

MODEL "E" & "A" LABELER TROUBLE SHOOTING GUIDE

PRELIMINARY CHECKS:

1. CHECK THAT PASTE POT AND GUM POT HAVE THE PROPER AMOUNTS OF ADHESIVE.
2. CHECK THE TEMPERATURE IN THE GUM POT.

PROBLEMPROBABLE CAUSE

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| 1. CONTAINER WILL NOT PICK UP LABELS. | <p>A. THE GUM POT IS NOT ON THE CORRECT SETTING. THE SETTING ON THE GUM POT ADJUSTMENT SCALE IS THE SAME AS THE SETTING FOR THE DIAMETER OF THE CONTAINER. (REFER TO GENERAL INSTRUCTIONS "GUM POT ADJUSTMENT")</p> <p>B. THE LABEL PACK IS NOT FEEDING HIGH ENOUGH. THE LABEL FEED SHOULD BE ADJUSTED SO THAT THE LABELS WILL BE AUTOMATICALLY KEPT AT THE CORRECT LEVEL DEPENDING ON THE DIAMETER OF THE CONTAINER. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>C. THE LABEL RETAINER SPRINGS (NLE-1117L & R, AND NLE-1118B) MAY NEED READJUSTING. THESE SPRINGS SHOULD EXTEND APPROXIMATELY 3/16" OVER THE END OF THE LABEL AND BE BENT SO THAT THEY HAVE SLIGHT PRESSURE ON THE LABELS. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>D. THE TEMPERATURE VARIATION OF THE CONTAINER, OR THE CONTAINER HAVING A SLIGHT COATING OF MOISTURE OR OIL. THESE PROBLEMS CAN BE SOLVED BY THE SELECTION OF THE TYPE OF PICK UP GUM USED. (REFER TO "HOT GUM POT INSTRUCTIONS SHEET")</p> |
| 2. CONTAINERS PICK UP MORE THAN ONE LABEL. | <p>A. THE GUM POT IS NOT ON THE CORRECT SETTING. THE SETTING ON THE GUM POT ADJUSTMENT SCALE IS THE SAME AS THE SETTING FOR THE DIAMETER OF THE CONTAINER. THE GUM PICK-UP SPOT SHOULD START 1/16" TO 1/8" IN FROM PICK-UP END OF THE LABEL. (REFER TO GENERAL INSTRUCTIONS "GUM POT ADJUSTMENTS")</p> <p>B. THE LABEL RETAINER SPRINGS (NLE-1117L & R, AND NLE-1118B) MAY NEED READJUSTING. THESE SPRINGS SHOULD EXTEND APPROXIMATELY 3/16" OVER THE END OF THE LABEL AND BE BENT SO THAT THEY HAVE SLIGHT PRESSURE ON THE LABELS. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>C. THE LABEL PACK IS FEEDING TOO HIGH. THE LABEL FEED SHOULD BE ADJUSTED SO THAT THE LABELS WILL BE AUTOMATICALLY KEPT AT THE CORRECT LEVEL DEPENDING ON THE DIAMETER OF THE CONTAINER. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>D. THE LAP END KNIVES ARE NOT EXTENDED OVER THE EDGE OF THE LABELS FAR ENOUGH. THEY SHOULD EXTEND 3/16" TO 1/4" OVER THE EDGE OF THE LABELS. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>E. THE LABELS MAY STICK TOGETHER BECAUSE OF THE VARNISH OR PRINTERS INK. FANNING THE LABELS BEFORE PLACING THEM INTO THE MACHINE WILL HELP SEPARATING THEM. (REFER TO GENERAL INSTRUCTIONS "TO SET MACHINE")</p> |
| 3. LABEL PACK PUSHES TOWARD DISCHARGE END OF MACHINE WHEN CONTAINERS ROLL OVER IT. | <p>A. THE LABEL PACK IS FEEDING TOO HIGH. IF LABELS ARE TOO HIGH ABOVE THE TRACKS, THE CONTAINERS WILL PUSH THE LABELS FORWARD. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>B. THE PICK-UP END KNIVES NEED SHARPENED OR THEY ARE NOT EXTENDING BEYOND THE SIDE GUIDES FAR ENOUGH. THESE KNIVES SHOULD BE SHARPENED AT LEAST ONCE PER WEEK, AND THEY SHOULD EXTEND 1/8" TO 3/16" BEYOND THE SIDE GUIDES. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> |

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<u>PROBLEM</u>	<u>PROBABLE CAUSE</u>
4. LABELS TEAR WHEN BEING PULLED OUT OF LABEL BED.	<p>A. THE LAP END KNIVES MAY HAVE SHARP EDGES OR CORNERS. ANY SHARP EDGES ON THESE KNIVES WILL HAVE A TENDENCY TO TEAR THE LABEL AS IT'S PULLED OUT FROM UNDER THE BLADES. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>B. THE PICK-UP END KNIVES MAY BE EXTENDING BEYOND THE SIDE GUIDES TOO FAR. THEY SHOULD EXTEND 1/8" TO 3/16" BEYOND THE SIDE GUIDES. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>C. THE CURLING BAR HAS TOO MUCH SPRING TENSION ON IT. THE TENSION SHOULD BE SET AS TIGHT AS POSSIBLE WITHOUT TEARING THE LABELS. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p> <p>D. IF THE MACHINE RUNS IDLE OR IS STOPPED FOR ANY LENGTH OF TIME, THE TOP LABEL MAY STICK TO THE CURLING BAR. THE LABEL BED SHOULD BE LOWERED WHEN THE MACHINE IS LEFT IDLE. (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p>
5. THE LAP PASTE BELT DOES NOT APPLY AN EVEN AND UNINTERRUPTED FLOW OF PASTE TO THE LABEL.	<p>A. THE PASTE IS NOT OF THE RIGHT CONSISTENCY. AN INDICATION OF PROPER CONSISTENCY IS WHEN A SEMI-TRANSPARENT WEB WILL PULL OUT BETWEEN THE DRIVE WHEEL AND THE BELT. (REFER TO "LAP PASTE POT INSTRUCTIONS SHEET")</p> <p>B. THE PASTE HAS FOREIGN MATTER, DRIED PASTE, LUMPS OR SCALE IN IT. THE PASTE MUST BE FREE OF THIS MATTER BECAUSE IT WILL COLLECT BEHIND THE SCRAPER AND CLOG THE HOLES IN THE SCRAPER WHEEL. (REFER TO "LAP PASTE POT INSTRUCTIONS SHEET")</p>
6. THE EXCESSIVE STRINGING OF HOT GUM.	<p>A. INCREASE HEAT IN THE GUM POT. THE STRINGS ARE CAUSED BY THE GUM COOLING OFF. (REFER TO "HOT GUM POT INSTRUCTIONS SHEET")</p>
7. THE ADHESIVE FROM THE GUM POT ACCUMULATING ON THE CARRIER BELTS.	<p>A. INCORRECT SETTING OF GUM ROLL SCRAPERS WILL CAUSE THE GUM TO COLLECT ON THE ROLLS, WHICH WILL TRANSFER TO THE CAN TRACKS, THEN TO THE CONTAINERS, AND FINALLY ONTO THE BELTS. THE SCRAPER SHOULD BE SET CLOSE ENOUGH TO THE ROLL TO ALLOW A VERY THIN SMEAR OF GUM TO BE DEPOSITED ON THE CONTAINER. (REFER TO "HOT GUM POT INSTRUCTIONS SHEET")</p> <p>B. THE TEMPERATURE OF THE GUM MAY BE TOO COLD. THE RESULT IS THE GUM ROLLS WILL CARRY AN OVER SUPPLY OF GUM ON THEIR SIDES. THE TEMPERATURE MUST BE INCREASED. (REFER TO "HOT GUM POT INSTRUCTIONS SHEET")</p>
8. THE LAP END OF THE LABEL PACK STICKS TOGETHER.	<p>A. THE PASTE SHIELD IS NOT SET CORRECTLY. THE SHIELD IS USED TO ASSIST THE BELT IN CARRING THE PASTE OVER THE EDGE OF THE LABELS. IT SHOULD EXTEND OVER THE LABEL PACK ABOUT 3/32". (REFER TO GENERAL INSTRUCTIONS "LABEL BED")</p>

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