reel. Lock (1) and rotate (2) clockwise to pull out the reel; CCW to pulls out.



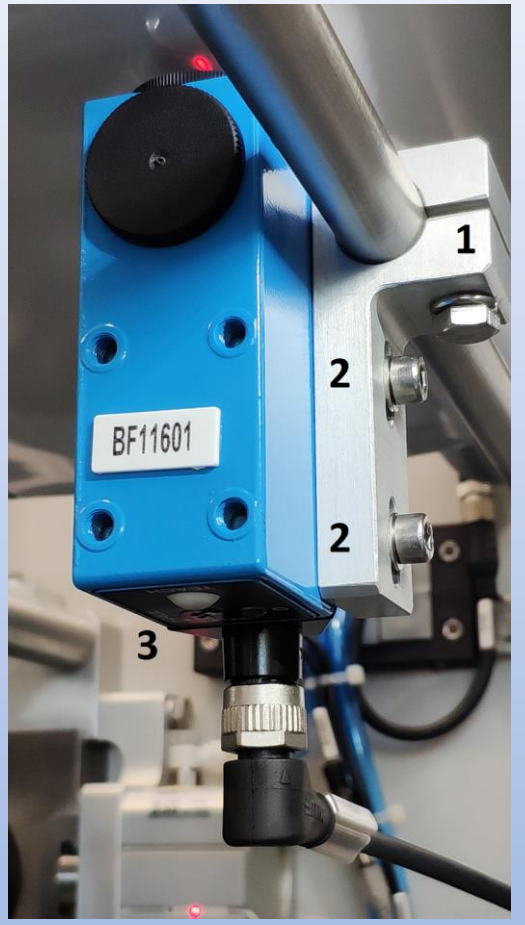
NOTE: After the joint of bottom reel, pay attention to printers and pre-cut.

- When joint is near to the printers area, disable momentary the printers to avoid damage to the headprint or ribbons.
- When joint is near to the pre-cut area, disable momentary the pre-cut to avoid cutting the joint.
- When joint pass through the sealing area, checks if there are residues on crossbar. If necessary use dry cloth, paying attention to hot surface of crossbar.

Reels notches

Set notch sensor:

1. Rotate with flat screw driver the selector in teach.
2. Place under the sensor light the notch and press the button.
3. Place under the sensor light the background and press again the button.
4. Check the correct switching (light on when notch is under light).



Set sensor position:

1. Loosen the screw (1) to set the sensor along the guide. Tight it on the printed notch at 90°.
2. If necessary, adjust the height using the 2 screws (2). Aproximately 10 mm distance between lense and material is needed for a good notch reading.

If background color isn't a uniform color, teaching the background with the darkest area of the film helps the sensor to read only the notch avoiding errors.

Product Area

Pressure Tank Settings:

The following instructions shows how to set pressure inside the tank(MAX 0.2 Mpa)

1. Rotating the ferrule of the manometer you could set the maximum pressure limit (green arrow). We suggest 0.2 Mpa
2. To Unlock the regulation slide the knob to low position (when you see orange area). Rotate clockwise to add pressure and counterclockwise to remove pressure.
3. When you finish the process, lock the knob slideing it up.

Attention: the air pressure inside the hopper needs time to stabilize. Check the pressure gauge after few minutes to check the real value.