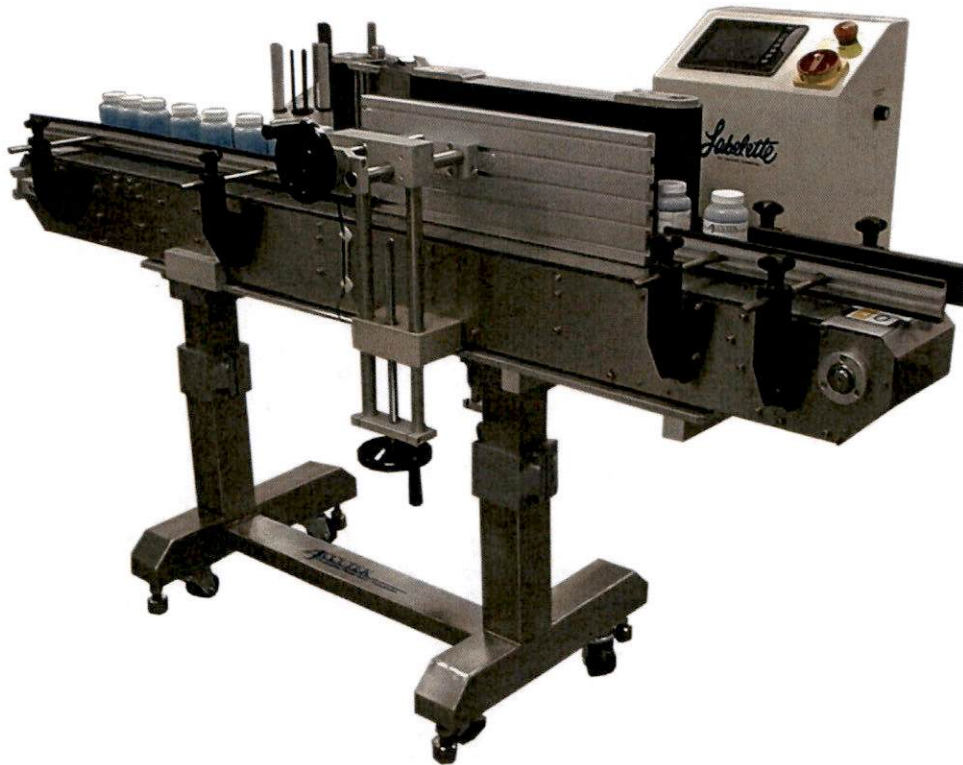# ACCUTEK
Packaging Equipment Companies, Inc.

APS - 106 / 108

Operations Manual

BINER ELLISON High Speed Packaging Solutions an ACCUTEK COMPANY

PHASE FIRE Shrink Tunnel Technologies

Labelette Labelers

KISS Packaging Systems

Accutek Packaging Equipment Companies 2980 Scott St, Vista, CA 92081 (760)734-4177 www.AccutekPackaging.com

Table of Contents

Safety and Precautions

It is important that personnel working on this equipment understand the warning messages seen throughout this manual. The safety of equipment and plant facilities should be considered during equipment operation, change of product, and any equipment modification. If you have any questions or concerns regarding the information in this manual, please contact your Accutek Packaging Equipment representative at **760-734-4177 or 800-989-1828 or** service@accutekpackaging.com before proceeding.

Warning messages that you should become familiar with before proceeding

DANGER — This is an immediate hazard alert. Ignoring this warning could cause severe personal injury or death.

WARNING — This is a possible hazard alert. Ignoring this warning could cause severe personal injury or death.

CAUTION — Follow this caution to avoid unsafe practices that could cause permanent damage to equipment or property. Ignoring a caution may lead to personnel injury

IMPORTANT — Points out proper equipment use to avoid damage or extend the parts life.

NOTE — Provides information that suggests best practices or equipment adjustments for best results.

Safety and Precautions (Cont.)

Lock Out – Tag Out Standard Procedure:
Any individual working on this equipment should follow the procedures outlined in this document. These procedures are in line with OSHA standards and SORM guidelines for safe work practices. The purpose is to protect workers from injury or death due to unexpected activation of the equipment while they are working on the equipment.

Definitions:

Lockout - The practice of using keyed or combination security devices ("locks") to prevent the unwanted activation of mechanical or electrical equipment.

Tag out - The practice of using tags in conjunction with locks to increase the visibility and awareness that equipment is not to be energized or activated until such devices are removed. Tags will be non-reusable, attachable by hand, self-locking, and not easily removed.

DANGER — This machine must be connected to a receptacle equipped with a ground wire. There are lethal voltages present inside the control box. Disconnect the machine from the AC mains prior to opening the control box.

All measurements, adjustments, maintenance, and inspection work must be performed by qualified personnel.

⚠ CAUTION — Disconnect air pressure from the machine when performing service to the machine. The air cylinders used to operate this machine are powerful and can cause serious injury or death.

IMPORTANT — The safety of personnel, equipment, and plant facilities should be considered with each change of product and any machinery modifications. Contact your Accutek packaging equipment representative BEFORE processing toxic, corrosive, or flammable materials with this machine. Design modifications will be needed if you process products other than the product the machine was built for. Verify that your machine configuration meets all local, state, and federal codes and regulations.

⚠ CAUTION — Please read this manual to become familiar with all the mechanical and electrical points that may pose a hazard to personnel prior to plugging in air and electricity.

Unpacking Your Machine

Your machine will arrive in a crate. As you unpack your machine check the shipping crate / skid for loose bolts, screws, fasteners, and adjustment handles. Your machine may also have some shrink-wrapped assemblies. Check all packaging material for loose fasteners. Your machine was tested and passed a stringent quality control process. Shipping vibration and impact may cause some fasteners to loosen and fall out of the machine.

Accutek utilizes permanent liquid thread lock on all fasteners that are not used for adjustment and a semi-permanent thread lock for fasteners that require occasional adjustment. Accutek does not use liquid thread lock on fasteners located in the fluid path or liquid section of a machine or where routine adjustment is required. Accutek will not over tighten these fasteners due to potential damage to the machine. These fasteners may loosen during shipment.

⚠ CAUTION	**Always lift your machine from the bottom of its frame. Make sure that electrical wires or pneumatic hoses are not pinched or crimped anytime you move the machine.**

Locate your machine on the production floor so that the machine operators have access to all sides of the machine. The air supplied to the machine should be clean and dry. Pneumatic components are sensitive to water and dust in the air supply. Accutek recommends that your compressor be equipped with a good filter / regulator to minimize dust and water in the air supplied to the machine.

Accutek recommends a thorough cleaning, upon receipt of all machinery, according to your product specifications. Pay special attention to any areas that will be in contact with product. The machinery will be cleaned before leaving our facility, but it cannot be guaranteed that residue from building, testing, or transport will not be present.
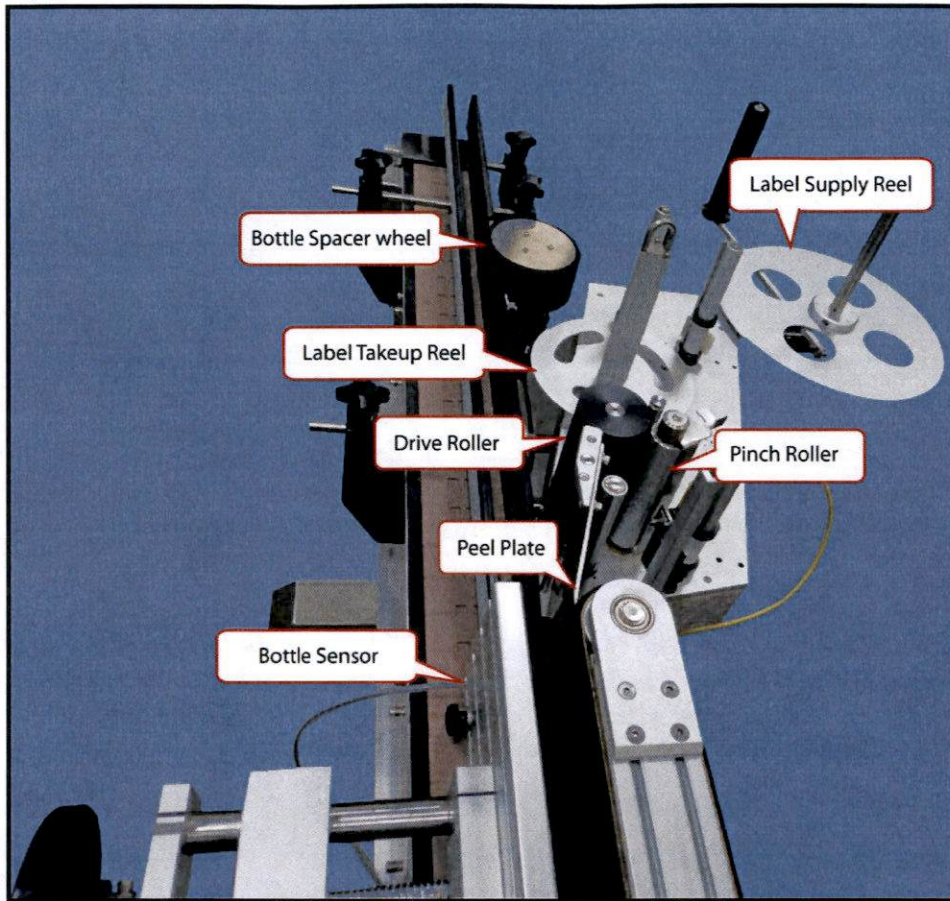
Specifications:

APS 106 and 108 Features and System Requirements:

Features:

- In Line Automatic Applications
- Touch Screen Control System with Job Memory
- Heavy Duty Construction built for 3 Shift Operations
- Sanitary Stainless Steel Thick Wall Frame
- Easy Adjusting Hand Wheels for Quick Setup
- Synchronized Operation
- Synchronized Powered Wrap Station
- Infeed Separator Wheel

Touch Screen Controls:

- Control Conveyor, Label Head, Wrap Station with 8 different Speed Selections
- Fully Synchronized Motor Package
- Auto Teach for New Labels / with Job Memory
- On-Screen Troubleshooting & Help Menu
- Missing Label Detector
- Label Count Down for batch run count
- Easy to use Operator Controls

Options Available:

- Hot Stamp Coder
- Alpha Numeric Starter Kit
- Pneumatic Separator
- Star Wheel Separator
- Clear Label Sensor
- Conical Label Heads for Conical Bottles

System Requirements:

(APS-106 & 108)

Dimensions:
Height: 45" (114.3 cm)
Length: 72" (182.9 cm)
Depth: 41-53" (104.1-134.6 cm)
Weight: 527lbs. (239.04 kg)

Labeling Speed:
Up to 175 CPM

Label Direction:
Left Side Off Outside Peel (counter clockwise)

Label Size:

APS 106
Length: 0.5" – 17" (1.25-43 cm)
Width: 0.75" – 5.75" (1.9-14.6 cm)

APS 108
Length: 0.5" – 22" (1.25-55cm)
Width: 0.75" – 8" (1.9-20.3cm)

Electrical Requirements:
110VAC - 10 AMPS
(220VAC Optional)

Label Specifications

If there are any questions regarding your specific label, contact your Accutek representative for assistance.

Base Paper:	Translucent
Reel Core Diameter:	3.0" (76 mm)
Max. Outer Diameter:	14.5" (370 mm)
Interval of Labels:	Minimum .125" (3 mm) between labels
Width of Base Paper:	Label Width + .16" (4 mm)
Label Dimensions:	**APS 106** - Height: .75" – 5.75" (1.9 – 14.6 cm)
	Length: .5" – 17" (1.25 – 43 cm)
	APS 108 - Height: .75" – 8" (1.9 – 20.3 cm)
	Length: .5" – 22" (1.25 – 55 cm)

Standard APS series Labeler uses

Left Side Off, Outside Peel (counter clockwise) Pressure Sensitive Labels

What it Does

Bottle Spacer wheel
Label Supply Reel
Label Takeup Reel
Drive Roller
Pinch Roller
Peel Plate
Bottle Sensor

Filled and capped bottles enter the labeler on the conveyor belt and are slowed at the bottle spacer wheel. The bottle spacer wheel speed sets the space between bottles as they travel towards the peel plate. When the bottle sensor sees a bottle, it signals the drive roller to pull a label across the peel plate. The flagged label's sticky leading edge attaches to the bottle as it passes the peel plate. The wrap belt rolls the bottle against the pressure plate and this presses the label into place around the bottle. The conveyor moves the labeled bottle past the label head.

Pressure Plate Positioner
Wrap Belt Tension Adjuster
Pressure Plate
Wrap Belt
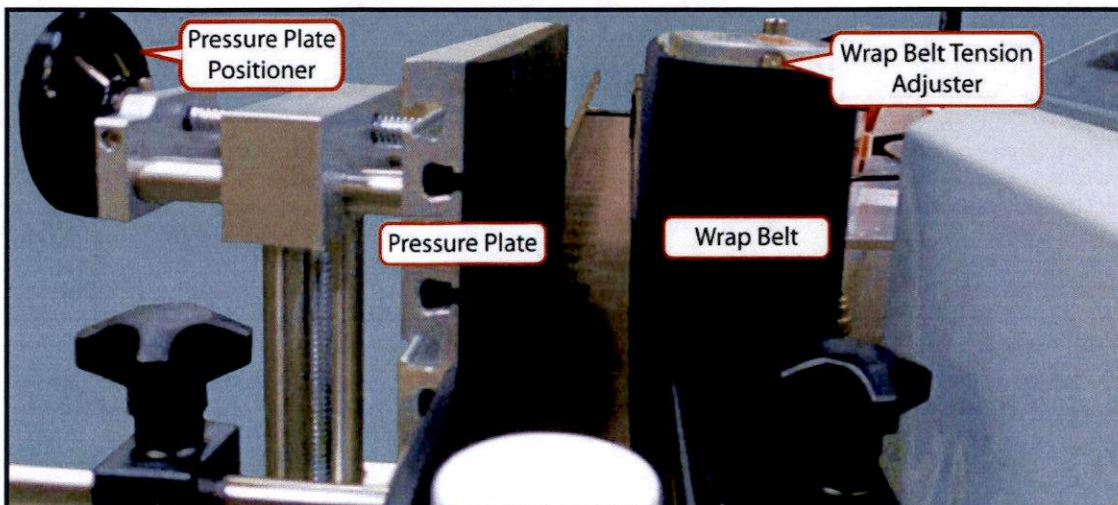
How it Works

Label Sensor
The label sensor detects the gap between labels. The control logic positions the label at the peel plate based on gap location. Calibrating the label sensor is the first task during setup.

Bottle Spacer Wheel
The bottle spacer wheel meters the space between bottles. The speed of the conveyor also affects bottle spacing.
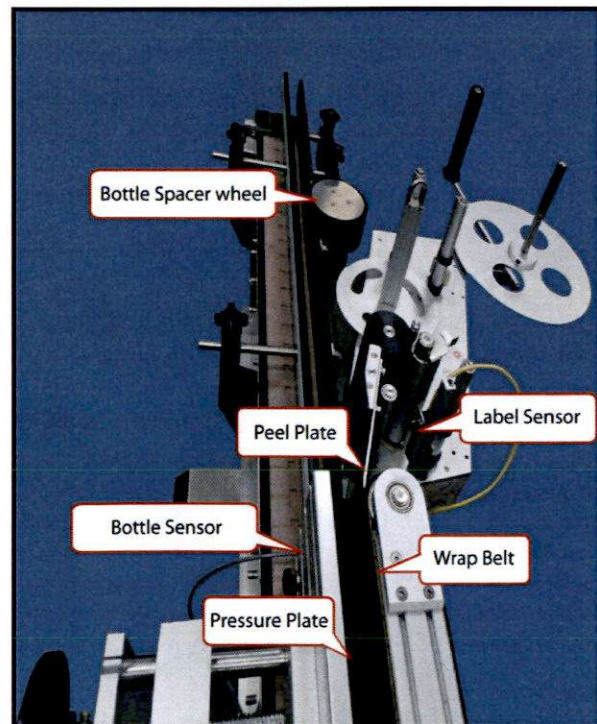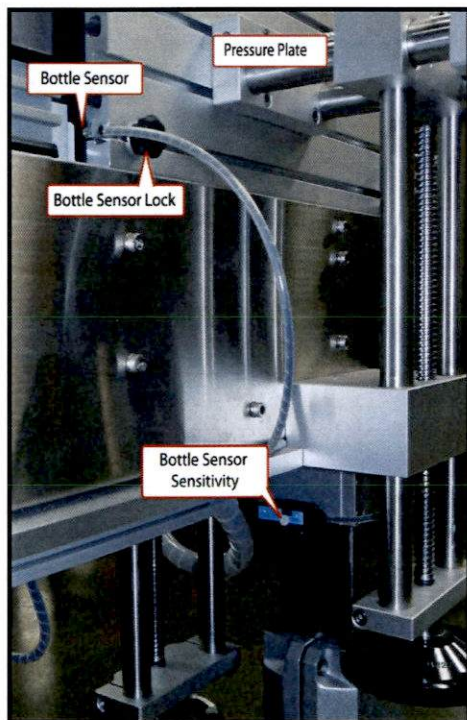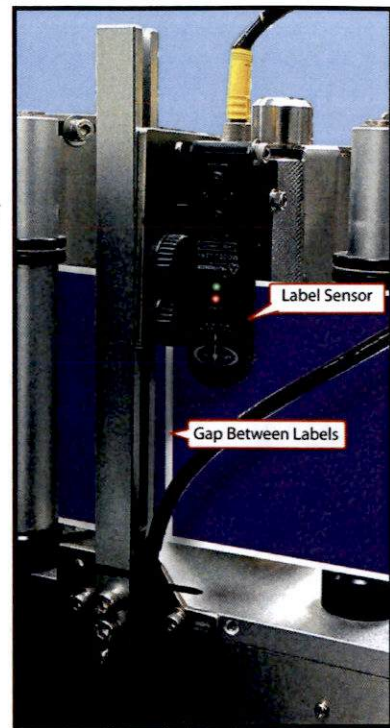
Bottle Sensor
The bottle sensor provides the trigger to dispense a label. There is a programmable delay between the bottle detection and label dispensing. The position of the bottle sensor and its calibration are an important part of setup.

Wrap Belt
The wrap belt presses the label onto the bottle as it comes off the peel plate. The wrap belt rolls the bottle against the pressure plate to press the label in place on the bottle.

The distance between the pressure plate and the wrap belt is adjusted so that bottle rolls but does not hang up.

The wrap belt tension must be even from top to bottom so there is a tension adjustment cap screw at the top and bottom of the roller next to the control box.

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Operation

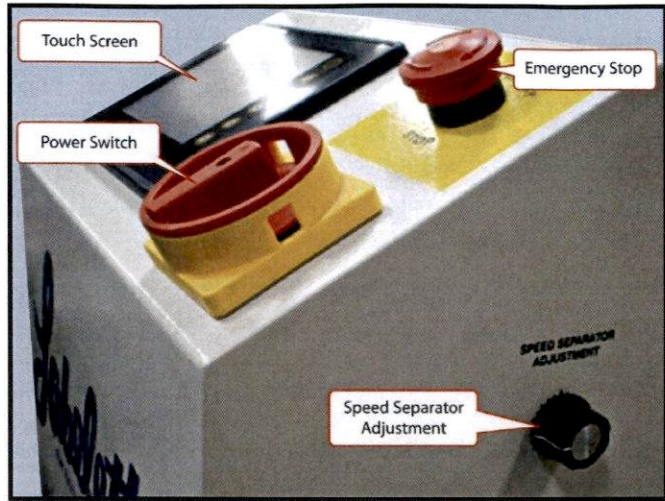## Main Control Panel

Touch Screen
The Touch Screen is used for operation, setup, and troubleshooting.

Power Switch
This switches the AC main power to the machine on or off.

Emergency Stop
Push the emergency stop button to turn off AC power to the labeler.

NOTE Do not attempt to restart the system for at least 10 seconds.....
After 10 seconds has passed turn the emergency stop button clockwise to energize the system.

Speed Separator Adjustment
The speed separator adjustment controls the rotation speed of the bottle spacer wheel. If you change the speed of the conveyor the speed separator must also be adjusted. The bottles should be spaced so that the label head has time to finish labeling a bottle and does not have to wait for the next bottle.

Home Screen

Allow a few moments for the equipment to initialize after the AC power has been switched on. The machine is ready to begin operation when this screen appears. Touch the **Enter** key to display the menu screen.

Operation (Cont.)

Menu Screen

Access each of the six screens of the labeler by pressing its key on the menu screen.

Home
Press to return to the home screen.

Labeling Mode
The labeler's routine operation is controlled form this screen.

Setting Mode
This screen selects labeler speed, and toggles missing label and select printer timing.

Memory Mode
Save and recall job settings from this screen.

Guide Mode
This screen guides the operator through a step by step machine calibration.

Troubleshooting
Press to open the troubleshooting screens. Common operation problems and possible solutions are detailed there.

Operation (Cont.)

Labeling Mode Screen

?

Press the question mark button and it will turn pink, if you press any other button on the screen while it is pink an explanation of the button pressed will appear.

Menu

Press to return to menu screen.

Setting Mode

Press to open setting mode screen.

Memory Mode

Press to open memory mode screen.

Length Set

The label sensor must be calibrated before performing a length set. Press and hold the length set button to advance the label web.

The number to the right of the length set button will increment as the web advances. The number resets to zero each time a gap between labels is detected by the label sensor.

Hold the length set button until the leading edge of a label is sticking out from the peel plate approximately an eighth of an inch. This label "flag" must stick out just far enough to catch and stick to a bottle as it goes by. Increasing the number in the length set window will increase the amount of label exposed. Press the length number and a keypad will appear where you can change the length value.

Label Peel Delay

If the label is dispensed too soon the label could wrinkle. If the label is dispensed too late it might not stick to the container at all. Use the container sensor position to get the label close to dispensing at the right time. Use this delay time to optimize label positioning.

Conveyor

Toggle the conveyor system **On** or **Off**. The conveyor must be "On" to label bottles.

Label

Toggle the labeling head **On** or **Off**. Both conveyor and label must be "On" to label bottles.

Precount Set

Press the small square button to the right of the precount number to open the numeric keypad. Enter the number of bottles that you wish label in the current run. The labeler will stop labeling when the label counter equals the precount number. You must turn precount off or zero the label counter to dispense the next label.

Counter Clear

Press this button to zero the label count.
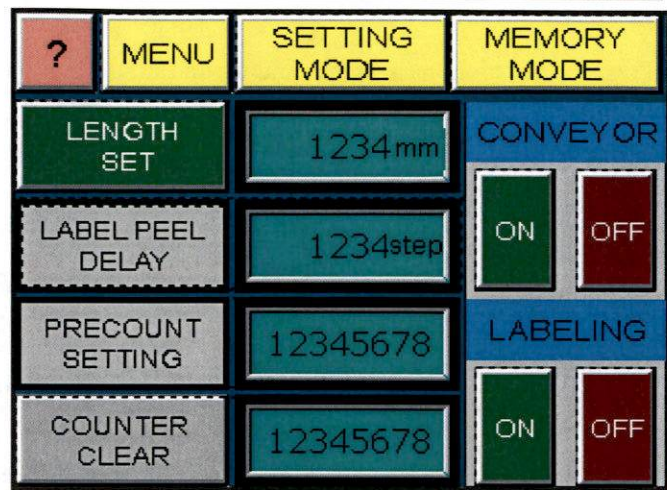
Operation (Cont.)

Setting Mode Screen

?
Press the question mark button and it will turn pink, if you press any other button on the screen while it is pink an explanation of the button pressed will appear.

Menu
Press to return to menu screen.

Labeling Mode
Press to open labeling mode screen.

Memory Mode
Press to open memory mode screen.

Eight Numbered Buttons
Select one of eight conveyor speeds. "1" is the slowest and "8" is the fastest speed. Adjust the conveyor speed and the bottle spacer speed to maximize labeling speed.

Peeling Speed
This determines how fast the web is pulled across the peel plate. If peeling speed is too fast the label will wrinkle. If the peel speed is too slow labeling will be inconsistent or jam. Press the number to open a keypad where you can enter a new value.

Missing Label
Turn the missing label function on by pressing the Off switch icon to On. When the missing label function is on a missing label will cause the machine to halt.

The labeler stops when the label sensor detects a distance between labels that exceeds the programmed distance. Press the number to open a keypad and enter the maximum allowed distance between labels in millimeters.

Hot Stamp Printer
This function is active only when an optional hot stamp printer is attached to the labeler. Turn the printer on by pressing the on/Off switch icon to "On". Press the number window and the on/Off switch icon and the numeric keypad will appear. Set the printer speed value to 0.2 sec. The labeler will send a print signal to the printer once for each label.

Operation (Cont.)

Memory Mode

?
Press the question mark button and it will turn pink, if you press any other button on the screen while it is pink an explanation of the button pressed will appear.
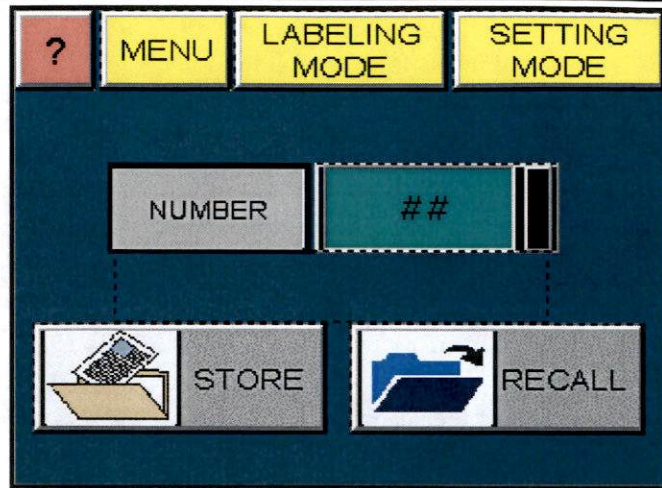
Menu
Press to return to menu screen.

Labeling Mode
Press to open labeling mode screen.

Setting Mode
Press to open setting mode screen.

Number
This is the job number used when either the store or recall button is pushed. All the parameters on the labelling and setting screens are stored or recalled. Press the number to open the numeric keypad. Enter a number between 0 and 30 to save your current parameters to that memory location.

Store
Saving to a location overwrites all the data that was previously saved to the job number showing in the number window above.

Recall
Recalls all parameters associated with the job number appearing in the number window above.

Trouble shooting Screen

Use the trouble shooting screens as a general guide to resolving problems that may arise with your machine. Use the arrow keys, located in the lower right corner of the screen, to navigate through the eight problems listed.

Press the problem button that addresses your situation to open a sub-screen. The sub screens detail possible causes and remedies.

There is a trouble shooting section later in this manual that parallels the trouble shooting screens with additional information to expedite the trouble shooting process.
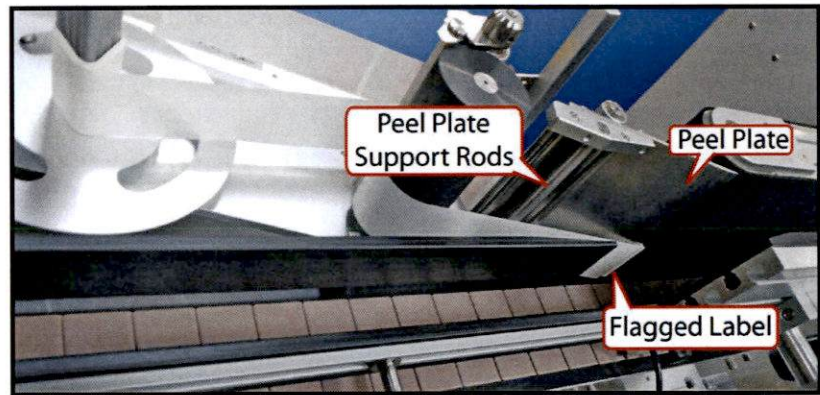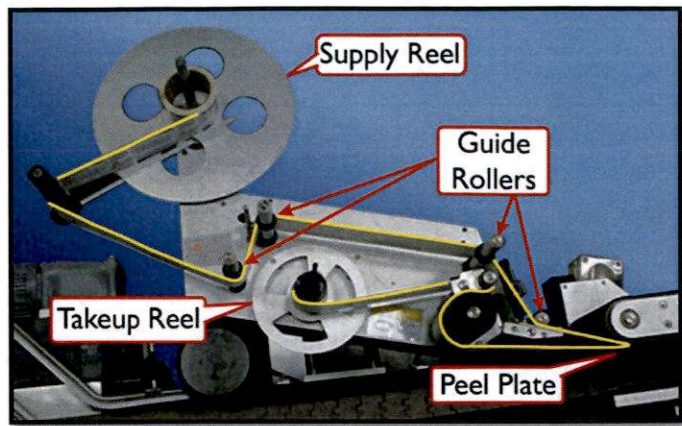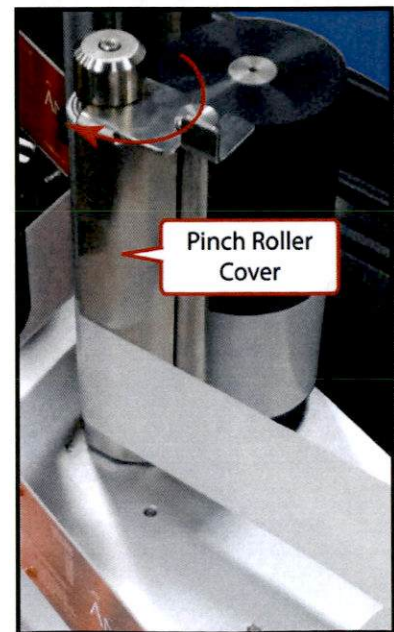
Setup

Mounting Labels

Set a roll of labels on the supply reel. Pull about 5 feet of labels from the roll to form a leader. Peel the labels off the leader and then lace it through the guide rollers, label sensor and around the peel plate. The black top collars on the guide rollers slide up and down. The collars should be positioned just above the labels without touching the web.

Open the pinch roller and then bring the leader around the drive roller between the pinch roller and the drive roller. Close the pinch roller and then captured the leader on the takeup hub. Roll up any slack in the label web with the takeup reel.

The labels must be outside the peel plate support rods and outside of the pinch roller cover as shown in these pictures.
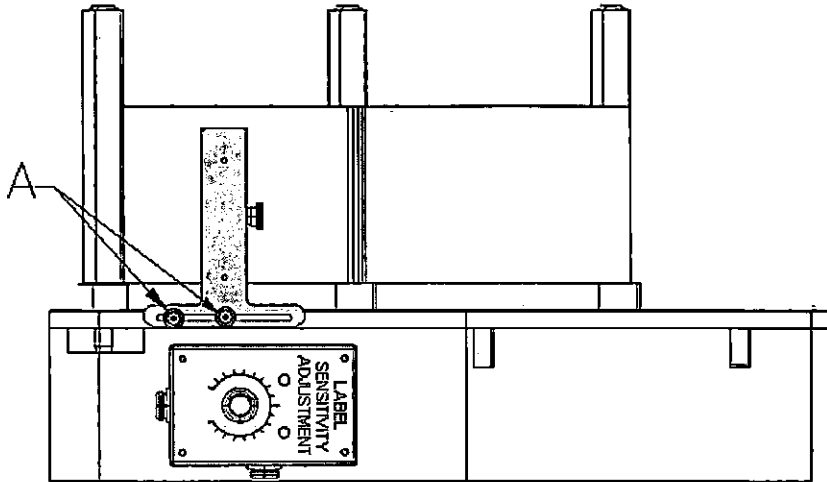
Setup (Cont.)

Label Sensor Adjustment

There are three types of label sensors that Accutek uses on its labeling machines. Adjusting the sensor so that it reliably detects the gap between labels is critical to consistent label placement. Setting the label sensor in the correct position and adjusting sensor sensitivity varies between sensor types.

Type 1, Label Sensor

Sensor Position
Lace the label web through the label sensor slot. Loosen the mounting screws (A) and adjust the horizontal position of the label sensor. The sensor should be as close to the middle of a label as possible with a label flagged at the peel plate. Tighten the mounting screws when you are satisfied with the sensor position.

Sensor Calibration
Adjust the sensor sensitivity so that the red and green lights are off when it is reading a label and both lights come on when it is reading a gap.

Pull the web back and forth through the sensor to verify that both lights flash when a gap passes through the sensor.

Setup (Cont.)

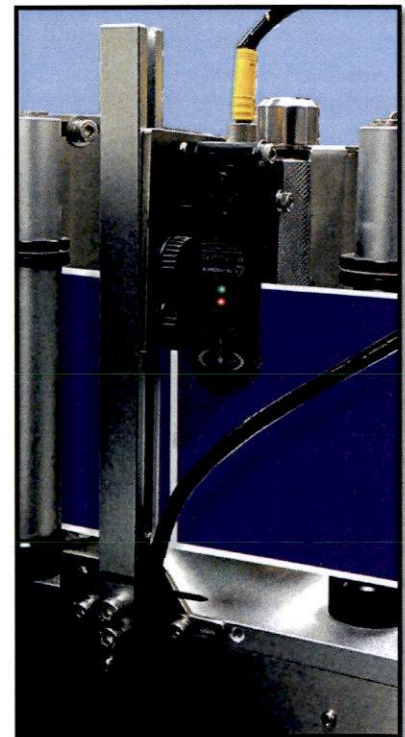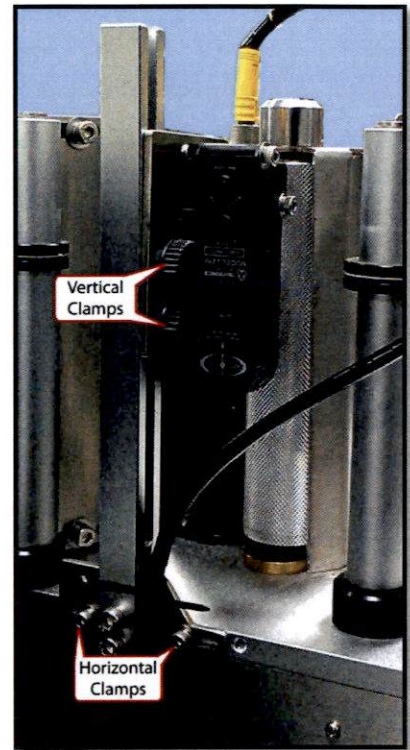## Type 2, Label Sensor

Sensor Position

Use the vertical and horizontal clamps to position the sensor over the label web as shown. The sensor is best positioned towards the middle of the label so that the longest portion of the label is read before the gap.

Sensor Calibration

Remove the labels from a section of the backing so that the sensor is reading the backing without a label. Press the normal button, when the green LED flickers, release the button. The green LED will remain illuminated.
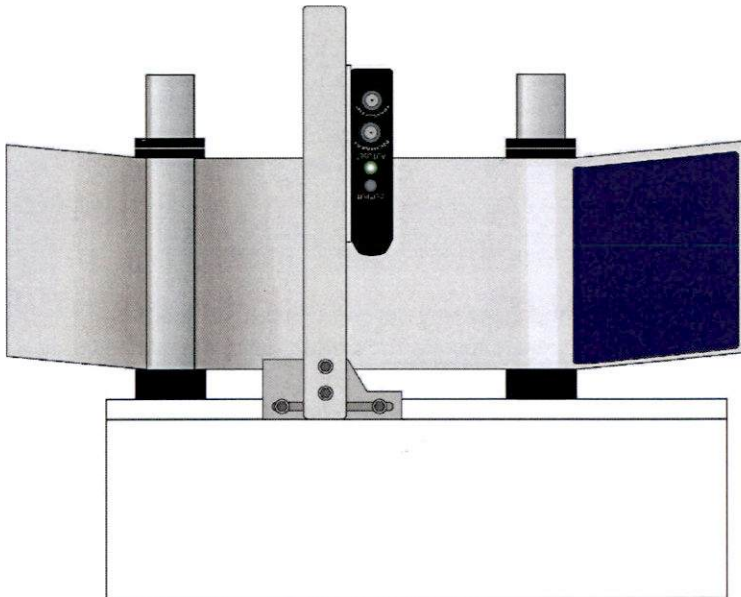
Pull a section of the web with labels through the sensor and confirm that the red LED illuminates when the sensor sees a label and turns off when the sensor sees the gap between labels. If you have an irregular shape label make sure that the sensor only sees the gap between labels rather than some point in the middle of the label.

Setup (Cont.)

## Type 3, Clear Label Sensor

The clear label sensor is mechanically and electrically compatible with the standard sensor. Unplug the standard label sensor and plug in the clear label sensor using the same mounting hardware.

Sensor Calibration
Remove the labels from a section of the backing so that the sensor is reading the backing without a label. Press the "+" and "-" buttons at the same time, and then release the buttons.
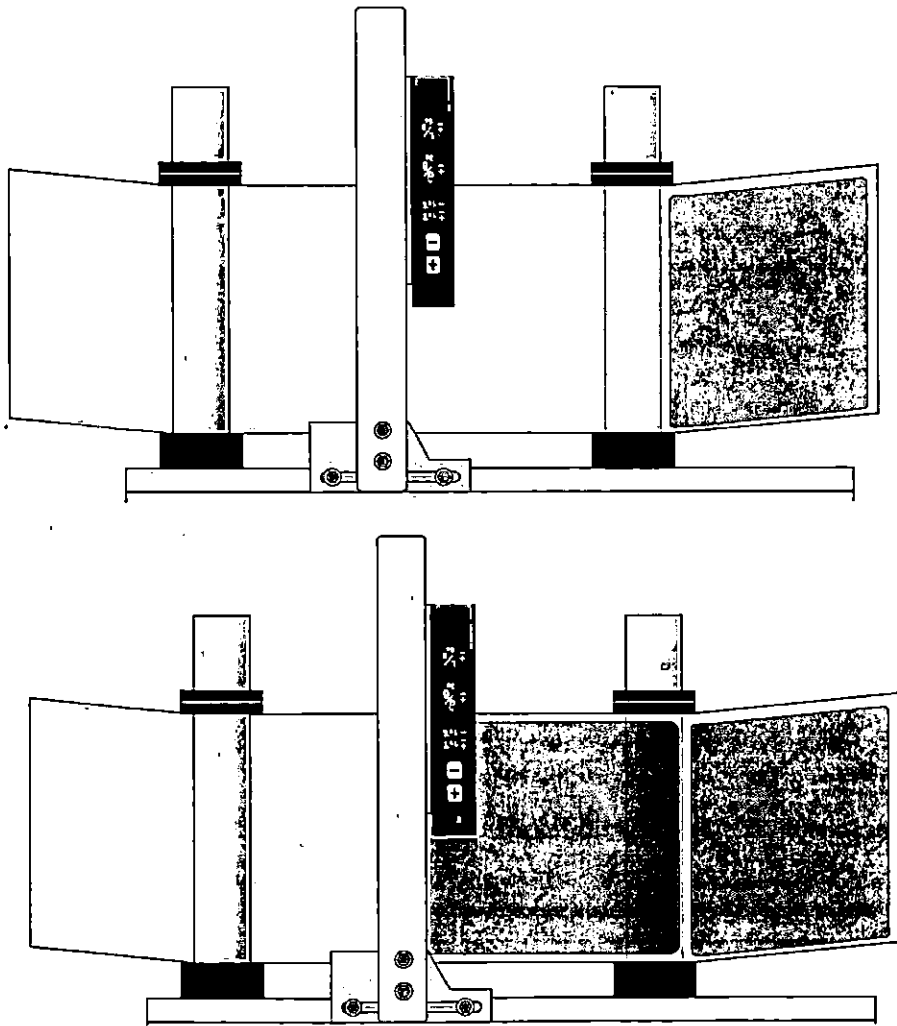
Pull a section of the web through the sensor so that the sensor is reading a label. Press the "+" button and the yellow LED will come on. Move the web back and forth so that the sensor reads a gap between labels. The yellow LED should go dark when the sensor sees a gap between labels.

Setup (Cont.)

Bottle Sensor Adjustment

Sensor Calibration
Adjust the sensor sensitivity so that the red and green lights are off when there is no bottle present and both lights come on when a bottle passes in front of the sensor. The sensitivity is adjusted with the small white knob shown in the picture or a small Philips head screw driver inserted in the same location.

Sensor Position
The bottle sensor triggers the label head to dispense a label. The position of the sensor sets the point on the bottle where the label lands. The sensor can be slid left or right by loosening the bottle sensor lock knob.

Once the sensor position is locked down, use the position set function on the labeling mode screen to make small adjustments to the label position.
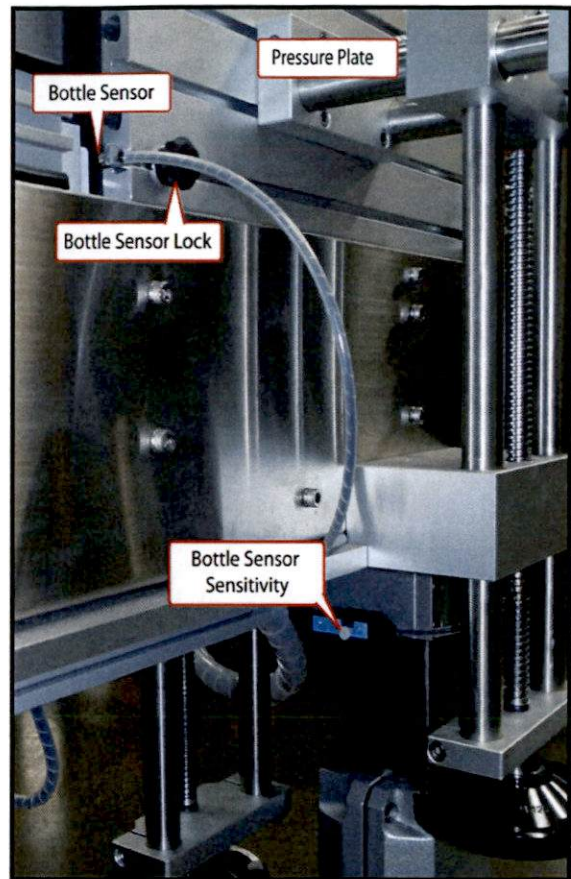
Wrap Belt Adjustment and Replacement

The wrap belt may need adjustment from time to time. The belt tension is adjusted by tightening or
op and bottom tension screws should be
belt top to bottom. Check belt tension by
ith the pressure plate. The bottle should roll
vrap belt without climbing or diving.
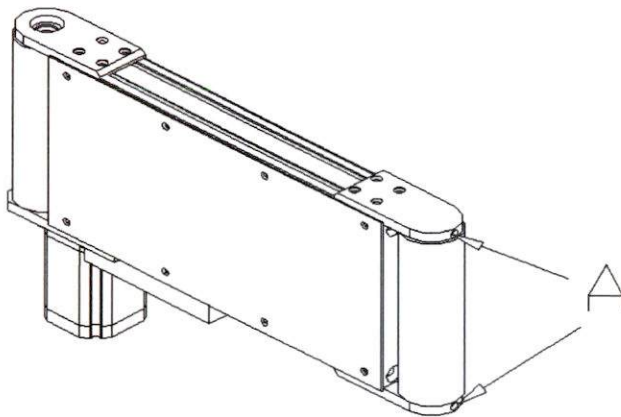
the top tension screw.

tighten the bottom tension screw.

ap belt needs replacing loosen both tension
ews the same number of turns, note how
many turns you loosened the screws. Slide
the wrap belt up and off the rollers when
ie tension screws are loose enough.

Slide the new wrap belt down over the rollers and then tighten the tension screws the same number of turns that you used to free the belt. Check for even top to bottom tension as detailed above.

Setup (Cont.)

Peel Plate Setup

The edge of the peel plate must be at a right angle to the conveyor belt for accurate and level labeling. Use a square as shown in the picture to check the peel plate alignment.
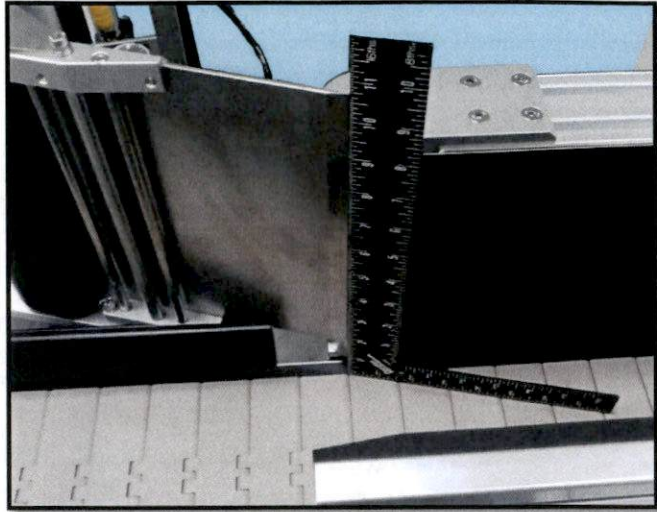
If the peel plate is not perpendicular to the conveyor loosen the mounting screws and nudge the plate up or down to square it up. When the plate is square tighten the mounting screws. There is some pressure on the peel plate so make sure the mounting screws are snug.
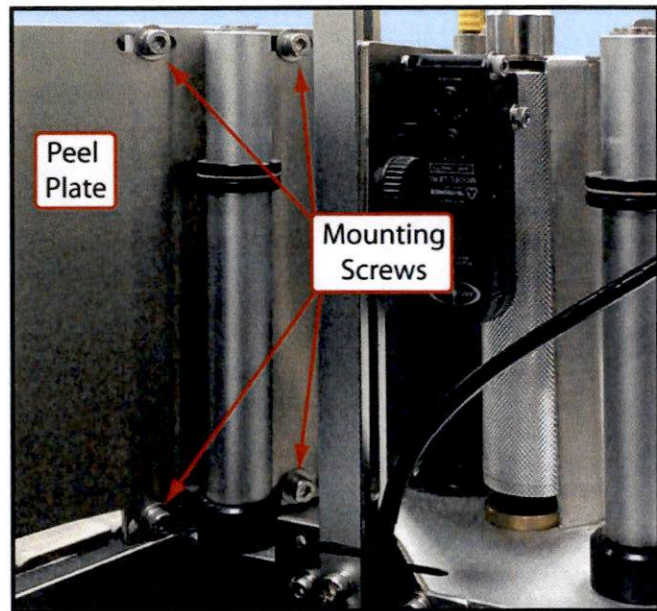
Setup (Cont.)

Spacer Wheel Setup

The spacer wheel catches bottles as they come down the conveyor. The bottles are released to continue down the conveyor as the spacer wheel rotates.

Begin by loosening the rear entry guide clamps. Position the rear entry guide so that it is an eighth of an inch to the right of the spacer wheel and tighten the guide clamps.

Position the front guide so that a bottle travels freely on the conveyor until it encounters the spacer wheel. The bottle will be caught by the spacer wheel until the wheel rotates to release it. The spacer wheel speed and the conveyor speed each have their own adjustment. The space between bottles is set by the ratio of conveyor to spacer wheel speed.
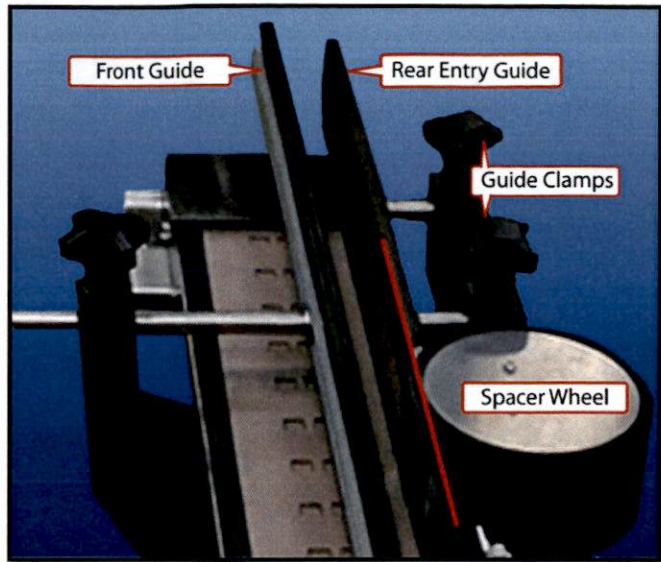
Setup (Cont.)

Setting Conveyor Height

The labeler's conveyor needs to be at the same height as other conveyors in the production line. The labeler has telescoping legs that are secured by pinch plates. Support the labeler at points "A" and "B" and then loosen the eight pinch plate bolts. Adjust the supports at "A" and "B" so the conveyor surfaced is level and at the correct height.

Adjust the four stabilizer feet to lift the four wheels off the floor and level the base. Tighten the four lock nuts. Verify that the conveyor is level and at the correct height. Make sure the pinch plate is seated on the base and tighten the eight pinch plate bolts.
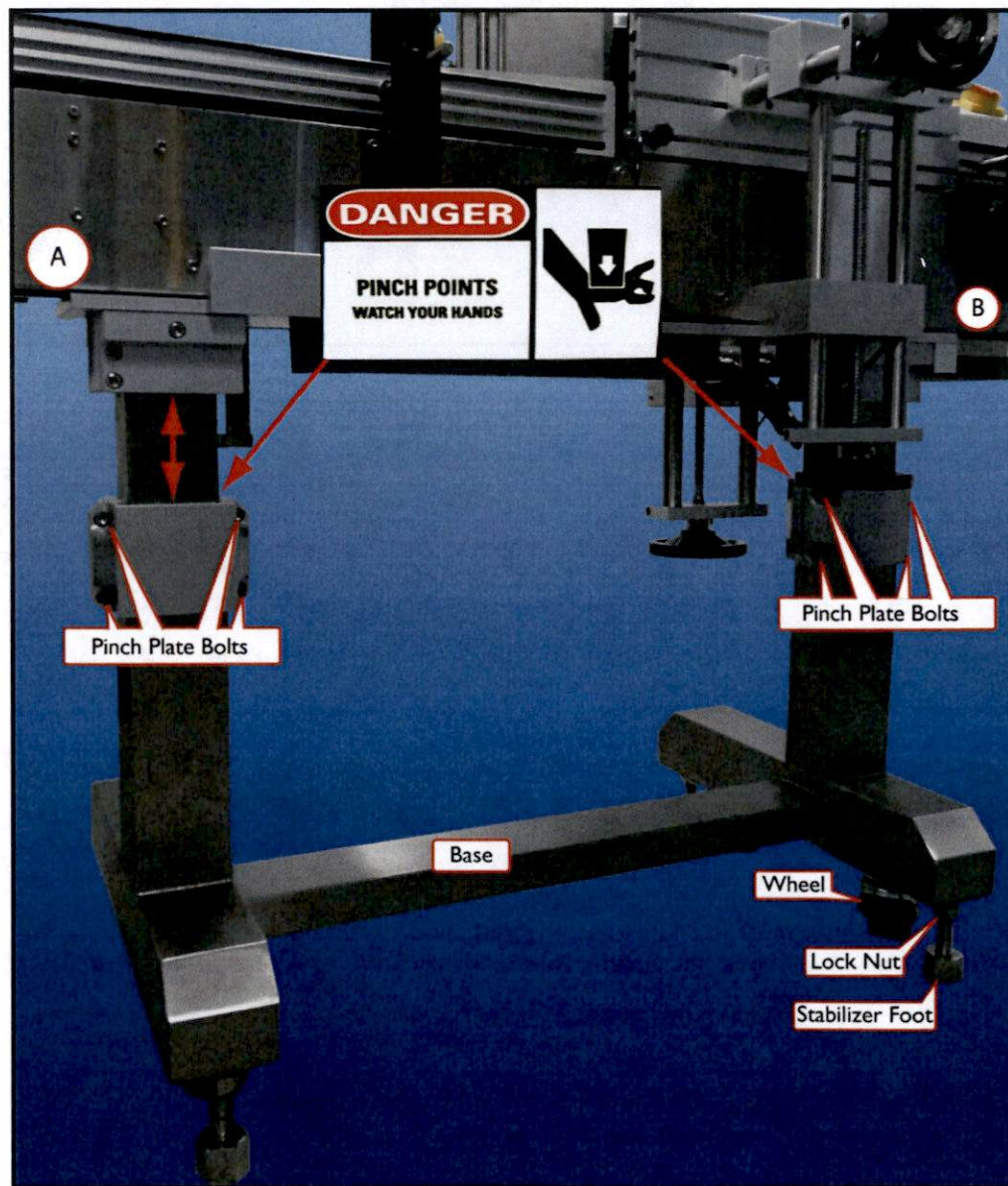
Setup (Cont.)

Conveyor Tensioning

Conveyor tension is set at the factory. You will need to relax the tension on the conveyor to remove the conveyor belt for cleaning. Loosen the lock nut before attempting to adjust the conveyor tensioner bolts.

When you reinstall the cleaned belt, do not over tighten it. The tension bolts should be adjusted the same number of turns to keep the belt tracking straight. The conveyor will make abnormal clicking sounds around the motor end of the belt when it is too tight. Once the belt is running smoothly go ahead and tighten the lock nuts.

Conveyor Tensioner Bolts

Lock Nut
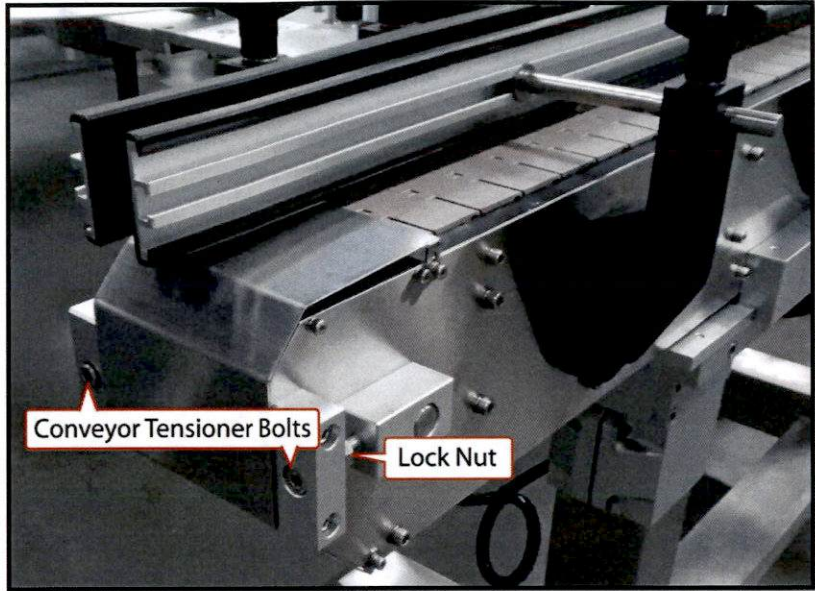
Use a punch or small screwdriver to remove the link pin from a link. The link pin only comes out in one direction. The conveyor belt can now be removed from its track for cleaning.

The conveyor links can be cleaned with warm soap and water. Check for product residue or debris build up between the conveyor chain links and remove any accumulation. Also clean the track where the conveyor belt rides.

Remove pin this direction only.

Belt must move in this direction only
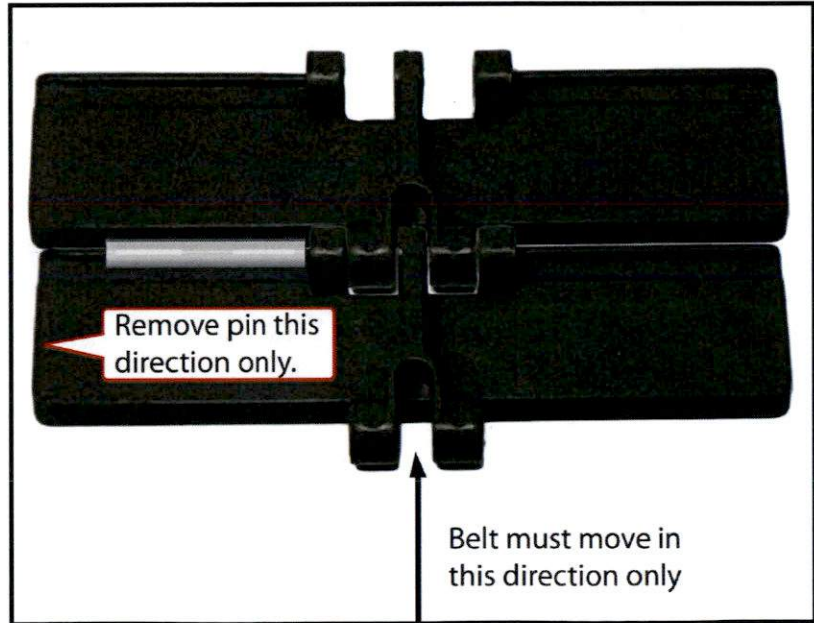
Troubleshooting

Problem	Solution
Label length cannot be set	Recalibrate the label sensor
	Label sensor may need replacing
More than one label is dispensed at a time	Recalibrate label sensor
	Position set value is greater than label length value.
	Label length is set to zero
	Move bottle sensor to the left to avoid reading the tail of current label.
Labels won't dispense	Check labeling mode screen, both Conveyor and Label must be "On"
	Recalibrate the label sensor
	Recalibrate the bottle sensor
	Check stepper motor fuse 3. Remove and replace if needed
Labels Are Slanting Upward Or Downward	Is the peel plate perpendicular to the conveyor
	Does the container have tapered sides
	Are the guide rails set correctly
No Screen Display	Is there AC power coming into the labeler
	Is the main AC switch "On"
	Is the emergency stop switch disengaged
Labels not sticking to container	Is the label "flagged" at the peel plate? You need about an eighth of an inch of the label sticking out from the peel plate.
	Is the bottle sensor positioned correctly?
	Are the label and bottle compatible? Will the label stick to the bottle if you apply it manually?
Labels do not come out smoothly:	Is the pinch roller in firm contact with drive roller?
	Adjust the pinch roller pressure.

Troubleshooting

Labels wrinkle or bubble	Adjust position set with the touch screen or move the bottle sensor to the right if the label comes out too early.
	Is the peel plate perpendicular to the conveyor?
	Recalibrate the label sensor.
	Verify that the labels have consistent gap spacing.
	Do the bottles have a smooth regular surface?
	Check pressure plate position.

Electrical Schematics

Parts List
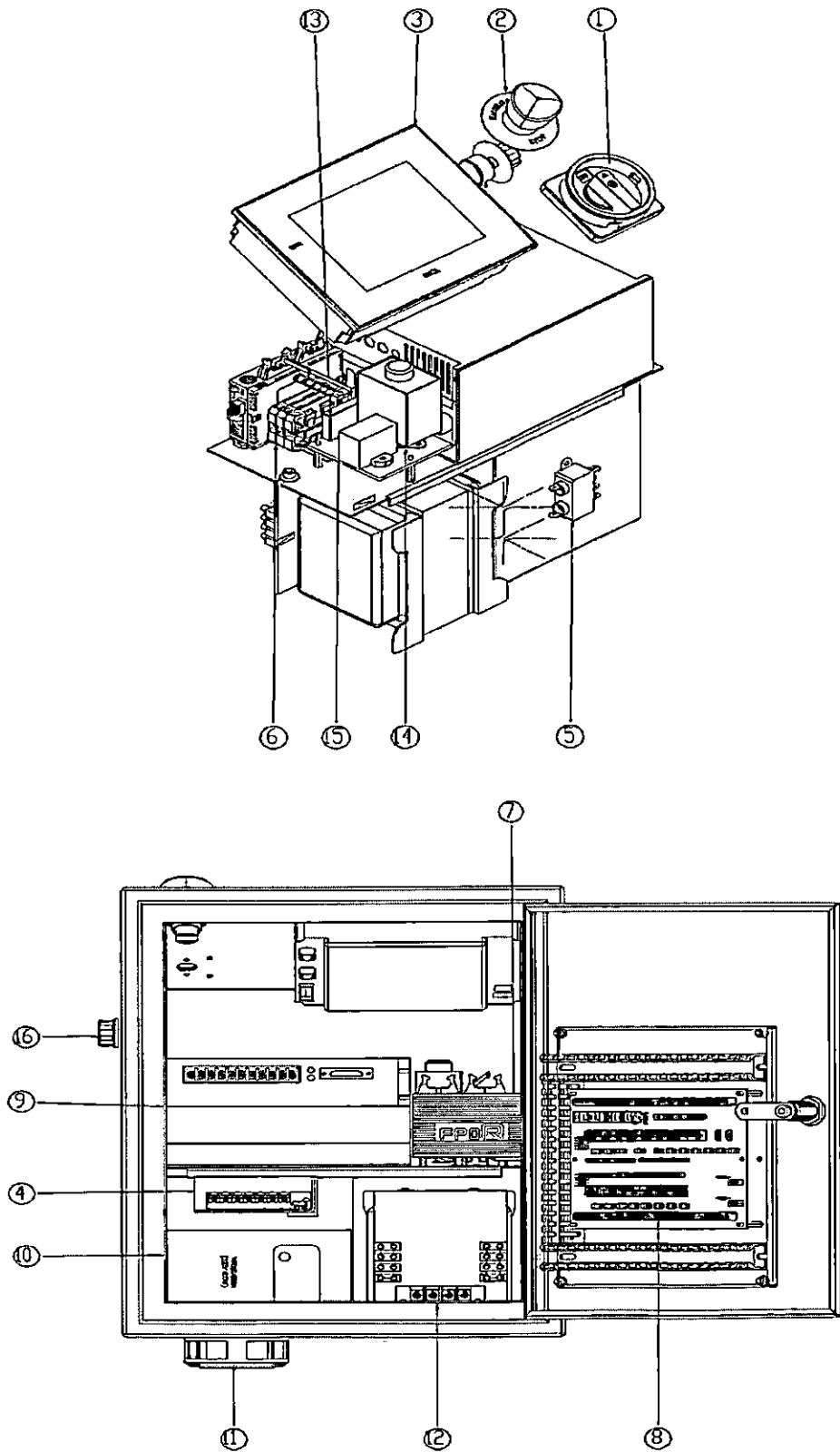
CONTROL BOX

Parts List

Control Box Parts List

NO	DESCRIPTION	PARTS NO.	QTY
1	Power switch CQ1203KL6	C-1400	1
2-1	Emergency button I	C-1403	1
2-2	Emergency button II	C-1402	2
2-3	Emergency button III	51WR-800E15YE112	1
3	Delta Touch screen	2YBR-DOPB05S111	1
4	Switching Power Supply	2YE2-RD65B	1
5	EMI filter YC10T1(10A/250VAC)	2YXQF-10A250VAC	1
6-1	Fuse bracket	C-1500	3
6-2	Fuse bracket plate	C-1505	3
6-3	Fuse 5A UL	C-1702	4
6-4	Fuse 8A UL	C-1703	1
7	PLC AFP0R-C16CT	2YPLC-AFP0RC16CT	1
8	PCB board A10324B3	2YPCB-A10324B3	1
9	Stepping Motor Drive	2YF2-ST2811MAA	1
10	Inverter VFD002S23A	2Y1Q-VFD002S23A	1
11	Exhaust Fan 8cm 24VDC	2Y2G-FD24025HB	1
12	Transformer 660VA 220V/110V	E-0006	1
13	Capacitor 1.5UF	E-0156	1
14	Speed controller MGSDB2	C-1065	1
15	SSR-4A	E-0220	1
16-1	VR 24YNB 20K	E-0190	1
16-2	Knob RN99D	E-0230	1
16-3	Panel	51WR-0051	1

Applicator Parts Breakdown

Labeling Head
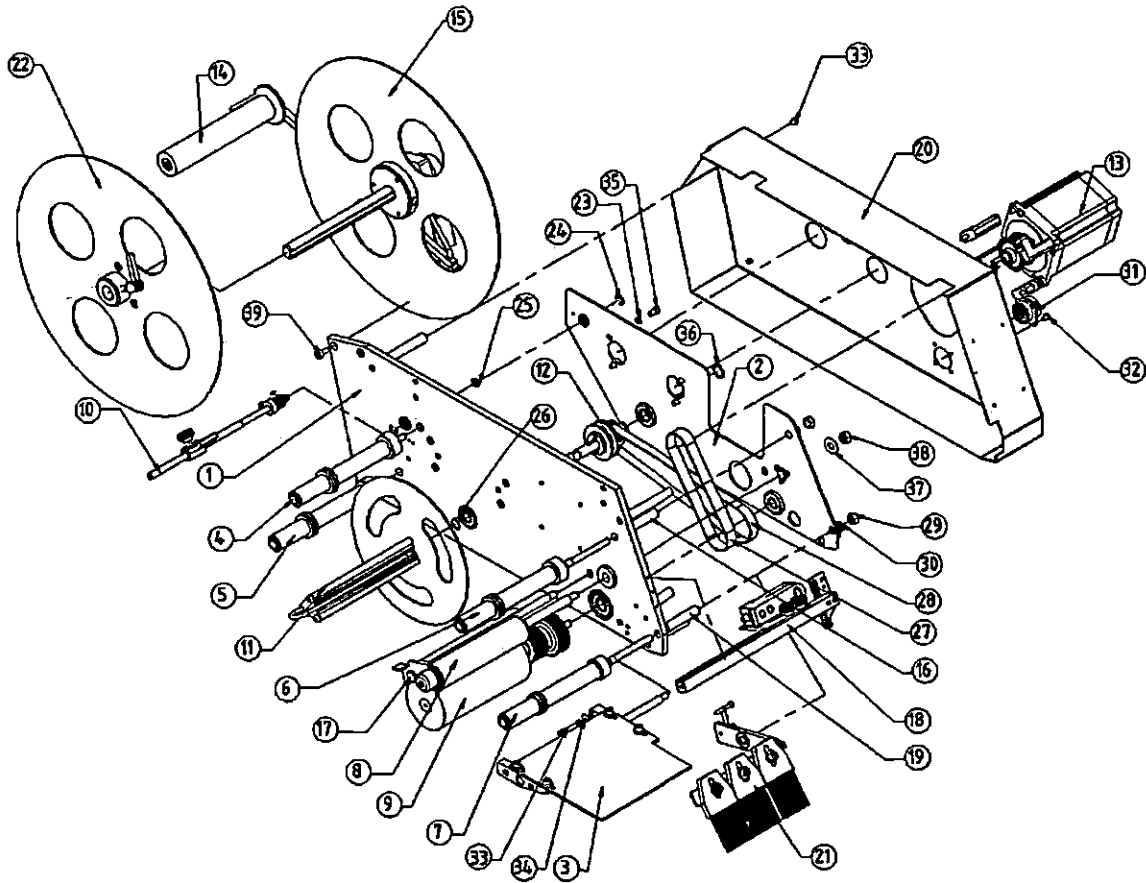
Parts List

Label Applicator Parts List

NO	DESCRIPTION	PART NO.	QTY.
1	Applicator base plate assembly		1
2	Applicator back plate assembly		1
3	Label peel plate assembly		1
4	Fixed label lead assembly		1
5	Label lead assembly 1		1
6	Label lead assembly 2		1
7	Label lead assembly 3		1
8	Lever sleeve assembly		1
9	PU roller assembly		1
10	Label press assembly		1
11	Base paper collect assembly 1		1
12	Base paper collect assembly 2		1
13	Applicator motor assembly		1
14	Tension bar assembly		1
15	Label supply plate assembly		1
16	Spacing roller	LA1-PL150-018	4
17	Position shaft	LA1-PL150-058	1
18	Label sensor fixing base Assembly		1
19	Spacing tube	LA1-PL150-072	1
20	Back cover	LA1-PL150-068C	1
21	Brush set/ Sponge roller assembly		1
22	Label Supply Plate Top Cover Assembly		1
23	Spring washer	M5 2FWO-M5	5
24	E-ring	E7 DCEV-E7	2
25	Nylon	2FWO-8121.0T	1
26	S-ring	S12 DCSV-S12	1
27	Timing belt 150XLU-065	T2Q2-150XLU065	1
28	Timing belt 240XL-050	T2Q2-240XL050	1
29	Hex Nuts M8	XAXR-M8	1
30	Spring washer M8	2FWO-M8	1
31	Plug connector	EC2066	1
32	Philips Head Screws	XNMW-M46	8
33	Socket Head Cap Screws M5*25	XNJW-M525	1
34	Washer M4	XNQC-M4	2
35	Spring washer M4	2FWO-M4	2
36	Socket Head Cap Screws M5*10	XNJW-M510	4
37	Socket Head Cap Screws M4*10	XNJW-M410	2
38	Washer M5	XNQC-M5	1
39	Socket Head Cap Screws M6*12	XNJW-M612	2

Parts List
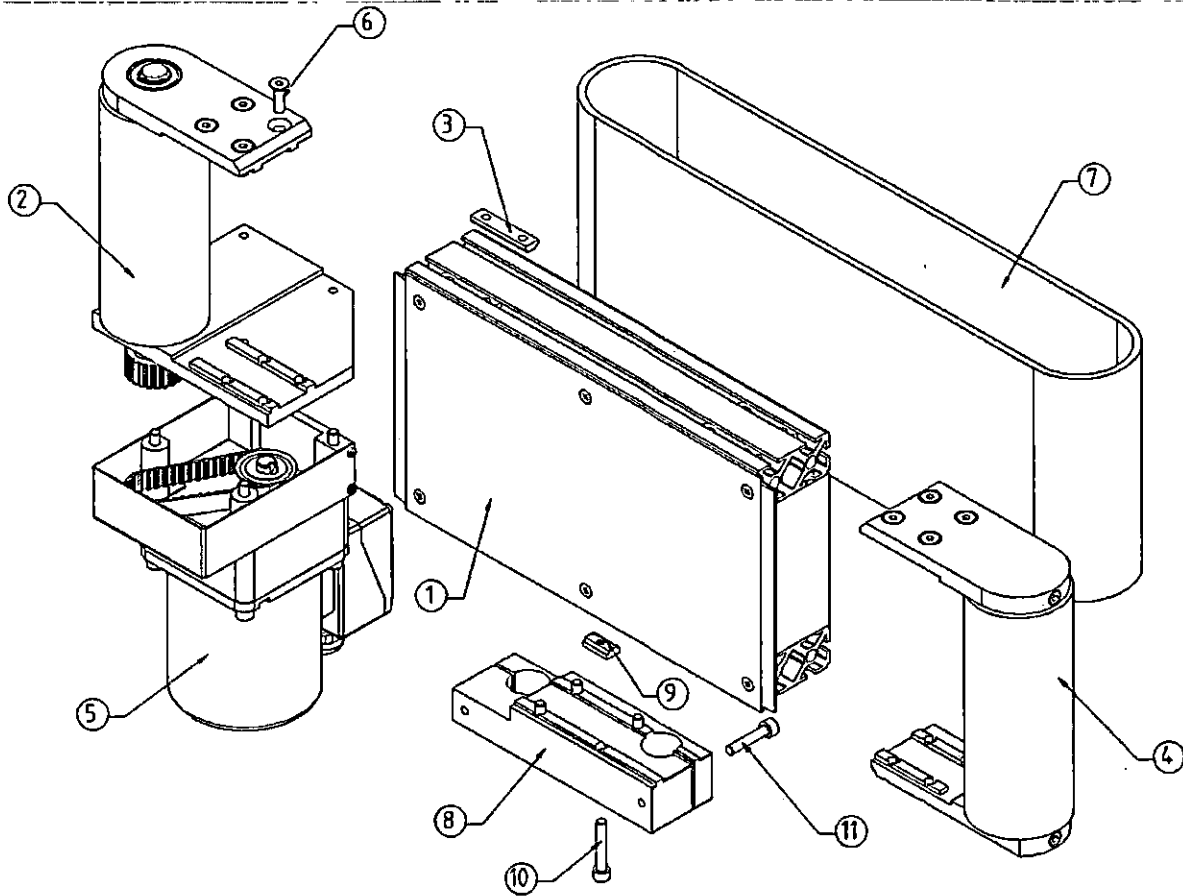
NO·	DESCRIPTION	PART NO.	QTY.
1	Wrap station frame assembly		1
2	Wrap station driving pulley assembly		1
3	Square Nut	XAZV-N30M6	8
4	Wrap station driven pulley assembly		1
5	Wrap station motor assembly		1
6	Bolt M6	XNAW-M620	16
7	Wrap around belt 160W*930L	T2EW-160W930L	1
8	Wrap station fixed base	WB1-PL160-010	1
9	Square Nut NS-M6	XAZV-NSM6	4
10	Socket Head Cap Screws M6	XNJW-M635	4
11	Socket Head Cap Screws M6	XNJW-M630	2

Parts List
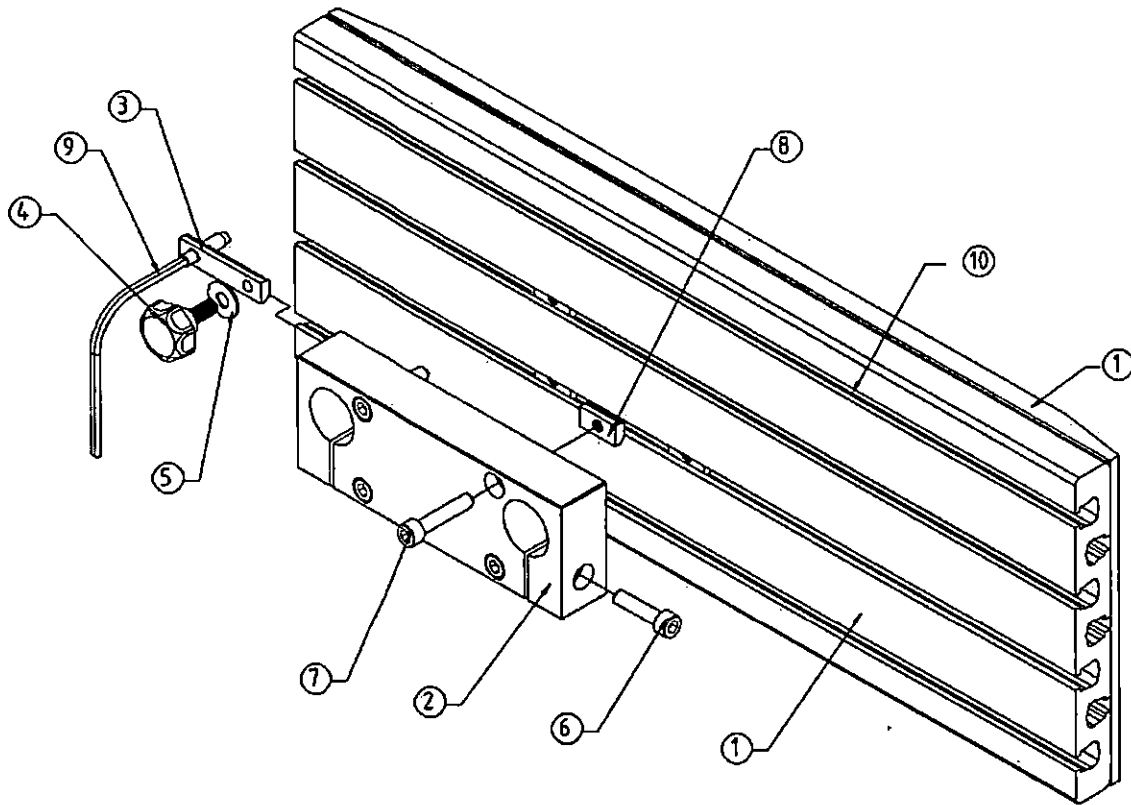
NO	DESCRIPTION	PART NO.	QTY.
1	Pressure rubber	WB1-PL160-023	1
2	fixed base of pressure plate	WB1-PL160-015	1
3	sensor bar	WB1-PL160-016	1
4	Knob	51WR-606025M615	1
5	Washer M6	XNQC-M6	1
6	Socket Head Cap Screws	XNJW-M625	2
7	Socket Head Cap Screws	XNJW-M630	4
8	Square Nut NS-M6	XAZV-NSM6	4
9	Fiber FU-6F	2YE2-FU6F	1
10	pressure plate	51XR-TL20160440	1

Parts List

Conveyor
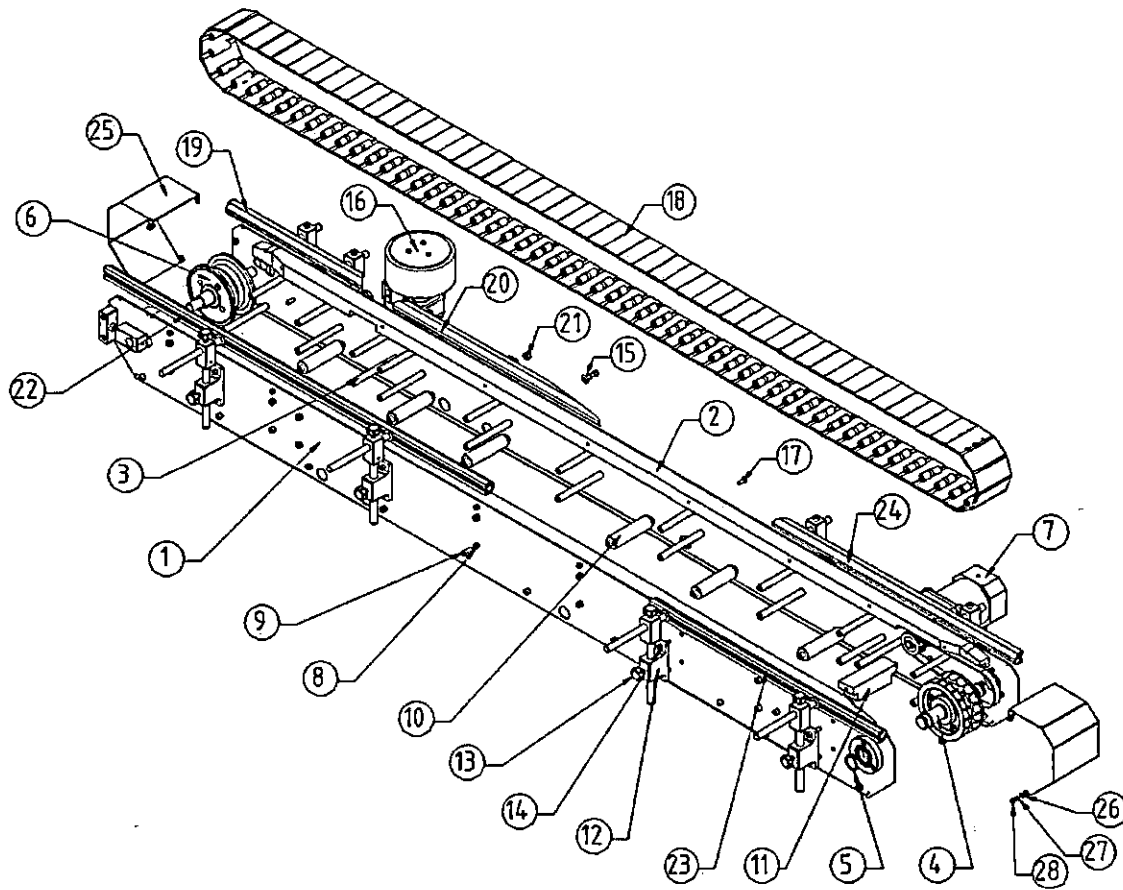
Parts List

Conveyor Parts List (Width 110mm)

NO	DESCRIPTION	PART NO.	QTY.
1	Conveyor front side plate Assembly		1
2	Conveyor back side plate assembly		1
3	Spacing pillar	CV1-PL501-011	29
4	Conveyor driving pulley assembly		1
5	S-ring S25	DCSV-S25	4
6	Conveyor driven pulley assembly		1
7	Conveyor motor assembly		1
8	Spring washer M6	2FW0-M6	43
9	Socket Head Cap Screws	XNJW-M616	39
10	Conveyor sliding wheel	CV1-PL501-007	6
11	conveyor base	FT1-PL501-001	1
12	Supporter of guide rail	GR1-PL501-001	8
13	Knob	51WR-606025M615	8
14	Socket Head Cap Screws	XNJW-M625	20
15	Washer	XNQC-M6	4
16	Bottle Separator Assembly		1
17	Bolt M6	XNAW-M616	1
18	Conveyor chain 820K325	T2GB-820K325	107
19	Guide rail A01		1
20	Guide rail A02		1
21	Hex Nuts	XAXR-M8	2
22	Guide rail A03		1
23	Guide rail A04		1
24	Guide rail A05		1
25	Cover of conveyor end	CV1-PL501-001	2
26	Washer M4	XNQC-M4	8
27	Spring washer M4	2FW0-M4	8
28	Socket Head Cap Screws	XNJW-M410	8

ACCUTEK
Packaging Equipment Companies, Inc.

Setup Sheet for
Labelette APS-106 and APS-108 Labeling Machines

Sensor Height

5 4 3 2 1
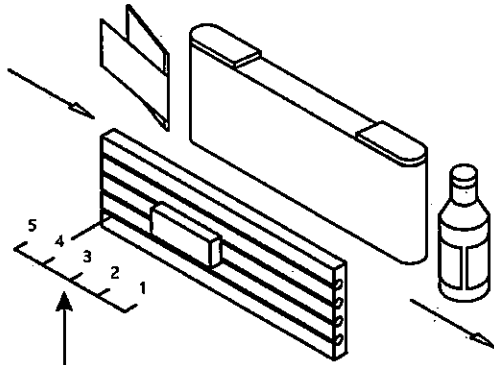
Sensor Position: _____
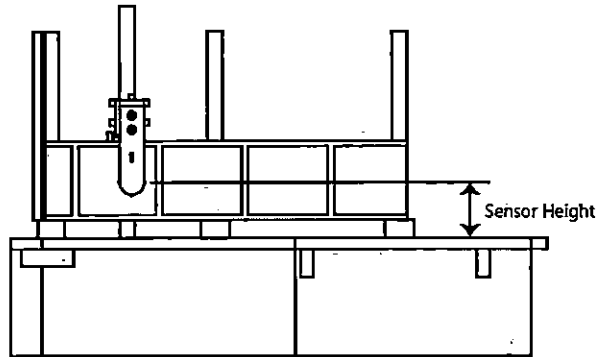
Sensor Height: _____

Customer: _____

Invoice #: _____

Label Size: _____

Memory #: _____

?	MENU	SETTING MODE	MEMORY MODE
LENGTH SET		mm	CONVEYOR
LABEL PEEL DELAY		step	ON OFF
PRECOUNT SETTING			LABELING
COUNTER CLEAR			ON OFF

?	MENU	LABELING MODE		MEMORY MODE
1	2	3	4	PEELING SPEED
5	6	7	8	
MISSING LABEL		mm		ON/OFF
HOT STAMP PRINTER		sec		ON/OFF

Notes