

## GENERAL INSTRUCTIONS FOR MODEL "E" LABELERS

THESE INSTRUCTIONS ARE FOR STANDARD ADJUSTABLE LABELING MACHINES AND SHOULD BE USED ACCORDINGLY. SPECIAL ADJUSTABLE MACHINES FOR BOTTLES, JARS, SCREW TOP CANS, ETC., ALWAYS HAVE SPECIAL INSTRUCTIONS FOR SETTING MACHINE WITH EACH CONTAINER HAVING SEPARATE INSTRUCTIONS. THESE SHOULD BE READ CAREFULLY, TOGETHER WITH THE GENERAL INSTRUCTIONS BEFORE ANY ADJUSTMENTS ARE MADE.

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

## TO SET MACHINE

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 PASTE AND GUM POTS HAVE PROPER AMOUNT OF ADHESIVE.

1. DIAMETER ADJUSTMENT BY GAUGE ATTACHED TO FEED END. LAY THE CAN ON DIAMETER GAUGE PLATE PUSHING THE END OF THE CAN AGAINST STOP. WHEN ADJUSTING FROM A LARGE DIAMETER TO A SMALLER ONE, TURN LOWEST HAND WHEEL LOCATED AT FEED END TO LEFT UNTIL MIDDLE MARK ON GAUGE BLOCK STUD SHOWS AT THE TOP EDGE OF CONE GAUGE BLOCK. WHEN ADJUSTING FROM A SMALL DIAMETER TO A LARGER, TURN TO THE RIGHT INSTEAD OF TO THE LEFT. THIS IS ALL THAT IS NECESSARY TO COMPLETE DIAMETER SETTING OF THE CARRIER FRAME.

DIAMETER ADJUSTMENT BY SCALE MEASUREMENT. FIRST MEASURE DIAMETER OF CAN, THEN TURN LOWEST HAND WHEEL LOCATED AT FEED END OF MACHINE IN DIRECTION REQUIRED TO ATTAIN DIMENSION ON VERTICAL SCALE AT THE TOP EDGE OF DIAMETER GAUGE BLOCK LOCATED AT FEED END OF MACHINE. THIS COMPLETES DIAMETER SETTING OF CARRIER FRAME.

2. HEIGHT ADJUSTMENT. BEFORE MAKING ANY HEIGHT ADJUSTMENTS READ THE FOLLOWING INSTRUCTIONS THOROUGHLY. BE SURE THE PICK-UP GUM IS MELTED TO LIQUID OR SOFT ENOUGH TO ALLOW THE GUM POT DRIVEN SHAFT TO BE ROTATED BY HAND. THEN CONNECT IT TO THE DRIVING SHAFT.

ALSO, BE SURE TO HAVE THE PROPER BRUSH BETWEEN THE CARRIER FRAME, OR REMOVE IT UNTIL THE ADJUSTMENT IS MADE. ON THE LONG FRAME MACHINES, BE SURE TO LOOSEN THE CENTER GAUGE CLAMP SCREW. WHEN USING FORM 'D' GUM ROLLS (SEE INSTRUCTION SHEET NO. 1EV-A), BE SURE TO HAVE THE PROPER GUM ROLLS IN THEIR RESPECTIVE PLACES TO SUIT THE SHORTER OR TALLER CAN BEFORE ADJUSTMENT IS MADE. WHEN MAKING ANY ADJUSTMENTS OF ANY KIND, BE SURE TO HAVE MACHINE RUNNING SINCE THE OUTSIDE GUM ROLLS, CAN TRACKS, GUIDE RAILS AND CARRIER FRAME ARE SO CONSTRUCTED THAT ALL MOVE IN AND OUT AS ONE UNIT.

HEIGHT ADJUSTMENT. MEASURE CAN HEIGHT. IF FOR EXAMPLE, IT MEASURES 4-9/16" HIGH, TURN THE HIGHEST HAND WHEEL LOCATED AT FEED END OF MACHINE IN DIRECTION REQUIRED TO MOVE CAN HEIGHT ADJUSTMENT GAUGE UNTIL 4-9/16" MARK SHOWS JUST AT THE OUTSIDE EDGE OF THE HOLE THAT THE GAUGE PASSES THROUGH. THIS COMPLETES THE HEIGHT ADJUSTMENT.

3. GUM POT ADJUSTMENT. LOOSEN CLAMP KNOB ON RIGHT HAND SIDE OF GUM POT AND TURN LEFT HAND KNOB UNTIL BRASS POINTER AT RIGHT SIDE OF POT IS IN LINE WITH CORRESPONDING FIGURES OF THE SCALE TO MATCH DIAMETER OF CAN. NOTE - THIS SCALE IS DIRECT READING IN 32NDS AT TOP EDGE AND 16THS AT THE BOTTOM. AS AN EXAMPLE, A 3-1/4" DIAMETER CONTAINER REQUIRES THE POINTER TO BE SET AT 3-4/16" ON THE BOTTOM OF SCALE. THEN TIGHTEN CLAMP. SEE INSTRUCTION SHEET 3EV.

NOTE: WHEN CHANGING OVER FROM A LARGE DIAMETER CAN TO A SMALL DIAMETER CAN AND HOT PICK-UP GUM IS BEING USED, IT MAY BE DISCOVERED THAT THE SMALLER CAN IS NOT PICKING UP THE LABELS AS FREQUENTLY AS THE LARGER DIAMETER DID. THIS MAY BE BECAUSE IT WAS NECESSARY TO MOVE THE GUM POT CLOSER TO THE LABEL BED AND THEREFORE THE INTERVAL OF TIME BETWEEN PICK UP OF THE GUM SPOT AND PICK UP OF THE LABEL HAS DECREASED SO THAT THE GUM DOES NOT HAVE TIME TO COOL DOWN TO THE PROPER STICKINESS TO PICK PROPERLY. IN THAT CASE IT MIGHT BE WISE TO GIVE THE CAN TWO REVOLUTIONS BETWEEN THE GUM PICK UP AND THE LABEL PICK UP TO GIVE A LONGER INTERVAL BETWEEN THE TWO STEPS AND THEREFORE GIVE THE GUM A CHANCE TO COOL DOWN A LITTLE BIT MORE. HOWEVER, IF THE CAN EXCEEDS 2-1/2" DIAMETER, (ON SHORT FRAME MACHINES ONLY) THIS CANNOT BE DONE. AS AN EXAMPLE, A CAN MEASURING 2-1/8" DIAMETER MULTIPLIED BY TWO WOULD EQUAL 4-1/4" WHICH THEN WOULD REQUIRE THE GUM POT TO BE SET AT 4-4/16" TO GIVE TWO REVOLUTIONS.

4. FEED AND DISCHARGE CHUTE ADJUSTMENT. ADJUST FEED CHUTE GUIDE RAIL ON STATIONARY GUIDE RAIL SIDE FIRST. SET THIS RAIL IN LINE WITH STATIONARY GUIDE RAIL OF MACHINE. THEN ADJUST RAIL ON FLEXIBLE GUIDE RAIL SIDE TO LEAVE APPROXIMATELY 1/8" CLEARANCE FOR CONTAINER TO ROLL INTO MACHINE. DISCHARGE CHUTE RAILS ARE TO BE ADJUSTED SO THAT CONTAINER WILL ROLL OUT OF MACHINE FREELY.

5. TO PUT LABELS IN MACHINE. BEFORE PLACING LABELS IN MACHINE, SEE THAT CENTER LABEL PLATE, WHICH IS EASILY REMOVED, IS OF PROPER WIDTH TO RECEIVE PACK OF LABELS. THE PROPER PLATE SHOULD BE FROM 1-1/4" TO 1-3/4" NARROWER THAN LABELS. THESE LIMITS SHOULD BE ADHERED TO. SEE INSTRUCTION SHEET 7E. ALWAYS SEE THAT LABELS ARE WELL SEPARATED BEFORE PLACING IN MACHINE, SINCE THEY SOMETIMES STICK TOGETHER BECAUSE OF VARNISH OR PRINTER'S INK. THIS IS OVERCOME BY HOLDING PACK OF LABELS TIGHTLY IN CENTER AND ROUGHING END THOROUGHLY. IF STUCK TOGETHER VERY BADLY, HIT ENDS GENTLY OVER EDGE OF LABEL SHELF. IF LABELS ARE NOT THOROUGHLY SEPARATED AS INDICATED ABOVE,

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THE CONTAINERS, IN PASSING OVER LABELS, WILL PICK UP TWO OR MORE, DEPENDING ON QUANTITY STUCK TOGETHER, AND WILL THEN DROP THE SURPLUS LABELS WHEN HALF OVER THE PACK. THE FOLLOWING CONTAINER WILL THEN PICK UP THE LABELS. HOWEVER, THESE LABELS WILL HAVE NO PASTE ON THE LAP END.

ALSO SEE THAT LABELS ARE OF PROPER DIMENSION FOR THE CONTAINER TO BE LABELED. ALL LABELS SHOULD BE LONG ENOUGH TO LAP OVER FROM 1/2" TO 5/8". FOR CANS, THE LABEL WIDTH SHOULD BE AT LEAST 3/32" NARROWER THAN THE DISTANCE BETWEEN THE BEADS. FOR GLASS, THE LABEL WIDTH SHOULD BE AT LEAST 1/4" LESS THAN THE WIDTH OF THE STRAIGHT SECTION OF THE BODY OF THE BOTTLE OR JAR. FOR THE FIRST PACK OF LABELS HAVE THE SIDE GUIDES SET FOR 1/8" TO 1/4" WIDER THAN THE LABELS. THIS DIMENSION CAN BE GAUGED BY PLACING LABELS ON THE LABEL BED AND ADJUSTING THE SIDE GUIDES IN OR OUT TO THE ABOVE APPROXIMATE DIMENSION.

CARE SHOULD BE TAKEN SO THAT ENDS OF LABELS ARE PUSHED BACK EVENLY AGAINST END GUIDE AT PICK UP END OF LABEL BED. THEN RAISE THE LABEL BED UNTIL LABELS ARE APPROXIMATELY 1/4" BELOW TOP OF SIDE LABEL GUIDES. SEE INSTRUCTION SHEET 6EV.

FOR FINAL ADJUSTMENT OF GUIDES, OPERATOR SHOULD LOOK DOWN THRU MACHINE ALLOWING HIMSELF A GOOD VIEW OF TOP OF LABELS AND GUIDES. THEN ADJUST GUIDES BY TURNING OUTSIDE KNOBS IN JUST TIGHT ENOUGH SO THAT LABELS DO NOT BULGE IN CENTER. IF GUIDES ARE TOO TIGHT, THIS MAY INTERFERE WITH PICKING UP LABELS. IF SET TOO LOOSE, PASTE WILL RUN OVER THE EDGE OF LABELS OR CAUSE CONTAINERS TO SLIP OFF EDGE OF TRACKS. SEE INSTRUCTION SHEET 7E.

THEN ADJUST PASTE POT BY LOOSENING WING SCREW LOCATED AT BACK OF ADJUSTING KNOB AND MOVE POT UNTIL PASTE BELT OVERLAPS END OF LABELS 3/16" MINIMUM TO 1/2" MAXIMUM. SEE "D" ON INSTRUCTION SHEET 6EV. BE SURE TO TIGHTEN WING SCREW.

NOW RAISE THE LABELS UNTIL THE TOP OF THEM IS EVEN WITH THE TOP EDGE OF THE CAN TRACKS JUST AT POINT WHERE CONTAINERS COME IN CONTACT WITH THE PICK UP END OF THE LABELS. SEE INSTRUCTION SHEET 6EV.

WHEN FIRST STARTING TO LABEL, ALWAYS INSPECT THE CONTAINERS FOLLOWING THE FIRST ONE, OBSERVING IF THE PICK UP END OF LABEL IS EVENLY PLACED ON CONTAINER, AND IF THE LAP END OF LABEL IS IN LINE WITH THE PICK UP END. IF LABELS ARE STRAIGHT ON CONTAINERS, MACHINE IS NOW READY FOR LABELING. IF NOT STRAIGHT, SEE INSTRUCTION SHEET 6EV.

## LABEL BED

THE LABEL BED INCLUDES, BESIDES THE VARIOUS SUPPORTS FOR HOLDING THE LABELS IN PLACE, SEVERAL DIFFERENT ELEMENTS SUCH AS SPRINGS, KNIVES, PASTE SHIELD AND CURLING BAR, EACH OF WHICH IS FOR A SPECIFIC PURPOSE.

1. SPRINGS NLE-1117L & R AND NLE-1118B ARE USED TO ASSIST THE CANS IN ROLLING ON TOP OF THE LABELS BY HOLDING THE ENDS OF THE LABELS DOWN AND THEY ALSO HELP IN SEPARATING THE LABELS IF THEY HAVE A TENDENCY TO STICK AT THE END. THESE FLAT SPRINGS SHOULD EXTEND APPROXIMATELY 3/16" OVER THE END OF THE LABEL AND BE BENT SO THAT THEY PUT SLIGHT PRESSURE ON THE LABEL STACK. IF THEY ARE DOWN TOO TIGHT ON THE LABELS, THE CANS WILL NOT PICK THEM UP. SEE INSTRUCTION SHEET 6EV.

2. SIDE KNIVES NL-2121A AT THE PICK UP END OF THE LABELS ARE USED TO PREVENT THE LABELS FROM PUSHING FORWARD WHILE THE CANS ROLL ON THEM. THEY SHOULD EXTEND 1/8" TO 3/16" BEYOND THE SIDE GUIDES AND SHOULD BE SHARPENED AT LEAST ONCE OR TWICE PER WEEK DEPENDING UPON THE AMOUNT OF USAGE.

3. THE ANGLE BLADE NL-2120A AT THE LAP END OF THE LABEL BED MOUNTED IN A SPRING TENSION HOLDER NLE-2118A IS USED TO RETAIN THE LOWER LABELS IN PLACE WHILE THE CAN PULLS THE TOP LABEL OFF THE PACK. THEY SHOULD BE ADJUSTED TO EXTEND 3/16" TO 1/4" OVER THE EDGE OF THE LABELS. NOTE THE ANGLE OF THESE BLADES HAS ROUNDED EDGES AND SHOULD BE KEPT THAT WAY BECAUSE IF THEY HAVE SHARP EDGES OR CORNERS, THEY WILL TEAR THE LABELS AS THEY ARE PULLED UP THROUGH THE BLADES BY CANS PASSING THROUGH THE MACHINE.

4. THE LABEL CURLING BAR WHICH LAYS ACROSS THE LABELS AT THE LAP END IS USED TO CREATE A CURL IN THE LAP END OF THE LABEL TO CONFORM TO THE BODY OF THE CANS TO HELP TO HOLD THE END DOWN UNTIL THE PASTE DRIES. IN ORDER TO FORM THIS CURL THE SPRING TENSION SHOULD BE SET AS TIGHT AS POSSIBLE WITHOUT TEARING THE LABELS. NOTE THE SPRINGS MUST BE ADJUSTED EVENLY AT BOTH ENDS OF THE BAR. SEE INSTRUCTION SHEET 6EV. IF AFTER EVEN CURLING BAR TENSION IS ATTAINED AT EACH END OF THE BAR, A CHANGE IN TENSION IS REQUIRED, THE LAP END OF THE LABEL BED MAY BE RAISED OR LOWERED BY TURNING SCREW "G". SEE INSTRUCTION SHEET 5EV. THE CURLING BAR BECOMES VERY STICKY FROM PASTE ON THE LABELS PASSING UNDER IT, THEREFORE IT SHOULD BE WASHED OFF SEVERAL TIMES A DAY AND ALSO BE SURE TO WASH AND CLEAN IT EVERY NIGHT. IF THE MACHINE RUNS IDLE OR IS STOPPED FOR ANY LENGTH OF TIME, THE TOP LABEL MAY STICK TO THE BAR AND TEAR OFF WHEN THE NEXT CAN PASSES THROUGH. IT IS, THEREFORE, ADVISABLE TO RUN ONE CAN THROUGH THE MACHINE TO OBSERVE IF THIS HAPPENS BEFORE STARTING WITH THE FULL RUN. THIS TROUBLE CAN BE PREVENTED IF THE LABEL BED IS LOWERED WHEN THE MACHINE IS LEFT IDLE.

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5. PASTE SHIELD NLE-290G ON THE REAR SIDE OF MACHINE IS USED TO ASSIST THE BELT IN CARRYING THE PASTE OVER THE EDGE OF THE LABELS. THIS SHIELD SHOULD WORK FREELY UP AND DOWN IN THE SLOT. THE SHIELD SHOULD BE REMOVED FROM THE MACHINE AND WASHED AFTER EACH DAY'S RUN. SEE INSTRUCTION SHEET DWG. NO. 4153C.

6. THE LABEL FEED SHOULD BE ADJUSTED SO THAT THE LABELS WILL BE AUTOMATICALLY KEPT UP EVEN WITH THE TOP EDGE OF THE INFEED CAN TRACK FOR CONTAINERS UP TO 3-3/16" DIAMETER OR 1/32" TO 1/16" ABOVE THE CAN TRACKS FOR LARGER DIAMETERS. IF MACHINE FEEDS LABELS TOO HIGH ABOVE THE CAN TRACKS AT ANY TIME, THE CONTAINERS WILL PUSH THE LABELS AHEAD AND CAUSE THREE OR MORE LABELS TO BE PICKED UP AT ONE TIME. IF LABELS ARE BELOW THE TOP EDGE OF THE TRACKS, IT WILL CAUSE CONTAINER TO MISS PICKING THE LABELS UP. SEE INSTRUCTION SHEET 6EV. WHEN REFILLING LABELS, IT IS NECESSARY, OF COURSE, TO LOWER THE STANDARD LABEL FEED BED. TO DO THIS, PUSH THE CONTROL DISC BELL CRANK HANDLE NLE-W253 TOWARD THE REAR SIDE OF MACHINE AS FAR AS IT WILL GO. THIS HANDLE WILL STAY IN THIS POSITION AND THE LABEL BED WILL DROP DOWN ITSELF IF IT IS WELL OILED AND IN WORKING ORDER. THEN LOWER, TURN THE HAND WHEEL NLE-AC2148 TO THE LEFT TO LOWER THE BED. NOTE-AFTER LOWERING THE BED, THE BELL CRANK HANDLE MUST BE RELEASED BY PRESSING DOWN ON THE LABEL CONTROL ROD NLE-261 AT "A" AS THIS ENGAGES THE AUTOMATIC FEEDING. SEE INSTRUCTION SHEET 6EV.

7. FOR REFILLS OF SIMILAR SIZE LABELS, NO FURTHER ADJUSTMENTS ARE NECESSARY AS LONG AS LABELS REMAIN THE SAME WIDTH AND LENGTH. IF LONGER OR SHORTER LABELS ARE USED BUT SAME WIDTH IS RETAINED, PASTE POT ONLY MUST BE MOVED TO CORRESPOND TO THE LENGTH OF THE LABELS. IF WIDER OR NARROWER LABELS ARE USED BUT THE SAME LENGTH IS RETAINED, GUIDES ONLY MUST BE ADJUSTED IN OR OUT TO CORRESPOND TO THE WIDTH OF THE LABELS. FOR CARE AND ADJUSTMENT OF THE LABEL FEED ASSEMBLY, STUDY CAREFULLY INSTRUCTION SHEETS 5EV AND 6EV.

## CONTINUOUS LABELING

IF NOT FAMILIAR WITH LABELING, IT IS ADVISABLE TO USE THE STANDARD LABEL FEED FOR A PERIOD OF TIME TO BECOME THOROUGHLY FAMILIAR WITH ITS OPERATION. STUDY ALL THE PRECEDING INFORMATION AND INSTRUCTION SHEETS 5EV AND 6EV. THEN PROCEED TO PUT LABELS IN MACHINE AS FOLLOWS.

1. DISENGAGE THE RIGHT HAND CLUTCH AND TURN RIGHT HAND WHEEL IN DIRECTION INDICATED BY ARROW UNTIL LABEL PLATE CARRIER BAR IS ON OUTSIDE AT LOCATION "B". THEN DISENGAGE LEFT HAND CLUTCH AND LOWER STANDARD FEED BED. ON THE TOP OF THIS FEED BED LAY A CONTINUOUS FEED PLATE, BE SURE THIS PLATE IS PUSHED BACK SQUARE AGAINST THE REAR GUIDE AS SHOWN ON INSTRUCTION SHEET 6EV. ON THE TOP OF THIS PLATE STACK EVENLY, TWO ONE THOUSAND, OR FOUR FIVE HUNDRED PACKS OF LABELS, BEING SURE THAT ALL THE LABELS ARE STACKED EVENLY ON TOP OF EACH OTHER AND PUSHED SQUARE AGAINST THE END GUIDE AND THE REAR LABEL GUIDE AS SHOWN ON INSTRUCTION SHEET 6EV. IF THIS IS NOT ADHERED TO IT WILL CAUSE VERY UNSATISFACTORY LABELING.

2. NOW DEPRESS THE BAR AT "A" TO ENGAGE THE LABEL FEED, THEN RAISE THE LABEL BED UP BY TURNING THE LEFT HAND WHEEL UNTIL THE LABELS ARE EVEN WITH THE TOP OF THE CAN TRACKS AND ENGAGE THE LEFT HAND CLUTCH. SEE INSTRUCTION SHEET 6EV. NOW RELEASE THE CAN STOP AND LET FOUR OR FIVE CANS ROLL THROUGH THE MACHINE, INSPECT THE CONTAINERS, THEN READJUST MACHINE IF NECESSARY.

3. NOW WHILE THE MACHINE IS LABELING, GET MORE LABELS READY TO INSERT INTO THE MACHINE WITHOUT STOPPING IT. NOTE: WHEN INSERTING LABELS, NEVER USE MORE THAN A ONE THOUSAND PACK OR TWO PACKS OF FIVE HUNDRED EACH AT A REFILL. NOW PROCEED WITH THE REFILL AS FOLLOWS. TURN THE RIGHT HAND WHEEL IN THE DIRECTION INDICATED BY ARROW UNTIL THE LABEL PLATE CARRIER BAR COMES UP UNDER THE ANGLE OF THE CONTINUOUS FEED PLATE AT LOCATION "E". SEE INSTRUCTION SHEET 6EV. TURN THIS BAR TIGHT ENOUGH AGAINST THE BOTTOM OF THE CONTINUOUS FEED PLATE TO RELIEVE THE PRESSURE FROM THE STANDARD LABEL FEED BED AND IMMEDIATELY ENGAGE THE RIGHT HAND CLUTCH. NOW DISENGAGE THE LEFT HAND CLUTCH AND LOWER THE STANDARD FEED BED. LAY ON TOP OF THIS BED ANOTHER CONTINUOUS FEED PLATE AND ON TOP OF THIS PLATE LAY THE READIED PACK OF LABELS MENTIONED ABOVE. AGAIN RAISE THE FEED BED UP UNTIL THE LABELS PUSH TIGHT ENOUGH AGAINST THE UNDERSIDE OF THE CONTINUOUS FEED PLATE TO RELIEVE THE PRESSURE ON THE CONTINUOUS LABEL PLATE CARRIER BARS, AND IMMEDIATELY ENGAGE THE LEFT HAND CLUTCH AND DISENGAGE THE RIGHT HAND CLUTCH. NOTE: NEVER USE THE CHAINS FOR FEEDING PURPOSE ANY LONGER THAN THE TIME REQUIRED TO INSERT MORE LABELS.

4. AS WE NOW HAVE TWO CONTINUOUS FEED PLATES OPERATING, ONE ABOVE THE OTHER, FEEDING UP AS FAST AS THE CANS REMOVE THE LABELS WHILE ROLLING THROUGH THE MACHINE, THE TOP PLATE MUST BE PULLED OUT IMMEDIATELY WHEN IT HAS MOVED TO POSITION "H" AS SHOWN ON INSTRUCTION SHEET 6EV. TO PULL THIS PLATE OUT, TURN THE RIGHT HAND WHEEL IN DIRECTION OF ARROW, THIS WILL PULL THE PLATE OUT PART WAY. KEEP TURNING UNTIL CARRIER BAR IS BACK TO POSITION "B", THEN FINISH PULLING THE PLATE OUT BY HAND AS QUICKLY AS POSSIBLE. IMMEDIATELY REPEAT THE REFILL INSTRUCTIONS AS MENTIONED ABOVE AND BE READY TO PULL OUT THE NEXT PLATE WHEN IT REACHES LOCATION "H", AS LONG AS CONTINUOUS LABELING IS DESIRED. OCCASIONALLY LABELS WILL BE USED WHICH TEND TO STICK TO THE FEED PLATES. DUSTING BOTH SIDES WITH SOAP STONE OR CORN STARCH WILL GENERALLY ELIMINATE THIS CONDITION.

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## LABEL FEED ADJUSTMENTS WITH AND WITHOUT CONTINUOUS FEED

READ INSTRUCTION SHEETS 5EV AND 6EV. NOTE THAT CLUTCHES, DRIVE CHAIN AND THE HAND WHEEL AT DISCHARGE END OF THE LABEL BED ARE ONLY USED ON BEDS EQUIPPED FOR CONTINUOUS LABELING AND DOES NOT INTERFERE WITH THE FOLLOWING INSTRUCTIONS, BUT WILL BE MENTIONED LATER ON IN THESE INSTRUCTIONS.

1. TO CHECK IF LABEL FEED IS OPERATING CORRECTLY BEFORE LABELING, PROCEED AS FOLLOWS. START THE MOTOR AND LET THE MACHINE RUN IDLE. DISENGAGE THE LABEL FEED AND LOWER THE STANDARD FEED BED AS FAR AS IT WILL GO. THEN ENGAGE THE FEED AGAIN BY PRESSING DOWN ON BAR AT "A". SEE INSTRUCTION SHEET 5EV. IF THIS BAR DOES NOT HAVE ENOUGH DOWNWARD MOTION TO DISENGAGE THE FEED CONTROL PAWL FROM NOTCH "C" IN FEED CONTROL DISC, TURN THE LABEL FEED CONTROL NUT CLOCKWISE UNTIL IT DOES DISENGAGE.

2. IF LABEL BED IS EQUIPPED FOR CONTINUOUS FEED, ENGAGE THE LEFT HAND CLUTCH. NOW USE HAND WHEEL ON THE LEFT AND HOLD IT WITH ONE HAND EXERTING A LOT OF PRESSURE IN DIRECTION FOR LOWERING AS INDICATED BY ARROW. SEE INSTRUCTION SHEET 5EV. WHILE EXERTING THIS PRESSURE WITH ONE HAND, TAKE THE OTHER HAND AND DEPRESS THE BAR AT "A" AND HOLD IT DOWN UNTIL THE RATCHET FEED STARTS EXERTING PRESSURE AGAINST THE HAND HOLDING THE HAND WHEEL. THIS ACTION WILL CONTINUE AS LONG AS THE BAR IS DEPRESSED AT "A". RELEASE THE PRESSURE ON THE BAR AND IT WILL STOP FEEDING.

3. THE LABEL CONTROL ROD IS ACTUATED BY THE CANS ROLLING OVER THE CONTROL BLOCK REGULATOR "F". SEE INSTRUCTION SHEET 5EV. DEPRESSING THIS BAR QUICKLY AND RELEASING IT INSTANTLY CAUSES THE BED TO FEED UP ONE TOOTH AT A TIME ON THE RATCHET WHEEL UNTIL THE LABELS REACH A PREDETERMINED HEIGHT. THEREFORE DEPRESSING THE BAR BY HAND QUICKLY AND RELEASING IT INSTANTLY WILL CAUSE THE SAME ACTION AS THE CANS. IF THE FEED FAILS TO OPERATE AS MENTIONED, STOP THE MOTOR. TURN THE LABEL FEED BED UP ABOUT HALF WAY BY HAND AND ENGAGE THE FEED PAWLS BY DEPRESSING THE BAR AT "A".

4. IF BED IS EQUIPPED FOR CONTINUOUS FEEDING, ENGAGE THE LEFT HAND CLUTCH. THEN CHECK THE FEED CONTROL PAWL FOR WEAR OR BREAKAGE. SEE INSTRUCTION SHEET 5EV. THIS PAWL SHOULD SLIDE FREELY IN THE SUPPORT CASTING WHICH HAS A SPRING AND ADJUSTING SCREW IN TOP OF IT. THIS SCREW REQUIRES A 7/16" HOLLOW SET SCREW WRENCH FOR ADJUSTING THE TENSION ON THE SPRING AND THIS SCREW SHOULD SET APPROXIMATELY 1/4" TO 3/8" BELOW THE EDGE OF THE CASTING.

5. NOW GO TO THE REAR SIDE OF THE MACHINE AND PULL THE CARRIER BELTS IN RUNNING DIRECTION UNTIL THE ECCENTRIC DRIVE TURNS TO DEAD CENTER ON ITS UP STROKE. SEE INSTRUCTION SHEET 5EV. WITH THE ECCENTRIC SETTING AT THIS LOCATION, THE FEED CONTROL PAWL SHOULD DROP FREELY TO THE BOTTOM OF NOTCH "D" IN FEED CONTROL DISC. IF IT DOES NOT DROP IN PLACE, TRY PRESSING DOWN HARD ON TOP OF FEED BED BY HAND TO TAKE UP THE SLACK IN ALL MOVING PARTS OF THE LABEL FEED. IF IT DOES NOT ENTER, THEN LOOSEN THE LOCK NUTS ON TOP AND BOTTOM OF THE CONNECTION ROD AND STICK A PIN IN THE HOLE ON THE ROD AND TURN IN DIRECTION REQUIRED TO ALLOW THE FEED CONTROL PAWL TO DROP FREELY IN NOTCH "D".

6. WITH THIS ADJUSTMENT COMPLETED, PROCEED BY ADJUSTING THE DETENT PAWL WITH ECCENTRIC SETTING THE SAME AS IT WAS FOR THE ABOVE ADJUSTMENT. SEE INSTRUCTION SHEET 5EV. THIS PAWL IS ON AN ECCENTRIC STUD MOUNTED IN A HOLE IN THE LABEL BED RISER. LOOSEN THE SET SCREW THAT HOLDS THIS STUD AND START TURNING THE STUD UNTIL THE DETENT PAWL JUST ENTERS OVER THE EDGE OF A TOOTH IN THE RATCHET WHEEL AND TIGHTEN THE SET SCREW. NOTE: BE SURE THE PAWL JUST ENTERED OVER THE EDGE OF THE TOOTH. THIS IS VERY ESSENTIAL BECAUSE THIS PAWL AND THE FEED CONTROL PAWL MUST HAVE THE SAME AMOUNT OF CLEARANCE TO ENGAGE AT THE PROPER MOMENT WHEN THE ECCENTRIC DRIVE PASSES OVER DEAD CENTER OF THE UP STROKE. SEE INSTRUCTION SHEET 5EV. ONCE THEY ARE SET EVENLY, THE SMALL AMOUNT OF CLEARANCE REQUIRED FOR THEM TO ENTER THEIR RESPECTIVE POSITIONS, CAN BE ATTAINED BY SHORTENING THE CONNECTING ROD FOR MORE CLEARANCE OR LENGTHENING FOR LESS. SEE "S" ON INSTRUCTION SHEET 5EV. THIS DIMENSION WAS SET CORRECTLY WHEN THE MACHINE LEFT THE FACTORY AND WILL NEED ONLY MINOR ADJUSTMENTS TO COMPENSATE FOR WEAR OR IN CASE PARTS NLE-279 AND NLE-282 NEED TO BE REPLACED.

7. HOW TO OPERATE, ADJUST AND KEEP CONTINUOUS FEED CHAINS IN ALIGNMENT. THE AUXILIARY CHAIN FEED IS USED TO MAKE IT POSSIBLE TO INSERT MORE LABELS IN THE MACHINE WITHOUT STOPPING IT. IT SHOULD NOT BE USED FOR FEEDING ANY LONGER THAN THE TIME REQUIRED TO INSERT MORE LABELS. SEE INSTRUCTION SHEET 6EV.

8. WHEN LABELING CONTINUOUSLY, THERE WILL BE BETWEEN TWO AND THREE THOUSAND LABELS IN THE BED AT ALL TIMES. FOR GOOD OPERATING EACH PACK OF LABELS SHOULD MATCH THE PRECEDING PACK IN LENGTH AND WIDTH. WITH THIS QUANTITY OF LABELS IN THE LABEL BED AT ONE TIME, THE PRESSURE REQUIRED BY THE KNIVES TO CUT THROUGH THE LABELS AT THE PICK UP END DEPENDS ON THE QUALITY OF THE PAPER AND THE PRINTING. THEY MIGHT FLUFF UP 1/8" TO 1/4" AT THE LAP END, CAUSING TOO MUCH TENSION ON THE CURLING BAR AND MIGHT ALSO STOP THE PASTE BELT CAUSING TORN LABELS. TO OVERCOME THIS DIFFERENCE, LOWER THE STANDARD LABEL FEED BED AT THE LAP END 1/4" BY ADJUSTING SCREW "G". SEE INSTRUCTION SHEET 5EV.

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## GENERAL INSTRUCTIONS FOR MODEL "E" LABELERS

9. AFTER THE ABOVE ADJUSTMENT IS MADE, THE BED SHOULD JUST ABOUT LINE UP EVEN WITH THE LABEL PLATE CARRIER BARS AT THE LAP END. THESE BARS ARE SET AT THE FACTORY 1/8" TO 1/4" LOW AT THE LAP END AND NEED NO MORE ADJUSTING UNLESS THE LABELS VARY MORE THAN THE AVERAGE. TO ADJUST THESE BARS, SEE INSTRUCTION SHEET SEV AND NOTE "H"--"J"--"K"--"L"--"M".

10. TO ELIMINATE ERRORS FOR ADJUSTMENT OF THE LABEL PLATE CARRIER BARS, MAKE TWO STRIPS OF WOOD OR STEEL 1/4" X 1/2" X 12" LONG AND PROCEED AS FOLLOWS. STOP THE MACHINE. DROP THE STANDARD LABEL BED DOWN AND ENGAGE THE LEFT HAND CLUTCH AND THE FEED PAWLS BY DEPRESSING THE BAR AT "A". THEN USING THE RIGHT HANDWHEEL TURN THE LABEL PLATE CARRIER BARS TO THE INSIDE OF THE LABEL BED TO THE POSITION SHOWN ON END VIEW OF INSTRUCTION SHEET SEV. ENGAGE RIGHT HAND CLUTCH. LAY ONE OF THE STRIPS AS MENTIONED ABOVE ON ITS EDGE CROSSWISE OF THE LABEL BED AT THE DISCHARGE END OF THE LABEL BED SO IT RESTS ON BOTH CARRIER BARS, REAR AND OPERATOR SIDE. SEE "L" ON INSTRUCTION SHEET SEV. THEN TURN THE RIGHT HAND WHEEL IN DIRECTION OF ARROW UNTIL THE GAUGE STRIP TOUCHES THE UNDERSIDE OF BOTH DRIVE SHAFTS, REAR AND OPERATORS SIDE AT THE SAME TIME. IF THEY DON'T TOUCH BOTH SIDES, THEY ARE OUT OF ALIGNMENT CROSSWISE OF THE LABEL BED AND MUST BE ADJUSTED BY LOOSENING THE SCREW IN THE END OF THE REAR DRIVE SHAFT. SEE "M" ON INSTRUCTION SHEET SEV. THEN PULL THE DRIVE CHAIN AT THIS END BY HAND IN THE DIRECTION REQUIRED TO BRING BOTH ENDS OF THE GAUGE STRIP AGAINST THE UNDERSIDE OF BOTH TOP DRIVE SHAFTS AND TIGHTEN THE SCREW SECURELY. WITH THIS ADJUSTMENT COMPLETED, LAY THE OTHER GAUGE STRIP FLAT WAYS ACROSS THE CARRIER BARS AT THE FEED END OF THE LABEL BED. SEE "K" ON INSTRUCTION SHEET SEV. LOOSEN THE SCREWS IN THE END OF THE DRIVE SHAFT "H" AND "J". SEE FEED END VIEW ON INSTRUCTION SHEET SEV. THEN USE A SPANNER WRENCH IN THE HOLES DRILLED FOR THIS PURPOSE ON THE INSIDE OF THE SPROCKETS AT THIS END OF THE MACHINE AND TURN EACH SPROCKET UNTIL THE GAUGE STRIP TOUCHES THE UNDERSIDE OF EACH TOP DRIVE SHAFT. BE SURE THAT GAUGE STRIP LAYS FLAT WAYS ACROSS THE CARRIER BARS. THEN TIGHTEN THE SCREWS SECURELY. NOW REMOVE THE GAUGE STRIPS AND THE CARRIER BARS WILL BE SETTING 1/4" LOW AT THE LAP OR DISCHARGE END OF THE BED. IF A LITTLE MORE IS REQUIRED, WE WILL SAY 1/8", INSERT IT UNDER THE GAUGE STRIP AT "L" AND AGAIN ADJUST THIS END TO THE 1/4" GAUGE STRIP.

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