

**MODEL "E" & "A" LABELER TROUBLE SHOOTING GUIDE  
FOR MACHINES WITH VANSO PRESSURIZED PASTE SYSTEM**

<u>PROBLEM</u>	<u>CAUSE</u>	<u>SOLUTION</u>
NOT ENOUGH ADHESIVE	1. THE ADHESIVE PRESSURE IS TOO LOW	INCREASE THE PRESSURE ON THE TANK REGULATOR OR FLUID PRESSURE REGULATOR
	2. THE ADHESIVE SUPPLY IS EMPTY	REPLENISH THE ADHESIVE SUPPLY
	3. THE LIMIT VALVE IS MOUNTED TOO HIGH	LOWER THE LIMIT VALVE. THE LOWER THE LIMIT VALVE IS POSITIONED, THE LONGER THE "ON" TIME PROVIDING MORE ADHESIVE
	4. THE ANTI-FLOOD CONTROL IS SHUTTING THE ADHESIVE VALVE OFF	ADJUST THE CYCLE TIME ADJUSTMENT VALVE CLOCKWISE UNTIL THE ANTI-FLOOD CUTS THE 47 SERIES VALVE OFF APPROXIMATELY 1 SECOND AFTER THE LIMIT VALVE HAS BEEN ACTIVATED MANUALLY
TOO MUCH ADHESIVE	1. THE ADHESIVE PRESSURE IS TOO HIGH	REDUCE THE PRESSURE ON THE TANK REGULATOR OR FLUID PRESSURE REGULATOR
	2. THE LIMIT VALVE IS MOUNTED TOO LOW	RAISE THE LIMIT VALVE. THE HIGHER THE LIMIT VALVE IS POSITIONED, THE SHORTER THE "ON" TIME PROVIDING LESS ADHESIVE
CONTINUOUS ADHESIVE FLOW	1. THE AIR HOSES TO THE ADHESIVE VALVE ARE REVERSED	CHANGE THE AIR HOSES TO THE #1 AND #2 PORTS ON THE AIR CHAMBER OF THE ADHESIVE VALVE
	2. THE ANTI-FLOOD CONTROL IS NOT SHUTTING OFF THE ADHESIVE VALVE WHEN THE LIMIT VALVE IS HELD IN THE ACTUATED POSITION	ADJUST THE ANTI-FLOOD CYCLE TIME ADJUSTMENT VALVE COUNTER CLOCKWISE SO THE ADHESIVE IS SHUT OFF 1 SECOND AFTER THE INITIAL ACTIVATION OF THE LIMIT VALVE
THE APPLICATOR HEAD FAILS TO ROCK ON THE LABEL STACK	1. THE SET SCREWS ON THE ROCKING SHAFT ARE LOOSE	TIGHTEN THE SET SCREWS
	2. DEFECTIVE ROCKING CYLINDER	REPAIR THE ROCKING CYLINDER
	3. THE APPLICATOR HEAD IS OBSTRUCTED BY THE CONTAINER TRACK	CENTER THE APPLICATOR HEAD BETWEEN THE CONTAINER TRACKS (REFER TO THE INSTALLATION INSTRUCTIONS)
ADHESIVE DOES NOT COVER THE ENTIRE LABEL WIDTH	1. THE VEINS IN THE APPLICATOR HEAD ARE PLUGGED	OPEN THE VEINS IN THE APPLICATOR HEAD WITH 90-03-35 VEIN CLEAN OUT DEVICE
	2. THE APPLICATOR HEAD IS NOT PROPERLY CENTERED ON THE LABEL STACK	CENTER THE APPLICATOR HEAD ON THE LABEL STACK (REFER TO THE INSTALLATION INSTRUCTIONS)

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<u>PROBLEM</u>	<u>CAUSE</u>	<u>SOLUTION</u>
ADHESIVE DOES NOT REACH THE TRAILING END OF THE LABEL	1. THE CONTAINERS ARE RUNNING TOO CLOSE TOGETHER THROUGH THE CONTAINER TRACK	ADJUST THE CONTAINER SPACER MECHANISM
	2. THE APPLICATOR HEAD IS ROCKING OFF THE LABEL STACK TOO SOON	A) ADJUST THE CYCLE TIME ADJUSTMENT VALVE ON THE ROCKING CYLINDER CLOCKWISE SO THE HEAD STAYS IN THE DOWN POSITION LONGER  B) SLIDE THE LIMIT VALVE "DOWNSTREAM" APPROXIMATELY 1/8" AT A TIME UNTIL THE ADHESIVE PATTERN IS ACCEPTABLE
	<u>NOTE:</u> WHEN THE PRODUCT IS FLOWING AT A STEADY RATE THE HEAD SHOULD STAY IN THE DOWN POSITION	
	<u>NOTE:</u> IN THE CASE OF THE VERY SLOW MOVING PRODUCTS, THE LIMIT VALVE SHOULD BE MOVED UPSTREAM	
THE ADHESIVE PATTERN IS ACCEPTABLE BUT THE TRAILING END OF THE LABEL "STICKS UP" FROM THE CONTAINER	3. THE ADHESIVE PRESSURE IS TOO LOW	INCREASE THE PRESSURE ON THE TANK REGULATOR OR FLUID PRESSURE REGULATOR
	4. THE ADHESIVE VALVE DOES NOT STAY "ON" LONG ENOUGH	IF THE ABOVE STEPS HAVE BEEN COMPLETED AND ADHESIVE STILL DOES NOT REACH THE TRAILING END OF THE LABEL, LOWER THE LIMIT VALVE APPROXIMATELY 1/16" AT A TIME UNTIL THE ADHESIVE PATTERN IS ACCEPTABLE
	1. THE LEADING EDGE OF THE LABEL IS FOLDED	MAKE THE NECESSARY ADJUSTMENTS TO THE "PICK-UP" SECTION OF THE LABELER
	2. THE LABEL IS NOT PROPERLY CURLED BECAUSE THE APPLICATOR HEAD DOES NOT ROCK FORWARD FAR ENOUGH ON THE LABEL STACK	LOOSEN THE SET SCREWS ON ONE OF THE UNIVERSAL JOINTS OF THE ROCKING CYLINDER COUPLING SHAFT AND ROTATE THE APPLICATOR HEAD FURTHER FORWARD OR DEEPER INTO THE LABEL STACK
	<u>NOTE:</u> FOR VERY DIFFICULT TO CURL LABELS, THE OLD CURLING BAR CAN BE REINSTALLED ON THE NEW WAY MACHINES ONLY	
THE ADHESIVE "PUDDLES" UNDER THE APPLICATOR HEAD OR "DROOLS" DOWN THE LABEL STACK	1. THE ADHESIVE PRESSURE IS TOO HIGH	DECREASE THE PRESSURE ON THE TANK REGULATOR OR FLUID PRESSURE REGULATOR
	2. THE ADHESIVE VALVE STAYS "ON" TOO LONG	IF THE ABOVE STEPS HAVE BEEN COMPLETED AND THE "PUDDLING" PROBLEM HAS NOT BEEN SOLVED, RAISE THE LIMIT VALVE APPROXIMATELY 1/16" AT A TIME UNTIL THE ADHESIVE FLOW IS ACCEPTABLE