

GENERAL INSTRUCTIONS FOR 5 GALLON LABELERS

SEE THAT THE MACHINE IS PROPERLY OILED, WHEN STARTING A NEW MACHINE CHECK CAREFULLY BEFORE PLUGGING IT IN TO MAKE SURE IT WILL RUN IN THE PROPER DIRECTION. CLEAN MACHINE THOROUGHLY AFTER EACH DAY'S RUN AND LUBRICATE WELL. SEE THAT GUM POTS HAVE PROPER AMOUNT OF ADHESIVE.

NOTE: WHEN ORDERING PARTS BE SURE TO GIVE MODEL NUMBER, MACHINE NUMBER AND SERIAL NUMBER.

5 GALLON LABELER OPERATION

CONTAINERS ARE FED INTO THE MACHINE MAKING SURE THAT THE HANDLE IS UP AND STARTED INTO THE HANDLE GUIDE RAIL. AS THE CONTAINER ROLLS INTO THE MACHINE IT TRIPS A LIMIT VALVE WHICH EXTENDS THE INFEEED CONTAINER STOP CYLINDER TO HOLD BACK THE NEXT CONTAINER.

THE CONTAINER IS PICKED UP BY THE CARRIER BELTS AND ONCE UNDER CONTROL IS MOVED ONTO THE TIMING ROLLER ASSEMBLY. ONCE ON THE TIMING ROLLER THE CONTAINER WILL SPIN IN POSITION UNTIL THE HANDLE TRIPS THE LIMIT VALVE MOUNTED ON THE HANDLE GUIDE RAIL. AT THIS SAME TIME AN ADJUSTABLE TIME DELAY TIMER IS ACTUATED. (THE ADJUSTABLE TIME DELAY, TIMER WITH DIAL KNOB LOCATED BELOW THE TIMING ROLLER ASSEMBLY, SHOULD BE SET WITH THE PROPER TIME REQUIRED FOR LOCATION OF THE LABEL ON THE CONTAINER.) WHEN THE TIME DELAY TIMES IN THE TIMING ROLLER GOES DOWN AND ALLOWS THE CONTAINER TO CONTINUE THRU THE MACHINE. AS THE CONTAINER LEAVES THE TIMING ROLLER THE INFEEED CONTAINER STOP CYLINDER GOES DOWN AND THE TIMING ROLLER GOES UP SETTING THE INFEEED FOR THE NEXT CONTAINER.

THE CONTAINER NOW MOVES TO THE FIRST HOT MELT POT (LABEL PICK UP END POT). THE CONTAINER PASSES OVER THE ROLLS AND RECEIVES A SERIES OF HOT MELT SPOTS WHICH WILL BE USED TO PICK UP THE LEADING END OF THE LABEL. THIS POT SHOULD BE ADJUSTED SO THAT THE CONTAINER MAKES ONE ROTATION TO THE LABEL PICK UP END.

THE CONTAINER NOW MOVES TO THE SECOND HOT MELT POT (LABEL TRAILING END POT). THE CONTAINER PASSES OVER THE ROLLS AND RECEIVES A SERIES OF HOT MELT SPOTS WHICH WILL BE USED TO HOLD THE TRAILING END OF THE LABEL IN PLACE. THIS POT SHOULD BE ADJUSTED FOR THE LENGTH OF THE LABEL BEING APPLIED. ALSO NOTE THAT THIS POT IS SUPPLIED WITH (2) SETS OF GUM ROLLS TO AID IN HOLDING LONGER LABELS IN PLACE. IN THE CASE OF SHORT LABELS, THE SET OF GUM ROLLS CLOSEST TO THE LABEL BED CAN BE REMOVED.

AS THE CONTAINER PASSES OVER THE LABEL BED IT PICKS UP A LABEL TO BE ATTACHED TO THE CONTAINER. THE LABEL WRAPS AROUND THE CONTAINER AND THE OVERHEAD RUBBER LABEL PRESSURE ROLLERS SMOOTH OUT THE LABEL AND PRESS ON THE GLUE FOR BETTER ADHESION AS IT IS POSITIONED ONTO THE CONTAINER. THE CONTAINER CONTINUES ON AND ENTERS THE 90 DEGREE DISCHARGE TWISTER WHICH WILL UPRIGHT THE CONTAINER TO TRANSFER ONTO THE REMAINING PACKAGING LINE.

THE LABELER CAN ALSO BE SUPPLIED WITH ADDITIONAL COLD PASTE SPRAY AND EXTRUSION HEAD APPLICATORS FOR APPLYING COLD PASTE OVER A LARGER SURFACE AREA FOR MORE LABEL ADHESION.



NEW WAY PACKAGING MACHINERY, INC.
P.O. BOX 467 210 BLETTNER AVENUE
HANOVER, PA. 17331
TEL. (717) 637-2133 OR 637-8998
FAX. (717) 637-2966 WEB SITE: www.labeler.com

GENERAL INSTRUCTIONS FOR 5 GALLON LABELERS

5 GALLON LABELER COLD PASTE APPLICATION OPERATION

TO ACHIEVE ADDITIONAL LABEL SURFACE ADHESION THE MACHINE IS SUPPLIED WITH A COLD PASTE APPLICATION SYSTEM. THE SYSTEM CONSISTS OF A SET OF (2) SPRAY VALVES FOR THE PICK UP END OF THE LABEL, A SET OF (2) SPRAY VALVES FOR THE CENTRAL AREA OF THE LABEL, AND AN EXTRUSION HEAD APPLICATOR FOR THE TRAILING END OF THE LABEL. THE LIMIT VALVES FOR THESE (3) AREAS ARE LOCATED ALONG THE MACHINE REAR SIDE GUIDE RAIL.

AS THE CONTAINER ROLLS THROUGH THE MACHINE IT TRIPS THE FIRST LIMIT VALVE WHICH ACTUATES THE PASTE SPRAY VALVES TO APPLY PASTE TO THE CONTAINER FOR THE PICK UP END OF THE LABEL. IN SERIES WITH THE LIMIT VALVE IS AN ADJUSTABLE PULSE TIMER TO CONTROL THE LENGTH OF TIME FOR PASTE APPLICATION. IT WILL BE NECESSARY TO ADJUST THE SPRAY VALVES AND LIMIT VALVE UP OR DOWN STREAM ON THE MACHINE FOR THE PROPER POSITION FOR PASTE APPLICATION TO START.

AS THE CONTAINER CONTINUES THROUGH THE MACHINE IT TRIPS THE SECOND LIMIT VALVE WHICH ACTUATES THE PASTE SPRAY VALVES TO APPLY PASTE TO THE CONTAINER FOR THE CENTER AREA OF THE LABEL. IN SERIES WITH THE LIMIT VALVE IS AN ADJUSTABLE PULSE TIMER TO CONTROL THE LENGTH OF TIME FOR PASTE APPLICATION. IT WILL BE NECESSARY TO ADJUST THE SPRAY VALVES AND LIMIT VALVE UP OR DOWN STREAM ON THE MACHINE FOR THE PROPER POSITION FOR PASTE APPLICATION TO START.

AS THE CONTAINER CONTINUES TO THE LABEL PICK UP AREA IT TRIPS THE THIRD LIMIT VALVE WHICH ACTUATES THE PASTE EXTRUSION HEAD APPLICATOR VALVES TO APPLY PASTE TO THE TRAILING END OF THE LABEL. IN SERIES WITH THE LIMIT VALVE IS AN ADJUSTABLE PULSE TIMER TO CONTROL THE LENGTH OF TIME FOR PASTE APPLICATION. THE APPLICATOR HEAD SHOULD BE ADJUSTED TO BE 2" TO 3" IN FROM THE END OF THE LABEL. AT THIS AREA THE ROUND CURLING BAR WILL AID IN SPREADING THE PASTE OVER THE TRAILING END OF THE LABEL AS THE CONTAINER PULLS THE LABEL OUT OF THE LABEL BED.

NOTE: THE APPLICATOR IS SUPPLIED WITH PLASTIC SLEEVES WHICH CAN BE SLID ALONG THE LENGTH TO EITHER CLOSE OFF OR OPEN UP THE ORIFICES AS REQUIRED FOR THE LABEL WIDTH.

NOTE: IF ANY OF THE THREE AREAS OF PASTE APPLICATION IS NOT REQUIRED IT WOULD BE A MATTER OF REMOVING THE LIMIT VALVE TRIP ARM TO DISABLE.

REFER TO COLD PASTE APPLICATION MANUALS FOR OPERATION OF PASTE SUPPLY TANK, SPRAY VALVES (472A) AND EXTRUSION HEAD APPLICATOR VALVES.



NEW WAY PACKAGING MACHINERY, INC.
P.O. BOX 467 210 BLETTNER AVENUE
HANOVER, PA. 17331
TEL. (717) 637-2133 OR 637-8998
FAX. (717) 637-2966 WEB SITE: www.labeler.com

GENERAL INSTRUCTIONS FOR 5 GALLON LABELERS

5 GALLON LABELER ADJUSTMENTS

FOLLOWING ARE STANDARD INSTRUCTIONS FOR SETTING MACHINE ADJUSTMENTS TO HANDLE EMPTY 5 GALLON METAL AND OR PLASTIC PAILS. REFER TO SPECIAL SET UP INSTRUCTION SHEETS FOR SETTINGS FOR EACH CONTAINER TYPE OR SIZE TESTED ON MACHINE.

1. HEIGHT ADJUSTMENT

- A. THE CARRIER FRAME BELTS SHOULD BE SET TO THE REQUIRED WIDTH ADJUSTMENT. IF NEEDED, BELT WIDTH ADJUSTMENTS CAN BE MADE BY TURNING THE HANDWHEEL LOCATED AT THE INFEED END - REAR SIDE OF MACHINE.
NOTE: BEFORE MAKING ANY BELT WIDTH ADJUSTMENT CHANGES, FIRST REMOVE THE (3) TOP SPRING LOADED RUBBER LABEL PRESSURE ROLLERS AND LOOSEN THE CENTER CARRIER FRAME SIDE PLATE SPACER PLATE.
- B. THE INFEED END AND DISCHARGE END CAN TRACKS SHOULD BE SET TO MARKS FOR THE REQUIRED WIDTH ADJUSTMENT. IF ADJUSTMENTS ARE NECESSARY THEY CAN BE MADE BY LOOSENING SET SCREWS AND/OR SET COLLARS TO MAKE ADJUSTMENTS.
- C. THE CONTAINER SIDE GUIDE RAILS SHOULD BE ADJUSTED TO THE SAW MARKS ON THE GUIDE PINS. ADJUST GUIDE RAILS OUT TO MARKS ON PINS FOR THE TALLER CONTAINERS AND IN TO MARKS ON PINS FOR THE SHORTER CONTAINERS.
- D. ON THE INFEED CHUTE ADJUST THE CONTAINER BOTTOM SIDE GUIDE RAIL TO BE IN LINE WITH THE MACHINE GUIDE RAIL.
- E. WITH A CONTAINER PLACED ON THE INFEED CHUTE ADJUST THE CONTAINER HANDLE GUIDE RAIL ASSEMBLY SO THAT THE HANDLE WILL BE CENTERED IN THE GUIDE.
- F. MOUNT THE PROPER 90 DEGREE DISCHARGE TWISTER ONTO THE SUPPORT ON THE DISCHARGE END OF THE MACHINE AND ALIGN WITH THE MACHINE GUIDE RAILS.

2. DIAMETER ADJUSTMENT

- A. TURN THE HANDWHEEL LOCATED AT THE INFEED END - OPERATOR SIDE OF MACHINE TO RAISE OR LOWER THE CARRIER BELTS TO HAVE THE NECESSARY PRESSURE TO ROLL THE CONTAINER THRU THE MACHINE.
- B. ADJUST THE CONTAINER HANDLE GUIDE RAIL ASSEMBLY DOWN AS CLOSE AS POSSIBLE TO THE CONTAINER, BUT NOT AGAINST THE CONTAINER, TO CONTROL THE HANDLE AS MUCH AS POSSIBLE.

3. TIMING ROLLER ASSEMBLY

- A. THIS ASSEMBLY IS PRE-SET INTO POSITION FOR ALL CONTAINERS AND SHOULD NEED NO ADJUSTMENT EXCEPT FOR THE TIME DELAY SETTING FOR CYCLING.



NEW WAY PACKAGING MACHINERY, INC.
P.O. BOX 467 210 BLETTNER AVENUE
HANOVER, PA. 17331
TEL. (717) 637-2133 OR 637-8998
FAX. (717) 637-2966 WEB SITE: www.labeler.com

GENERAL INSTRUCTIONS FOR 5 GALLON LABELERS

5 GALLON LABELER ADJUSTMENTS

4. GUM POT ADJUSTMENTS

- A. ADJUST THE FIRST HOT GUM POT (LABEL PICK UP END POT) SO THAT THE BRASS POINTER IS IN LINE WITH THE CORRESPONDING SAW MARK ON THE GEAR RACK. (METAL = MARK TOWARD INFEED END AND PLASTIC = MARK TOWARD LABEL BED.)
- B. ADJUST THE SECOND HOT GUM POT (LABEL TRAILING END POT) AS REQUIRED FOR THE LENGTH OF THE LABEL.
- NOTE: THE SECOND GUM POT IS SUPPLIED WITH (2) SETS OF GUM ROLLS TO AID IN HOLDING LONGER LABELS IN PLACE. IN THE CASE OF SHORT LABELS, THE SET OF GUM ROLLS CLOSEST TO THE LABEL BED CAN BE REMOVED.

5. LABEL BED ADJUSTMENTS

- A. BECAUSE OF LABELING CONTAINERS WITH TAPERED SIDES IT WILL BE NECESSARY TO PIVOT THE LABEL BED AS REQUIRED PER THE LENGTH OF THE LABEL. LABEL PICK UP END ADJUSTS TO OPERATOR SIDE AND LABEL TRAILING END ADJUSTS TO REAR SIDE. THE LONGER THE LENGTH OF LABEL THE MORE THE LABEL BED WILL REQUIRE TO PIVOT.
- NOTE: THE LABEL PLATE SUPPLIED WITH THE MACHINE IS A SLOTTED LABEL PLATE AND IS ADJUSTABLE TO ACCOMMODATE FOR THE LABEL BED PIVOTING.
- B. ADJUST THE ROUND CURLING BAR AND / OR PASTE APPLICATOR TO BE 2" TO 3" OVERLAPPING THE LABELS.

NOTE: FOR OTHER ADJUSTMENTS SEE GENERAL INSTRUCTIONS FOR MODEL "E" OR "A" LABELER.



NEW WAY PACKAGING MACHINERY, INC.
P.O. BOX 467 210 BLETTNER AVENUE
HANOVER, PA. 17331
TEL. (717) 637-2133 OR 637-8998
FAX. (717) 637-2966 WEB SITE: www.labeler.com