



OPERATOR MANUAL NEW Mk 2 SEAM SEALING MACHINE

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ALL LOCAL SAFETY LEGISLATION MUST BE IMPLEMENTED AND OBSERVED AT ALL TIMES

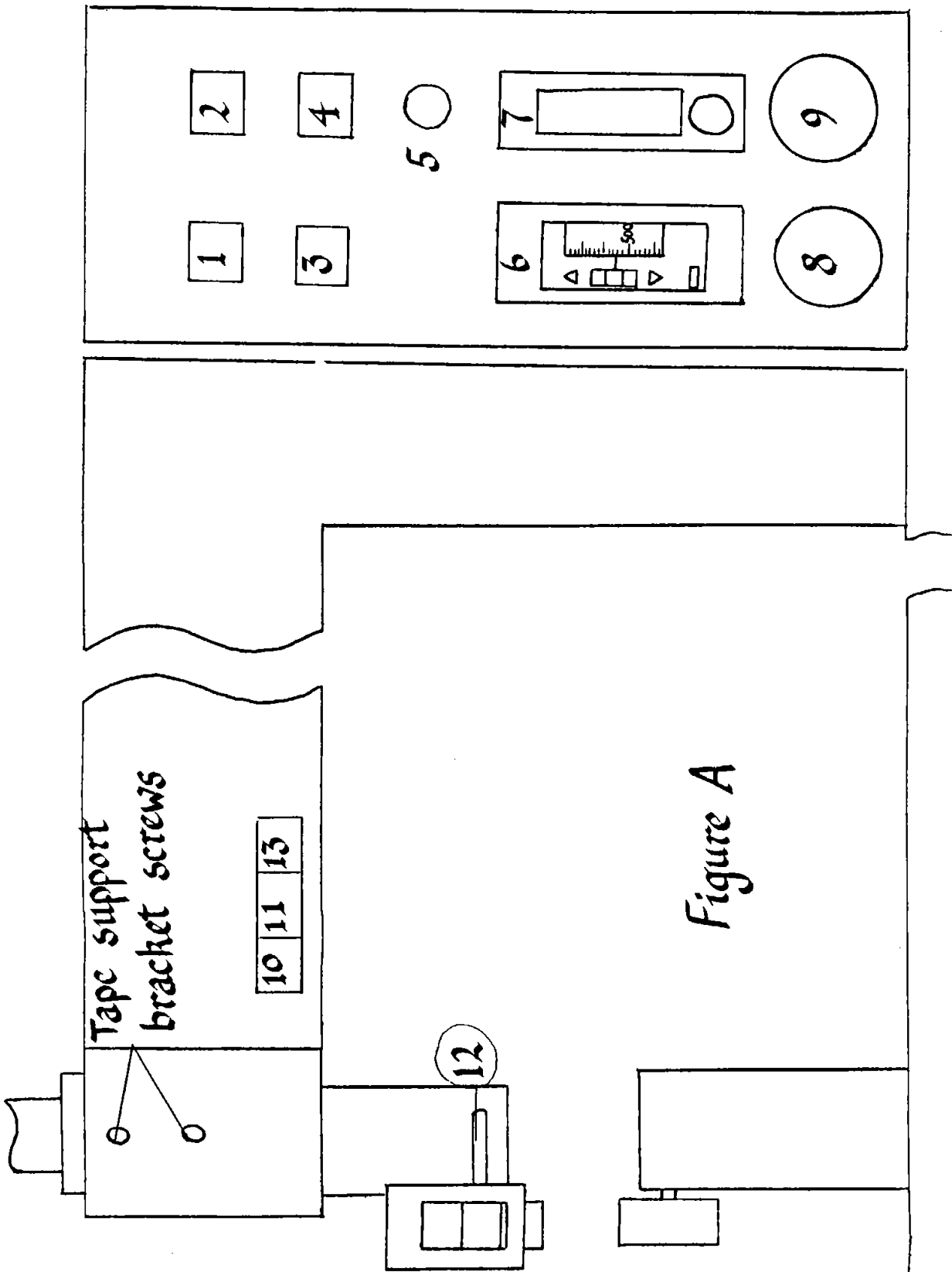
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Manufacturer ~

ARDMEL AUTOMATION LIMITED
NAYSMYTH ROAD
SOUTHFIELD INDUSTRIAL ESTATE
GLENROTHES
FIFE
KY6 2SD
GREAT Britain







Local Agent ~

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1. Power -
When fully depressed power can be switched on/off.
The switch will illuminate when in the on mode.
2. Air Failure -
This will illuminate if there is a failure in the air pressure. Full depression of the switch will reset the machine once the air pressure is restored.
3. Heat -
When fully depressed the heater can be switched on/off.
The switch will illuminate when the heater is on.
4. Heater in -
When fully depressed will swing heater nozzle in/out.
When used will illuminate when heater is in.
Normally used for setting up.
5. Speed -
Rotating knob will increase/decrease the drive speed up to 6m per minute.
6. Temperature -
Controls temperature of air at heater nozzle. To set : open door and turn thumbwheel to desired temperature.

Indicators - when illuminated.

Red		Temperature more than 3% above setting.
Red		Temperature between 1% and 3% above setting.
Green		Temperature within 1% of setting.
Red		Temperature between 1% and 3% below setting.
Red		Temperature more than 3% below setting.
Cream		Load being applied to heater.
7. Air Flow -
The amount of air flowing through the heater nozzle is controlled by turning the knob to increase/decrease the supply, the float indicates the amount of air flowing.
8. Quill Pressure Indicator -Indicates pressure on quill when pedal fully depressed and machine in operating mode.
9. Quill Pressure Set -
Turning knob will increase/decrease pressure on quill when pedal fully depressed and machine in operating mode.
10. Quill Down/Up -
When depressed the quill will go down and lock independant of the foot pedal. The quill is under low pressure. Reprising the switch will return the quill to its up position, unless foot pedal depressed.
11. Roller Drive/Creep -
When depressed and held the drive rollers will operate independant of the foot pedal, releasing the switch will stop the drive rollers.
12. Tape Roller/
Guide Latch -
Pull roller out using pin on right side of roller, roller will stay out until latch is pushed up.
13. Reverse Mode -
When fully depressed will switch on reverse mode and will illuminate. Reprising will switch off the reverse mode. The reverse turns the drive rollers back a small amount, set by timer 3 in the control box. When used the reverse mode eliminates the danger of "weld gap" if the operator stops in mid seam.

Foot Pedal - Gray.

Operating Sequence (a) Reverse Mode Off.

Top of Stroke	Quill up, heater retracted.
Half Way Down	Quill down on low pressure.
Fully Down	Quill on high pressure, heater nozzle in and drive rollers on.
Half Way Up	Quill on low pressure, heater retracts and drive rollers stop.
Top of Stroke	Quill lifts.
or Fully Down	Quill back on high pressure heater nozzle in and drive rollers restart.

Operating Sequence (b) Reverse Mode On.

Top of Stroke	Quill up, heater retracted.
Half Way Down	Quill down on low pressure.
Fully Down	Quill on high pressure, heater nozzle in and drive rollers on.
Half Way Up	Quill on low pressure, drive rollers reverse then stop, heater retracts.
Top of Stroke	Quill lifts.
or Fully Down	Quill back on high pressure, heater nozzle in and drive rollers restart on forward run.

Setting Tape Feed Guide Pressure

The knurled knob directly behind the assembly adjusts the pressure on the tape guide roller, screwing in increases pressure, out decreases pressure. Care should be taken not to put too far in as the threaded part of the adjuster may interfere with the latch.

CONTROL BOX.

In the control box there is a panel with six knobs. The small black lug at the base of each knob is a lock and has to be moved to the right before the knob can be turned.

Timer 1. Motor Start Delay.

Delays the start of the motor once the heater has moved in. Higher the setting longer the delay.

Timer 2. Heater Out Delay.

Delays heater retraction once motor has stopped. Higher the setting longer the delay.

Timer 3. Reversing Time.

Sets the length of time the motor runs in reverse i.e. how far back the drive rollers turn. Higher the setting longer the reverse.

Timer 4. Tape Feed Delay - Before Start.

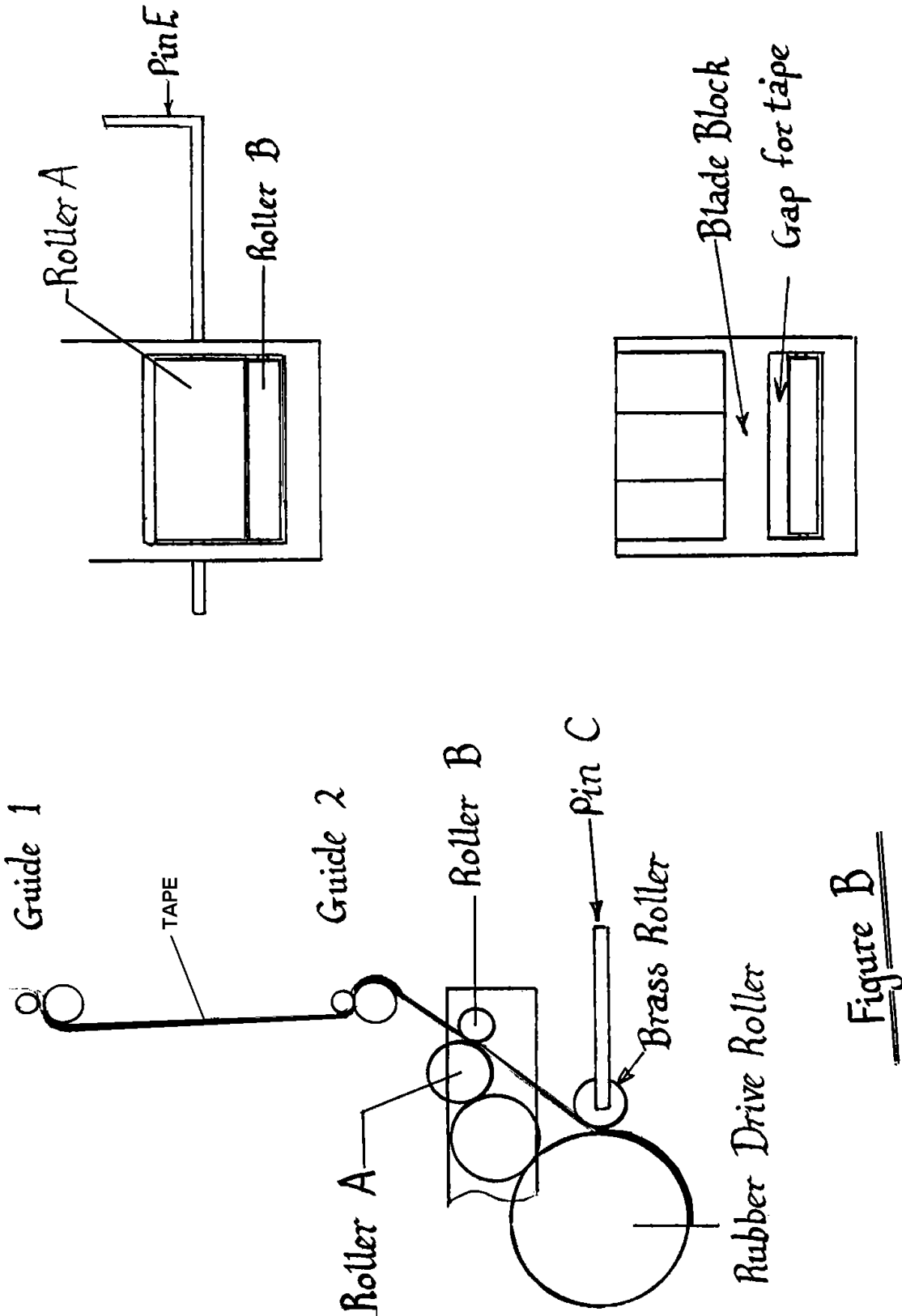
Delays start of the tape feed cycle after cutting cycle complete. Higher the setting the longer the delay. This is preset and should require no further setting.

Timer 5. Tape Feed Time.

Sets length of time motor runs after cutting cycle complete i.e. the length of tape fed through after cutting. The higher the setting the longer the start 'tail' of tape.

Timer 6. Reversing Time - delay before reverse.

Delays start of reverse cycle once heater has retracted. The higher the setting the longer the delay. This is preset and should require no further adjustment.



CUTTER OPERATION.

Threading Cutter - See figure B

Method 1.

Disengage brass roller by pulling on pin C until it locks out.

Feed tape through clip guides 1 and 2. Position tape to go through rollers A and B.

Press override switch for motor drive/creep (switch 11 on diagram A).

Take care tape does not come out between block and roller B - arrowed Gap.

Run motor until tape is at bottom of drive roller.

Reinsert Brass roller.

If tape misfeeds use Method 2.

Method 2.

Disengage brass roller.

Feed tape through clip guides 1 and 2. Remove pin E and lift roller A out of cutter block.

Drop tape down through gap between roller and blade block.

Pull tape through bottom and feed it under drive roller.

Reinsert brass roller.

Replace roller A and reinsert pin E. Press down on roller A to insert pin.

OPERATING CUTTER.

The cutter is activated by the pedal to the right of the main control pedal.

As the item is being put through the drive rollers the cutter pedal is pressed when the item is about 6 cms from the end. The drive rollers must be turning when the cutter is operated.

When the quill is lifted the tape is automatically fed through by the amount set on Timer 5.

BACK COVER