QUADREL
LABELING SYSTEMS

Operating & Maintenance
Manual
For

VENTURA FOODS

TECHLINE ZDT FRONT/BACK/WRAP
Automatic Labeling System

Labeler Model #: Q125 SERVO
Serial #: 84219-100

QUADREL LABELING SYSTEMS
7670 Jenther Drive
Mentor, Ohio 44060
440.602.4700

customerservice@quadrel.com
parts@quadrel.com

TERMS AND CONDITIONS OF SALE
QUADREL, INC
D/B/A Quadrel Labeling Systems Hereinafter Referred to as Quadrel

PERFORMANCE GUARANTEE:

If the surface of the product to be labeled is free from contamination so as to ensure proper label adhesion, the labels are manufactured in accordance with label specifications provided and the equipment is operated and maintained in accordance with the instructions contained in the Quadrel manual (two copies of the manual will be supplied by Quadrel with the labeling system; one printed copy, and one electronic copy). Quadrel guarantees the EQUIPMENT to perform after installation as stated.

1. Provided a sufficient amount of products are presented to the labeling system.
2. Dimensional inconsistency from one like product to be labeled to the other may result in additional label placement inaccuracy in direct relationship to the product inconsistency.
3. Slitting inconsistency within a given roll of labels or from one like roll to another may result in additional label placement inaccuracy in direct relationship to the slitting inconsistency.
4. If the Quadrel labeling system proposed herein does not include physical control of the product during label application, additional placement inaccuracy can occur in direct relationship to the product control inconsistency.
5. Label Placement Accuracy: Within Sigma 2 (approximately 95.5%) to be normal.

In the event of the failure if the Quadrel system to meet customer's specifications, as quoted by Quadrel or subsequently agreed to by Quadrel. Quadrel upon written notice from buyer shall, at its option, repair the system, or refund the purchase price upon return of the system. The warranty provided in this article and the obligations and liabilities of Quadrel thereunder are exclusive and in lieu of, and buyer hereby waived, other remedies warranties, guarantees or liabilities, express or implied arising by law or otherwise (including without limitation, any obligations of Quadrel with respect to fitness for a particular purpose, merchantability, specific performance, incidental and consequential damages) whether or not occasioned by Quadrel's negligence. This warranty should not be extended altered or varied except by written instrument signed by Quadrel and buyer.

EXCLUSIVE TERMS OF SALE: The proposal attached hereto or to which these Terms and Conditions of Sale apply (the "Proposal"), together with these Terms and Conditions of sale (collectively, the "Sale Agreement"), constitutes the complete and exclusive statement of the agreement between Quadrel and the purchaser specified in the Proposal ("Purchaser") concerning the equipment and other goods specified in the Proposal (collectively, the "Equipment"), as well as any and all services specified in the Proposal (collectively, the "Services"), and supersedes all prior contemporaneous agreements, representations and/or communications, either oral or written, between Quadrel and Purchaser or any representative such as parties with the respect to the subject matter of the Sale Agreement. No change to the Sale Agreement or waiver of any provision thereof will be binding on Quadrel unless made in writing and signed off by and authorized officer of Quadrel. Acceptance of the Equipment, in whole or part, or other express or implied assent by Purchaser to the terms hereof shall constitute Purchaser's agreement to the terms of the Sale Agreement. Acceptance of any purchase order or other document of Purchaser by Quadrel is expressly made conditional on the Purchaser's assent to the Sale Agreement. ANY ATTEMPTED MEMORIALIZATION OF THIS SALE BY A PURCHASE ORDER OR OTHER DOCUMENT CONTAINING TERMAND CONDITIONS INCOSISTANT WITH OR IN ADDITION TO THE CONDITIONS CONTAINED IN THE SALE AGREEMENT SHALL NOT BE BINDING UPON QUADREL AND QUADREL HEREBY EXPRESSLY OBJECTS TO AND REJECTS THE SAME.

GENERAL WARRANTY (EXCLUDES TABLETOP LABELERS)

Time from date of shipment	Covered Expenses
Up to 90 Days	All Parts , service time, living and travel expenses
UP to 12 Months	All parts

THE WARRANTIES PROVIDED ABOVE ARE IN LIEU OF ANY AND ALL OTHER WARRANTIES AND LIABILITIES, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO ANY WARRANTIES OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE. NO OTHER WARRANTIES ARE OFFERED BY QUADREL WITH RESPECT TO THE EQUIPMENT OR SERVICES AND QUADREL HAS NOT AUTHORIZED ANY EMPLOYEE OR AGENT TO OFFER ANY WARRANTIES EXCEPT THOSE PROVIDED ABOVE. PURCHASER AND QUADREL EXPRESSLY AGREE THAT THE WARRANTIES PROVIDED ABOVE SHALL SERVE AS PURCHASER'S SOLE AND EXCLUSIVE REMEDY WITH RESPECT TO THE EQUIPMENT AND SERVICES.

PURCHASER REEQUIRMENTS. Purchaser must provide Quadrel descriptions and specifications of all labels and items to be labeled, including, without limitation, label material, product and label dimensions, and any other items required by Quadrel. Further, purchaser shall furnish Quadrel one (1) production size roll of each label and 100 samples of each item to be labeled for testing purposes. **Quadrel shall have no liability (whether under its Limited One-Year Warranty or otherwise) for labeling performance on labels or items to be labeled:**

(a) Which were not specified or sufficiently described in the Proposal: or

(b) With respect to which Purchaser fails to provide Quadrel the samples specified herein, even if such labels or items to be labeled were specified in the Proposal. Further, Quadrel shall have no liability for delays caused by Purchaser's failure to furnish samples as specified herein.

LIMITATION OF WARRANTIES. Quadrel shall have no obligation to honor its warranties and shall have no liability with respect to defective Equipment if:

(a) The Equipment has been modified, altered, damaged, abused or used for any other than those purposes intended by Quadrel.
(b) The Equipment has been changed without prior written consent from Quadrel.
(c) The equipment has not been operated and maintained in accordance with generally accepted commercial practices for similar equipment and Quadrel's specifications and instructions, as published in the Quadrel manual.
(d) The surface if the product to be labeled is not clean and free of contamination, including, but not limited to, mold release agents, condensation, dirt and oil.
(e) Labels are not manufactured in accordance with label specifications provided by Quadrel, or are not from defects such as cracked edges, deep die strikes, *etc*.
(f) Labels and items to be labeled are not set forth in the Proposal.
(g) Samples of all products and labels were not provided to Quadrel for testing prior to Equipment shipment as required under "Purchaser Requirements" outlined above.
(h) There is dimensional inconsistency from one like roll of labels to another.
(i) *The Equipment does NOT include physical control of the product.*

LIMITATION OF REMEDIES. All warranty claims shall be subject to review and approval by Quadrel. Quadrel's obligation to honor warranties is in all cases limited to, at Quadrel's sole option:

(a) Repair of defective Equipment or components: or
(b) Providing a cash refund or credit, after Purchaser has returned Equipment to Quadrel.

Where warranty service is to be provided at the Quadrel facility, Purchaser shall return Equipment claimed to be defective to Quadrel, freight prepaid, for review. No Equipment shall be returned to Quadrel, whether for inspection, repair, refund, or any other reason, without prior return authorization from Quadrel. Quadrel may charge Purchaser cost resulting from testing, handling and disposition of Equipment claimed to be defective by Purchaser which is found by Quadrel to conform to Quadrel's warranties.

LIMITIATION OF LIABILITY. QUADREL SHALL HAVE NO LIABILITY FOR ANY CONSEQUENTIAL, INCIDENTAL, PUNITIVE OR SPECIAL DAMAGES BY REASON OF ANY ACT OR OMISSION OR ARISING OUT OF OR IN CONNECTION WITH THE (a) EQUIPMENT OR ITS SALE, DELIVERY, INSTALLATION, MAINTENANCE, OPERATION, OR PERFORMANCE, OR (b) SERVICES. IN NO EVENT SHALL QUADREL'S LIABILITY EXCEED THE PRICE OF THE EQUIPMENT (OR THE PRICE OF THE SERVICES IF A CLAIM IS MADE WITH RESPECT TO THE SERVICES) WITH RESPECT TO WHICH A CLAIM IS MADE REGARDLESS OF WHETHER SUCH CLAIM IS BROUGHT

AT LAS OR IN EQUITY AND REGARDLESS OF WHETHER SUCH CLAIM IS BROUGHT UNDER CONTRACT, BREACH OF WARRANTY, TORT OR ANY OTHER THEORY OF LAW OR EQUITY.

ORDERS:
Orders entered, verbal or written, cannot be cancelled except upon terms that will compensate Quadrel against any and all claims

START-UP SERVICE:
Quadrel will provide, at standard installation rates, the number of normal eight-hour working days for the Quadrel Field Service Technician to start the EQUIPMENT and to train PURCHASER'S operating and maintenance personnel. EQUIPMENT is not uncrated and emplaced in desired location by PURCHSER prior to arrival of Quadrel Field Service Technician, or if the EQUIPMENT cannot be made operational due to non-availability of products, labels, appropriate utilities and/or related production equipment, PURCHASER shall pay Quadrel for additional service time required including travel expenses, if applicable, in accordance with Quadrel's Field Service rates. It is PURCHASER's obligation to schedule the start-up service at a time when PURCHSER'S engineering, maintenance and selected production personnel are available.

SERVICE AFTER INSTALLATION:
Quadrel Field Service Technicians are available to customers who do not maintain their own service departments. This can be handles on a per visit basis. Field Service rates are available on request.

PAYMENT TERMS:
Payment terms are as follows: 50% of purchase with purchase order, 40% of purchase at the time of shipment, 10% of purchase (plus freight charges) due net 30 days. If shipment is delayed beyond 30 days after the EQUIPMENT has been made ready for shipment, and the delay is caused directly or indirectly by the PURCHASER, then the total of the unpaid balance, at option of Quadrel, may become immediately due and payable upon written notice. Payments not paid when due shall thereafter bear monthly service charges at the rate of 1.5% per month on the unpaid balance until paid. If, in Quadrel's opinion, PURCHASER'S financial condition does not justify continuance of production or shipment on the terms of payment specified above, Quadrel may require payments in advance.

FINANCIAL IMPAIRMENT. Quadrel may, at its option, suspend performance if in its opinion the credit of the Purchaser becomes impaired until such time as Quadrel has received full payment, including any general price increases or surcharges, is satisfactory security for deliveries made and is satisfied as to Purchasers credit for future deliveries. Quadrel reserves the right to cancel Purchaser's credit at any time for any reason. In addition, Quadrel reserves the right by written notice to cancel any order or require full or partial payment or adequate assurance of performance from Purchaser without Liability to Quadrel in the event of:

(a) Purchaser's insolvency
(b) Filing of a voluntary petition in bankruptcy by Purchaser
(c) Filing of an involuntary petition in bankruptcy against Purchaser
(d) Appointment of a receiver or trustee for Purchaser
(e) Execution by Purchaser of an assignment for the benefit of creditors

TAXES:
The amount of any present or future federal, state, local or other taxes applicable to the sale of EQUIPMENT shall be added to the price and paid by PURCHASER unless PURCHASER provides a valid exemption certificate acceptable to Quadrel and the appropriate tax authority.

GOVERNING LAW AND JURISDICTION. The sale agreement shall be governed and construed in accordance with the domestic laws of the State of Ohio without giving effect to any choice or conflict of law provision or rule that would cause the application of the laws of any jurisdiction other than the State of Ohio. Any legal action, suit or proceeding relating to the Sale Agreement shall be heard and determined exclusively in the United States District Court for the Northern District of Ohio or the Court of Common Pleas of Lake County, Ohio, and each party irrevocably submits to the jurisdiction of either such courts and waives any objection which such party may have to the laying of venue of any such legal action, suit or proceeding in any such court.

The Sale Agreement shall not be governed by the United Nations Convention on the International Sales of Goods. No actions arising out of the sale of Equipment or Services may be brought by either party more than one (1) year after shipment.

RETURNS:
EQUIPMENT sold by Quadrel is returnable only in accordance with the provisions hereof. Before returning of any EQUIPMENT or items thereof, PURCHASER must obtain Quadrel's written return authorization and instructions.

FORCE MAJEURE:
Quadrel shall not be liable for any loss, damage, delay, changes in shipment schedules or failure to deliver due to act of God, accidents, fires, strikes, riots, civil commotion, insurrection, war, the elements, embargoes, failure of carriers, inability to obtain electricity or other type of energy, transportation facilities, raw material, equipment or any problem or any similar or different contingency beyond its reasonable control which would make performance commercially impractical whether or not the contingency is of the same class as those above. Quadrel shall in no event be liable for any consequential damages.

TITLE AND RISK OF LOSS:
Title and risk of loss to EQUIPMENT shall pass to PURCHASER upon delivery by Quadrel to a common carrier, regardless of the freight terms stated or method of payment for transportation charges. Quadrel reserves the right to specify routing of shipments.

ENTIRE AGREEMENT:
This agreement embodies the entire agreement and understanding between the parties, is intended as complete and exclusive statement of terms of the agreement between the parties and supersedes any prior agreements or understandings between the parties relating to the subject matter hereof. PURCHASER acknowledges that Quadrel has not made any representations to PURCHASER other than those which are contained herein. Except as provided in this agreement, no change in or addition to the terms contained herein shall be valid as between the parties unless set forth in writing which is signed by an authorized representative of both parties and which specifically states that it constitutes an amendment to this agreement.

The parties may use their normal commercial forms in connection herewith: however, any such forms shall be used for convenience only and any terms or provisions which may be contained therein inconsistent with or in addition to those contained herein shall have no force or effect whatsoever between parties hereto.

EFFECTIVE:
This proposal is based upon the current cost of labor and materials and shall remain in effect for a period of sixty (60) days from the date hereof unless revoked by Quadrel in writing prior to acceptance.

INDEMNIFICATION:
The purchaser of this product ("Customer") hereby agrees to release, indemnify and hold harmless Quadrel and its agents, assignees and representatives for any and all liabilities, losses, costs, damages and expenses (including attorneys' fees and expenses) arising, directly or indirectly, from any and all manner of claims, demands, actions and proceedings that may be instituted against Quadrel on any grounds.
The Customer agrees to, at the Customer's own expense, promptly defend and continue the defense of any such claim, demands, actions or proceeding that may be brought against Quadrel, provided that Quadrel shall, within thirty (30) days of Quadrel receiving notice thereof, notify the Customer of such claims, demand, action or proceeding.
Quadrel shall at all times retain the right to defend itself and/or to otherwise participate in the defense of any such claim or action, and no settlement or other resolution of any such claims or action shall be finalized without Quadrel's written approval. Any failure by Quadrel to give prompt notice or provide copies of documents or furnish relevant data shall not constitute a defense in whole or in part to any claim by Quadrel against the Customer except to extend that such failure by Quadrel shall result in a material prejudice to the Customer.
The forgoing notwithstanding, if suit shall have been against Quadrel and the Customer shall have failed, after the lapse of a reasonable time after written notice to it of such suit, to take action to defend the same. Quadrel shall have the sole right to

defend the claim and shall be entitled to charge the customer with the reasonable cost of any such defense, including reasonable attorney's fees, and Quadrel shall have the right, after notifying but without consulting the Customer, to settle or compromise such claim on any terms reasonably provided by Quadrel.

This release and indemnification is and shall be binding upon the Customer, as well as the Customer's respective heirs, subsidiaries, affiliates, successors, assigns, agents and employees. If any provision or provisions of this release and indemnification shall be held to be invalid, illegal or unenforceable for any reason whatsoever, the validity, legality and enforceability of the remaining provisions aft h Agreement shall not in any way be affected or impaired thereby. No supplement, modification or amendment of this Agreement shall be binding unless executed in writing by all of the parties hereto.

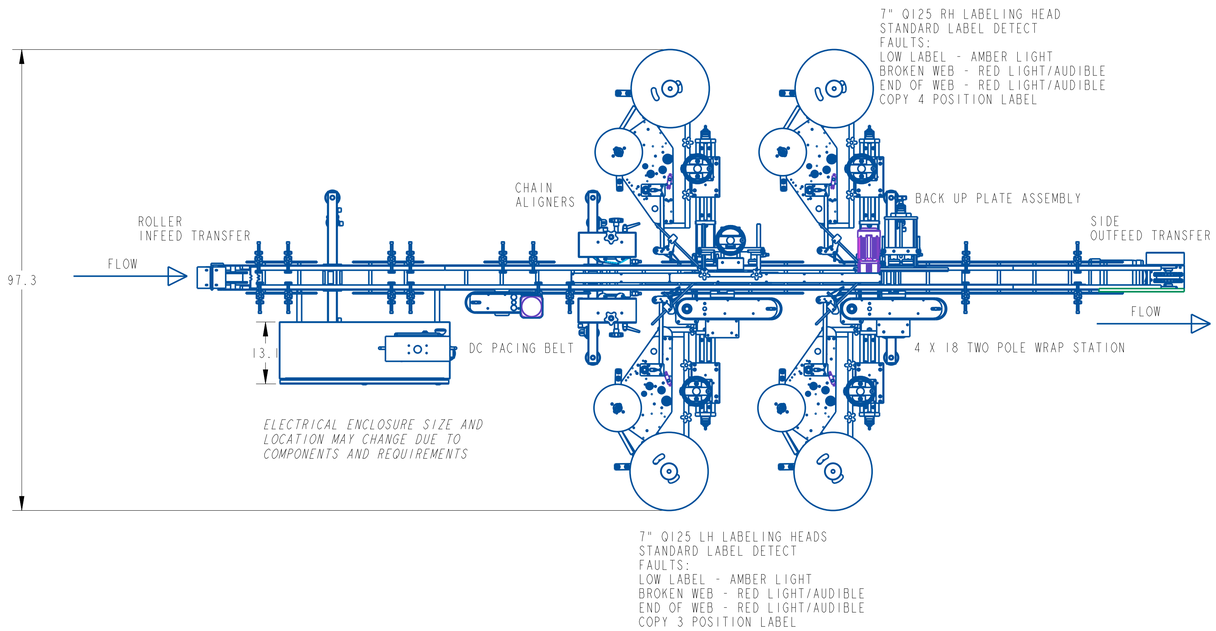
Any order put on hold or left dormant for any reason for 90 days will be considered cancelled. See Cancellation Policy below.

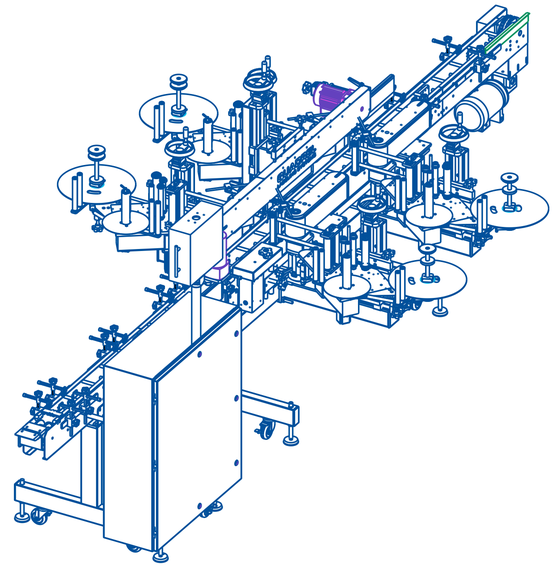
CANCELLATION POLICY:

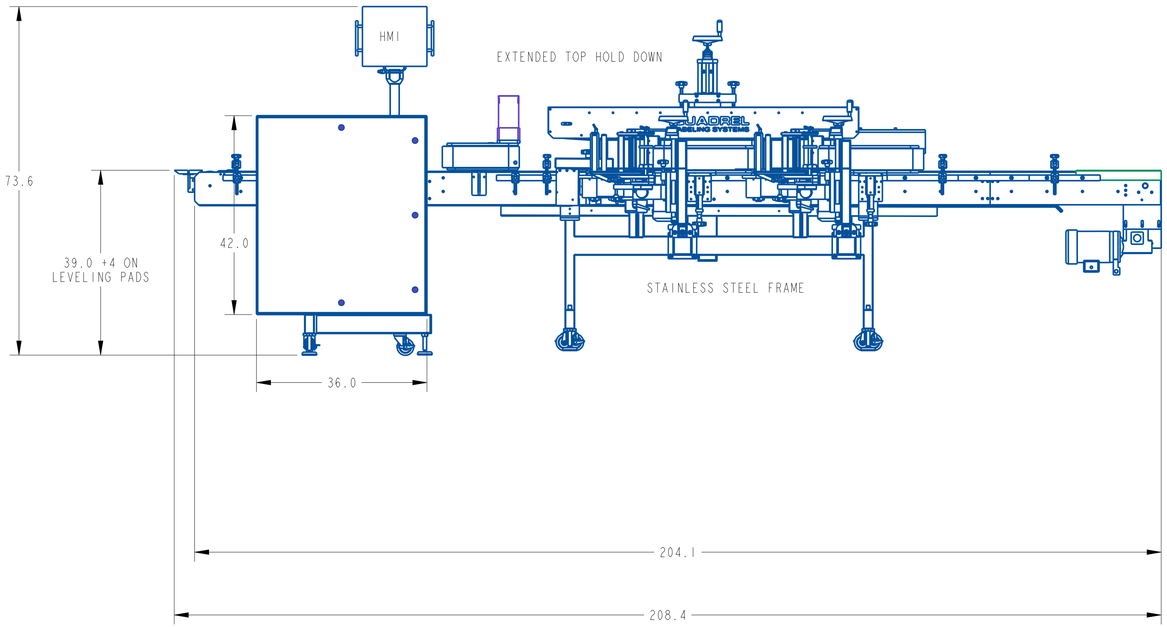
In the event of order cancellation, the 50% down payment is non-refundable. Customer may also be responsible for additional charges covering engineering resources expended and committed materials depending upon the custom nature of the project and the point in the order process in which the cancellation occurs.

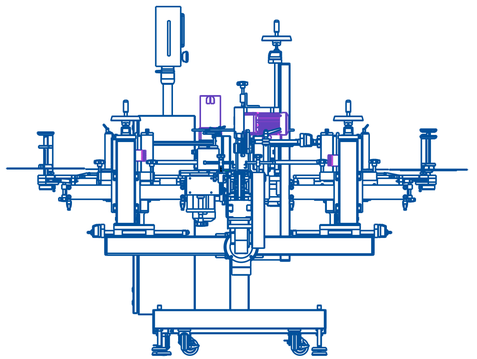
NOTE. No salesman, representative or agent of Quadrel is authorized to give a guarantee, warranty or make any representation contrary to above.

Please sign and acknowledge acceptance to these terms and conditions_____Date_____









REV	DATE	DESCRIPTION	BY
E	Sep-22-25	FLIPPED PACING BELT	TAZ
D	Sep-15-25	HEIGHT WAS 42	TAZ
C	Sep-15-25	HEIGHT WAS 34	TAZ
B	Sep-12-25	SIDE TRANSFER, WRAP ON LHH	TAZ
A	Sep-10-25	NEW DRAWING	TAZ

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/16
DATE: Sep-10-25
DRW BY: TAZ
CHK BY:
APPR BY:

TECHLINE ZDT F/B/W LABELING SYSTEM

MAT'L
M-PACK/VENTURA FOODS
APPROVAL DRAWING

84219-100

SHEET 1 OF 1

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Quadrel Labeling Systems
Quality Manual

Quality Statment:

Quadrel Labeling Systems strives to provide our customers with the highest quality labeling/sleeving solutions available on the market. In order to achieve total customer satisfaction, we shall adhere to the following objectives:

100% on-time delivery

zero defects

Value added service and support

Engineered solutions

Employee development and diversity

We will commit to continuously improve each facet of our business operations through implementation of, and compliance of this manual.

C. Wepl

Chuck Wepler
General Manager / President

Approved by: Jim Brazee
Issue Date: 1/1/2018

1 MANUAL PREFACE

Thank you for choosing Quadrel Labeling Systems. We have designed and manufactured this equipment with the upmost pride and care ensuring you the absolute best quality, maximum versatility and reliability.

This equipment is intended to be used only as described in this document. Quadrel Labeling Systems Inc. cannot be held responsible for the improper use or functioning of non-described functions of this machinery. Liability for any personal injury, loss of production or revenues, or property damage occasioned by the use of this manual in effect maintenance, operation, or repair of the equipment is in no way assumed by Quadrel Labeling Systems Inc. Anyone one using a procedure not recommended by the end user should first completely satisfy himself/herself that personal safety and equipment integrity will not be jeopardized in the method selected.

DO NOT attempt to install, operate, or adjust the labeling system without first reading and understanding the contents of this manual.

Only a trained person is to be permitted to operate this equipment. Training should include instruction in operation under normal conditions and emergency situations. Under no circumstances should an untrained person operate this machine.

This manual will provide operating instructions, parts listing and schematics. The information contained in this manual will help the user in his/her operations, troubleshooting, and maintaining the machine in good operating conditions. Information, illustrations and specifications contained in this manual are based on the latest product information available at the time of this manual release. Quadrel Labeling Systems Inc. reserves the right to alter and substitute information contained herein at any time.

Due to the customization it is also possible that you have received a different variation of this equipment, with several different options. Some pictures used in this manual may not totally reflect your configuration, although the labeling is completely the same.

2 GENERAL DISCRIPTION - TECHLINE

In-line labeling machines apply labels to a wide variety of container shapes. In addition to conventional cylindrical containers, the in-line labeler can be used with specially contoured, elliptical or flat-sided containers. In-line labelers are manufacturing in a variety of configuration. Diagrams illustrate standard in-line labeler arrangements for different container designs.

The Techline labeling system is a high performance, economically priced labeling system for front/ back, wrap or custom applications with production rates up to 275 ppm. Built with quality, versatility and durability from the bottom up. This system surpasses all equipment in its price range and is suitable for multi-shift operations where long-term reliability is important. All critical components are designed for 24/7 reliability. The versatility of Techline makes it ideal for contract packagers or companies requiring frequent changeovers on a wide variety of products. Features such as PLC control with color touchscreen and simple “no tool/ no change parts” operation provide maximum flexibility for today’s packagers. This system has a compact footprint, suitable for harsh/ multi-shift environments. Allen-Bradley PLC control with color touchscreen with 50 programmable product presets. Encoder-based speed compensation. AC inverter controlled product handling. Ideal for Pharmaceutical, Food, Personal Care, Automotive and other markets.

3 WARNING/CAUTION SAFETY INSTRUCTION

Where safety is dependent upon starting or stopping devices, or both, they are to be kept free of obstructions that could endanger personnel.

The areas around loading and unloading points are to be kept free of obstructions that could endanger personnel. Instruct personnel working on or near this equipment as to the location and operation of pertinent stopping devices.

This equipment is to be used only for the purpose for which it is constructed.

Under no circumstances are the safety characteristics of this equipment to be altered.

Conduct routine inspections and corrective / preventive maintenance measures to ensure that all guards are installed and function properly. Alert personnel to the potential hazards indicated by the safety labels on this equipment.

3.1 SAFETY INTEGRATION

The end user's safety risk assessment will be the guiding document for proper integration of the equipment provided. Consideration of the following guidelines is recommended in order to achieve a safe result:

- Open areas under the equipment are to be guarded by the end user to prevent entry.
- Where conveyor flight lugs or product enters or exits the equipment, proper guarding and interlock are put in place by the end user to ensure mitigation of shear/jam points.
- The end user is responsible for properly guarding drive components on equipment that requires mechanical drive integration.

3.2 GENERAL SAFETY INFORMATION

This Quadrel Labeling System is engineered to feed and apply labels on your products. In designing the device, Quadrel valued personal safety; however we would like to draw your attention to the following safety acknowledgments.

⚠ WARNING Hazards or unsafe practices, which **COULD** result in severe personal injury or death.

⚠ CAUTION Hazards or unsafe practices, which **COULD** result in minor injury

⚠ CAUTION The presence of safety systems in these units does not exempt the operators to act cautiously, avoiding behaviors that could

endanger their health or the equipment. These models are engineered to feed and apply labels on your products. In designing this device, Quadrel valued personal safety; however we would like to draw your attention to the following safety acknowledgments.

- Operators should know the basic operations and setup procedures before operating this equipment.
- Safe operations should be maintained at all times.
- Know the location of E-stops and power switches prior to operating machinery such as this.

⚠ WARNING

To reduce risk of fire, electrocution, or other personal injury when operating. Follow basic safety precautions, including the following:

- This equipment must have an operator attending the machine at all times to monitor the operations. **DO NOT** leave this equipment unattended during maintenance or perform any maintenance unless the e-stop condition has been activated or power turned off.
- The electrical power to device is: _____220_ Volts, _SINGLE (1)_Phase, __60__Hz, __25__Amps.
  While installing make sure it's properly configured and connected by a qualified electrical technician.
- **DO NOT** by pass any of the safety circuits or safety features designed into this equipment.

- ALWAYS turn off **power and pneumatics** before performing repairs.
- The doors on all electrical enclosures must be closed. All covers on labeling heads must be on labeling heads. (if applicable)

- This device is built to perform in humid conditions, but must not be pressure washed. Wiping down the device is the recommended cleaning method.

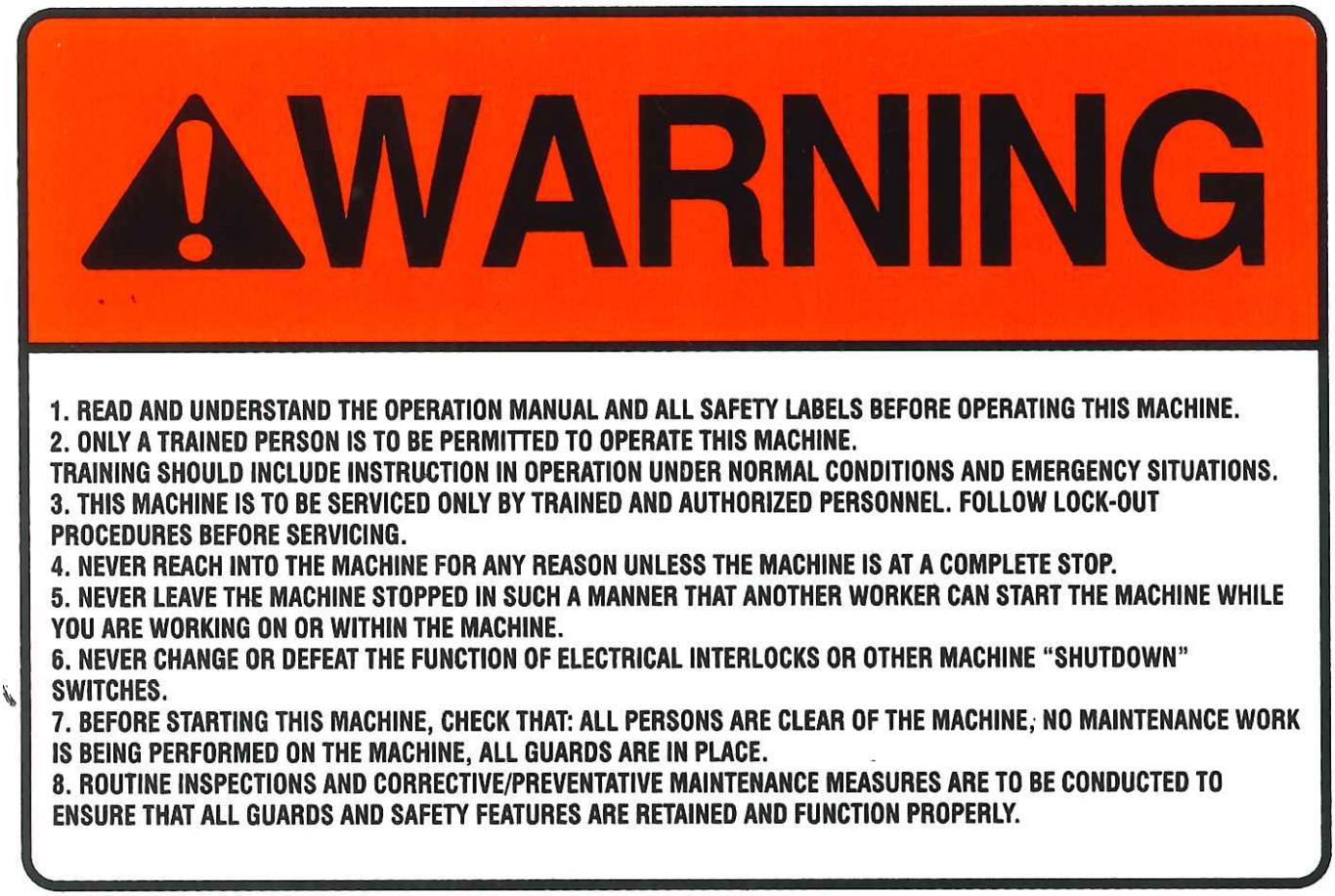
- Do not stand, sit, or allow any personnel to be within reach of the tamp cylinder/ swing arm activation (if so equip).
- Report any malfunctions, or problems with the equipment to qualified maintenance personnel for repair or adjustments that may be required.
- Keep hands clear of moving parts. Do not place hands near labeling head when in operation.

For systems containing conveyors, you must be vigilant with loose clothing or bodily parts as they can get caught in the conveyor's belt or chains as direct injury or death can incur. **DO NOT** use the conveyor as a working platform or walkway.

TUCK IN ANY LOOSE CLOTHING. DO NOT WEAR TIES. PENDANTS, JEWLERY OR ANY OTHER ARTICLE OF CLOTHING OR ACCESSORY THAT MAY GET CAUGHT ON ANY PORTION OF THE SYSTEM.

FOR PROLINE SYSTEMS ONLY

CASTERS WERE IMPLEMENTED FOR EASE OF SHIPPING PURPOSES ONLY. PLEASE USE CAUTION WHEN MOVING PROLINE THROUGH FACILITY. THE PROLINE RECOMMENDED USE: SET IN PLACE/POSITION WITH LEVELING PADS DOWN TO SECURE.



Using VFDs On GFCI Devices

By Bill Szatkiewicz, Senior Software Engineer
KB Electronics
for more information, email: info@kbelectronics.net
or visit: www.kbelectronics.com

The National Electrical Code, or NEC, continues to expand protection requirements for safety reasons resulting in an increase in Ground-Fault Circuit-Interrupter (GFCI) outlets being used in more environments. As a result, the Variable Frequency Drives (VFDs) industry is finding more instances of VFDs being powered from GFCIs. VFDs introduce high frequency harmonic content which may cause nuisance tripping on some GFCI devices. This paper is intended to assist anyone that needs to use a VFD on a circuit with GFCI protection. KB Electronics has developed special VFDs suitable for use with most GFCIs*.
* Please contact KB Electronics with information regarding your specific GFCI.

What is a VFD?

A VFD (also termed adjustable frequency drive, variable speed drive, AC drive, adjustable speed drive, micro drive, motor control, or inverter drive) is a power conversion device that will accept normal fixed branch circuit voltage of (115V or 230V) and frequency (50 Hz or 60 Hz) and allow the operator to control the speed of an induction motor (AC Motor) by varying the output voltage and frequency. A simplistic version of a typical VFD system is shown in Figure-1.

In addition to operator controllability, the VFD with soft start/stop features offers extended equipment life, increased performance, reduced maintenance, protection from excessive currents and voltages, as well as energy savings.

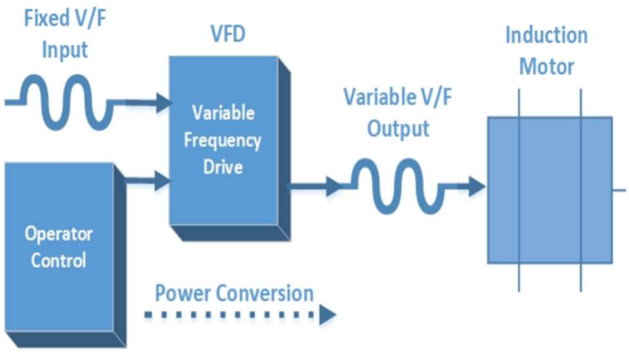


Figure-1: Typical VFD System

What is a GFCI?

A GFCI (shown in Figure-2) is a circuit breaker device which is designed to protect people from hazardous shock or electrocution by shutting off an electric power circuit when it detects current flowing in a way that it is not meant to, such as through water or a person.

Figure-2: Typical GFCI Outlet

The GFCI is intended to protect people from electrical shock, therefore, it is completely different from a fuse in the sense that it needs to shut off the electric power circuit at a low current, typically no more than 5 mA, in a quick amount of time (less than 1/10 of a second).

The GFCI does this by measuring and comparing the amount of current flowing in the ungrounded (hot) and grounded (neutral) conductors of the circuit. If the GFCI detects an imbalance in the circuit, it immediately shuts off the circuit.

Why Nuisance Trips Occur with Standard VFDs

Standard VFDs, when powered from GFCI outlets, can cause the GFCI to trip due to the leakage currents generated from the high switching frequency of the VFD's power devices and the harmonics associated with them. These high frequency leakage currents are not at the base frequency of the drive output which is normally 50 Hz or 60 Hz. These high frequency leakage currents, typically greater than 4 kHz, may cause the GFCI to trip because the GFCI is designed to work with 50 Hz or 60 Hz frequency inputs, not this higher value.

The high switching frequency of the VFD's power devices induce more capacitive-coupled currents, since a capacitor approximates a short circuit at high frequencies. This creates common-mode noise, referred to as leakage current, which travels through ground and can cause the GFCI to trip. The path to ground is made through the motor bearings or auxiliary equipment bearings.

In addition to the high switching frequency of the drive, there can be many other contributing factors which cause the GFCI to trip. Some drives have built-in filters which couple additional leakage current to earth ground. Other drives use external filters and replacing them with a low leakage filter may help.

One way to help determine if the GFCI tripping is occurring from the input filter or the VFD output is to remove either the input filter or the motor and observe if the GFCI still trips. For example, if the input filter is easily removed and doing so prevents the GFCI from tripping, the source of the leakage currents tripping the GFCI was largely from the input filter.

Another method is to disconnect the motor. If doing so prevents the GFCI from tripping the contributing source of leakage current is most likely from the output stage of the VFD. However, most often than not, the GFCI is tripping from a combination of the two and improvements on both the input and output will help.

Long motor power cables can also create noise spikes. These long leads add more capacitance which increases noise spikes from the fast switching power devices of the VFD. Use a VFD rated cable with the shortest leads possible when connecting the motor power cables. A choke on the VFD's motor outputs may help reduce noise spikes.

In addition, ensure that motor cables are properly shielded, sized, routed, terminated, and grounded at both the motor and drive.

KB's GFCI Solution

KB's engineering team has studied VFDs powered from a variety of GFCI devices. A solution has been created which considers all contributing factors to get a best-case scenario that successfully works with most GFCIs.

KB investigated switching frequencies and developed custom switching frequency algorithms to reduce audible noise and leakage currents. High frequency noise spikes and ringing were reduced by modifying our proprietary power circuits for optimal results. In addition, output chokes, low leakage filters, and shielded cable were introduced, if needed, to find a GFCI solution.

Conclusion

KB has had great success providing VFDs that work with GFCIs for numerous original equipment manufacturers (OEMs). KB offers a full range of motor controls (shown in Figure-3) which can be customized to work with GFCIs. Let KB Electronics provide a solution for you.

Figure-3: VFDs Available from KB Electronics

Unboxing & Installation of your

Quadrel Labeling Systems Machine

This section of your manual is aimed towards making the transition from Shipping Crate to Assembly line less Dramatic. If you have scheduled an install with one of our Professional Technicians the set-up of your machine will be a breeze. If not your manual as all of the information needed to get you going. In this section there may be some equipment shown that does not apply to the machine you purchased.

NOTE This is general instruction for all equipment (your equipment may vary slightly).

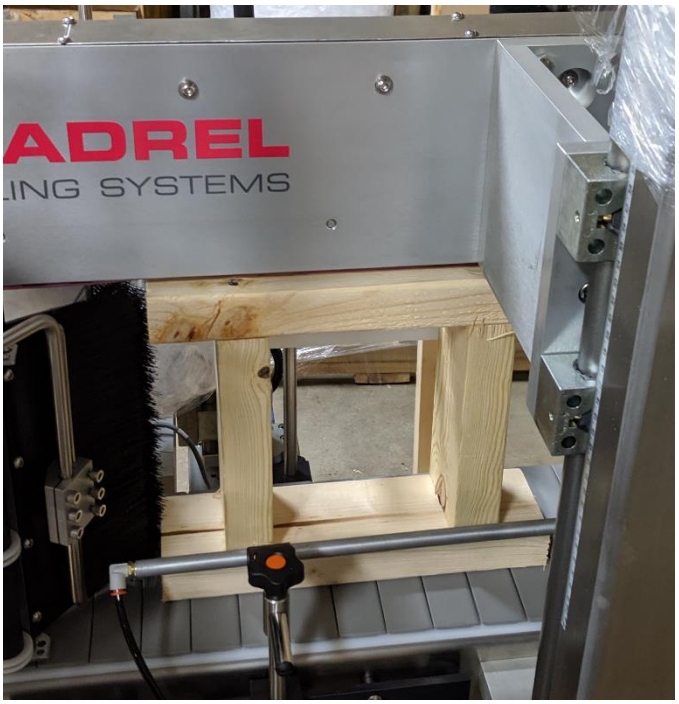
Let's get started…

First things first, check your crate/box/machine for damage. If there is damage please note the exception and contact Quadrel immediately. Any extra boxes or pallets will be either in your crate or tethered to the crate or pallet. Once you have inspected your shipment you can open the crate. Check packing slip Bill of lading against boxes received. Notify Quadrel of any discrepancies.

Carefully remove all banding on the legs, misc. boxes and assemblies in the crate or on the pallet. If your machine is wrapped in bubble wrap or plastic wrap go ahead and carefully cut and remove that as well. Ensure you are wearing the appropriate safety gear when removing your machine from the crate.

Ensure all plastic wrap is removed from the assembly you are removing the support from before removing the support.

Remove the supports under your labeling heads, wrap station, top trap, HMI, Pacing wheel or belt. See images for various supported assemblies.



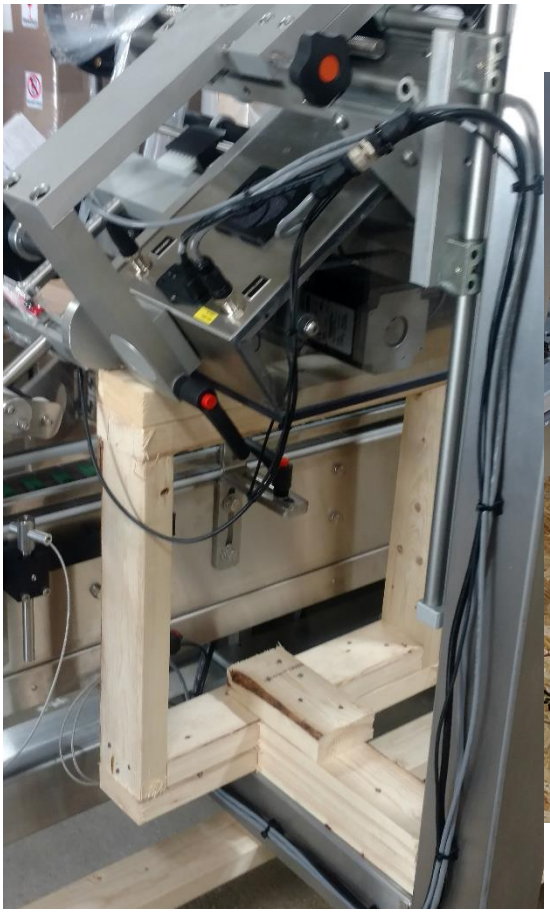
Most assemblies supported have a tool-less vertical adjustment using a knob or hand wheel.

The hand wheel may be wrapped to the assembly to prevent damage.

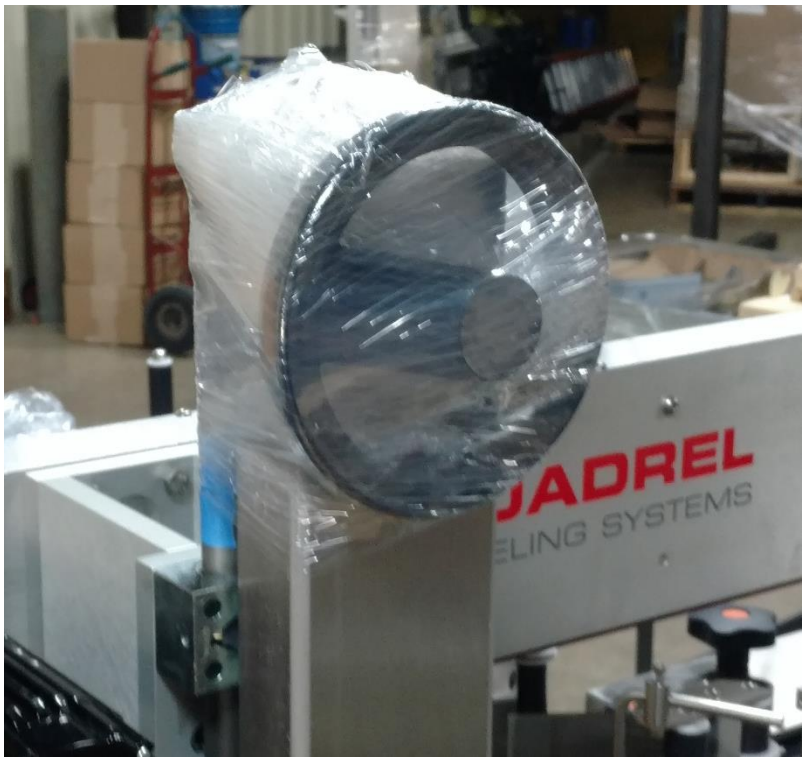
Remove the hand wheel from the wrap, then fasten the hand wheel to the square end on the lead screw using a 3/32 “L” handle Allen wrench.

Turn the handle/knob to raise the assembly this will take the weight off the supports so you can remove them.

Top Trap Support (top) Labeler Head Support (bottom) Plastic wrapped hand wheel (right)



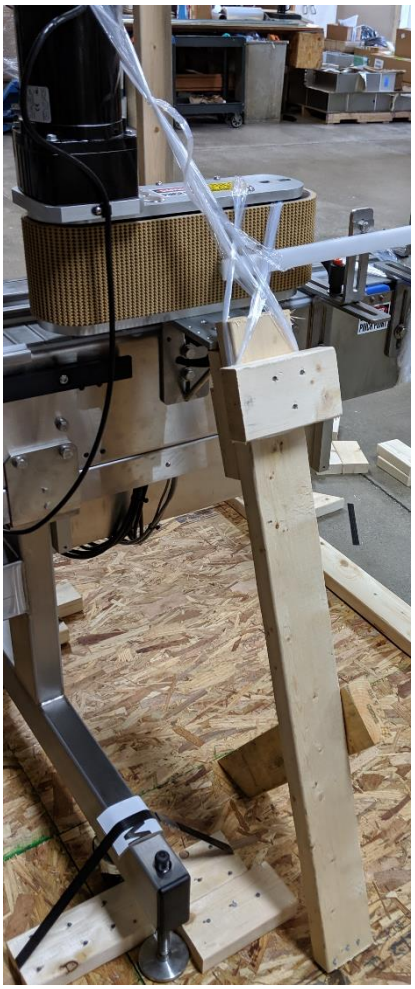
All top and bottom labeling heads will be supported



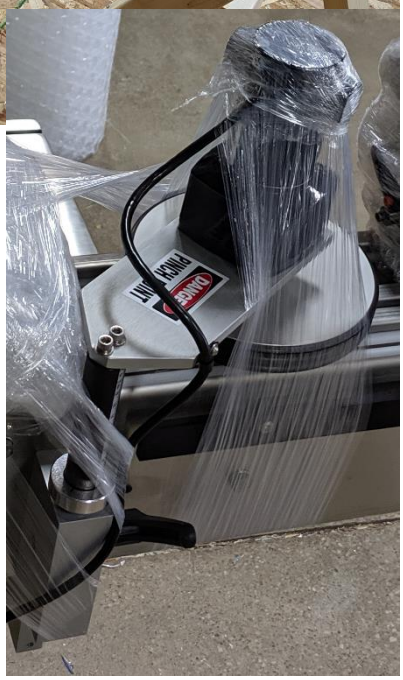
similar to the image shown on the left.

Wrap stations will have supports similar to the image to the right. These supports do not require moving the assembly.

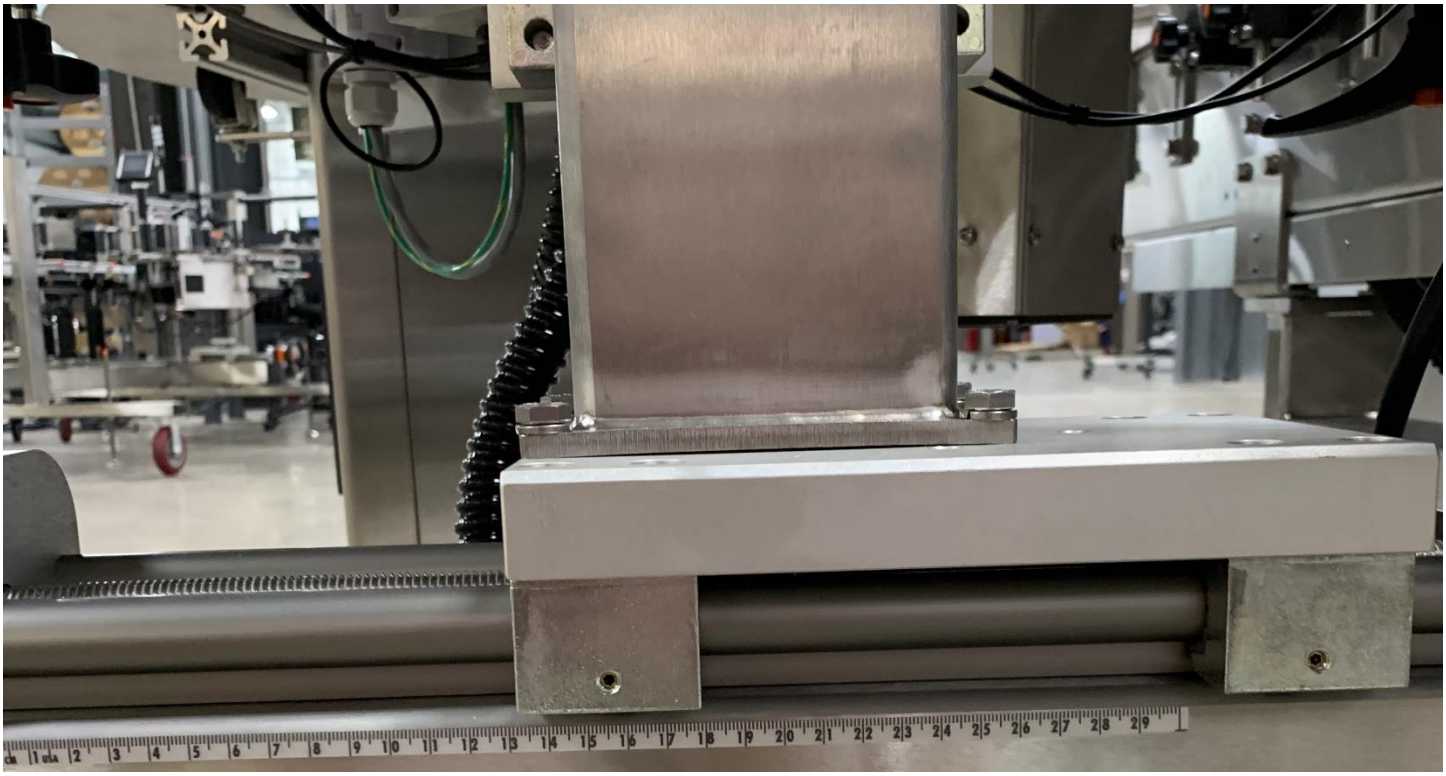
Pacing belt assembly supports can be removed will be without raising the assembly.



Pacing wheels supported as shown



Often the head support will be moved in shipping or moved to be supported. When you are setting up your machine refer to your set up sheet in this manual. There are scales on the side of the assembly to line the carriage up to (as shown in the Image to the left and below).



Peel plates with or without the rods may be removed from the labeling head to move the head all the way in during shipping.

All assemblies removed will be bubble wrapped then plastic wrapped to the machine (as shown in image on the right) or in box on the pallet the machine is on (as shown in image below).

Mount the peel plate assembly using a 5/16 L handle Allen wrench (as shown in image on the left). The bolts are located in the assembly. You simply put the wrench in the quick change access holes to loosen or tighten the assembly.

NOTE When you are setting up your machine make sure the peel plate assembly is perpendicular to the conveyor. When the peel plate assembly is on the rods there is a small amount of play allowing you to make small adjustments to the assembly.

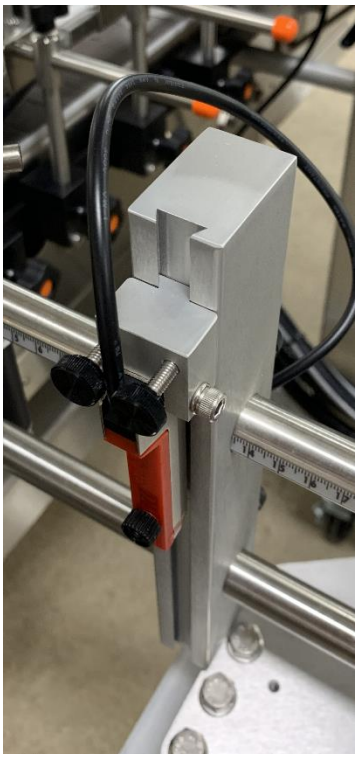
If you have the peel plate rods removed with the peel plate assembly and the label detect assembly (as shown below).

All assemblies removed will be bubble wrapped then plastic wrapped to the machine or in box on the pallet the machine is on.

First back the head out all the way. Locate your peel plate assembly and slide it into the holes in the drive roll assembly (as shown on the left of the image above). Make sure you take the bolts out of the end of the rods before putting them into the drive roll assembly.

Fasten the assembly to the drive roll with the bolts supplied using a 5/16 L handle Allen wrench. Make sure you have the lock washers on the bolts.

NOTE When you are setting up your machine make sure the peel plate assembly is perpendicular to the conveyor. When the peel plate assembly is on the rods there is a small amount of play allowing you to make small adjustments to the assembly.



When the peel plate rods are removed the label detect sensor is removed with it (show in image to the left). The sensor is locked into place so it won't move or need adjusted. All that will need done is simply reconnect the sensor to the zip port. To re-connect the sensor first locate the zip port (as shown in image on the right). The zip port is located under the head on the chassis or mounting plate. Take the cable coming from the sensor, route it neatly under the head, and screw it into the zip port where it says "label detect".

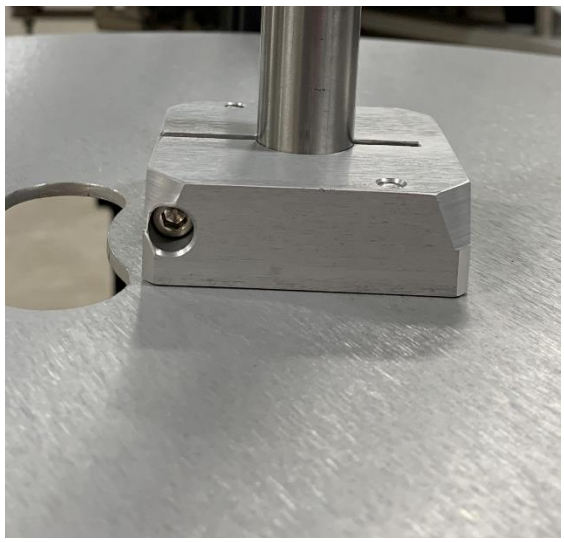
Some machines may have the unwind flange (shown in image to the right) removed to protect the flange during shipping do to the width of the machine.

All assemblies removed will be bubble wrapped then plastic wrapped to the machine or in box on the pallet the machine is on.

First, slide the unwind flange (with the collar facing towards you as shown in image to the right) over the unwind shaft. Make sure the top of the flange is 1 ¼ inches off the side plate.

Then, lock into place by tightening the collar with a 5/32 L handle Allen wrench.

Slide the quick lock collar over the shaft by lining the set screw up with the flat. The collar locks into place by rotating the collar 90 degrees.



Some machines may have the rewind flange (shown in image to the right) removed to protect the flange during shipping do to the width of the machine.

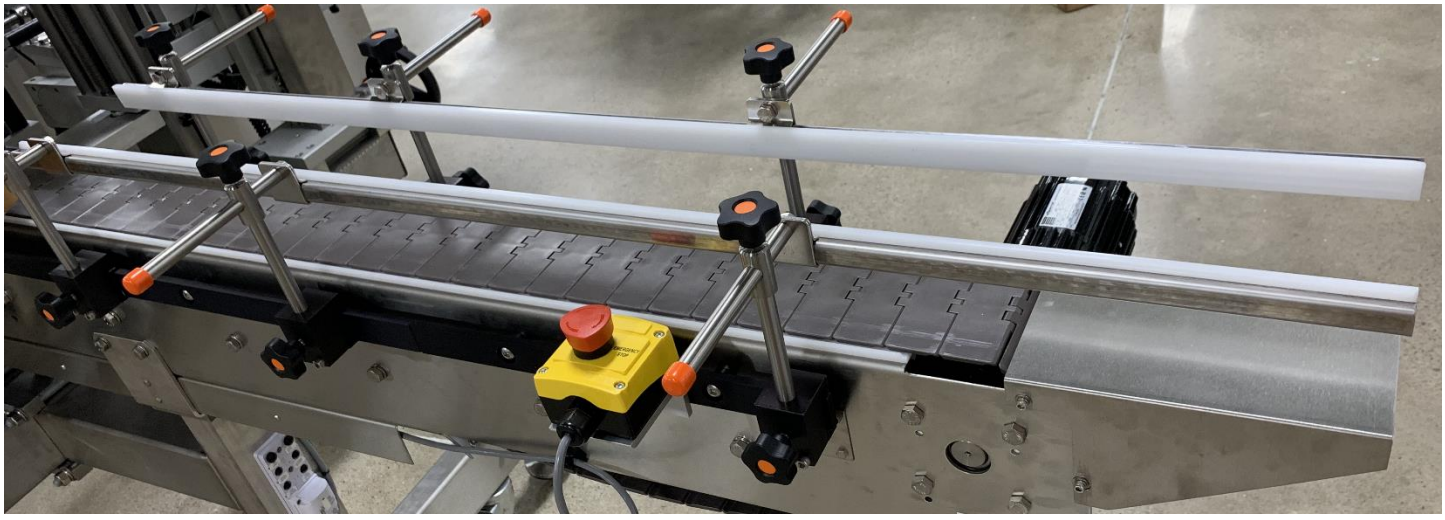
All assemblies removed will be bubble wrapped then plastic wrapped to the machine or in box on the pallet the machine is on.

First, slide the rewind flange (with the collar facing away from you as shown in image to the right) over the rewind hub make sure the flange just above the rubber bumper roughly 1/2 inch off the side plate.

Then, lock into place by tightening the collar with a 5/32 L handle Allen wrench.

Rails and transfers on the infeed and outfeed may be removed for shipping purposes. They will be wrapped in bubble wrap and wrapped to the machine. Carefully remove wrap and place in position as shown lock into place by tightening the knobs or ratchet handles.

NOTE Your machine may have a different rail system either adjustment is tool-less and fastened by a knob of ratchet handle.



End transfers will be wrapped in bubble wrap and plastic wrap. They will be located in a box on the pallet with your machine or wrapped to the machine itself.

Fasten the end transfer plate to the machine using a 5/32 L handle Allen wrench and the supplied 10-32 socket head screws. Ensure the transfer plate is both level with the conveyor and DOES NOT hit the conveyor chain.

Stack lamps are usually placed at the highest point of the machine and for that reason they are either removed or rotated 180 degrees. The stack lamp will wrapped in bubble wrap and wrapped to the machine.

If the stack lamp is rotated then all you need to do is remove one of the bolts, rotate the stack lamp and put the screw back in. We use various screws on stack lamps you will need one of the following tools for the job.

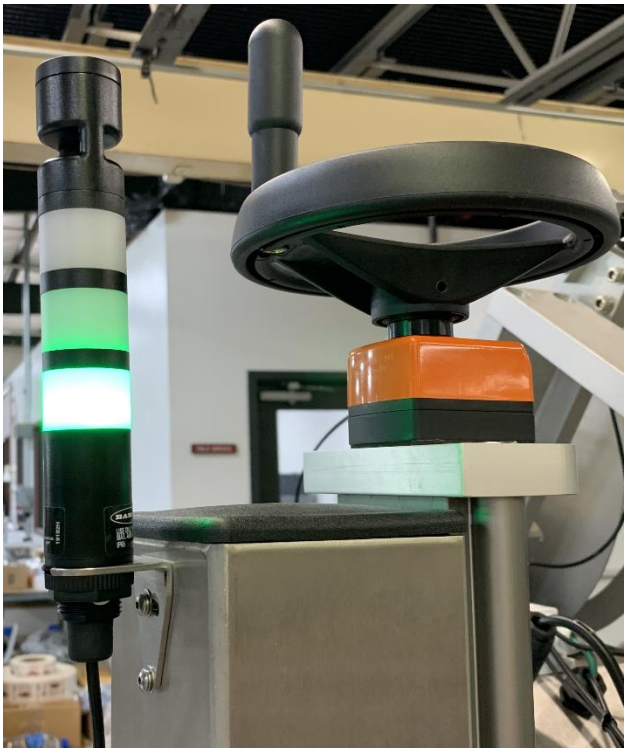
-3/32 L handle Allen wrench

-1/8 L handle Allen wrench

-5/32 L handle Allen wrench

-3/16 L handle Allen wrench

-1/2 open end wrench



HMI over head touch screen displays may be laid flat across the top of the enclosure wrapped in bubble wrap and plastic wrap.

Carefully remove the plastic wrap and bubble wrap.

Rotate the HMI 90 degrees and slide into the mount on the enclosure.

Fasten the pole in place by tightening the 2 set screws on the mount with a 6MM L handle Allen wrench.

The HMI may be enclosed in a wooden support off the enclosure to hold it in place during shipping.

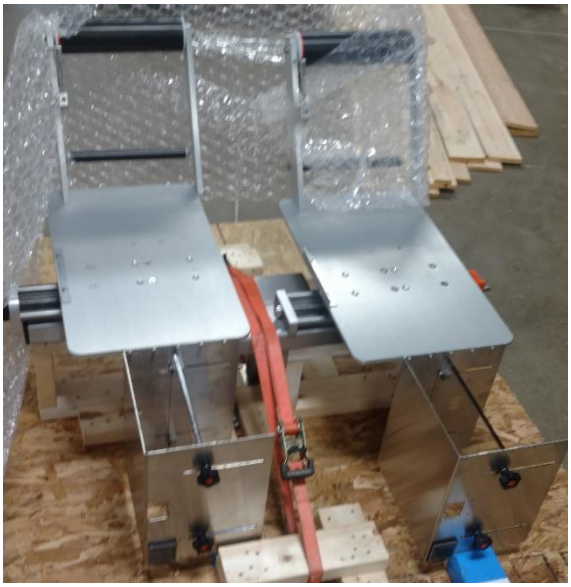
If HMI is located remotely off the enclosure it will still be supported during shipping.

If so, carefully remove the supports and you are done.

All printers, printer controllers and lasers are removed from the machine when shipping and placed in the manufacturer's box. The cabling will remain on the machine for ease of installation.

The printer is mounted to the printer mount with 1 ¼-20 ratchet handle. Make sure you line up the indents in the plates with the brass nut on the threaded rod. Then slide the ratchet handle through the center of all of the blocks and tighten. Plug in the cables and you are done.

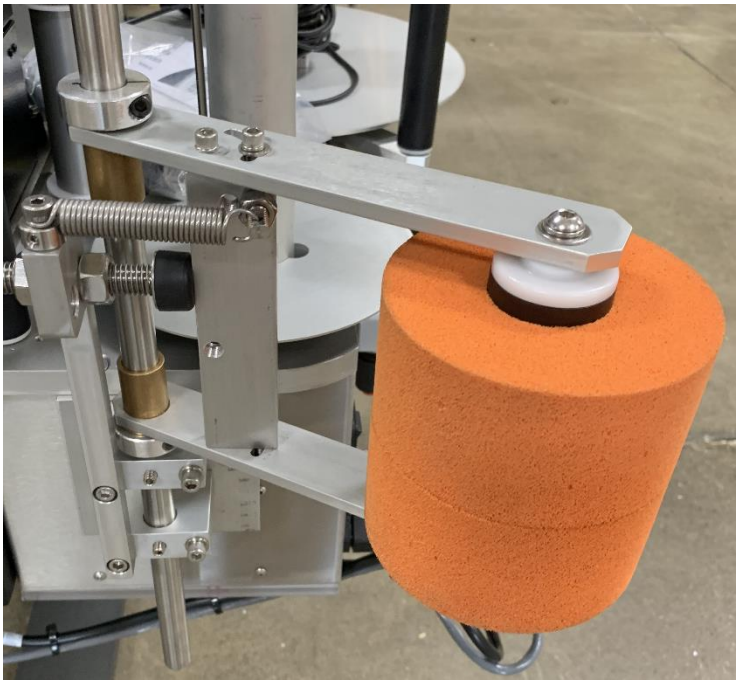
Table top printers with printer tables will ship in separate boxes or pallets (as shown to the left) the printer will be disconnected and placed in the manufacturer's box. The table will either get banded to the pallet with the machine or a separate pallet tethered to the machine pallet. Printer tables may be connected to the machine via weldment or a remote from machine. If you have a weldment connected table, refer to the lay out drawing of your machine in this manual. Fasten the weldment to the frame of the conveyor using the supplied hardware and an open end wrench. If the table is remote then move into the desired position referring to your layout drawing. Remove the printer from the box set on the table and plug in the pre-wired connectors.



Print and apply printers will be removed from the labeling head as well and placed in the manufacturer's box. Your labeling head will likely ship in its own boxes with a few of the assemblies or flanges removed. Occasionally your head on a stand will ship on a framed pallet which will requires little work to get started.

The unwind flange is installed like the previous one discussed previously.

Remove the printer from the box and place it into the opening of the labeling head (as shown in image to the right). Fasten the printer to the side plate of the labeling head using the supplied (5) 10-32 socket head screws and a 5/32 L handle Allen wrench. Then, plug the printer in.

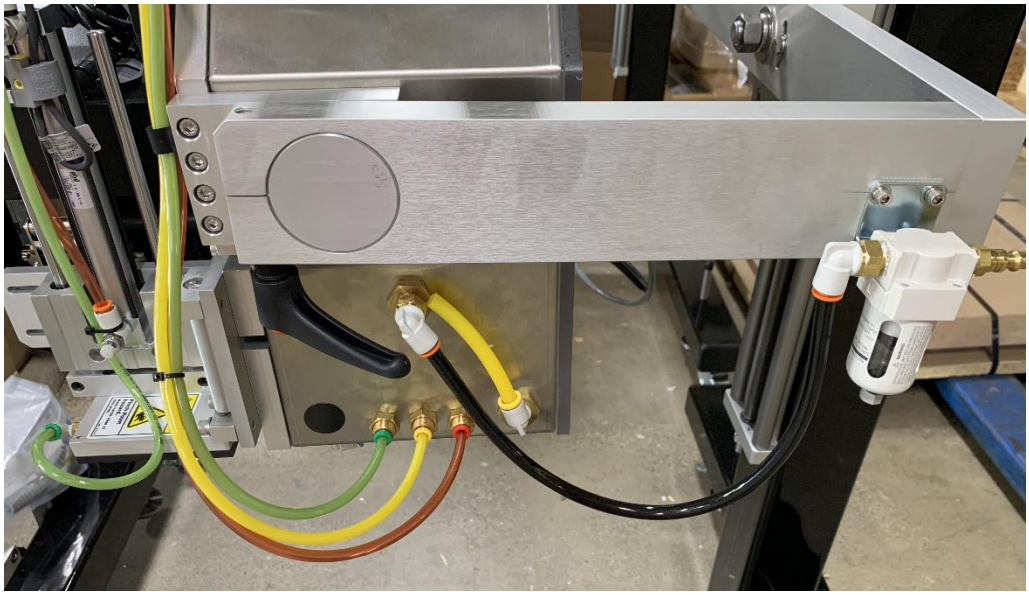


The corner wrap modules will be removed for shipping purposes. They will be wrapped in bubble wrap, plastic wrap, and placed into the box with the labeler.

Take out of the box, carefully remove the wrapping.

Then mount to the labeling head with (4) ¼-20 bolts using a 3/16 L handle Allen wrench.

To prevent kinking of the air lines during shipping on our q34 print and apply labeling heads. All lines are pulled and labeled to the corresponding color. The hoses are color coded and marked. Simply plug in hose into the matching color (as shown in image to the right).



Rotary accumulation tables are banded to a pallet and wrapped.

These tables usually operate independently to the machine.

Carefully un-band and unwrap the table.

Line it up to the transfer plate on the conveyor.

Level the table using the leveling pads.

Plus in and adjust speed through the control box.

Sleeving applicators are typically on a stand and will ship on a pallet. They will be banded have many supports and be wrapped to protect the machine during the shipping process.

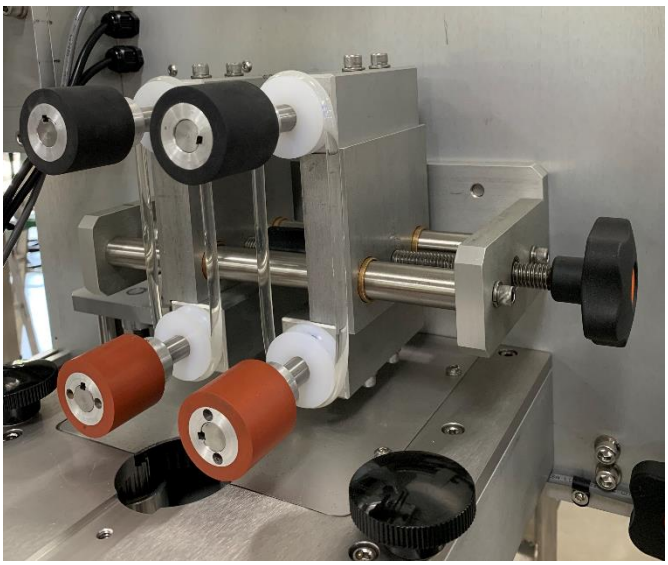
Carefully remove the banding and wrapping.

Raise the head and remove the supports.

The pallet will contain boxes with. Misc assemblies and or parts (ie mandrels).

Below is an image of the mandrel. The mandrel is the most precise and important part of the sleever system. Always handle the mandrel extremely carefully.

Your mandrel will be located on the machine pallet tethered to the machine. It will be wrapped and in a box or tube (as shown below).



Carefully remove the mandrel from the packaging.

Rotate the black handle to move the throw down rollers apart far enough to slide the mandrel in.

Ensure each roller is between 2 bearings, the fin on the top is between the sensor, and the cutter blades are in line with the cut in the mandrel.

Rotate the black handle to move the throw down rollers closer to the mandrel pinching it in the middle. DO NOT OVER TIGHTEN THE THROW DOWN ROLLERS INTO THE MANDREL. They need to be just tight enough that the bearing spins and a label feeds through.

Proline machines with guarding will either be left on the machine and have wooden supports to protect during shipping or the guards are removed and places on a pallet.

If the guarding has supports carefully remove the supports from the guarding.

If the guarding is removed from the machine each panel will be labeled and the machine will be labeled to make it easy to figure out which door goes where.

The doors are fastened to the frame of the machine with the supplied hardware.

Line the hinges up to the holes on the frame put the bolt through.

Tighten a nut on the opposite end with the supplied flat and lock washer.

During shipment if the conveyor gets skewed you may need to re-square it. First check the conveyor with a square to verify (as shown in images below). If the conveyor needs adjusted, adjust the conveyor by slightly loosening the 4 bolts connecting the 2 sections on conveyor you would like to adjust (as shown in image to left).

Make your adjustments and check the top and side with a square. Placing a square across the top will check the squareness vertically. Placing a square along the side will check squareness horizontally.

When the conveyor is square tighten the bolts and you are all set.

When shipping a proline with an extended boom the dual swiveling elbows in the center of the boom get flipped 180 degrees to allow the machine to have enough over head clearance to ship safely (shown in image below).

Below are the instructions to flip the elbows to the correct configuration (as shown in image below)

Ensure the overhead controls are safely supported by a tow motor or at least 2 people so it does not fall when disconnecting the elbows.

Locate the 2 screws on the top and 2 screw on the bottom holding the prospective covers on.

With a t25 torx bit screw driver, loosen the 2 bolts holding the cover on the top and bottom.

With the cover off you can now access the 4 bolts holding each of the tubes in place.

Ensure the overhead enclosure is supported enough to hold for a few minutes while you loosen the bolts and flip the elbow.

Using a 6MM L handle Allen wrench loosen the 4 bolts on the top and bottom tube.

Quickly pull the tubes out and rotate the elbow as shown below.

BEFORE

AFTER

Slide the tubes in. the overhead enclosures elevation is going to change when flipping the elbows if you have it supported via tow motor you will have to raise it.

Fasten the 8 bolts with a 6MM L handle Allen wrench.

Fasten the covers to the top and bottom elbow using a T25 torx bit screw driver.

To the left shows the correct orientation of the dual elbow boom for the overhead enclosure.

If you have any questions please give our professional technicians a call.

HMI GUIDE

QUADREL
LABELING SYSTEMS

Operator Interface Guide

Techline Labeling System

For Use with Files 84219_v000

Allen Bradley Panel View Plus 1000 Touch Screen with Allen Bradley CompactLogix L306 PLC

General Overview:

The Operator interface communicates to one PLC through an Ethernet connection. The application file is stored in the terminal's internal memory area and is executed on power-up. The actual data written to any parameter is stored in the PLC and is saved in its battery backed-up memory area.

Table of Contents

Opening Splash Screen

Upon initial power up, the terminal will initialize and display a splash screen. Once this screen appears it sends a signal to the PLC to start executing logic.

Button / Indicator Reference:

Menu Navigation Buttons: Navigation buttons will be purple circles with white outlines and icons of the target screen. Some buttons will have text below them to identify the target screen.

Standard Buttons: Standard buttons are used to turn features on/off, reset faults, clear counters, or various other functions that require operator control. Toggle buttons will typically have icons to reflect the status of the function that is being toggled while momentary buttons like Resets are circular and do not change images/colors.
Many buttons and toggles may be password protected, which will appear differently if the current user does not have proper access.

Indicators: Status Indicators will be circular and will change color based on states. Mode indicators will be oval in shape and will change colors and texts based on states.

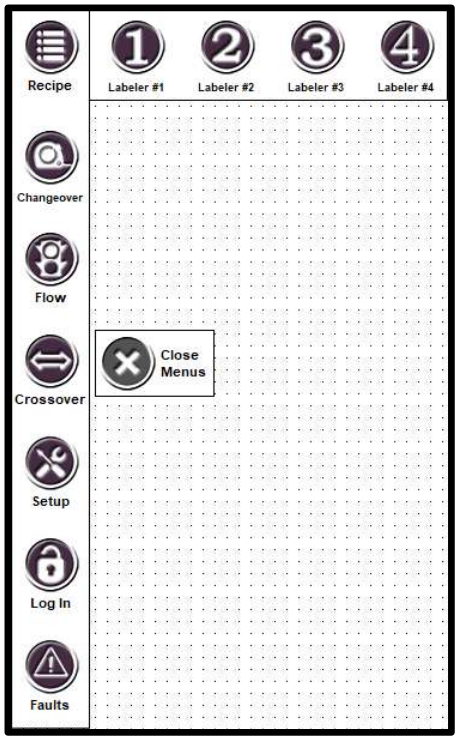
Numeric and Text Displays: Numbers or Text displays will have a light orange background with black text, surrounded by a dark orange border. These are used to reflect numbers or recipe descriptions.

Numeric and Text Inputs: If a number or text can be entered, the button will have a dark green background with white text. The right side of the button will have a touch icon signify that it is an entry box.

System Menus:

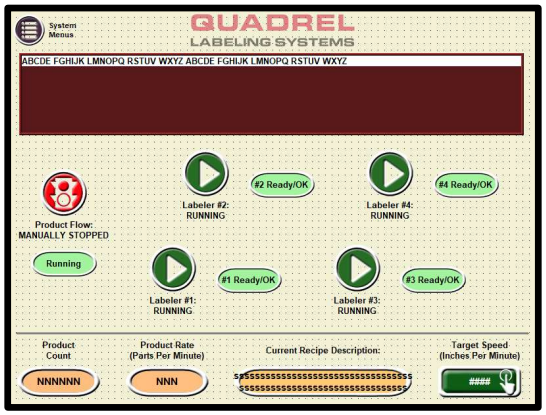
Pressing the System Menu button in the top left corner of the screen will cause the menus to appear as pictured below.

Press any button to navigate to that menu, or the Close Menus button to close the menu bar.



Main Screen:

After touching the splash screen, the touch screen will display the Main screen.
You can also get to the Main screen by pressing the Home icon (pictured left).



Menu/Setup Navigation Buttons:
These purple buttons across the top allow the operator to access the various screens that make up the entire touchscreen application. If you are currently on one of the screens, that screen's button will be green in color.

Fault/Message window:
Displays current alarms and status messages about the status of the labeling system.
The Faults Menu button can be used to display more messages or a history if needed. Pressing a reset button on the touch screen or physical button on the machine will clear these messages if the fault was remedied.

Labeler Run/Stop:
Each Labeler can be toggled between Run and Stop (pending fault conditions). The Run/Stop button will change colors and text based on the current status.

Green "Running" Button: This indicates the labeler is currently running and cannot be jogged. While running, the labeler will automatically apply labels to passing products. To **stop** the labeler, press this button.

Red "Stopped" Button: This indicates the labeler is currently stopped and may be jogged. While stopped, the labeler will ignore products passing by. To **run** the labeler, press this button.

Labeler Status Indicator:
The status indicator below the Run/Stop button will identify which fault state the labeler is in.
Ready/OK(green): The labeler has no fault conditions and may operate normally.
Warning (yellow): The labeler has a warning present (typically low on labels). The labeler may operate normally, but will require attention soon.
Faulted (red): The labeler has a fault on it that will prevent it from dispensing labels.
Disabled (grey): Each labeler can be disabled in the Labeler Service menu. Faults and functions will be ignored.
Crossing (purple): If a crossover is in progress, the indicator under the running labeler will turn purple and indicate which direction the crossover is occurring.

Product Rate (Parts Per Minute):
This indicator will reflect how many parts per minute are being labeled by the system. This number will average out over a period of time and may need at least 10 products in order to start calculating a rate.

Product Count:
This counter reflects how many Products have passed the first product detect sensor while either labeler is Running. This count can be reset in either Labeler Menu.

Current Recipe Description:
This display reflects the description for the currently selected recipe. Recipes are explained in the Recipe / Labeler Menu.

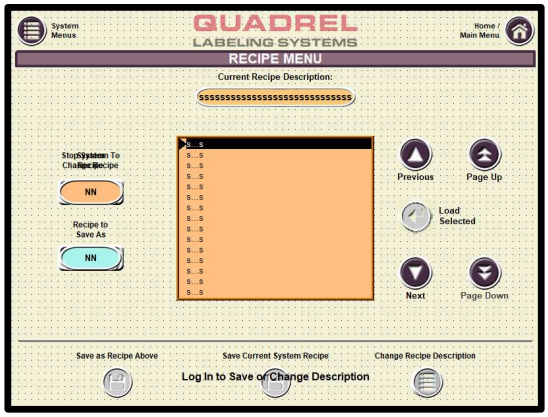
Target Speed:
This entry box will change the speed of the system. It is entered as Inches per Minute.

Product Flow Mode:

Green "Automatic" Button: Pressing this button will put the product flow into an automatic mode. The feedscrew/stop gate will stop/close and start/open based on the state of the system and any optional external sensors installed.

Red "Manually Stopped" Button: Pressing this button will stop the feedscrew/stop gate and keep them stopped/closed until placed into the Automatic mode.

Recipe Menu:



Current Recipe Description:
The description display at the top of the screen reflects the stored description for the recipe currently loaded.

Change Recipe Description (Supervisor Level): Pressing this button will allow the operator to change the current recipe description.
Note that the current recipe must be saved to retain the new description.

System Recipe (Load):
When the system is stopped, a new recipe number can be entered. When this number is changed, the newly entered recipe settings will automatically be loaded to the system.

Recipe to Save As (Supervisor Level):
Enter a target recipe to overwrite in this box. Note that the "Save As" button must be pressed in order to execute a save.

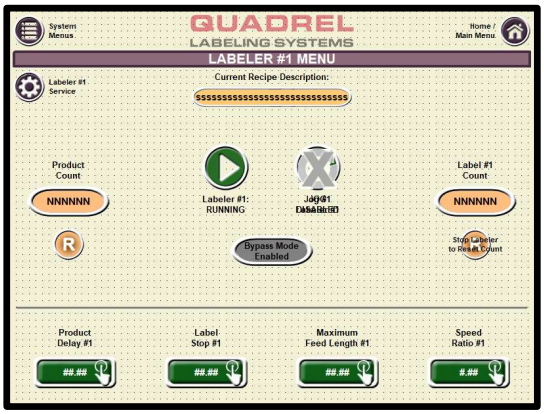
Save As Recipe Above (Supervisor Level): Pressing this button will save all current recipe values to the Recipe Number entered in the
"Recipe to Save As" box. Note that pressing this button will not change the system recipe, it only writes values to the target recipe.

Save Current System Recipe (Supervisor Level): Pressing this button will save all current recipe values to the currently loaded recipe.

Load Recipe by Description:
The center table shows the stored description for each recipe. The navigation buttons to the right of the table can be used to select descriptions. When
the desired recipe is highlighted, the "Load Selected" button must be pressed to load that recipe to the system.

Labeler Menu:

The Labeler Menu contains parameters related to dispensing labels on products.



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Disabled (grey): Each labeler can be disabled in the Labeler Service menu. Faults and functions will be ignored.
Crossing (purple): If a crossover is in progress, the indicator under the running labeler will turn purple and indicate which direction the crossover is occurring.

Product Count and Reset:
This counter reflects how many Products have passed the product detect sensor while any labeler is Running. The reset button below the counter will set this value to 0. The Product count and reset are global, so they will be identical on all labeler menus.

Labeler Jog:
When the Labeler is stopped, the Jog button becomes available. Pressing the Jog button will cause the labeler to dispense one label (pending proper threading and label gap detection). It is important to jog labels upon threading or changing over to verify the labeler is threaded and functioning properly.

Green "Jog" Button: This indicates the labeler can be jogged. Press this button to start a jog process. This button will be grey while the labeler is jogging.

Greyed out "Jog" Button: This indicates the labeler is currently running, and may not be manually jogged.

Label Count and Reset:
This counter reflects how many Labels have been dispensed when Jogging and Running. Pressing the reset button below the counter will set this value to 0.

Product Delay:
Product Delay (in inches) controls the point at which the labeler dispenses a label. A lower product delay value will cause the labeler to dispense "earlier" as the product passes by. A higher product delay value will cause the labeler to dispense "later" as the product passes.

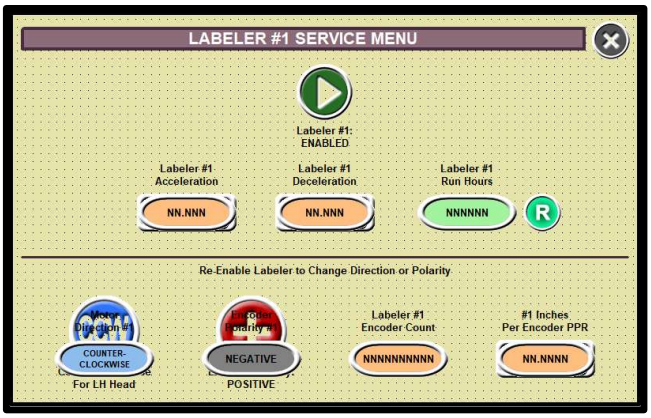
Label Stop:
Label Stop (in inches) controls the label's stop position. Typically, the label should stop with 1/8" to ¼" sticking off of the peel plate. A higher Label Stop will result in more label off of the peel plate.
Note that a high label stop can result in more than one label being dispensed at once.

Max Feed:
The Max Feed Length (in inches) determines how much of the liner will advance when no label division is detected by the Label Sensor. If this value is lower than the physical length of the label, poor label stop will result. This value is typically set to a value at least ¼" longer than the actual label length.

Labeler Speed Ratio:
Labeler Speed Ratio is the value that determines the speed of the labeler in relation to the conveyor belt.

Labeler Service Menu:

Each Labeler Service Menu contains parameters and toggles related to the Labeler that are not typically accessed on a regular basis. The Labeler Service Menu button is only visible when logged in.



Enable Button:
The Labeler can be Enabled and Disabled by using the toggle button in the middle of the screen.
Green "Enabled": This indicates the labeler drive is enabled. While enabled, the labeler may be jogged, placed into run, and will be monitored for faults.
Red "Disabled": This indicates the labeler is disabled. While disabled, the labeler drive roller will be free to spin so that any jams in the drive system can be cleared easily. Also, while disabled, the labeler will not jog or dispense labels when running. It is necessary to disable the labeler when clearing jams or changing settings found on this menu.

Acceleration and Deceleration (Supervisor Level):
These are the ramp values used by the labeler drive when dispensing labels while running. A lower value will result in a longer Acceleration or Deceleration rate.

Toggle the labeler from Stop to Run for new Ramp values to take effect.

Labeler Run Hours and Reset (Supervisor Level):
This counter will count the hours that the Labeler has been in the run mode while the conveyor is running. The reset button is only visible when logged in at the Supervisor Level.

Direction (Quadrel Level):
The Direction button sets the direction of the drive roller. This should be set at the factory and not need to be changed. Note that the drive must be re-enabled after changing the direction.

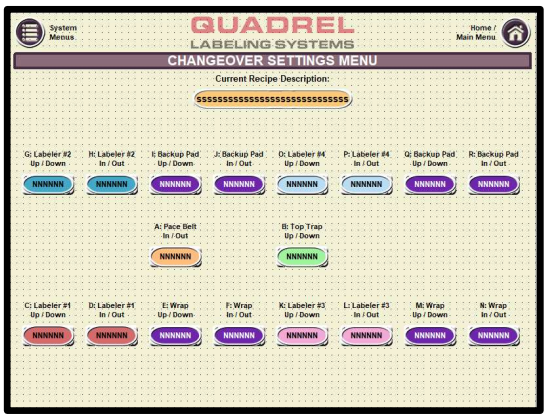
Polarity (Quadrel Level):
The polarity of the encoder count can be changed with this button. The encoder count must increment in a positive direction for the labeler to dispense labels while running. If the Encoder Count is counting in a negative direction, the Polarity button must be toggled. (note that the Polarity may not match the actual counting direction).

Encoder Count:
This is the current encoder count as interpreted by the Labeler drive. This value may not equal that of any other drives on the system.

Labeler Inches per Encoder PPR (Quadrel Level):
This value determines the dispensing speed of the labeler in relation to the encoder. This value will equal the inches of conveyor travel per encoder pulses listed on the encoder itself.

Re-enable the drive after changing the settings to properly take effect.

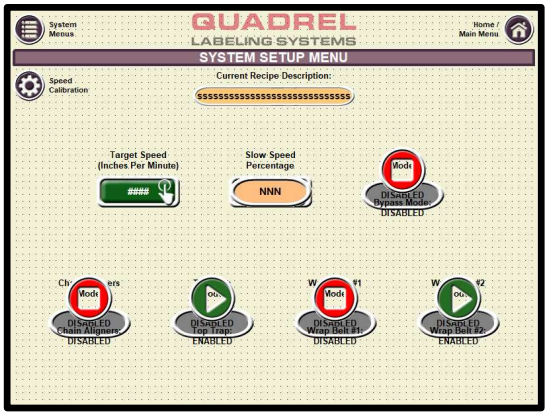
Changeover Menu:



The Changeover / Dial settings menu contains indicators that make changing over from one product to another easier. These values can only be changed when logged in at the Supervisor level.

System Setup Menu:

The System Setup Menu contains parameters and indicators related to the optional equipment and motors installed on the system.



Target Speed:
This entry box will change the speed of the system. It is entered as Inches per Minute.

Slow Speed Percentage (Maintenance Level):
When product flow is stopped, the System will run at a slower rate, which is a percentage of the Target Speed.

Bypass Mode (Supervisor Level):
Enabled: When the Bypass Mode is enabled, only the conveyor will be allowed to run. The top trap, chain aligners, wrap belts, and all labelers will be permanently disabled.
Disabled: When disabled, all motors will operate according to their respective toggles.

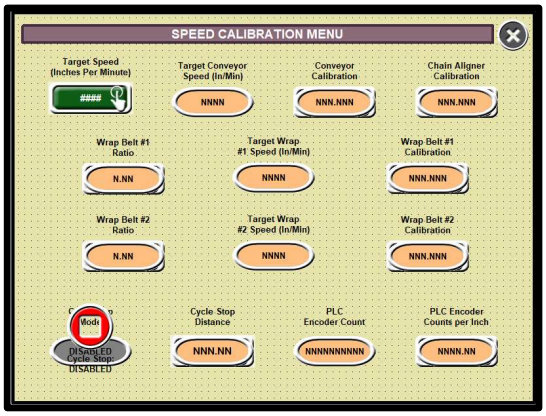
Chain Aligners Mode (Supervisor Level):
Enabled: When the Chain Aligners Mode is enabled, the chain aligners will be allowed to run.
Disabled: When disabled, the chain aligners will not run.

Top Trap Mode (Supervisor Level):
Enabled: When the Top Trap Mode is enabled, the top trap belt will be allowed to run.
Disabled: When disabled, the top trap belt will not run.

Wrap Belt Modes (Supervisor Level):
Enabled: When either Wrap Mode is enabled, the corresponding wrap belt will be allowed to run.
Disabled: When disabled, the wrap belt will not run.

Speed Calibration Menu:

The System Speed Menu contains parameters and indicators related to the linear speed of the system.



Target Speed:
This entry box will change the speed of the system. It is entered as Inches per Minute.

Target Conveyor Speed:
This indicator reflects the current target linear speed of the conveyor in Inches per Minute.

Conveyor Calibration (Supervisor Level):
This value allows the conveyor to run at the Target Main Conveyor speed. It is calibrated at the factory using a tachometer and should not be changed.

Chain Aligners Calibration (Supervisor Level):
This value allows the chain aligners to run at the Target Main Conveyor speed. It is calibrated at the factory using a tachometer and should not be changed.

Wrap Belt Ratios (Maintenance Level):
This entry box will change the speed of the corresponding wrap belt. The ratio in relationship to the conveyor speed, in Inches per minute. For example, a Wrap Belt Ratio of 1.00 means the wrap belt will travel at the same speed as the conveyor.

Target Wrap Belt Speed:
This indicator reflects the current target linear speed of the corresponding wrap belt in Inches per Minute. It is calculated by the Current Conveyor Speed x Wrap Belt Ratio.

Wrap Belt Calibrations (Supervisor Level):
This value allows the corresponding wrap belt to run at the Target Wrap Belt speed. It is calibrated at the factory using a tachometer and should not be changed.

Cycle Stop Mode (Supervisor Level):
Enabled: When the Cycle Stop Mode is enabled, the system will continue running for a set amount of conveyor travel when a fatal fault occurs or the stop button is pressed. This is used to purge products out of the system when stopping.
Disabled: When disabled, the system will immediately stop when requested.

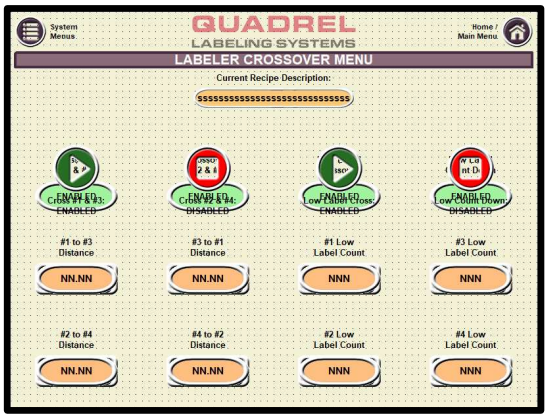
Cycle Stop Distance (Maintenance Level):
The Cycle Stop Distance is entered in inches and determines how long the cycle stop will be active when it is initiated.

PLC Encoder Count:
This indicator shows the encoder counts as received by the PLC.

PLC Encoder Counts per Inch (Quadrel Level):
This value tells the PLC how many encoder counts it receives for every inch of conveyor travel.

Crossover Menu:

The System Setup Menu contains shortcuts to the sub menus of the system and displays the status of any options.



Crossover Mode (Supervisor Level):
Enabled: When the Crossover is enabled the labelers will automatically run and stop based on fault conditions. For example, if the running labeler runs out of labels by the End of Web sensor being activated, the other labeler will start running (if it does not have a fault).
To manually switch labelers, simply press the **running** labeler button.
Disabled: When disabled, the labelers will function independently of each other. Note that any fault to a running labeler while Crossover is disabled will result in the machine stopping.

Distances (Supervisor Level):
When crossing over, the labelers will either remain running or stopped for a specified distance of conveyor travel. This distance is related to the relation of label lengths and product detect sensors to peel plates. Change these parameters to ensure that every product gets labeled during a changeover. For example, Labeler #1 runs out of labels and Labeler #2 takes over but starts running too late and misses 2 products. The operator would then look at the "1 to 2 Distance" and LOWER the number by at least 2 product pitch values. Now, Labeler #2 will start running earlier and should apply labels to all products on the next Crossover.

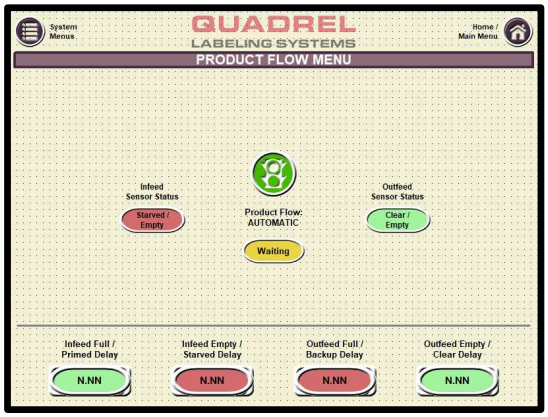
Low Label Mode (Supervisor Level):
A Crossover can be initiated from the low label sensor becoming active on either head when this is enabled.

Low Label Batch (Supervisor Level):
When a low label fault occurs, the system will start counting how many labels are fed out from the labeler. Once this count reaches the specified Low Label Count, a crossover will be triggered.

Low Label Count (Supervisor Level):
This is the amount of labels that will be counted if the Batch Mode is enabled.

Product Flow Menu:

The Product Flow Menu controls timers and values associated with allowing products to enter the system.



Product Flow Control:

The pacing system can be stopped independently of the main system in order to prevent products from flowing into the system. This can be useful during setup or to purge the system. A pacing system can be a feedscrew, pacing wheel, pacing belt, stop gate, or combination of listed items.

Green "Automatic" Button: This indicates the pacing system will stop and start the pacing system based on external conditions.

The Pacing System will stop/close when:

- The system is stopped
- The infeed sensor is not blocked by products or "starved".
- The outfeed sensor is blocked by products or "full".
- The Product Flow button has been toggled to "Stopped"
- A Cycle Stop is active

Red "Stopped" Button: This indicates the pacing system is stopped and will not allow products into the system until toggled back to Automatic.

Product Flow Status Indicator:
The indicator below the Product Flow Control button identifies the actual status of the pacing system.
Green: Running. The pacing system is currently allowing products into the system.
Yellow: Waiting. The system is running but the pacing system is stopped because of a condition listed above.
Red: Stopped. The pacing system has been stopped manually and will not function until placed in the Automatic Mode.

Infeed Starved / Empty Delay (Maintenance Level):
This timer will start when the Infeed sensor does NOT see products, which results in an Empty/Starved condition. After this timer expires, the product flow will stop.

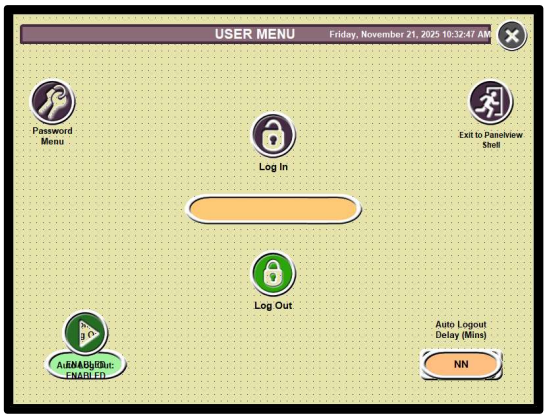
Infeed Primed/ Full Delay (Maintenance Level):
This timer will start when the Infeed sensor sees products, which results in an Primed/Full condition. After this timer expires, the product flow will start.

Outfeed Clear / Empty Delay (Maintenance Level):
This timer will start when the Outfeed sensor does NOT see products, which results in a Clear/Empty condition. After this timer expires, the product flow will start.

Outfeed Backup / Full Delay (Maintenance Level):
This timer will start when the Outfeed sensor sees products, which results in an Backed Up/Full condition. After this timer expires, the product flow will stop.

User Menu:

The User Menu enables alternate login levels to access protected screens and buttons. You can access this Menu by pressing the Lock icon (pictured left).



Log In: Press this button to enter a user password.

Log Out: Press this button to enter to log the current user out.

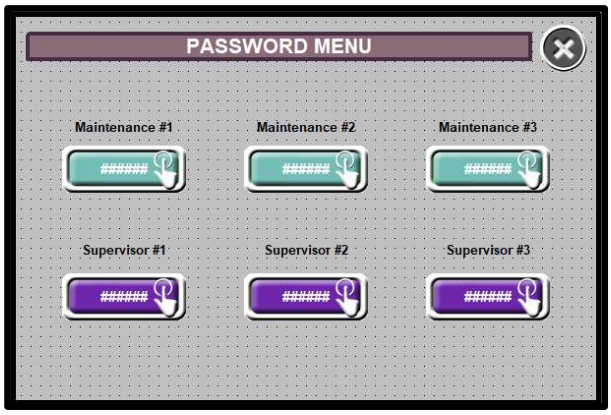
Password Menu: This will open up a security prompt before opening the password menu, where the passwords for the Maintenance and Supervisor levels are set.

Auto Log Out (Supervisor Level):
When Enabled (button will be Green), the logged in user will automatically be logged off at a set amount of time. Note that the system automatically enables the Auto Log Out feature upon startup.

Log Out Timer (Supervisor Level):
This timer (in minutes) determines the time it takes to log off a user if Auto Log Out is enabled.

Password Menu:

The Password Menu allows the creation and editing of the passwords for different security levels.



Maintenance:
There can be 3 user defined passwords for the Maintenance level. Note that there is one hard coded Maintenance Level password that cannot be viewed or changed.

Supervisor:
There can be 3 user defined passwords for the Supervisor level. Note that there is one hard coded Supervisor Level password that cannot be viewed or changed.

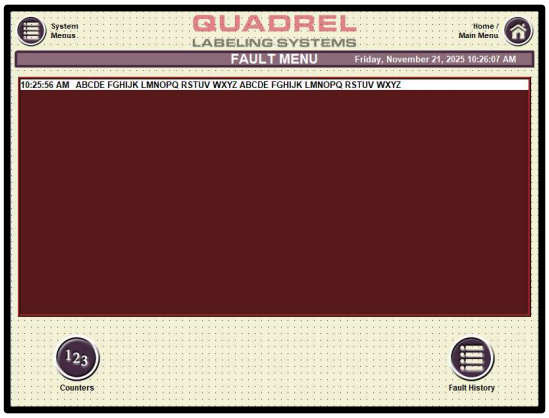
If a Maintenance and Supervisor password are the same, the system will log that user in at the Maintenance level.

The password(s) to open the Password Menu are stored in the HMI and cannot be modified. This will prevent any password loss in the event the PLC logic is altered.

Quadrel:
There is a hard coded Quadrel level password that cannot be viewed or changed. This is typically only used when a machine is first commissioned to set motor directions or global variables that do not change on a regular basis.

Fault Menu:

The Fault Menu displays all fault messages, shows system level counters, and gives access to a Fault History. You can access this Menu by pressing the Alert icon.

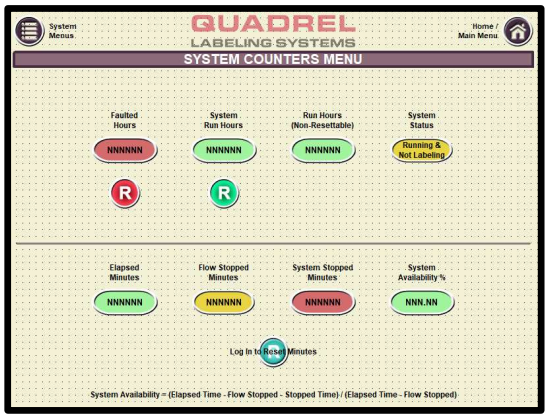


Fault Display:
The Fault dialog box will display all of the active faults on the machine.

Fault Reset:
Used to reset active faults displayed above.

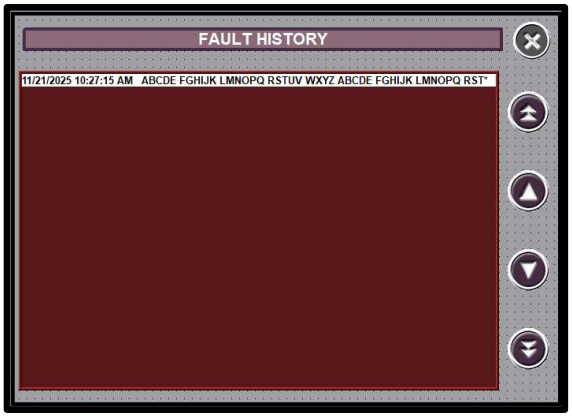
Counters Menus:

The Counters Menu shows system level counters and status indicators. Counters may be reset when logged in at the Supervisor level.



Fault History:

The Fault History will store the last 128 fault message events.



Fault Messages and Indicators:
Green Lamp:
Steady: The Green lamp will be steady while the system is running.

Amber Lamp:
Flash: The Amber lamp will flash while a warning is active on the system.

Red Lamp:
Flash: The Red lamp will flash while a fatal fault is active.

Buzzer: The Audible Alarm will long pulse (1 second) when a fatal fault is present. The buzzer will short pulse before the system starts.

Overhead Light Strip:
White: No faults are present on the system.
Amber Steady: A Labeler has an active warning.
Amber Flashing: A system warning is active (does not include the labeler warnings). Red Steady: A Labeler has an active fatal fault.
Red Flashing: A system fatal fault (does not include the labeler fatal faults).

Warning Messages: Warning messages identify a status or event that may need action soon. The machine will not stop from a warning message, but a warning may turn into a fatal fault that will stop the machine. Many warning messages will automatically clear once the problem is remedied.

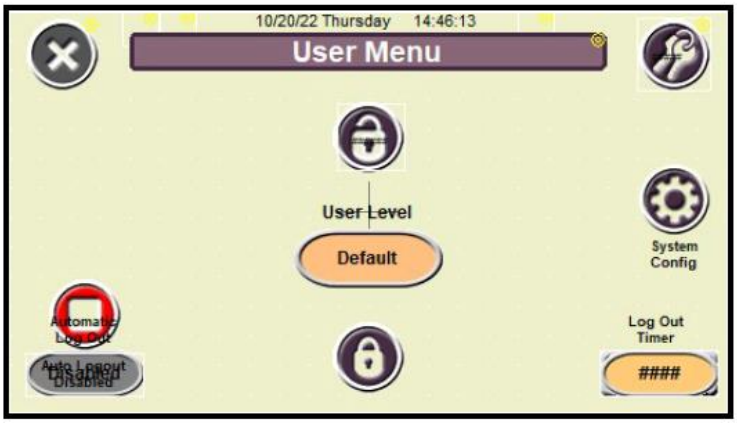
Fatal Messages: Fatal messages will cause the system to stop immediately or initiate a cycle stop. Fatal faults are typically associated to events that prevent labels being applied properly, safety related faults, or other events that may prevent proper machine operation.

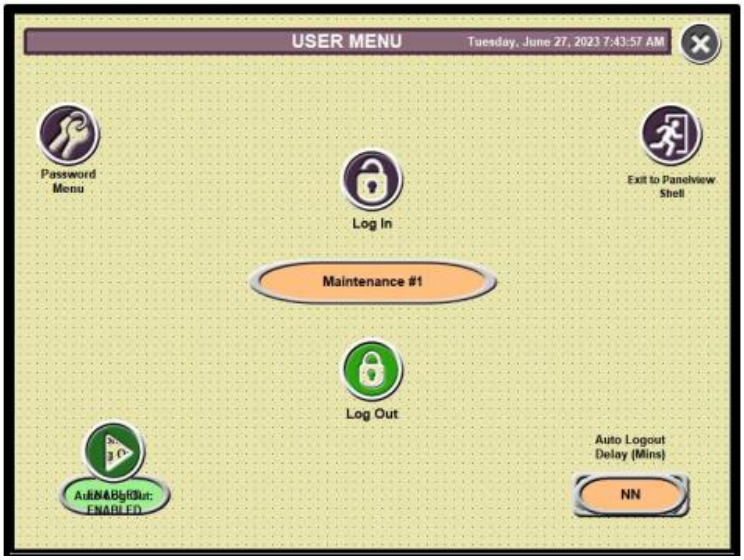
Messages	Cause/Solution
Warning Messages	
PLC Cycled without Screen. Restart System or Touch Screen	The PLC waits for a signal from the touch screen after power-up to verify communications before executing logic. If the PLC is cycled from power or downloading, the screen must be cycled as well.
Conveyor Drive (DR1) Faulted / Turned Off Warning	The drive that controls the conveyor motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Top Trap Drive (DR2) Faulted / Turned Off Warning	The drive that controls the top trap motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Wrap #1 Drive (DR3) Faulted / Turned Off Warning	The drive that controls the wrap #1 motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Wrap #2 Drive (DR4) Faulted / Turned Off Warning	The drive that controls the wrap #2 motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Conveyor Max Speed Command Reached. Check Calibration or Drive Settings	The maximum conveyor speed limit has been reached or exceeded. Verify proper target speed and conveyor calibration
Conveyor Max Linear Speed Reached. Rate Reduced to 50/min	The maximum conveyor speed limit has been reached or exceeded. Verify proper target speed and conveyor calibration
Cycle Stop in Progress. Please Wait or Press Stop	The machine is currently in a cycle stop and will stop once the cycle stop distance expires. Pressing the Stop button while a cycle stop is active will stop the machine immediately.
Infeed Empty / Starved. Product Flow Stopped	The Product Flow has stopped because the infeed sensor is not satisfied.
Outfeed Backed Up / Full. Product Flow Stopped	The Product Flow has stopped because the Outfeed sensor is not satisfied.
Labelers #1 and #3 Both Stopped. Place either in Run	When crossover is enabled, this message will alert the operator that one labeler must be placed into run before starting the system.

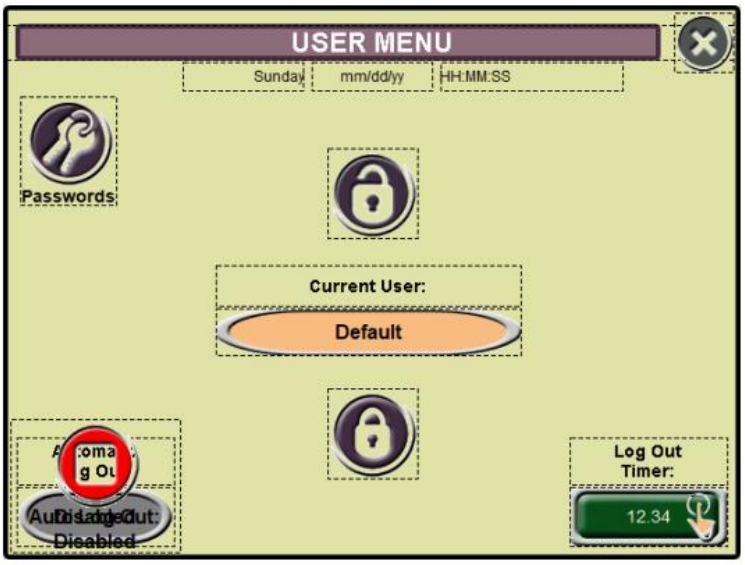
Labelers #2 and #4 Both Stopped. Place either in Run	When crossover is enabled, this message will alert the operator that one labeler must be placed into run before starting the system.
Wrap #1 Max Speed Command Reached. Check Calibration	The maximum wrap #1 speed limit has been reached or exceeded. Verify proper target speed and wrap belt #1 calibration.
Wrap #2 Max Speed Command Reached. Check Calibration	The maximum wrap #2 speed limit has been reached or exceeded. Verify proper target speed and wrap belt #2 calibration.
Chain Aligners Max Speed Command Reached. Check Calibration	The maximum chain aligners speed limit has been reached or exceeded. Verify proper target speed and chain aligners calibration.
Labeler #x Drive (DRx) Power Off / Faulted Warning	The drive that controls the listed labeler is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Labeler #x End of Web Warning. Correct Before Running.	The End Of Web sensor (between the drive system and unwind) on the Labeler is active and the Labeler is Stopped. Placing the Labeler into Run will generate a Fatal Fault.
Labeler #x Drive (DRx) Program Stopped Warning	The Broken Web sensor (between the drive system and rewind) on the Labeler is active and the Labeler is Stopped. Placing the Labeler into Run will generate a Fatal Fault.
Labeler #x Disabled. Navigate to Labeler #x Service Menu	The listed labeler has been disabled from its Service Menu. Re-Enable the drive before attempting to run it.
Labeler #1 Missing Label / Maximum Feed Length Reached	The labeler's drive has reported a maximum feed length movement while jogging. If there was no missing label on the web, ensure the "Max Feed Length" in the labeler menu is set to the proper value.
Labeler #1 Low Label Supply	The label supply on the labeler has been determined low by the sensor fiber under the flange.

Messages	Cause/Solution
Fatal Messages	
Safety Relay Active. Check E-Stops, Reset	The Safety relay has been activated by an Emergency Stop. Unlatch all Emergency Stops, close all doors, and press the Reset button to reset the safety relay.
Conveyor Drive (DR1) Faulted / Turned Off	The drive that controls the conveyor motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Top Trap Drive (DR2) Faulted / Turned Off	The drive that controls the top trap motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Wrap #1 Drive (DR3) Faulted / Turned Off	The drive that controls the wrap #1 motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Wrap #2 Drive (DR4) Faulted / Turned Off	The drive that controls the wrap #2 motor is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Encoder Signal Lost	The system was running but the PLC stopped receiving encoder counts. This can be from a faulty encoder, wiring, or conveyor drive.
Crossover from #1 to #3 Timed Out. Check Distance & Encoder	The crossover from Labeler #1 to Labeler #3 took too long to complete. Check crossover distance values and PLC Encoder Counts per Inch value.
Crossover from #2 to #4 Timed Out. Check Distance & Encoder	The crossover from Labeler #2 to Labeler #4 took too long to complete. Check crossover distance values and PLC Encoder Counts per Inch value.
Labeler #1 Not Ready for Crossover	The listed labeler was already in a fault / warning state when a crossover to that labeler was requested.
Labeler #2 Not Ready for Crossover	The listed labeler was already in a fault / warning state when a crossover to that labeler was requested.
Labeler #3 Not Ready for Crossover	The listed labeler was already in a fault / warning state when a crossover to that labeler was requested.
Labeler #4 Not Ready for Crossover	The listed labeler was already in a fault / warning state when a crossover to that labeler was requested.
Labelers #1 and #3 Both Stopped Fault	Both of the listed labelers were in “stop” mode, the crossover function is enabled, and the conveyor was requested to run.
Labelers #2 and #4 Both Stopped Fault	Both of the listed labelers were in “stop” mode, the crossover function is enabled, and the conveyor was requested to run.
PLC Faulted	The PLC has become faulted. If resetting power to the system does not clear this fault, contact Quadrel technical support.
Labeler #x Drive (DRx) Power Off / Faulted	The drive that controls the listed labeler is faulted or turned off. If pressing the reset button does not clear this message, verify that the drive is powered up.
Labeler #x End of Web Fault	The End of Web sensor (between the drive system and rewind) on the Labeler is active and the Labeler was Running or placed into Run.
Labeler #x Broken Web Fault	The Broken Web sensor (between the drive system and rewind) on the Labeler is active and the Labeler was Running or placed into Run.
Labeler #x Drive (DRx) Program Stopped Fault	The internal program of the listed labeler drive stopped executing logic while it was running or attempted to run. Reset the drive or re-enable the drive.
Labeler #x Disabled. Navigate to Labeler #x Service Menu	The labeler has been disabled from its Service Menu while it was running or attempted to run. Re-Enable the labeler from its service menu.
Labeler #x Missing Label / Maximum Feed Length Reached	The listed labeler’s drive has reported a maximum feed length movement while running. If there was no missing label on the web, ensure the “Max Feed Length” in the labeler menu is set to the proper value.

To set user passwords during initial setup navigate to the passwords screen, then Log in using password “7670” Once logged in users can set passwords per HMI Guide.






USER MENU
Sunday
mm/dd/yy
HH:MM:SS
Passwords
Current User:
Default
Log Out
Timer:
12.34
Disabled

Setup Sheets

QUADREL
LABELING SYSTEMS

s/n: 84219-100

LABEL SIZE: 3.75” x 8.125”

PRODUCT: 16oz Wrap

RECEIPE # 1

PACE SPEED POT: 5.5 12” PITCH

LABELER 1 MENU

PRODUCT DELAY	10.00
LABEL STOP	4.20
MAX FEED	9.00
SPEED RATIO	2.00

LABELER 1 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CCW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 2 MENU

PRODUCT DELAY	n/a
LABEL STOP	n/a
MAX FEED	n/a
SPEED RATIO	n/e

LABELER 2 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 3 MENU

PRODUCT DELAY	10.00
LABEL STOP	4.20
MAX FEED	9.00
SPEED RATIO	2.00

LABELER 3 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CCW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 4 MENU

PRODUCT DELAY	n/a
LABEL STOP	n/a
MAX FEED	n/a
SPEED RATIO	n/a

LABELER 4 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

SYSTEM SPEED MENU

TARGET SPEED	840
SLOW RATE	100
BYPASS MODE	**ENABLE X DISABLE**
CHAIN ALIGNERS	**ENABLE X DISABLE**
TOP TRAP	**ENABLE X DISABLE**
WRAP BELT #1	**X ENABLE DISABLE**
WRAP BELT #2	**X ENABLE DISABLE**

SPEED CALIBRATION MENU

TARGET RATE	840
CONVEYOR CALIBRATION	19.100
CHAIN ALIGNER CALIBRATION	6.350
WRAP BELT RATIO #1	2.00
WRAP BELT #1 CALIBRATION	9.401
WRAP BELT RATIO #2	2.00
WRAP BELT #2 CALIBRATION	9.401
CYCLE STOP	**ENABLE X DISABLE**
CYCLE STOP DISTANCE	**80.00**
PLC ENCODER COUNTS	**1642.00**

PRODUCT FLOW MENU

INFEED FULL / PRIMED	1.00
INFEED EMPTY / STARVED	1.00
OUTFEED FULL / BACKUP	1.00
OUTFEED EMPTY / CLEAR	1.00

CROSSOVER MENU

CROSSOVER 1 & 3	**X ENABLE DISABLE**
CROSSOVER 2 & 4	**ENABLE X DISABLE**
1 TO 3 DISTANCE	30.00
3 TO 1 DISTANCE	26.00
2 TO 4 DISTANCE	30.00
4 TO 2 DISTANCE	30.00
LOW LABEL CROSSOVER	**ENABLE X DISABLE**
LOW COUNTDOWN	**ENABLE X DISABLE**
#1 LOW LABEL COUNT	
#2 LOW LABEL COUNT	
#3 LOW LABEL COUNT	
#4 LOW LABEL COUNT	

CHANGEOVER SETTINGS

LABELER 1 UP/DOWN	3657
LABELER 1 IN/OUT	1400
LABELER 2 UP/DOWN	0
LABELER 2 IN/OUT	0
LABELER 3 UP/DOWN	3657
LABELER 3 IN/OUT	1400
LABELER 4 UP/DOWN	0
LABELER 4 IN/OUT	0
PACE BELT	5.5
TOP TRAP	0
#1 WRAP UP/DOWN	60
#1 WRAP IN/OUT	51
#1 BACKPAD UP/DOWN	90
#1 BACKPAD IN/OUT	130
#2 WRAP UP/DOWN	60
#2 WRAP IN/OUT	51
#2 BACKPAD UP/DOWN	80
#2 BACKPAD IN/OUT	535

QUADREL
LABELING SYSTEMS

s/n: 84219-100

LABEL SIZE: 3.25” x 10.875”

PRODUCT: 29oz Wrap

RECEIPE # 2

PACE SPEED POT: 7.5 12” PITCH

LABELER 1 MENU

PRODUCT DELAY	10.00
LABEL STOP	1.75
MAX FEED	12.00
SPEED RATIO	2.00

LABELER 1 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CCW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 2 MENU

PRODUCT DELAY	n/a
LABEL STOP	n/a
MAX FEED	n/a
SPEED RATIO	n/e

LABELER 2 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 3 MENU

PRODUCT DELAY	10.00
LABEL STOP	1.75
MAX FEED	12.00
SPEED RATIO	2.00

LABELER 3 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CCW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 4 MENU

PRODUCT DELAY	n/a
LABEL STOP	n/a
MAX FEED	n/a
SPEED RATIO	n/a

LABELER 4 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

SYSTEM SPEED MENU

TARGET SPEED	840
SLOW RATE	100
BYPASS MODE	**ENABLE X DISABLE**
CHAIN ALIGNERS	**ENABLE X DISABLE**
TOP TRAP	**ENABLE X DISABLE**
WRAP BELT #1	**X ENABLE DISABLE**
WRAP BELT #2	**X ENABLE DISABLE**

SPEED CALIBRATION MENU

TARGET RATE	840
CONVEYOR CALIBRATION	19.100
CHAIN ALIGNER CALIBRATION	6.350
WRAP BELT RATIO #1	2.00
WRAP BELT #1 CALIBRATION	9.401
WRAP BELT RATIO #2	2.00
WRAP BELT #2 CALIBRATION	9.401
CYCLE STOP	**ENABLE X DISABLE**
CYCLE STOP DISTANCE	**80.00**
PLC ENCODER COUNTS	**1642.00**

PRODUCT FLOW MENU

INFEED FULL / PRIMED	1.00
INFEED EMPTY / STARVED	1.00
OUTFEED FULL / BACKUP	1.00
OUTFEED EMPTY / CLEAR	1.00

CROSSOVER MENU

CROSSOVER 1 & 3	**X ENABLE DISABLE**
CROSSOVER 2 & 4	**ENABLE X DISABLE**
1 TO 3 DISTANCE	30.00
3 TO 1 DISTANCE	24.00
2 TO 4 DISTANCE	30.00
4 TO 2 DISTANCE	30.00
LOW LABEL CROSSOVER	**ENABLE X DISABLE**
LOW COUNTDOWN	**ENABLE X DISABLE**
#1 LOW LABEL COUNT	
#2 LOW LABEL COUNT	
#3 LOW LABEL COUNT	
#4 LOW LABEL COUNT	

CHANGEOVER SETTINGS

LABELER 1 UP/DOWN	3622
LABELER 1 IN/OUT	1400
LABELER 2 UP/DOWN	0
LABELER 2 IN/OUT	0
LABELER 3 UP/DOWN	3622
LABELER 3 IN/OUT	1400
LABELER 4 UP/DOWN	0
LABELER 4 IN/OUT	0
PACE BELT	5.5
TOP TRAP	0
#1 WRAP UP/DOWN	60
#1 WRAP IN/OUT	51
#1 BACKPAD UP/DOWN	90
#1 BACKPAD IN/OUT	156
#2 WRAP UP/DOWN	60
#2 WRAP IN/OUT	51
#2 BACKPAD UP/DOWN	80
#2 BACKPAD IN/OUT	1124

QUADREL
LABELING SYSTEMS

s/n: 84219-100

LABEL SIZE: 3 x4

PRODUCT: Quart Front Back

RECEIPE # 3

LABELER 1 MENU

PRODUCT DELAY	7.50
LABEL STOP	1.00
MAX FEED	5.00
SPEED RATIO	1.00

LABELER 1 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CCW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 2 MENU

PRODUCT DELAY	8.00
LABEL STOP	3.25
MAX FEED	5.00
SPEED RATIO	1.00

LABELER 2 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 3 MENU

PRODUCT DELAY	6.45
LABEL STOP	1.00
MAX FEED	5.00
SPEED RATIO	1.00

LABELER 3 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CCW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

LABELER 4 MENU

PRODUCT DELAY	6.80
LABEL STOP	3.25
MAX FEED	5.00
SPEED RATIO	1.00

LABELER 4 SERVICE MENU

ACCEL	5.00
DECEL	5.00
MOTOR DIRECTION	CW
ENCODER POLARITY	NEGATIVE
COUNTS PER INCH	0.6113

SYSTEM SPEED MENU

TARGET SPEED	600
SLOW RATE	100
BYPASS MODE	**ENABLE X DISABLE**
CHAIN ALIGNERS	**X ENABLE DISABLE**
TOP TRAP	**X ENABLE DISABLE**
WRAP BELT #1	**ENABLE X DISABLE**
WRAP BELT #2	**ENABLE X DISABLE**

SPEED CALIBRATION MENU

TARGET RATE	600
CONVEYOR CALIBRATION	19.100
CHAIN ALIGNER CALIBRATION	6.350
WRAP BELT RATIO #1	2.00
WRAP BELT #1 CALIBRATION	9.401
WRAP BELT RATIO #2	2.00
WRAP BELT #2 CALIBRATION	9.401
CYCLE STOP	**ENABLE X DISABLE**
CYCLE STOP DISTANCE	**80.00**
PLC ENCODER COUNTS	**1642.00**

PRODUCT FLOW MENU

INFEED FULL / PRIMED	1.00
INFEED EMPTY / STARVED	1.00
OUTFEED FULL / BACKUP	1.00
OUTFEED EMPTY / CLEAR	1.00

CROSSOVER MENU

CROSSOVER 1 & 3	**X ENABLE DISABLE**
CROSSOVER 2 & 4	**X ENABLE DISABLE**
1 TO 3 DISTANCE	30.00
3 TO 1 DISTANCE	30.00
2 TO 4 DISTANCE	30.00
4 TO 2 DISTANCE	30.00
LOW LABEL CROSSOVER	**ENABLE X DISABLE**
LOW COUNTDOWN	**ENABLE X DISABLE**
#1 LOW LABEL COUNT	
#2 LOW LABEL COUNT	
#3 LOW LABEL COUNT	
#4 LOW LABEL COUNT	

CHANGEOVER SETTINGS

LABELER 1 UP/DOWN	3456
LABELER 1 IN/OUT	1241
LABELER 2 UP/DOWN	3307
LABELER 2 IN/OUT	2467
LABELER 3 UP/DOWN	3456
LABELER 3 IN/OUT	1241
LABELER 4 UP/DOWN	3307
LABELER 4 IN/OUT	2467
PACE BELT	
TOP TRAP	3554
#1 WRAP UP/DOWN	
#1 WRAP IN/OUT	
#1 BACKPAD UP/DOWN	
#1 BACKPAD IN/OUT	
#2 WRAP UP/DOWN	
#2 WRAP IN/OUT	
#2 BACKPAD UP/DOWN	
#2 BACKPAD IN/OUT	

Fuji Ace for Master / Followers v.000

Job: 84219 Drive: DR1 Motor: Conveyor

SETUP AND ADJUSTMENTS: (Reference Fuji drive manual for detailed information)

Initial Power-Up:
The display will show "8.dES". Press the Func/Data Key.
"ASIA" will be displayed. Press the Stop and Up/Down keys until "ANEr" is displayed.
Press the Func/Data Key to save the setting.

F11 = 3.40

Set Primary Parameters:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
F01	0	1 (0-10V Terminals) 12* (PG Card)	1	Frequency Command
F02	2	1 (Terminals)	1 ✓	Operation
F03**	60.0	60.0	90.0	Max Frequency
F07	6.0	3.0	3.0	Accel Time
F08	6.0	3.0	3.0	Decel Time
F15	70	70	90.0	Upper Freq Limit
F29	0		0	Terminal FM Function
H04	0	5	5 ✓	Auto Reset Attempts
H05	5.0	3.0	3.0 ✓	Auto Reset Delay
P99	0	1 (HP)	1 ✓	Motor Type
P02	Varies	See Motor Nameplate	1.6	Rated Capacity (HP)

***For Follower Only: Top Trap / Hugger Drive**
****If Max Frequency exceeds 70.0, Adjust F15 first.**
***** 0 if FM going to another drive. 3 if being fed to PLC Encoder signal**

PG Card Parameters for Following Top Trap / Hugger Drive:
Following parameters required regardless if encoder installed:

D59*	2	2		Command Encoder Type
D60**	400 (1024)	Check Encoder See Note Below		Command Encoder PPR (HEX!)
D62	1	1	1	Command Scaling Factor 1
D63	1	1	1	Command Scaling Factor 2
F14	1	5	5	Restart Mode
F31	0	21	21	FM Terminal Output
H96	3	0	0	Stop/Start Check

*** Set to 3 to change Motor Direction**
**** 78 For Techline Bodine Top Trap / Hugger** (120 PPR Encoder to Motor Shaft)
**** 7D For Techline Conveyor** (1200 PPR Encoder to Conveyor Sidewall)
**** 400 For Leeson Conveyor / Hugger** (1024 PPR Encoder between Motor and Gearbox)

Following parameters if encoder installed on Top Trap/Slave Hugger Drive Motor:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
D14*	2	2		Feedback Encoder Type
D15**	400 (1024)	Check Encoder See Note Above		Feedback Encoder PPR (HEX!)
D16	1	1	1	Feedback Scaling Factor 1
D17	1	1	1	Feedback Scaling Factor 2
D41	0	2	2	Application Function
F42	0	6	6	Control Mode

***Set to 3 if drive Errors upon following the master**

Initialize Parameters

- **Navigate to Parameter H03**
- **Use the STOP and UP Arrow to change H03 to "2"**
- **H03 will revert back to "0" once the parameters are automatically set.**

Set the Motor Current based on the Motor Nameplate value. Entered as Amps.

Parameter	Fuji Default	Motor Nameplate	Quadrel Final value
P03	Varies	3.40	3.40

Fuji Ace for Master / Followers v.000

Job: 84219 Drive: DRZ Motor: Top Trap

SETUP AND ADJUSTMENTS: (Reference Fuji drive manual for detailed information)

Initial Power-Up:
The display will show "8.dES". Press the Func/Data Key.
"ASIA" will be displayed. Press the Stop and Up/Down keys until "ANEr" is displayed.
Press the Func/Data Key to save the setting.

F11 = 2.0

Set Primary Parameters:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
F01	0	1 (0-10V Terminals) 12* (PG Card)	12	Frequency Command
F02	2	1 (Terminals)	1 ✓	Operation
F03**	60.0	60.0	70.0	Max Frequency
F07	6.0	3.0	0.00	Accel Time
F08	6.0	3.0	0.00	Decel Time
F15	70	70	90.0	Upper Freq Limit
F29	0		0	Terminal FM Function
H04	0	5	5 ✓	Auto Reset Attempts
H05	5.0	3.0	3.0 ✓	Auto Reset Delay
P99	0	1 (HP)	1 ✓	Motor Type
P02	Varies	See Motor Nameplate	.38	Rated Capacity (HP)

***For Follower Only: Top Trap / Hugger Drive**
****If Max Frequency exceeds 70.0, Adjust F15 first.**
***** 0 if FM going to another drive. 3 if being fed to PLC Encoder signal**

PG Card Parameters for Following Top Trap / Hugger Drive:
Following parameters required regardless if encoder installed:

D59*	2	2	2	Command Encoder Type
D60**	400 (1024)	Check Encoder See Note Below	400	Command Encoder PPR (HEX!)
D62	1	1	# 100	Command Scaling Factor 1
D63	1	1	# 199	Command Scaling Factor 2
F14	1	5	5 ✓	Restart Mode
F31	0	21	21* 0	FM Terminal Output
H96	3	0	0 ✓	Stop/Start Check

*** Set to 3 to change Motor Direction**
**** 78 For Techline Bodine Top Trap / Hugger** (120 PPR Encoder to Motor Shaft)
**** 7D For Techline Conveyor** (1200 PPR Encoder to Conveyor Sidewall)
**** 400 For Leeson Conveyor / Hugger** (1024 PPR Encoder between Motor and Gearbox)

Following parameters if encoder installed on Top Trap/Slave Hugger Drive Motor:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
D14*	2	2		Feedback Encoder Type
D15**	400 (1024)	Check Encoder See Note Above		Feedback Encoder PPR (HEX!)
D16	1	1	1	Feedback Scaling Factor 1
D17	1	1	1	Feedback Scaling Factor 2
D41	0	2	2	Application Function
F42	0	6	6	Control Mode

***Set to 3 if drive Errors upon following the master**

Initialize Parameters

- **Navigate to Parameter H03**
- **Use the STOP and UP Arrow to change H03 to "2"**
- **H03 will revert back to "0" once the parameters are automatically set.**

Set the Motor Current based on the Motor Nameplate value. Entered as Amps.

Parameter	Fuji Default	Motor Nameplate	Quadrel Final value
P03	Varies	1.90	1.90

Fuji Ace for Master / Followers v.000

Job: 84219 Drive: DR3 Motor: Wrap #1

SETUP AND ADJUSTMENTS: (Reference Fuji drive manual for detailed information)

Initial Power-Up:
The display will show "8.dES". Press the Func/Data Key.
"ASIA" will be displayed. Press the Stop and Up/Down keys until "ANEr" is displayed.
Press the Func/Data Key to save the setting.

F11 = 2.0

Set Primary Parameters:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
F01	0	1 (0-10V Terminals) 12* (PG Card)	1	Frequency Command
F02	2	1 (Terminals)	1 ✓	Operation
F03**	60.0	60.0	90.0	Max Frequency
F07	6.0	3.0	3.0	Accel Time
F08	6.0	3.0	3.0	Decel Time
F15	70	70	90.0	Upper Freq Limit
F29	0			Terminal FM Function
H04	0	5	5 ✓	Auto Reset Attempts
H05	5.0	3.0	3.0 ✓	Auto Reset Delay
P99	0	1 (HP)	1 ✓	Motor Type
P02	Varies	See Motor Nameplate	1.38	Rated Capacity (HP)

***For Follower Only: Top Trap / Hugger Drive**
****If Max Frequency exceeds 70.0, Adjust F15 first.**
***** 0 if FM going to another drive. 3 if being fed to PLC Encoder signal**

PG Card Parameters for Following Top Trap / Hugger Drive:
Following parameters required regardless if encoder installed:

D59*	2	2		Command Encoder Type
D60**	400 (1024)	Check Encoder See Note Below		Command Encoder PPR (HEX!)
D62	1	1	1	Command Scaling Factor 1
D63	1	1	1	Command Scaling Factor 2
F14	1	5	5	Restart Mode
F31	0	21	21	FM Terminal Output
H96	3	0	0	Stop/Start Check

*** Set to 3 to change Motor Direction**
**** 78 For Techline Bodine Top Trap / Hugger** (120 PPR Encoder to Motor Shaft)
**** 7D For Techline Conveyor** (1200 PPR Encoder to Conveyor Sidewall)
**** 400 For Leeson Conveyor / Hugger** (1024 PPR Encoder between Motor and Gearbox)

Following parameters if encoder installed on Top Trap/Slave Hugger Drive Motor:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
D14*	2	2		Feedback Encoder Type
D15**	400 (1024)	Check Encoder See Note Above		Feedback Encoder PPR (HEX!)
D16	1	1	1	Feedback Scaling Factor 1
D17	1	1	1	Feedback Scaling Factor 2
D41	0	2	2	Application Function
F42	0	6	6	Control Mode

***Set to 3 if drive Errors upon following the master**

Initialize Parameters

- **Navigate to Parameter H03**
- **Use the STOP and UP Arrow to change H03 to "2"**
- **H03 will revert back to "0" once the parameters are automatically set.**

Set the Motor Current based on the Motor Nameplate value. Entered as Amps.

Parameter	Fuji Default	Motor Nameplate	Quadrel Final value
P03	Varies	1.90	1.90

Fuji Ace for Master / Followers v.000

Job: 84219 Drive: DR4 Motor: Wrap #2

SETUP AND ADJUSTMENTS: (Reference Fuji drive manual for detailed information)

Initial Power-Up:
The display will show "8.dES". Press the Func/Data Key.
"ASiA" will be displayed. Press the Stop and Up/Down keys until "ANEr" is displayed.
Press the Func/Data Key to save the setting.

F11 = 2.0

Set Primary Parameters:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
F01	0	1 (0-10V Terminals) 12* (PG Card)	1	Frequency Command
F02	2	1 (Terminals)	1 ✓	Operation
F03**	60.0	60.0	90.0	Max Frequency
F07	6.0	3.0	3.0	Accel Time
F08	6.0	3.0	3.0	Decel Time
F15	70	70	90.0	Upper Freq Limit
F29	0		0	Terminal FM Function
H04	0	5	5 ✓	Auto Reset Attempts
H05	5.0	3.0	3.0 ✓	Auto Reset Delay
P99	0	1 (HP)	1 ✓	Motor Type
P02	Varies	See Motor Nameplate	1.5	Rated Capacity (HP)

***For Follower Only: Top Trap / Hugger Drive**
****If Max Frequency exceeds 70.0, Adjust F15 first.**
***** 0 If FM going to another drive. 3 if being fed to PLC Encoder signal**

PG Card Parameters for Following Top Trap / Hugger Drive:
Following parameters required regardless if encoder installed:

D59*	2	2		Command Encoder Type
D60**	400 (1024)	Check Encoder See Note Below		Command Encoder PPR (HEX!)
D62	1	1	1	Command Scaling Factor 1
D63	1	1	1	Command Scaling Factor 2
F14	1	5	5	Restart Mode
F31	0	21	21	FM Terminal Output
H96	3	0	0	Stop/Start Check

*** Set to 3 to change Motor Direction**
**** 78 For Techline Bodine Top Trap / Hugger** (120 PPR Encoder to Motor Shaft)
**** 7D For Techline Conveyor** (1200 PPR Encoder to Conveyor Sidewall)
**** 400 For Leeson Conveyor / Hugger** (1024 PPR Encoder between Motor and Gearbox)

Following parameters if encoder installed on Top Trap/Slave Hugger Drive Motor:

Parameter	Fuji Default	Quadrel Default Value	Quadrel Final Value	Description
D14*	2	2		Feedback Encoder Type
D15**	400 (1024)	Check Encoder See Note Above		Feedback Encoder PPR (HEX!)
D16	1	1	1	Feedback Scaling Factor 1
D17	1	1	1	Feedback Scaling Factor 2
D41	0	2	2	Application Function
F42	0	6	6	Control Mode

***Set to 3 if drive Errors upon following the master**

Initialize Parameters

- **Navigate to Parameter H03**
- **Use the STOP and UP Arrow to change H03 to "2"**
- **H03 will revert back to "0" once the parameters are automatically set.**

Set the Motor Current based on the Motor Nameplate value. Entered as Amps.

Parameter	Fuji Default	Motor Nameplate	Quadrel Final value
P03	Varies	1.90	1.90

WARNING

- **KEEP HAND CLEAR OF MOVING PARTS. DO NOT PLACE HANDS NEAR LABELING HEAD WHEN IN OPERATION**

- **DO NOT OPERATE EQUIPMENT WITHOUT GUARDS OR COVERS INSTALLED**

6.1 LABELING HEAD INFORMATION

6.1.1 LOADING AND UNLOADING STOCK ROLL

⚠ CAUTION

To avoid injuries, you must keep the labeler stopped/paused. You can manually jog labels with the JOG button.

Look carefully at the diagram and follow the threading procedures indicated below.

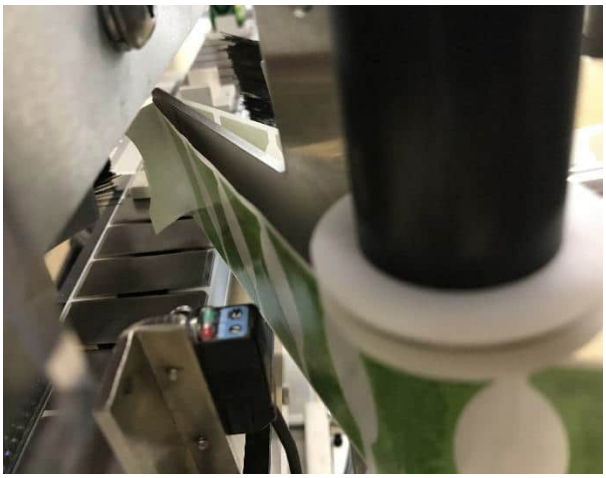
You will also find the threading diagram directly on the labeling head.

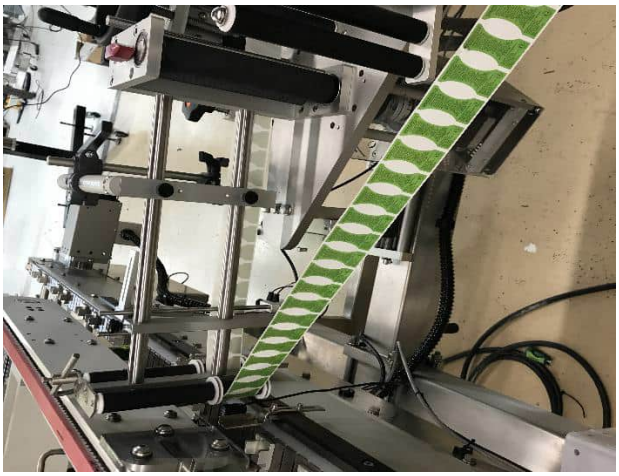
1) Place the label stock roll on the unwind shaft. Press the roll firmly against the flange. Then slide the locking collar over the unwind shaft aligning the set screw with the shaft. Press into the roll and twist to lock the collar in place.

2) Pull Approximately 36-40” of stock from label stock roll.

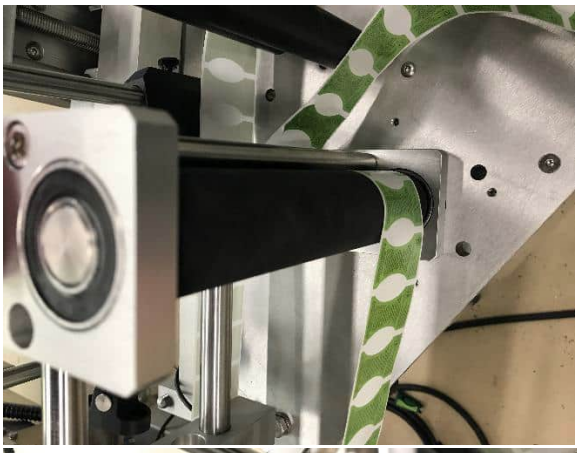
3) Follow the threading diagram on the labeling head for routing the web.
4) Thread through the dancer to the peel plate.

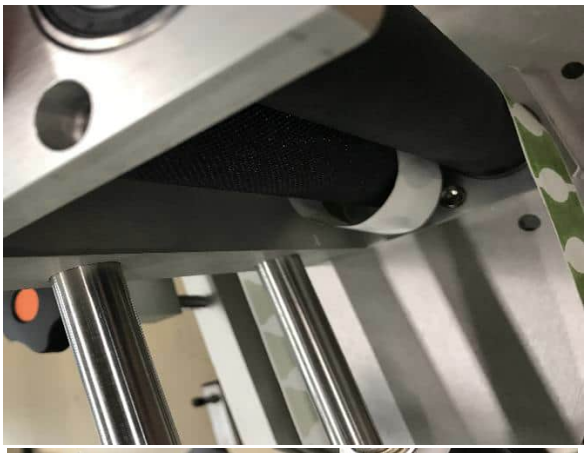
5) Feed the label around the peel plate and under the pressure shoe if (if there is one). Feed the label up the head to the pull roll. Pull all the slack out.

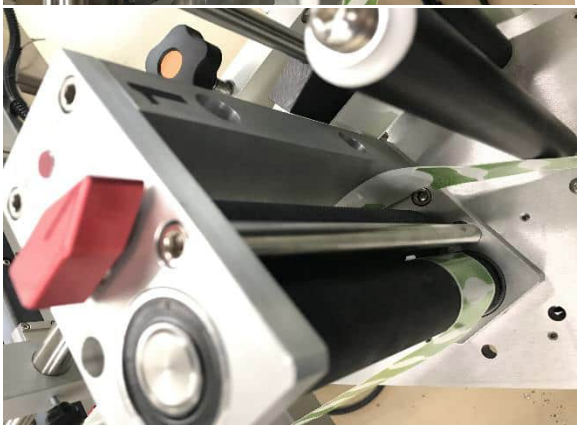




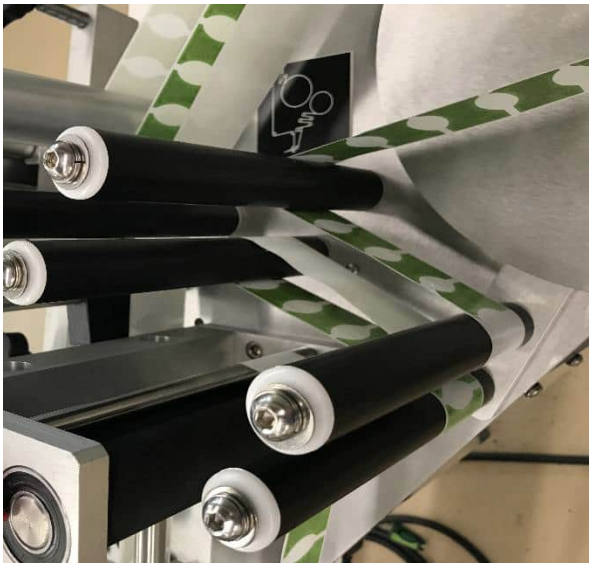
6) Wrap labels around the rubber roller as shown, then around the knurled roller. Make sure the knurled roller is not locked in by turning the red knob to the left or right of the red dot on the drive roll. When you have the labels completely threaded you can turn the knob to the red dot.



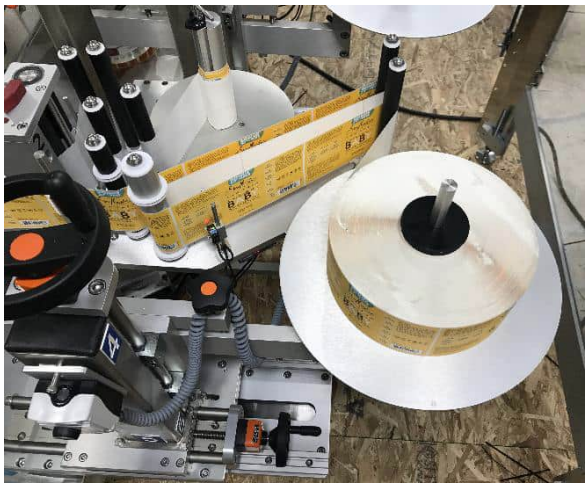




7) Thread the labels through the rewind dancers to the rewind shaft. Place the end of the label through the clip and rotate the rewind hub to take up the slack.



8) The finished product should look similar to the pictures below. Some heads are threaded differently depending on the style head you have. See threading diagrams on the head itself or the manual.

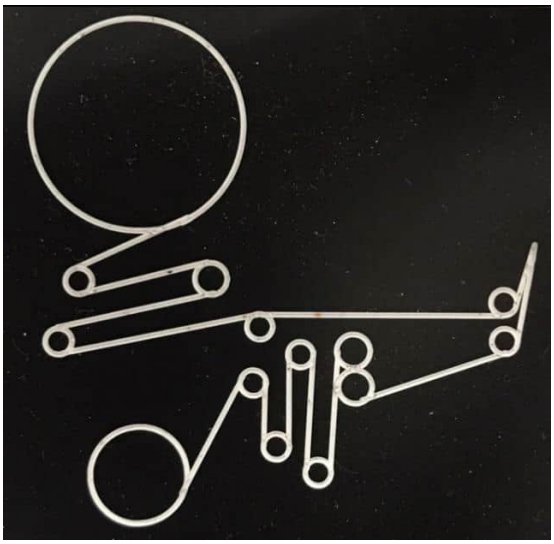


9) To unload the rewind loosen (counter clockwise) the “clevis” bolt on the top of the rewind hub. this will collapse the rewind and you can pull the liner off the hub.

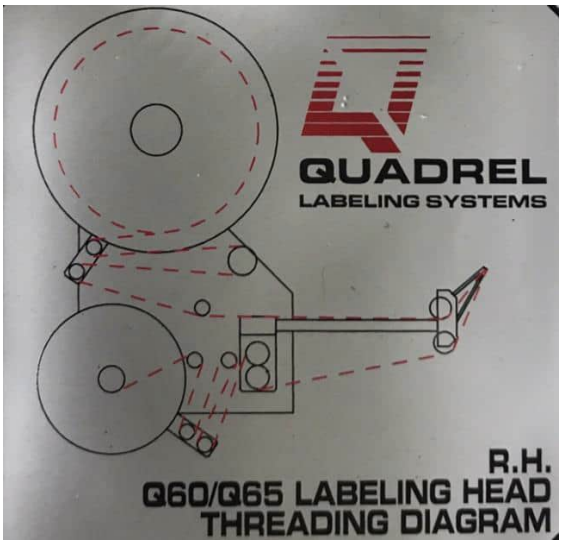
⚠ CAUTION There are many pinch points on a labeler. to avoid injury read and understand the owner’s manual before operating.

6.1.2 THREADING DIAGRAMS

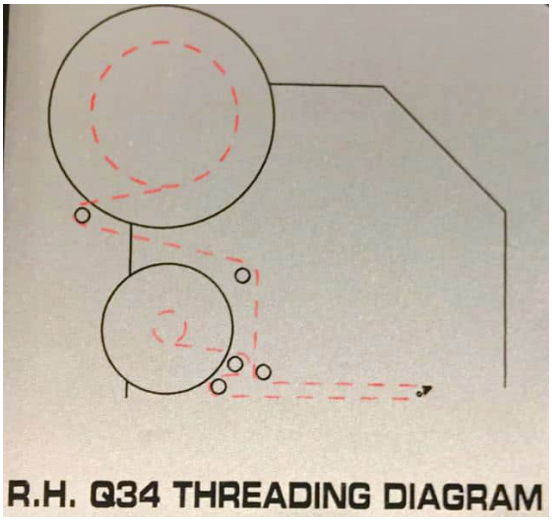
Here are the following threading diagrams for our standard labeling heads.



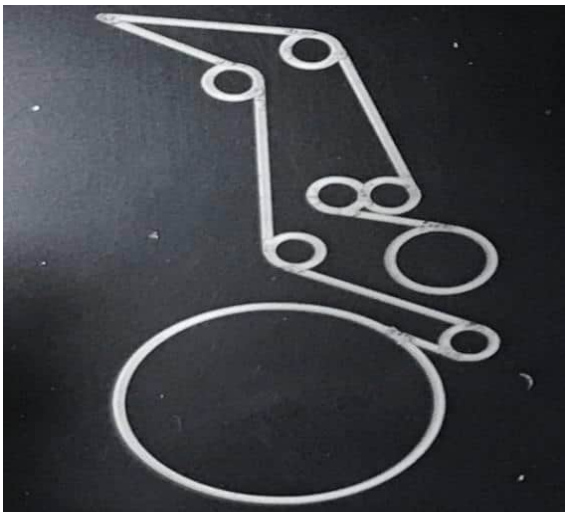
Q120/Q125/Q115/Q110



Q60/Q65



Q34



E100

6.1.3 LABELER ADJUSTMENTS

The vertical adjustment is to position the label on the container at different heights. It's practical if you have different size labels and/or containers. To adjust the height you simply rotate the handwheel at the top of the labeler counter clockwise to go down and clockwise to go up.

Horizontal adjustments are made the same way except you rotate the hand wheel under the labeler. Rotating the hand wheel counter clockwise will move the labeler in and rotating clockwise with move the labeler out.

To adjust the angle of the labeling head you first need to loosen the large ¾-10 nut with a 1 ¼ “wrench and the 5/16-18 hex head bolt. The angular adjustment is very important to increase the repeatability of the process. A good adjustment is when the exit of the label is tangent with the surface of the application.

⚠ CAUTION DO NOT remove the nut & bolt.

Now to adjust the tilt of the labeling head by tightening and loosening the jack screws.

Rotate adjustment is achieved by loosening the 2 ratchet handles under the labeling head. There is a jack screw holding the labeling head in place, but still use caution when loosening the ratchet handles the labeling head can rotate

freely when loose. This is a fine adjustment that increases the parallelism of the label to the shape of the container.

⚠ CAUTION When loosening the labeling head, the head may rotate freely. Keep positive pressure against the head to prevent the head from rotating on its own. `

QUADREL LABELING SYSTEMS

Q125 LABELING HEAD

GENERAL DESCRIPTION

- The Q125 has been developed as a heavy duty automatic labeling head system for integration into high speed, high rate production environments. The labeling head can be configured for either wrap or wipe on applications. The Q125 uses a servo drive and motor system that can be used independently or in conjunction with a PLC. All settings are controlled from a touch screen interface for easy setup and adjustments. In addition, a built in system of fault logic can easily interface with a host of optional sensors.

PRINCIPLE OF FUNCTION

- The Q125 labeling head applies pressure sensitive labels onto moving products. Various principles are involved to achieve accurate label application. In general, a labeling system integrates three (3) basic functions:

  - Product Handling: The most common product handling component is the conveyor. Conveyors allow the product to transport smoothly through the labeling station. The Q125 labeler can be supplied either as a stand alone head (head on a stand) or integrated into a complete conveying/product handling system. An encoder from the product handling system must be tied into the labeler's drive.

  - Label Application: Usually the label is "tacked" directly to the product during the label dispensing cycle. Secondary label applicators such as brushes, roller or wrap belts are used to finish the label application and to ensure good adhesion.

- Label Dispensing: The Q125 utilizes two movement types to dispense labels. The first movement is a fixed speed, “jog” movement that is used during setup purposes. Jogging labels verifies proper label threading and labeler operation prior applying labels to products. The second movement is a synchronized “run” movement that is used to apply labels on passing products. The labeler's drive system will synchronize speed with the product handling system from an encoder. This eliminates the need to change settings based on system speed and allows for accurate and repeatable labeling.

SEQUENCE OF OPERATION:

- The electrical and mechanical operating sequence described below is intended only to acquaint the operator with the operation of the label dispensing head and its related control circuitry.

- The Jog function is used for manual set-up of label dispensing. Under proper conditions, a jog sequence will dispense one label. Labels must be threaded properly and the labeler stopped (indicated on the touch screen) before Jogging labels.

- The Jog cycle is described in the following manner:

1. After verifying that labels are threaded properly and the labeler is stopped, a jog button (physical green button near the labeler or a button on the touch screen) must be pressed.
2. The labeler will start dispensing labels at a fixed speed.
3. The labeler's drive will monitor a label gap sensor input before finishing a dispensing cycle.
4. Once the label's gap is detected by the sensor, the labeler will continue dispensing the label for a length defined by the “Label Stop” parameter on the touch screen. This distance is entered as inches.
5. After the Label Stop distance is reached, the Jog cycle is complete and the labeler stops dispensing labels.
6. If no label gap is detected, the labeler will only index a maximum distance which is set by the “Max Feed” parameter on the touch screen. This distance is entered as inches.

– When the labeler is in the “Run” mode it will automatically dispense labels on products that are passing by. Labels must be threaded properly and the labeler placed in the Run mode (indicated on the touch screen) to automatically dispense labels

1. A product activates the Product Detect sensor.
2. The labeler drive captures the position of the product on the product handling system and starts an internal delay, which is the “Product Delay” parameter on the touch screen.
3. The Product Delay is equal to inches, so once the product travels the Product Delay distance from the product detect sensor, a label will be dispensed.
4. The labeler dispenses a label at the speed of the product which is multiplied by the “Speed Ratio” parameter found on the touch screen. The ratio is a multiplier, so a value of 1.0 determines the labeler will dispense at the exact speed of the conveyor.
5. The labeler monitors the label gap sensor in the same manner of the Jog movement before finishing the dispensing cycle.

ASSEMBLY TITLE: **Q125 LABELING HEAD ASSEMBLY**

DRAWING NO.: **NONE**

GENERAL FUNCTION:

- Applies labels to the front and/or back, top/bottom of the products
- Wraps labels around cylindrical products

SET-UP AND ADJUSTMENTS:

- Tighten all loose connections and screws
- As noted in each sub-assembly

MAINTENANCE:

- Remove glue residue and labels from all rollers and idlers
- As noted in each sub-assembly

TROUBLESHOOTING:

- As noted in each sub-assembly

ASSEMBLY TITLE: **Q125 LABELING HEAD - THREADING**

GENERAL FUNCTION:

- This section is used to guide the user through loading and feeding the label through the web path.

SET UP AND ADJUSTMENTS:

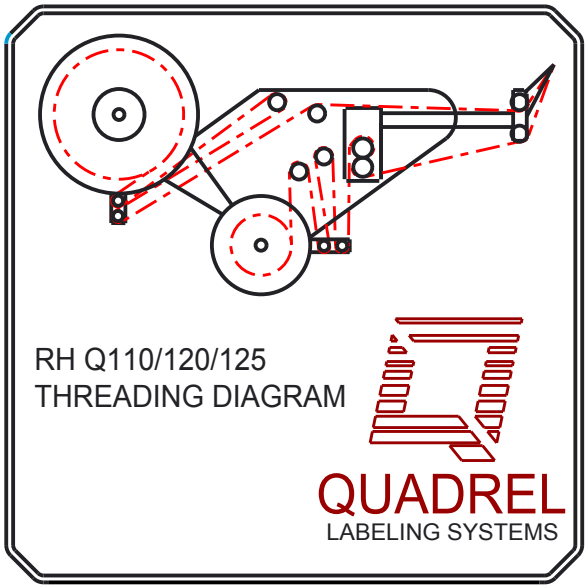
- Load label spool onto unwind hub. Secure unwind retainer onto hub and lock. Pull 3-4 feet of web from unwind and strip labels free of web.
- Unlock the drive roller locking handle.
- Using the threading diagram located on the labeling head, feed the web through the labeling head. Start at the unwind dancer assembly and work forward.
- Feed the web through the drive roller assembly.
- Feed the web around the rewind dancer assembly and onto the rewind hub. Wrap the web around the hub once. Lock the web in place with the rewind retaining bracket.
- Once the web has been threaded, lock down the drive roll assembly by rotating the drive roll locking arm into the locked position. (Towards the drive roller assembly)

MAINTENANCE:

- None this section.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Web break	- Check web path and insure web routed correctly. - Debris causing web tear and break. Clear as needed.
- No Web Tension	- Check web path through unwind and dancer assembly. - Check drive roller lock position.



NOTES:

1) LABEL MATERIAL IS .003" ALUMINUM FOIL W/PERMANENT PRESSURE SENSITIVE ADHESIVE.

2) ALL LETTERING IS .125" HIGH EUROSTYLE 2, BOLD EXTENDED 2.

3) USE QUADREL STANDARD LOGO.

4) ALL LINES AND LETTERS ARE BLACK ON A SILVER BACKGROUND QUADREL AND (WEB PATH) ARE RED #(199c) LINES ARE DASHED LINES.

5) LABEL SIZE 3.0" X 3.0".

REV	DATE	DESCRIPTION
A	5-8-19	NEW DRAWING

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE

.X± .1
.XX± .01
.XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

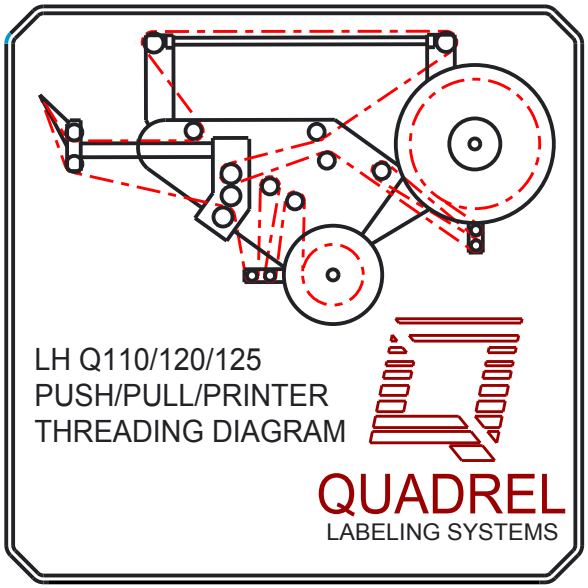
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	DRAWING SCALE
DATE:	5-8-19
DRW BY:	TJS
CHK BY:	
APPR BY:	

Q110/120/125 R.H. THREADING DIAGRAM

MAT'L
SEE NOTES

A26222-110RH



NOTES:

1) LABEL MATERIAL IS .003" ALUMINUM FOIL W/PERMANENT PRESSURE SENSITIVE ADHESIVE.

2) ALL LETTERING IS .125" HIGH EUROSTYLE 2, BOLD EXTENDED 2.

3) USE QUADREL STANDARD LOGO.

4) ALL LINES AND LETTERS ARE BLACK ON A SILVER BACKGROUND QUADREL AND (WEB PATH) ARE RED #(199c) LINES ARE DASHED LINES.

5) LABEL SIZE 3.0" X 3.0".

REV	DATE	DESCRIPTION
A	5-8-19	NEW DRAWING

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.X± .1
.XX± .01
.XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	DRAWING SCALE
DATE:	5-8-19
DRW BY:	TJS
CHK BY:	
APPR BY:	

Q110/120/125 L.H. THREADING DIAGRAM

MAT'L
SEE NOTES

A26222-110LHPPP

ASSEMBLY TITLE: **Q110 SIDE PLATE ASSEMBLY**

DRAWING NO.: **D24272-000**

GENERAL FUNCTION:

- To provide a rigid mounting surface for outboard labeling components, electronic components, and system components.
- The side plate also supports the system mount

SET UP AND ADJUSTMENTS:

- None

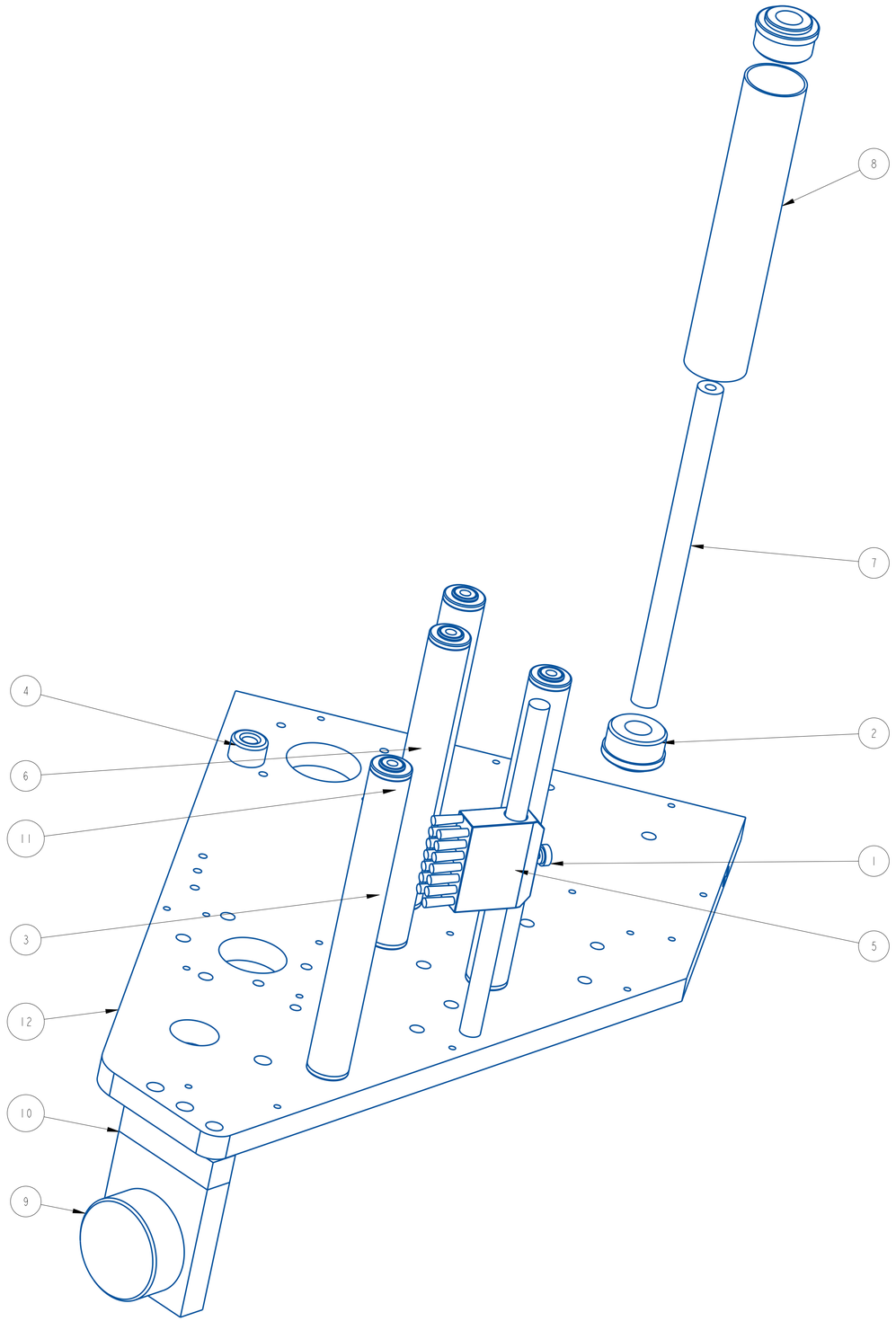
MAINTENANCE:

- None

TROUBLESHOOTING:

- None

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	00669-01	BRAKE BRUSH	22620SP-RHH
2	2	181062-000	BEARING, ROLL END	22620SP-RHH
3	8	181063-000	BEARING, ROLL END	22620SP-RHH
4	1	791459-000	RUBBER BUMPER	22620SP-RHH
5	1	A20654-003	ADJ. ROD	22620SP-RHH
6	4	A20928-001	ROLLER SHAFT	22620SP-RHH
7	1	A21618-001	IDLER SHAFT	22620SP-RHH
8	1	A22291-006	ROLLER	22620SP-RHH
9	1	A24905-006	PIVOT PIN MOUNTING PLATE	22620SP-RHH
10	1	A25912-000	MOUNTING PIN SPACER	22620SP-RHH
11	4	B20071-002	IDLER ROLLER (DANCER)	22620SP-RHH
12	1	D22800-120_REVC	Q125/Q120/Q110/Q105 SIDE PLATE	22620SP-RHH



REV	DATE	DESCRIPTION	BY
A	11-26-13	NEW DRAWING	CRT

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UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

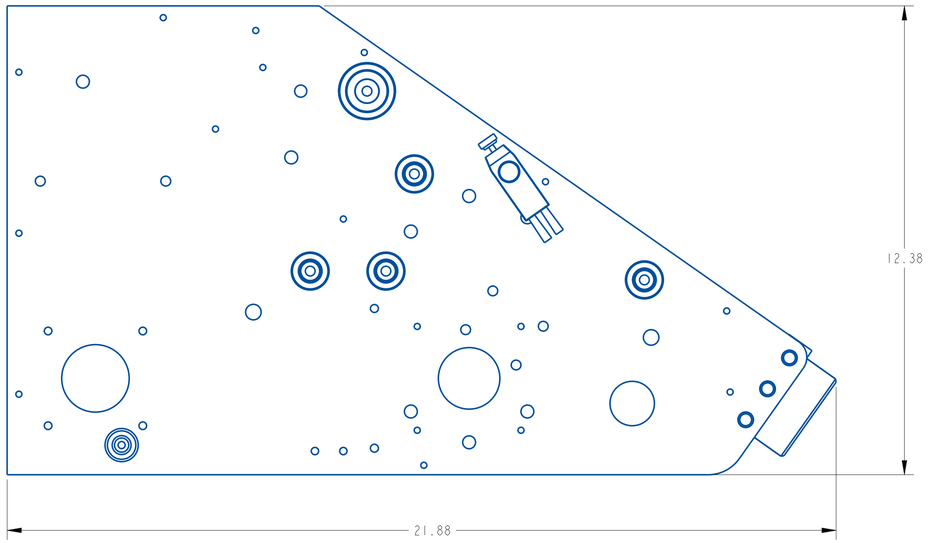
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

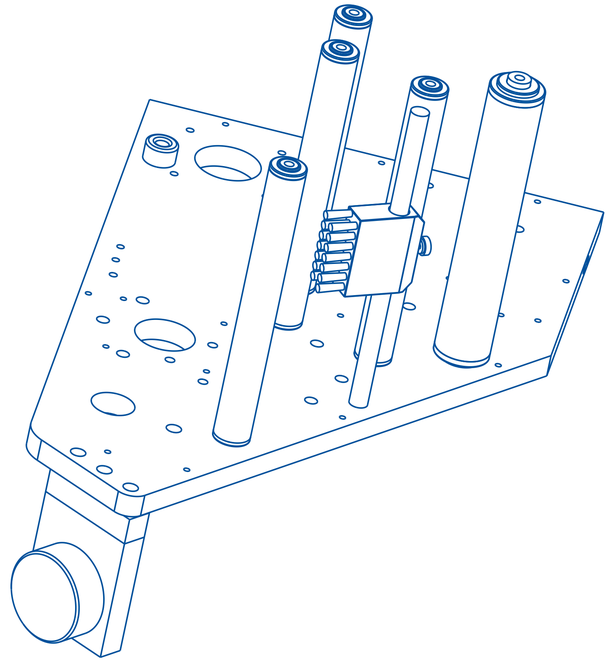
SCALE:	5/8
DATE:	11-26-13
DRW BY:	CRT
CHK BY:	
APPR BY:	

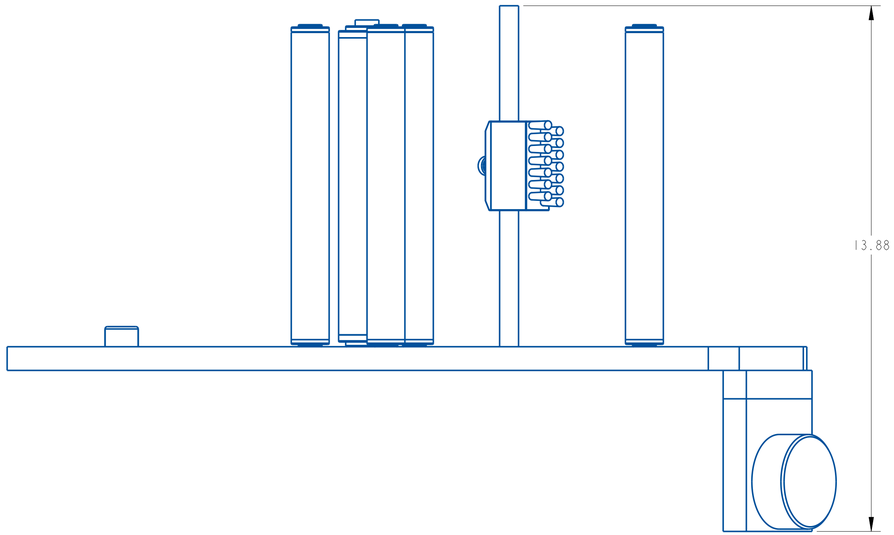
Q120 7" SIDE PLATE ASSEMBLY, RHH

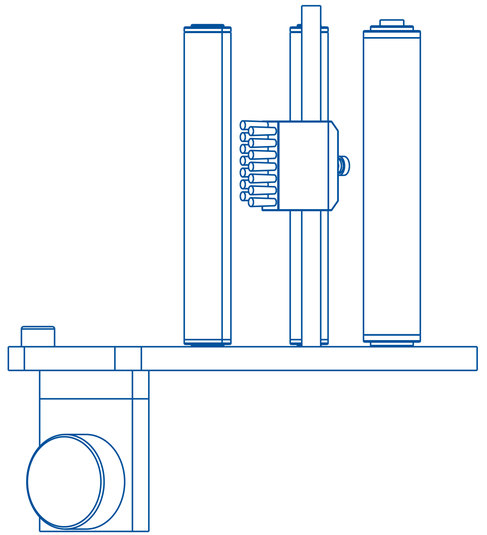
MAT'L

22620SP-RHH









REV	DATE	DESCRIPTION	BY
A	11-26-13	NEW DRAWING	CRT

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UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

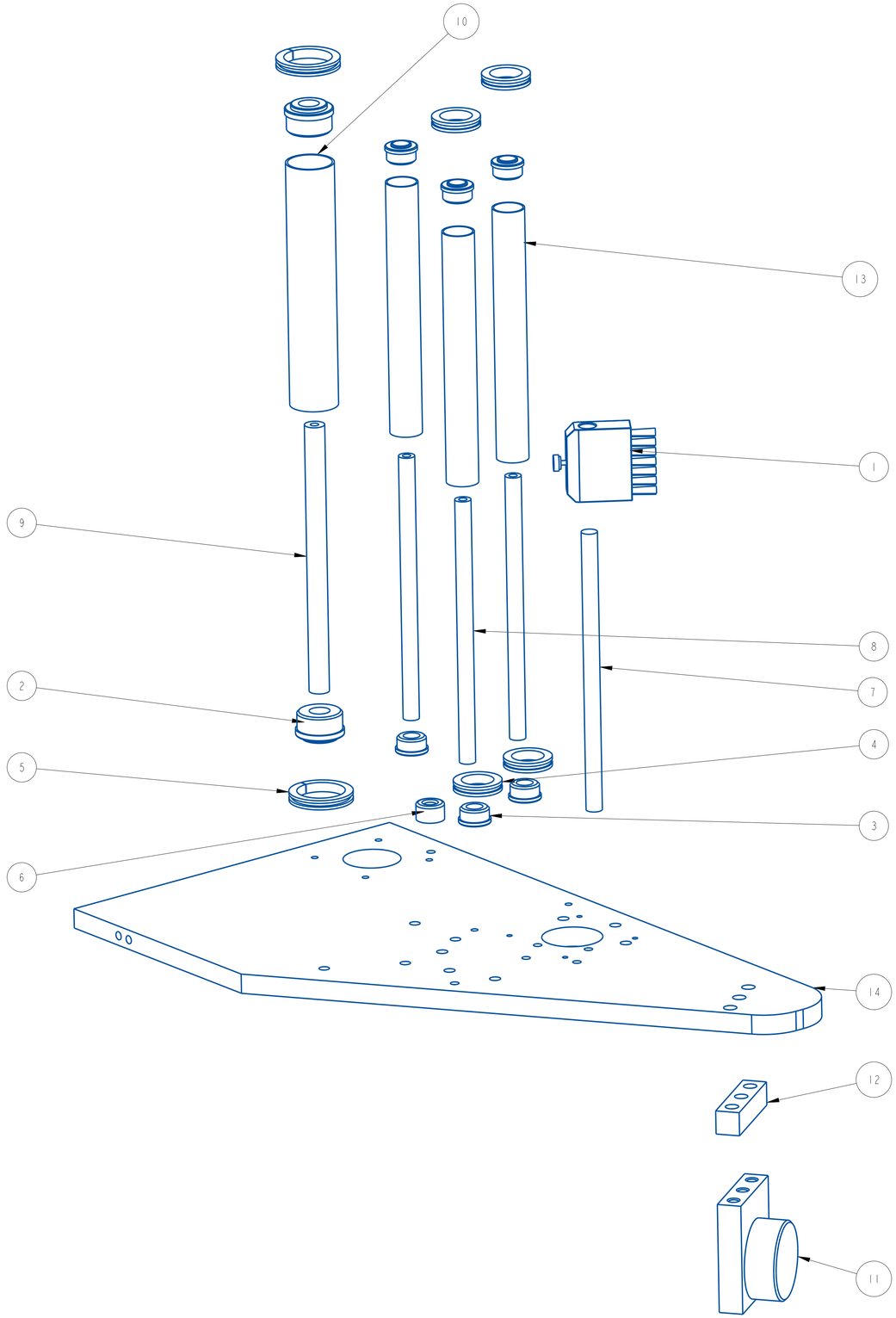
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	1/2
DATE:	11-26-13
DRW BY:	CRT
CHK BY:	
APPR BY:	

Q120 7" SIDE PLATE ASSEMBLY, RHH

MAT'L

22620SP-RHH



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	00669-01	BRAKE BRUSH	22620SP-LHH
2	2	181062-000	BEARING, ROLL END	22620SP-LHH
3	6	181063-000	BEARING, ROLL END	22620SP-LHH
4	4	361198-000	COLLAR, GUIDE, 1" ID	22620SP-LHH
5	2	361199-000	COLLAR, GUIDE, 1-1/2 IN. ID	22620SP-LHH
6	1	791459-000	RUBBER BUMPER	22620SP-LHH
7	1	A20654-003	ADJ. ROD	22620SP-LHH
8	3	A20928-001	ROLLER SHAFT	22620SP-LHH
9	1	A21618-001	IDLER SHAFT	22620SP-LHH
10	1	A22291-006	ROLLER	22620SP-LHH
11	1	A24905-006	PIVOT PIN MOUNTING PLATE	22620SP-LHH
12	1	A25912-000	MOUNTING PIN SPACER	22620SP-LHH
13	3	B20071-002	IDLER ROLLER (DANCER)	22620SP-LHH
14	1	D22800-120	Q120 SIDE PLATE	22620SP-LHH

REV	DATE	DESCRIPTION	BY
A	02-OCT-15	NEW DRAWING	CRT

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE

.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

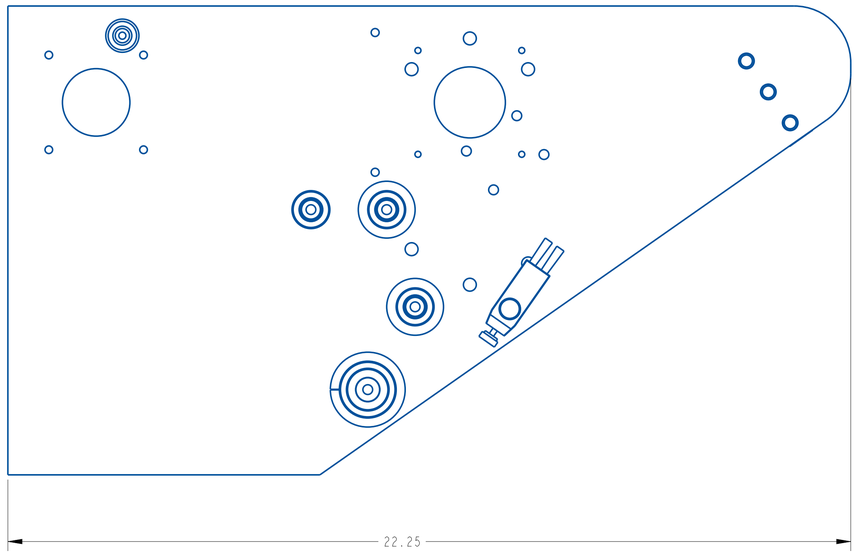
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

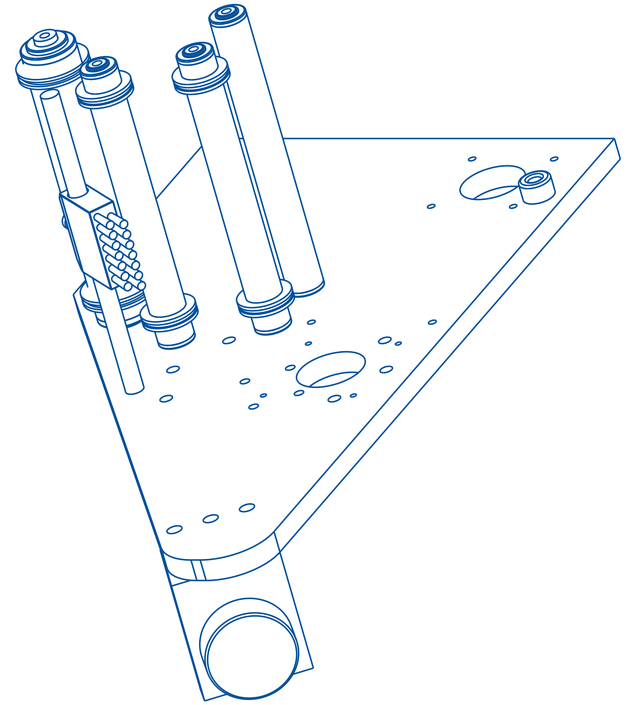
SCALE: 1/2
DATE: 02-OCT-15
DRW BY: CRT
CHK BY: 03/26/2024-SEM
APPR BY:

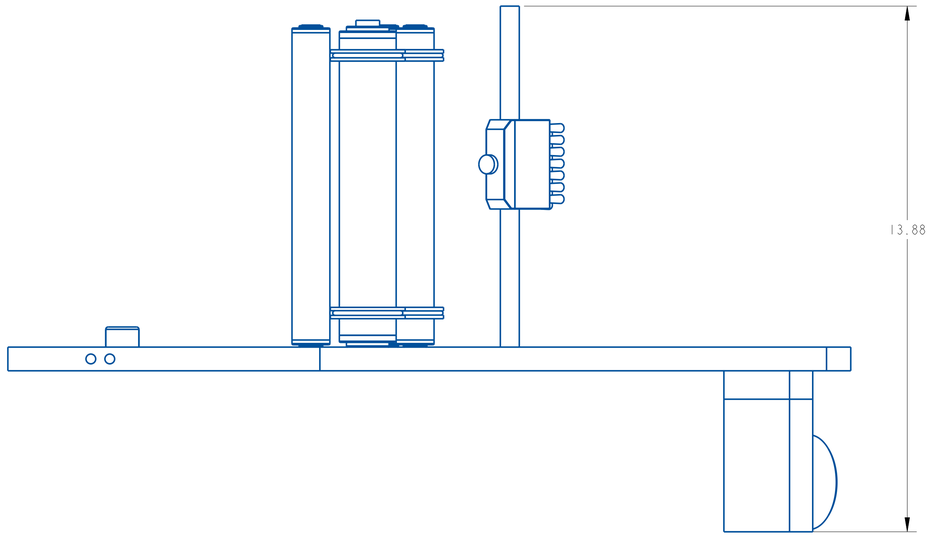
Q120 7" SIDE PLATE ASSEMBLY, LHH

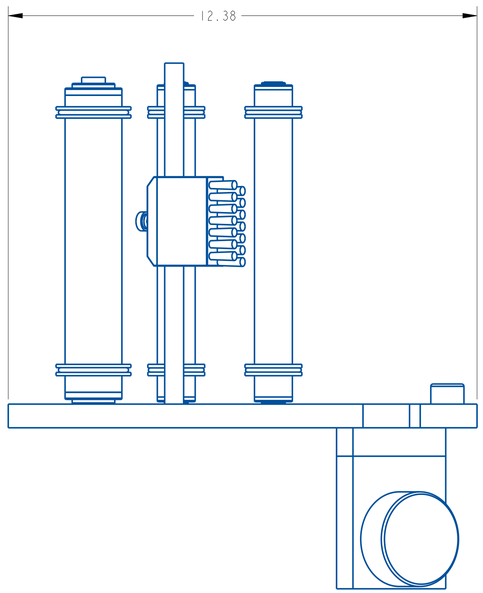
MAT'L

22620SP-LHH









REV	DATE	DESCRIPTION	BY
A	02-OCT-15	NEW DRAWING	CRT

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 02-OCT-15
DRW BY: CRT
CHK BY:03/26/2024-SEM
APPR BY:

Q120 7" SIDE PLATE ASSEMBLY, LHH

MAT'L

22620SP-LHH

ASSEMBLY TITLE: **Q120 UNWIND ASSEMBLY**

GENERAL FUNCTION:

- Unwind flange provides support for label rolls (side application)
- Dual flanges prevent roll and label movement (top application)
- Dancer arm prevents roll run-away.
- Idler roller with guide collars guides web through slot sensor.
- Brake brush prevents web buckling through slot sensor.

SET UP AND ADJUSTMENTS:

- Move flange to required height and tighten set screw in flange hub.
- For top labeling, add second flange and tighten ratchet knob.
- Adjust dancer tension by turning check nut so that dancer roll snaps back to braking position when labeling head is threaded.
- Slide brake brush so that center of brush lines up with center of web. Rotate brush to provide web tension, then lock into place using the locking knob.
- Position guide collars on idler roll, one slightly above, the other slightly below the web.

DANCER TENSION ADJUSTMENT LOCATION:

- **The unwind tension adjustment is located on the middle underside of the Q120 head. Use the knurled ring to adjust the dancer tension.**

MAINTENANCE:

- Clean all the parts that may acquire glue residue

TROUBLESHOOTING:

PROBLEM	**WHAT TO DO**
- Unwind roll run-away	- Tighten dancer spring, check nut or replace dancer spring, if necessary.
- Unwind roll not stopping	- Replace brake ring-belt if broken, or unevenly worn.
- Drive roll stalling	- Release web tension produced by brake brush.
- Brush taking fixed shape	- Turn brush around

ASSEMBLY TITLE: **Q120 LABELING HEAD - DANCER ARM ASSEMBLY**

DRAWING NO.: **None Applicable**

GENERAL FUNCTION:

- The dancer arm and braking mechanism are used to control the unwind unit which will only advance a few inches of web at any time
- The position of the dancer arm affects the advancement of the web off the label roll.

SET UP AND ADJUSTMENTS:

- The dancer normal position of the dancer arm is reached when the dancer arm locks the supply reel.
- The spring tension can be adjusted to correctly locate the dance arm
- The spring may be adjusted by turning the threaded tensioner located near the unwind unit.
- The spring should be tight enough to bring the dancer arm back to its normal position and hold it with some force, but not tight enough to tear the web during label feed.
- Spring adjustment is also possible by rotating the spring mounting pin on the spring take up pulley around the mounting shaft.
- While in its normal position, the dancer arm roller should not interfere with the supply reel flange.

MAINTENANCE:

- Replace dancer spring if final spring tension is too soft.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Web break	- Lower spring tension on dancer arm
- Too much web slack	- Increase sprint tension
- Dancer arm hits supply flange	- Correct dancer arm final position by loosening the brake cam.

ASSEMBLY TITLE: **Q120 LABELING HEAD - BRAKE BRUSH ASSEMBLY**

GENERAL FUNCTION:

- The brake brush establishes web tension and controls backlash

SET UP AND ADJUSTMENTS:

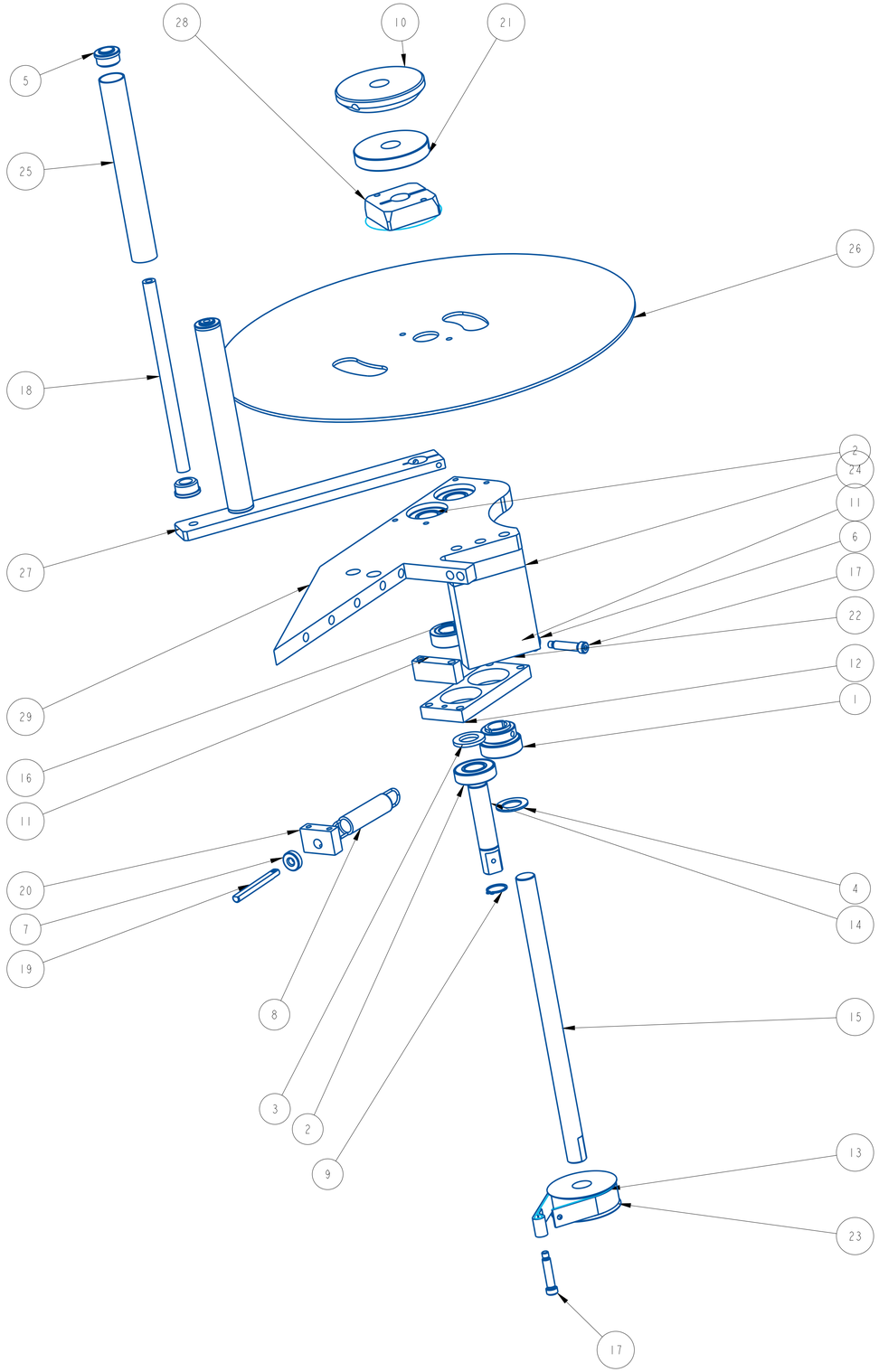
- For accurate label feeds, the web must establish proper tension.
- Loosen the holding set screw in the brake brush body. The brake brush assembly can now be rotated on axis.
- Turn brush body into the web and tighten. To check for proper web tension, jog a label and check for web slack. If the web is tight and the label feeds correctly, the brush tension is set correctly.
- If backlash persists, continue to increase brake brush tension.

MAINTENANCE:

- Replace brake brush when brush body contour no longer viable or bristles are worn down.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Web break	-Too much brake tension. Decrease until no slack in web. - Debris or brake flaw causing web tear
- Motor stall	- Decrease brake tension
- Too much web slack	- Increase brake tension



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	111044-000	BEARING, 3/4 ID CLAMP TYPE	22620U-RHH
2	3	111074-000	BEARING, BALL	22620U-RHH
3	1	151001-000	BEARING, THRUST WASHER	22620U-RHH
4	1	151006-000	BEARING, THRUST WASHER	22620U-RHH
5	4	181063-000	BEARING, ROLL END	22620U-RHH
6	1	361165-000	COLLAR, SETSCREW, 5/16" BORE	22620U-RHH
7	1	801601-000	CHECK NUT	22620U-RHH
8	1	811216-000	EXTENSION SPRING, STAINLESS	22620U-RHH
9	1	871025-000	EXTERNAL SNAP RING	22620U-RHH
10	1	A20583-000	QUICK LOCK COLLAR REWORK	22620U-RHH
11	2	A20585-000	SUPPORT SPACER	22620U-RHH
12	1	A20590-000	BEARING PLATE	22620U-RHH
13	1	A20591-000	UNWIND BRAKE DRUM	22620U-RHH
14	1	A20592-200	UNWIND DANCER SHAFT	22620U-RHH
15	1	A20593-001	UNWIND SHAFT	22620U-RHH
16	1	A20595-000	DANCER COLLAR	22620U-RHH
17	2	A20596-000	DANCER BOLT	22620U-RHH
18	2	A20928-002	ROLLER SHAFT	22620U-RHH
19	1	A23131-000	STUD	22620U-RHH
20	1	A23298-000	BLOCK, SPRING TENSION	22620U-RHH
21	1	A23406-000	SUPPLY REEL CENTER HUB	22620U-RHH
22	1	A24905-006	PIVOT PIN MOUNTING PLATE	22620U-RHH
23	1	A25825-000_22620	BRAKE BAND	22620U-RHH
24	1	A25912-000	MOUNTING PIN SPACER	22620U-RHH
25	2	B20071-003	IDLER ROLLER (DANCER)	22620U-RHH
26	1	B20980-001	UNWIND FLANGE	22620U-RHH
27	1	B21113-000	DANCER ARM, 16" UNWIND	22620U-RHH
28	1	B21931-001	CORE HUB	22620U-RHH
29	1	C21236-120	UNWIND SUPPORT PLATE	22620U-RHH

REV	DATE	DESCRIPTION	BY
A	05-OCT-15	NEW DRAWING	CRT

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

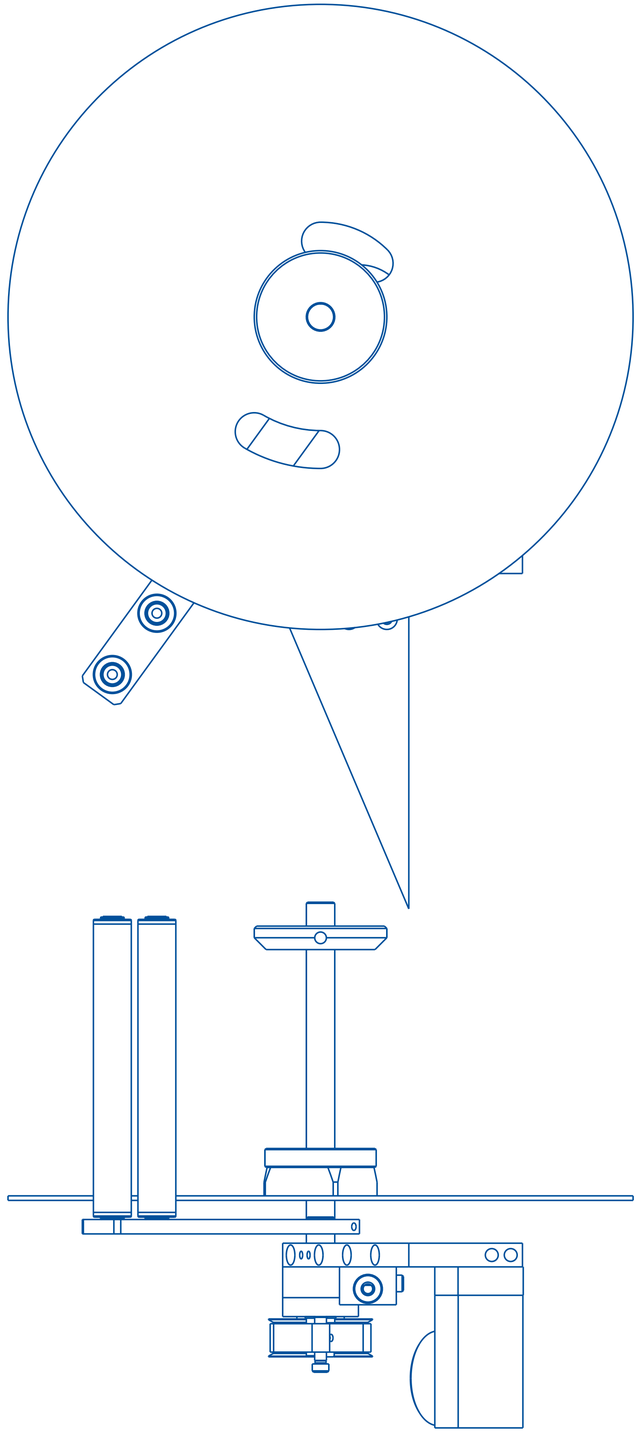
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

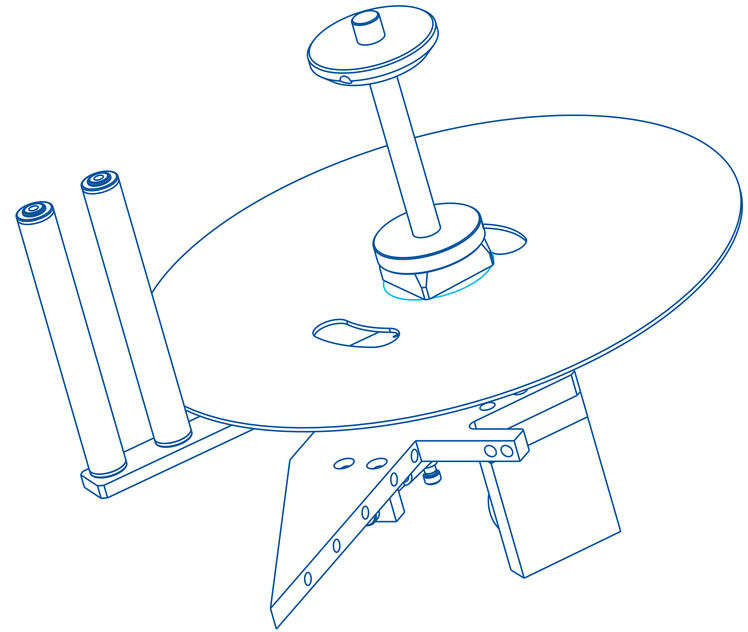
SCALE: 3/8
DATE: 05-OCT-15
DRW BY: CRT
CHK BY: 02/29/2024-SEM
APPR BY:

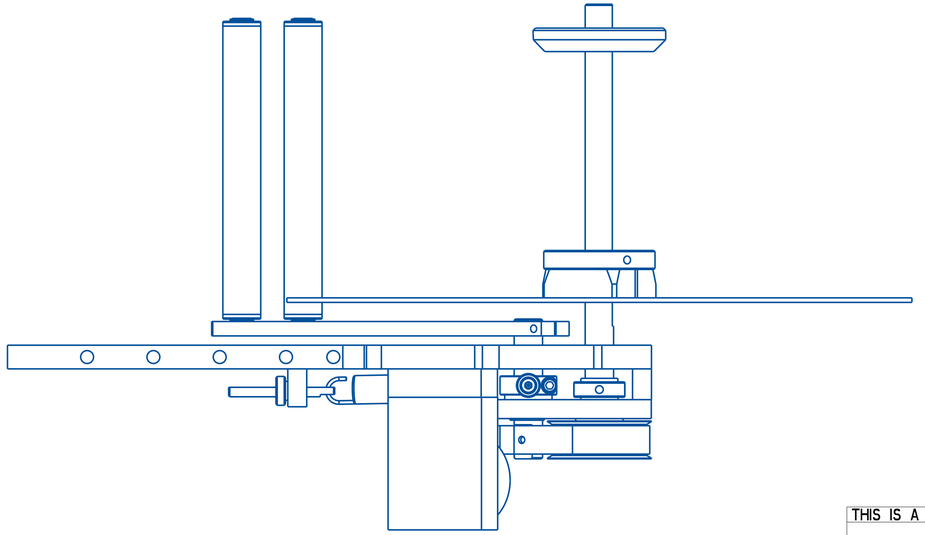
Q120 7" UNWIND ASSEMBLY, RHH

MAT'L

22620U-RHH







REV	DATE	DESCRIPTION	BY
A	05-OCT-15	NEW DRAWING	CRT

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

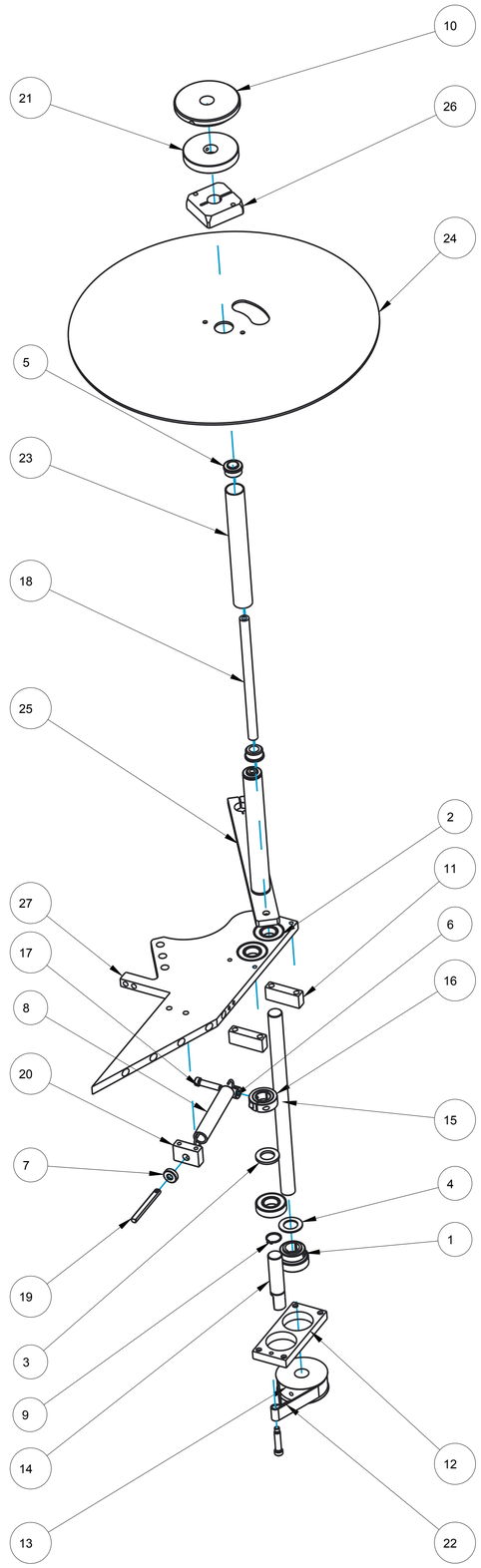
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 05-OCT-15
DRW BY: CRT
CHK BY:02/29/2024-SEM
APPR BY:

Q120 7" UNWIND ASSEMBLY, RHH

MAT'L

22620U-RHH



ITEM	QTY	PART NO.	DESCRIPTION
1	1	111044-000	BEARING, 3/4 ID CLAMP TYPE
2	3	111074-000	BEARING, BALL
3	1	151001-000	BEARING, THRUST WASHER
4	1	151006-000	BEARING, THRUST WASHER
5	4	181063-000	BEARING, ROLL END
6	1	361165-000	COLLAR, SETSCREW, 5/16" BORE
7	1	801601-000	CHECK NUT
8	1	811216-000	EXTENSION SPRING, STAINLESS
9	1	871025-000	EXTERNAL SNAP RING
10	1	A20583-000	QUICK LOCK COLLAR REWORK
11	2	A20585-000	SUPPORT SPACER
12	1	A20590-000	BEARING PLATE
13	1	A20591-000	UNWIND BRAKE DRUM
14	1	A20592-000	UNWIND DANCER SHAFT
15	1	A20593-001	UNWIND SHAFT
16	1	A20595-000	DANCER COLLAR
17	2	A20596-000	DANCER BOLT
18	2	A20928-002	ROLLER SHAFT
19	1	A23131-000	STUD
20	1	A23298-000	BLOCK, SPRING TENSION
21	1	A23406-000	SUPPLY REEL CENTER HUB
22	1	A25825-000_22620	BRAKE BAND
23	2	B20071-003	IDLER ROLLER (DANCER)
24	1	B20980-001	UNWIND FLANGE
25	1	B21113-000	DANCER ARM, 16" UNWIND
26	1	B21931-001	CORE HUB
27	1	C21236-120	UNWIND SUPPORT PLATE

REV	DATE	DESCRIPTION	BY
A	05-OCT-15	NEW DRAWING	CRT

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X± .1
XX± .01
XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

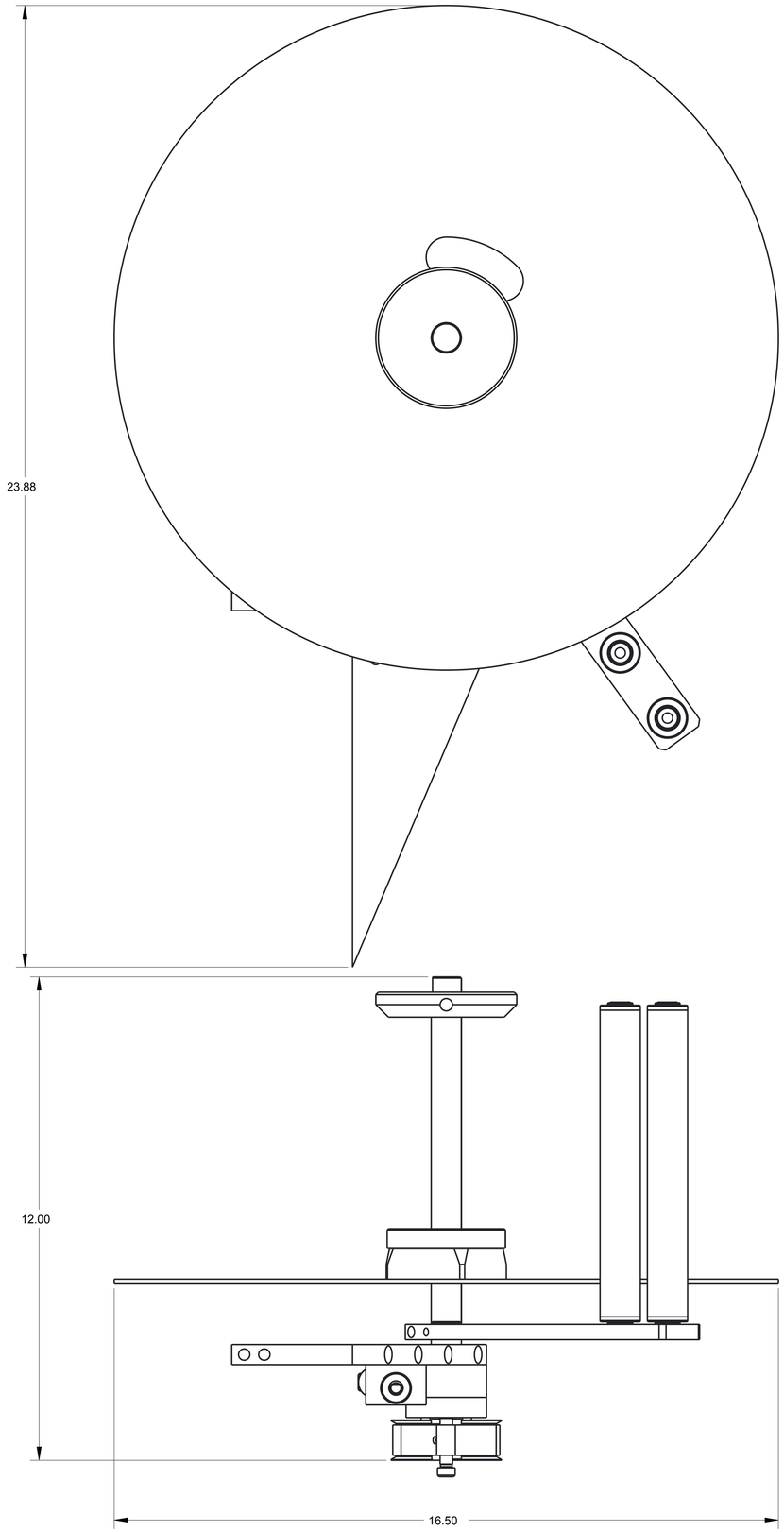
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

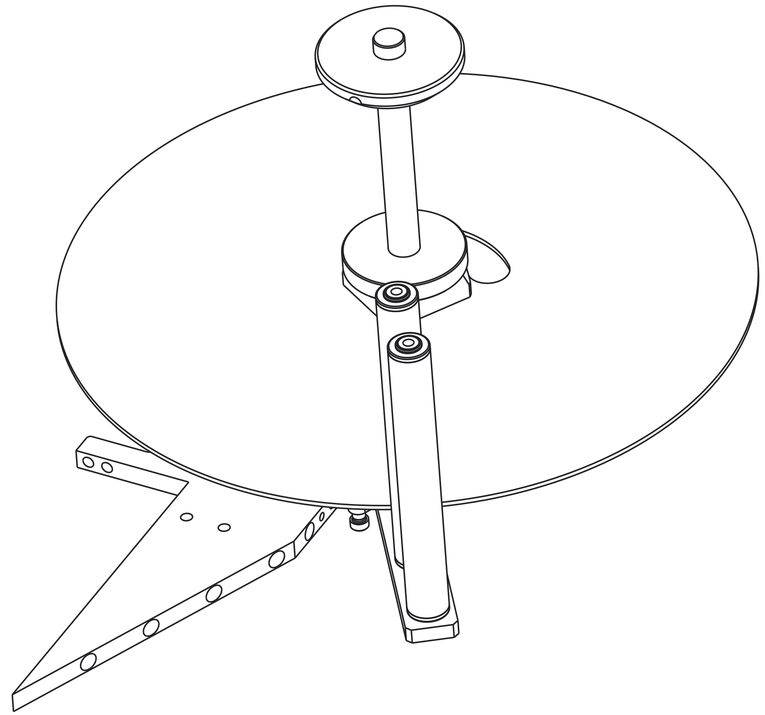
SCALE	1/4
DATE	05-OCT-15
DRAWN BY	CRT

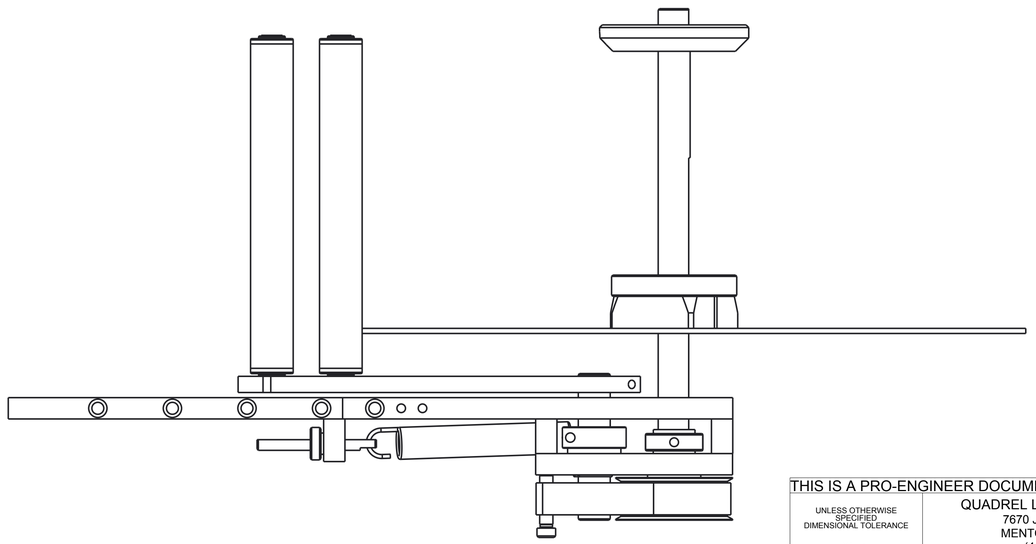
Q120 7" UNWIND ASSEMBLY

MAT'L: 22620U-LHH

22620U-LHH







REV	DATE	DESCRIPTION	BY
A	05-OCT-15	NEW DRAWING	CRT

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE

X± .1
XX± .01
XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE	9/16
DATE	05-OCT-15
DRAWN BY	CRT

Q120 7" UNWIND ASSEMBLY

MAT'L 22620U-LHH

22620U-LHH

ASSEMBLY TITLE: **Q120 PEEL PLATE ASSEMBLY**

GENERAL FUNCTION:

- The peel plate separates the label from the liner and puts the label in a “Flag" position.
- The mounting rods support the slot sensor assembly.
- The guide collars and the idler roller guide the web position over the peel plate
- The pivot pin provides for yoke mounting of the labeling head.

SET UP AND ADJUSTMENTS:

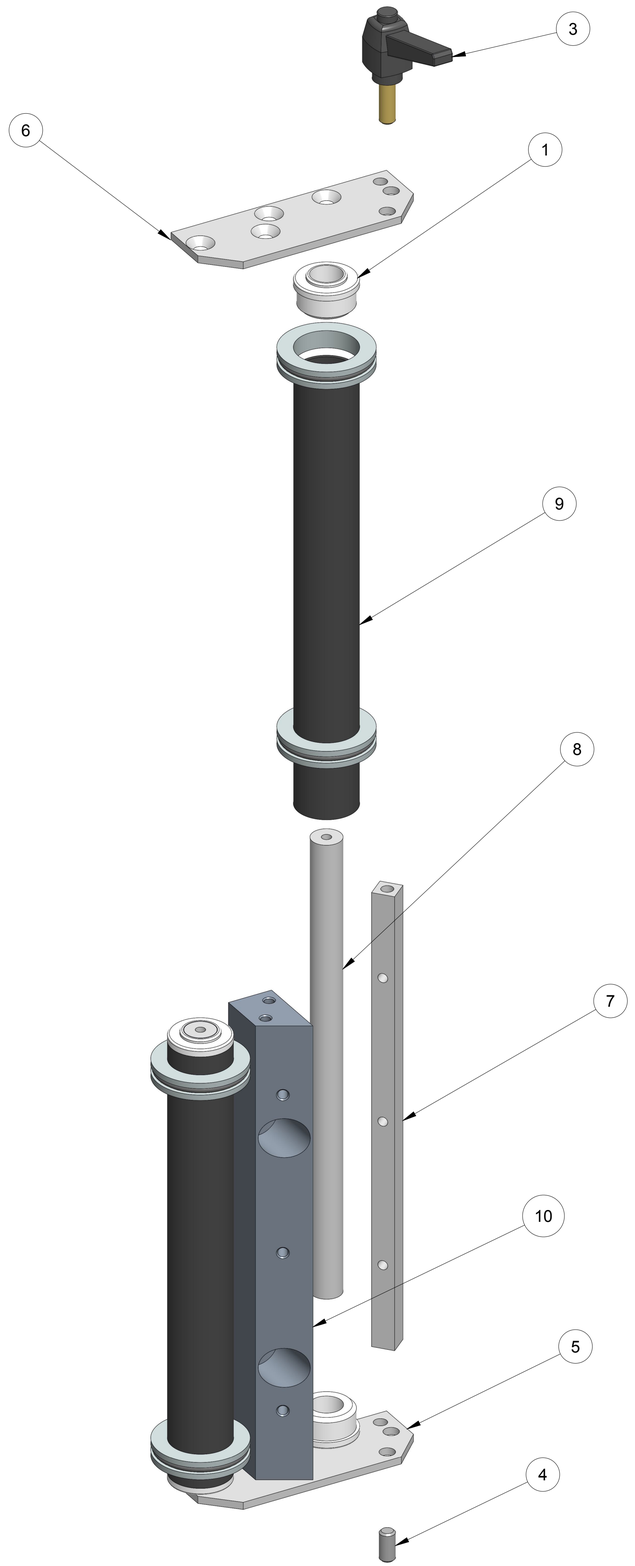
- On machines so equipped, the peel plate may be pivoted at various angles relating to the product by loosening the peel plate mounting bar. (The peel plate of all other models is mounted at a fixed angle and cannot be adjusted)
- To advance label flag on peel plate, move the slot sensor towards the peel plate. To decrease label flag, move slot sensor away from the peel plate.
- Position guide collars on idler roll, one slightly above and the other slightly below the web.

MAINTENANCE:

- Clean all the parts that may acquire labels or glue residue.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Too much label flag at peel plate	- Move slot sensor away from peel edge
- Too little label flag at peel	- Move slot sensor towards peel plate edge
- Web moving up and down peel plate	- Make sure guide collars are properly positioned on idler roll.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	4	181063-000	BEARING, ROLL END	21343PP-00R
2	4	361198-000	COLLAR, GUIDE, 1" ID	21343PP-00R
3	1	801857-000	ADJUSTABLE HANDLE	21343PP-00R
4	1	871369-000	DOWEL PIN, 1/4 DIA X 1/2 LONG	21343PP-00R
5	1	A21758-000	SIDE PLATE	21343PP-00R
6	1	A21758-001	SIDE PLATE	21343PP-00R
7	1	A22245-000	PRESSURE SHOE MOUNTING BAR - 7"	21343PP-00R
8	2	A23791-003	SHAFT, IDLER ROLLER	21343PP-00R
9	2	B21198-003	IDLER ROLLER-(PEEL PLATE)	21343PP-00R
10	1	B7639-000		21343PP-00R

NOT SHOWN:

B21199-001 PEEL PLATE
A21372-000 PRESSURE SHOE
791852-000 PEEL PLATE TAPE

REV	DATE	DESCRIPTION
A	05-FEB-2024	NEW DRAWING

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30°

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

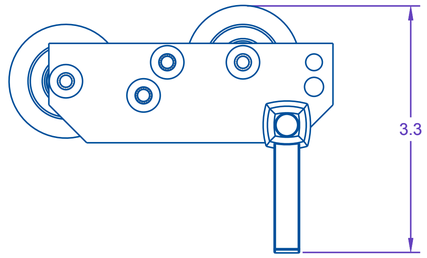
SCALE: 0.875
DATE: 05-FEB-2024
DRW BY: CRT
CHK BY: 03/07/2024-SEM
APPR BY:

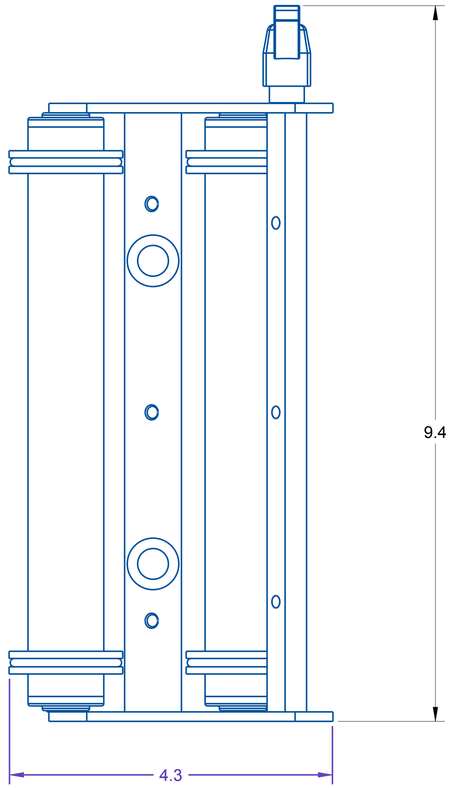
7" PEEL PLATE ASSEMBLY

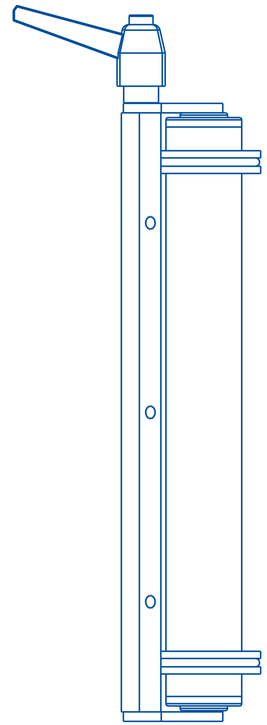
MAT'L

21343PP-00R

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	4	181063-000	BEARING, ROLL END	21343PP-00R
2	4	361198-000	COLLAR, GUIDE, 1" ID	21343PP-00R
3	1	801857-000	ADJUSTABLE HANDLE	21343PP-00R
4	1	871369-000	DOWEL PIN, 1/4 DIA X 1/2 LONG	21343PP-00R
5	1	A21758-000	SIDE PLATE	21343PP-00R
6	1	A21758-001	SIDE PLATE	21343PP-00R
7	1	A22245-000	PRESSURE SHOE MOUNTING BAR - 7"	21343PP-00R
8	2	A23791-003	SHAFT, IDLER ROLLER	21343PP-00R
9	2	B21198-003	IDLER ROLLER-(PEEL PLATE)	21343PP-00R
10	1	B7639-000		21343PP-00R







REV	DATE	DESCRIPTION
A	05-FEB-2024	NEW DRAWING

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIOS .010/.030

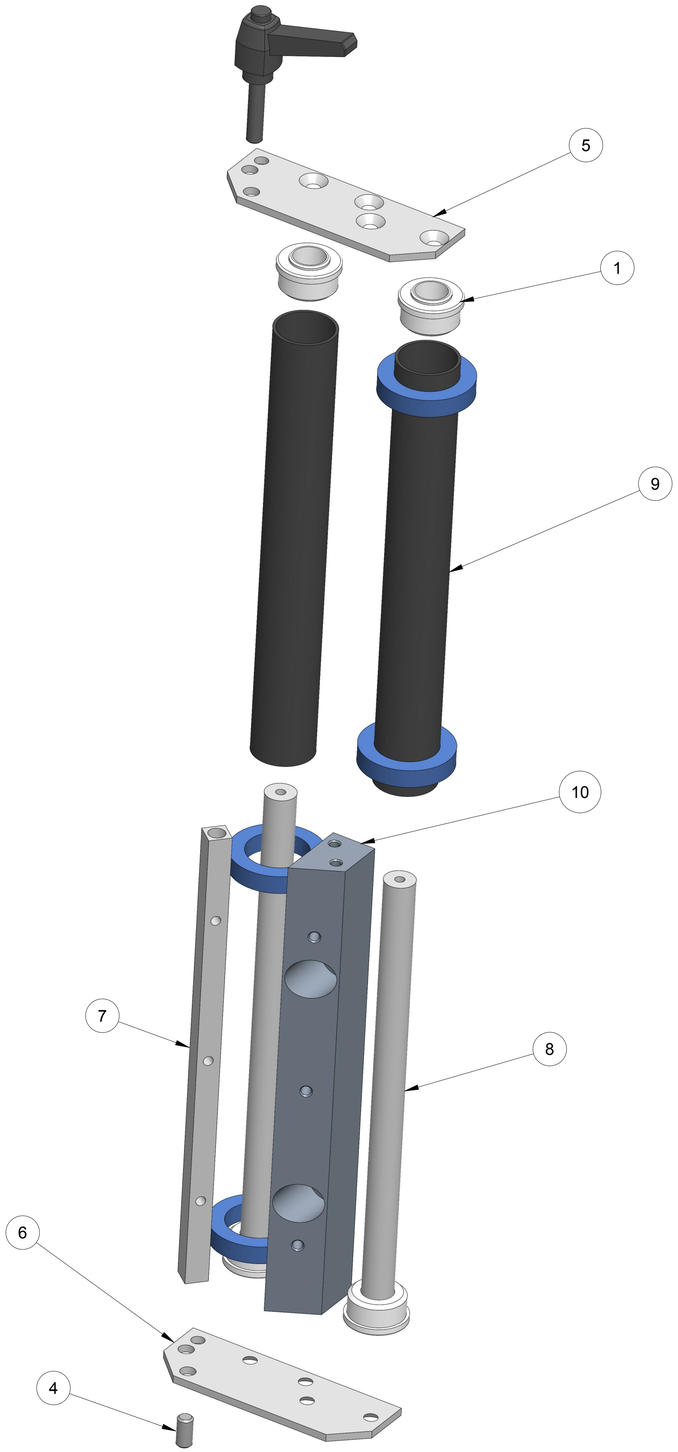
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1.000
DATE: 05-FEB-2024
DRW BY: CRT
CHK BY:03/07/2024-SEM
APPR BY:

7" PEEL PLATE ASSEMBLY

MAT'L

21343PP-00R



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	4	181063-000	BEARING, ROLL END	21343PP-00L
2	1	22811-000	HANDLE ASSEMBLY, LEFT HANDED	21343PP-00L
3	4	361198-000	COLLAR, GUIDE, 1" ID	21343PP-00L
4	1	871369-000	DOWEL PIN, 1/4 DIA X 1/2 LONG	21343PP-00L
5	1	A21758-000	SIDE PLATE	21343PP-00L
6	1	A21758-001	SIDE PLATE	21343PP-00L
7	1	A22245-002	PRESSURE SHOE MOUNTING BAR - 7"	21343PP-00L
8	2	A23791-003	SHAFT, IDLER ROLLER	21343PP-00L
9	2	B21198-003	IDLER ROLLER-(PEEL PLATE)	21343PP-00L
10	1	B7639-000		21343PP-00L

NOT SHOWN:

B21199-001 PEEL PLATE
A21372-000 PRESSURE SHOE
791852-000 PEEL PLATE TAPE

REV	DATE	DESCRIPTION
A	05-FEB-2024	NEW DRAWING

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X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30°

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .0107.030

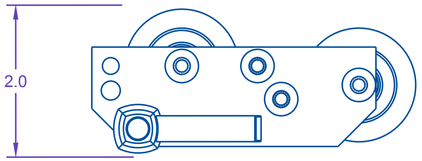
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

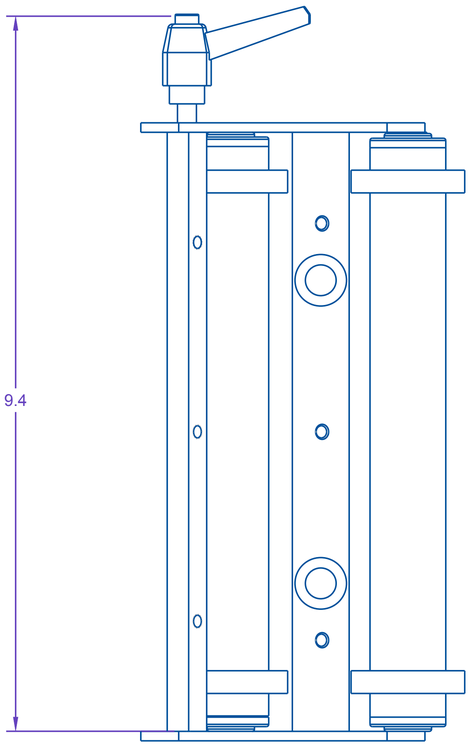
SCALE: 0.875
DATE: 05-FEB-2024
DRW BY: CBT
CHK BY:03/07/2024-SEM
APPR BY:

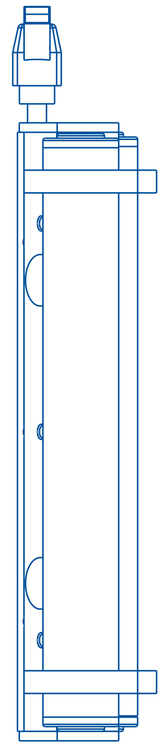
7" PEEL PLATE ASSEMBLY

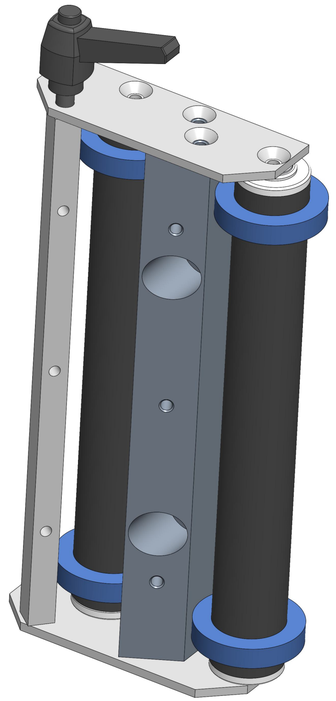
MAT'L

21343PP-00L









REV	DATE	DESCRIPTION	BY
A	2-5-24	NEW DRAWING	CRT

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

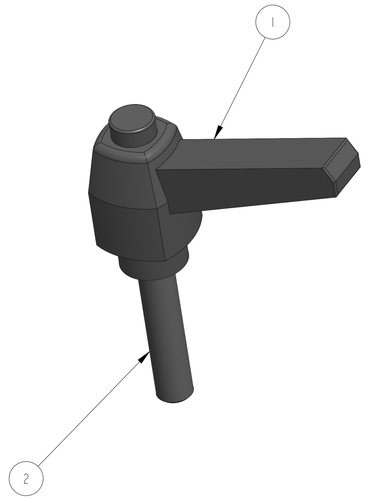
SCALE:	1.000
DATE:	05-FEB-2024
DRW BY:	CRT
CHK BY:	&CREO_CHK
APPR BY:	

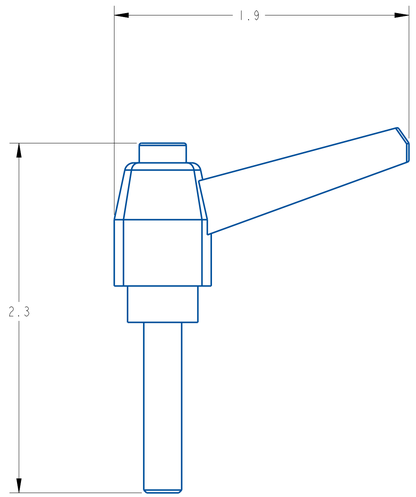
7" PEEL PLATE ASSEMBLY

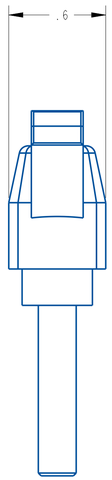
MAT'L

21343PP-00L

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	801899-000	HANDLE	22811-000
2	1	841812-000	STUD	22811-000







REV	DATE	DESCRIPTION	BY
A	Feb-05-24	NEW DRAWING	CRT

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 2/1
DATE: Feb-05-24
DRW BY: CRT
CHK BY:
APPR BY:

HANDLE ASSEMBLY, LEFT HANDED THREAD

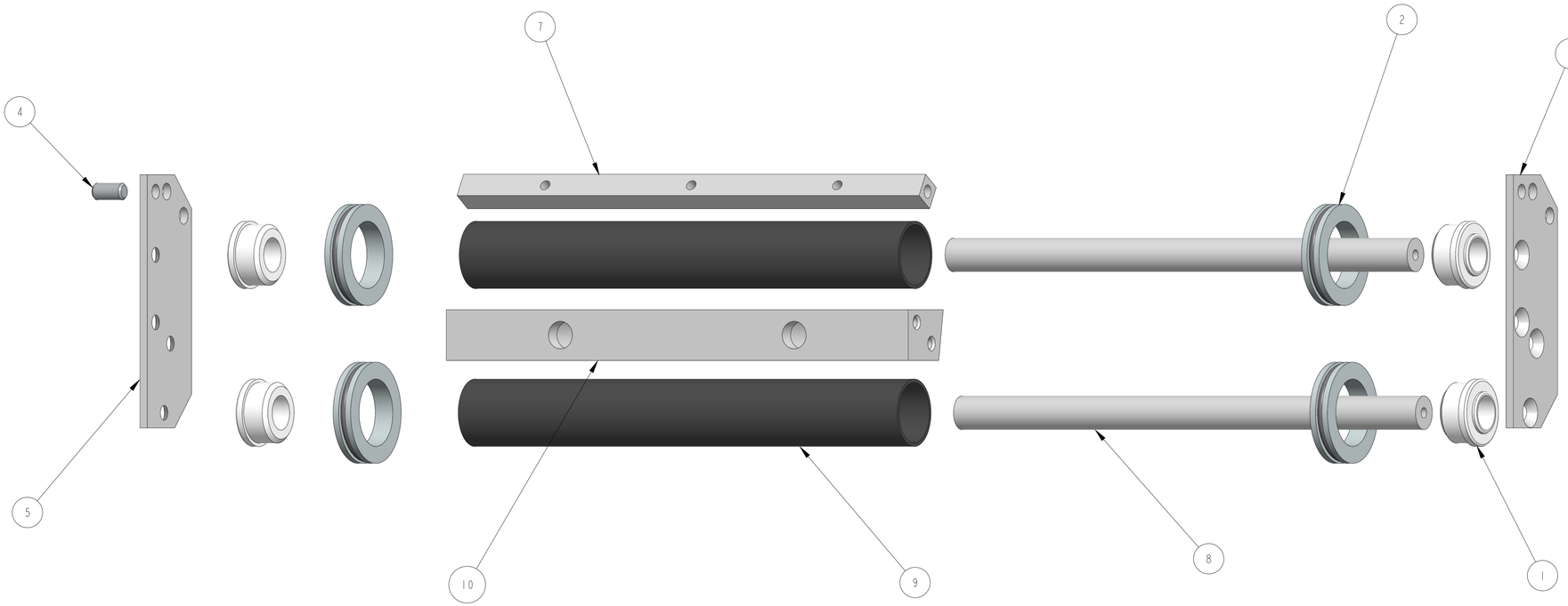
MAT'L

22811-000

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	4	181063-000	BEARING, ROLL END	20793-000
2	4	361198-000	COLLAR, GUIDE, 1" ID	20793-000
3	1	801857-000	ADJUSTABLE HANDLE	20793-000
4	1	871369-000	DOWEL PIN, 1/4 DIA X 1/2 LONG	20793-000
5	1	A21758-000	SIDE PLATE	20793-000
6	1	A21758-001	SIDE PLATE	20793-000
7	1	A22245-000	PRESSURE SHOE MOUNTING BAR - 7"	20793-000
8	2	A23791-003	SHAFT, IDLER ROLLER	20793-000
9	2	B21198-003	IDLER ROLLER-(PEEL PLATE)	20793-000
10	1	B7640-000	PEEL PLATE MTG. BAR - 7" WRAP	20793-000

NOT SHOWN:

B21199-001 PEEL PLATE
A21175-000 PRESSURE SHOE
791852-000 PEEL PLATE TAPE



REV	DATE	DESCRIPTION	BY
A	01-MAY-2024	NEW DRAWING	CRT

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIOS .0107.030

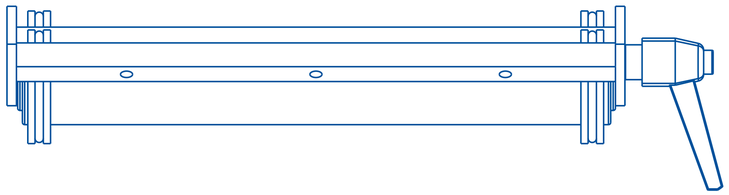
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

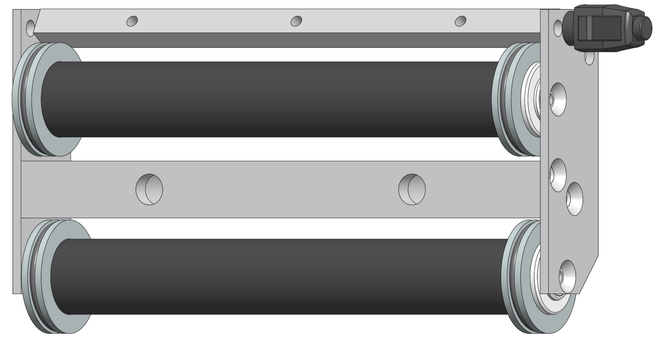
SCALE: 1/1
DATE: 01-MAY-2024
DRW BY: CRT
CHK BY:03/08/2024-SEM
APPR BY:

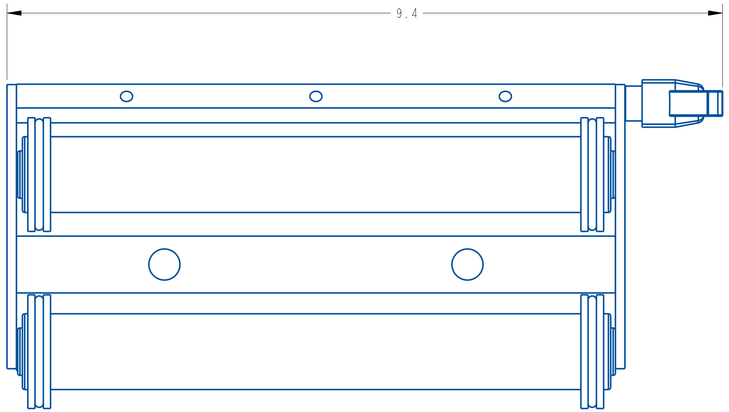
Q60/62 7" WRAP PEEL PLATE

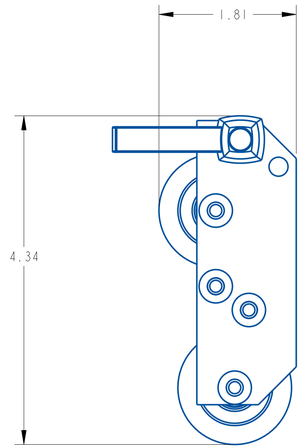
MAT'L 20793-000

20793-000









REV	DATE	DESCRIPTION	BY
A	01-MAY-2024	NEW DRAWING	CRT

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30°

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .0107.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/1
DATE: 01-MAY-2024
DRW BY: CRT
CHK BY: 03/08/2024-SEM
APPR BY:

Q60/62 7" WRAP PEEL PLATE

MAT'L 20793-000

20793-000

ASSEMBLY TITLE: **FIXED BRUSH IMPRESSER**

DRAWING NO.: **D21651-000**

GENERAL FUNCTION:

-The fixed roller impresser is an option used in applications where a secondary wipe down or label wipe is necessary.

SET UP AND ADJUSTMENTS:

- When installed, the brush assembly will be mounted by an adjustable clamp. The mounting assembly is fastener to the option rail located on the peel plate side wall.
- Four axis of adjustment is available by loosening the set screw locking the roller arm in place.
- Locate the brush as necessary and re-tighten the clamping screws.
- Run a product through the brush area and insure the brush layed on the product but do not impede product travel. The brush can be adjusted too close to the product which will prevent the product from smoothly traversing through the brush area.

MAINTENANCE:

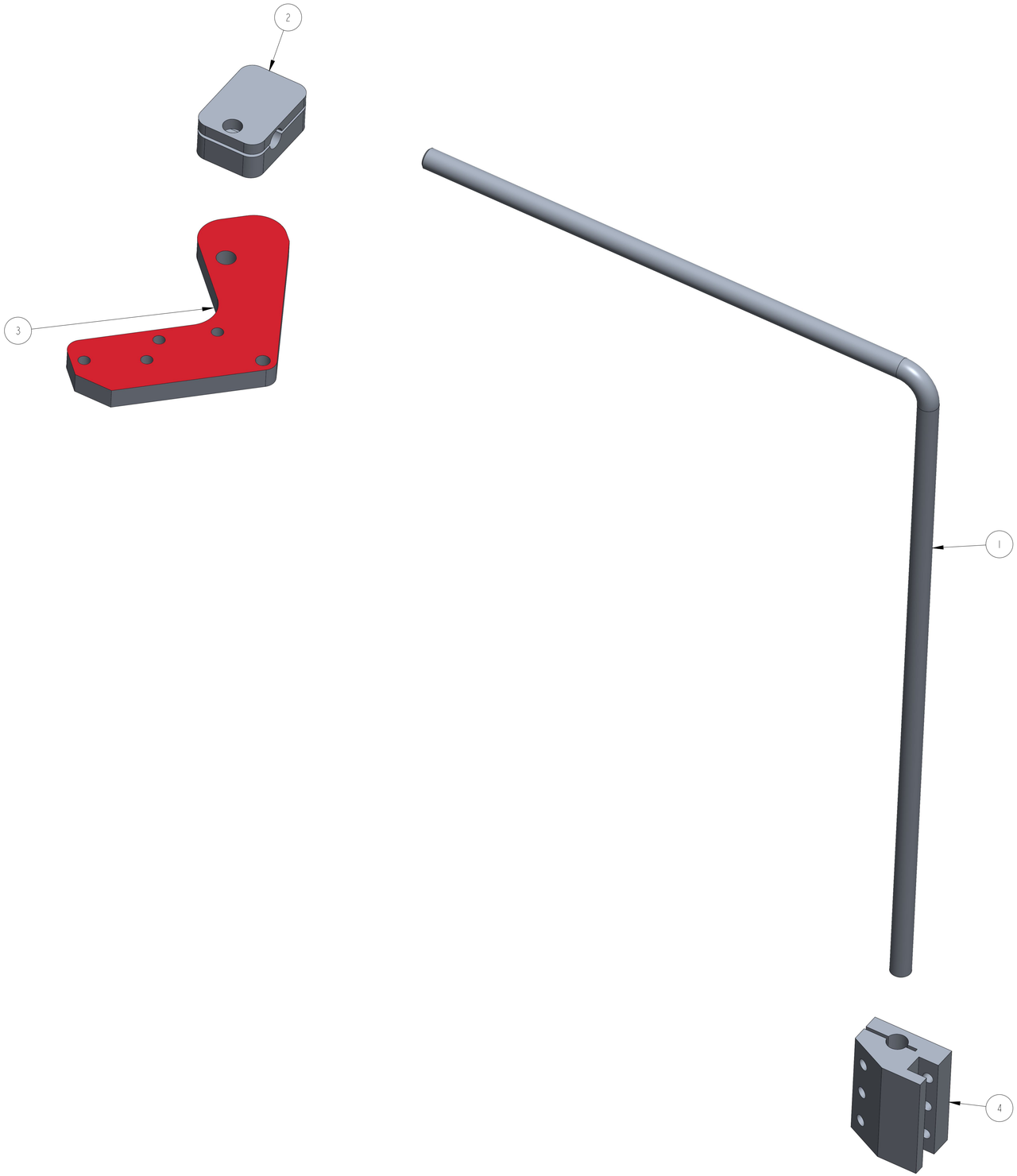
- Keep the brush free of label flash, glue and debris. This will prevent jamming and web tears.

NOTE: Exercise caution when removing bad labels from brush. Careless removal can result in brisals being pull out which may leave the labeler inoperable until the brush is replaced!

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Product jams at brush area	- Increase brush spacing.
- Bubbles in label	- Decrease labeling speed
- Label edge curling	- Decrease product delay
- Wipedown inadequate	- Decrease brush spacing.

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	A21264-018	CROSS ARM	10228-005_R
2	1	A21693-300	IMPRESSOR MOUNTING BLOCK	10228-005_R
3	1	A21758-300	PEEL PLATE SIDE PLATE .375"THK	10228-005_R
4	1	A23463-100	BRUSH HOLDER	10228-005_R



REV	DATE	DESCRIPTION	BY
A	Mar-02-20	NEW DRAWING	TJS

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE

.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30°

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

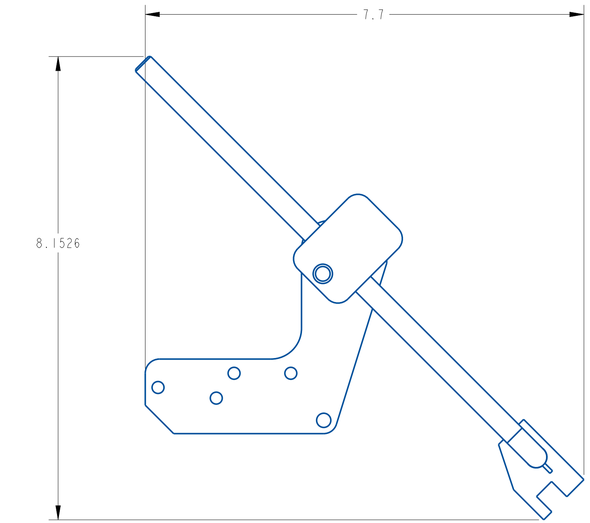
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

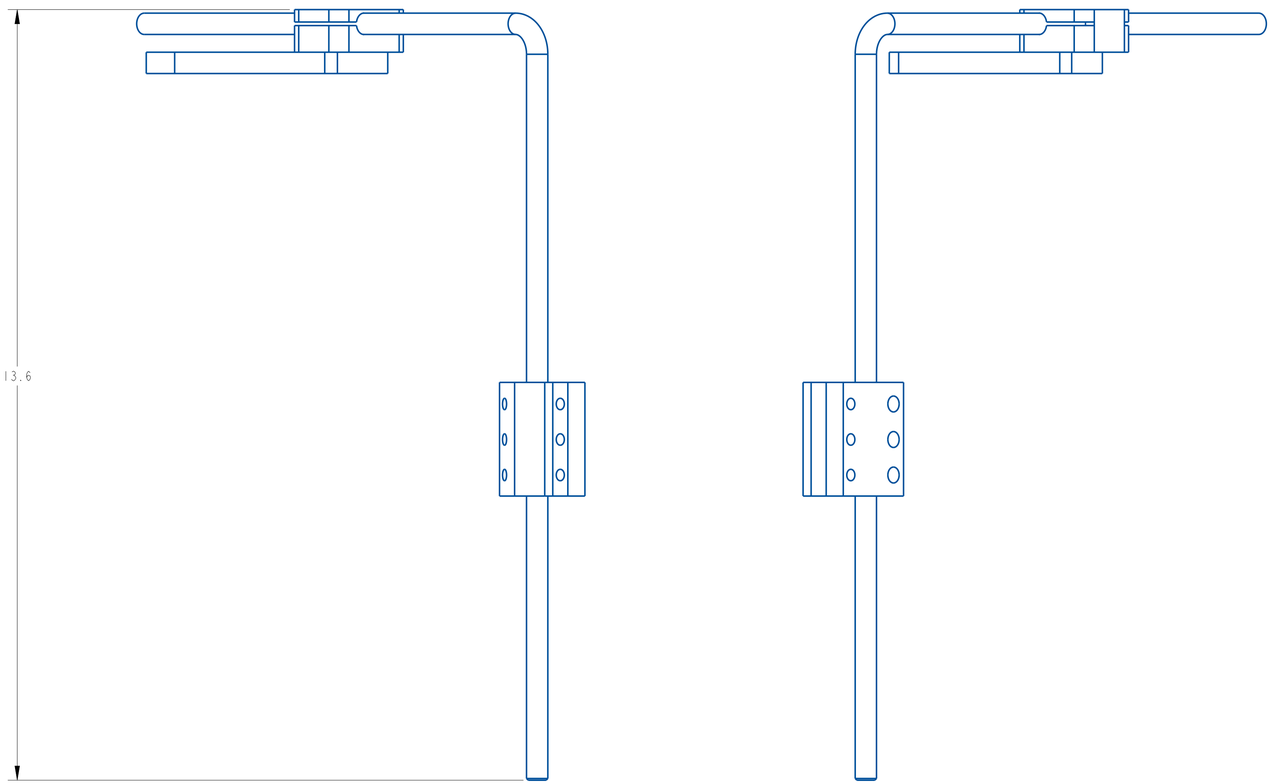
SCALE: 1/1
DATE: Mar-02-20
DRW BY: TJS
CHK BY: 03/06/2024-SEM
APPR BY:

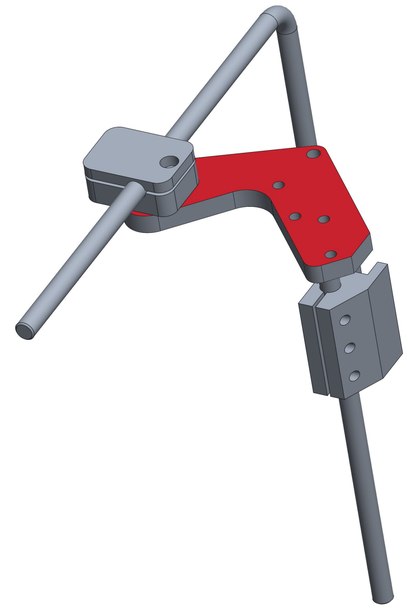
HEAVY DUTY IMPRESSOR

MAT'L

10228-005







A	Mar-02-20	NEW DRAWING	TJS
REV	DATE	DESCRIPTION	BY

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 3/4
DATE: Mar-02-20
DRW BY: TJS
CHK BY:03/06/2024-SEM
APPR BY:

HEAVY DUTY IMPRESSOR

MAT'L

10228-005

ASSEMBLY TITLE: **Q120 DRIVE AND PINCH ROLL ASSEMBLY**

GENERAL FUNCTION:

- The drive roll pulls the liner through the entire labeling head. As the liner is pulled over the peel edge, the label dispenses.
- The spring-loaded pinch roll squeezes the liner against the drive roll to provide positive drive.
- The primary roll is the pull or drive roll as shown. The knurl roll provides a constant pressure against the pull roll.

SET UP AND ADJUSTMENTS:

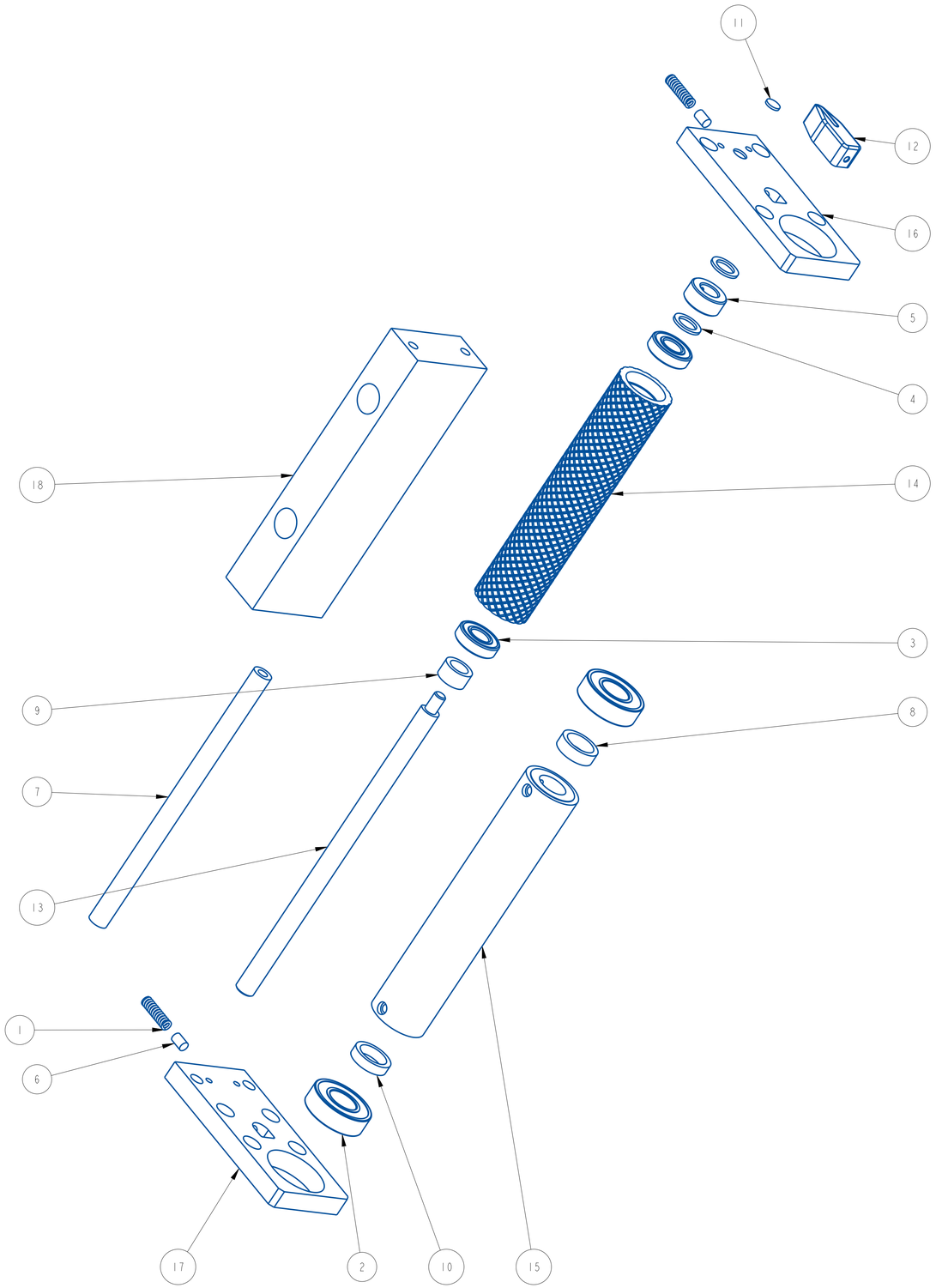
- When threading the labeling head, use the pinch roll lever to release the pinch roll from the drive roll.
- Use the spring plunger adjustment screws to adjust the contact pressure. between the knurl and pull rollers.
- The pressure should be adjusted as tight as necessary to prevent a loose liner, while still allowing full rotation of the pressure release arm.

MAINTENANCE:

- Clean all parts that may have acquired label or glue residue

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Meter pulley rubbing against side plate	- Center pulley on motor shaft and tighten two (2) set screws in pulley.
- Web slips	- Drive roller not closed. Turn drive roll arm to closed position.
- Drive roll not rotating when stepping motor rotates	- Replace timing belt from motor to drive roll
- Pinch roll not providing enough pressure against drive roll	- Replace pinch roll spring - Increase tension on drive roll by adjusting spring loaded locking pins.
- Drive roll unevenly worn causing tracking problem	- Replace drive roll



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	00301-17	SPRING, .275 x .052 x .94	22620D-LHH
2	2	111052-000	BEARING	22620D-LHH
3	2	111072-000	BEARING, BALL	22620D-LHH
4	2	151004-000	BEARING, THRUST WASHER	22620D-LHH
5	1	362161-000	COLLAR, SETSCREW, 1/2 IN. ID	22620D-LHH
6	2	A20567-000	WHITE NYLON SLUG	22620D-LHH
7	1	A21750-000	PINCH POINT GUARD ROD	22620D-LHH
8	1	A23125-000	SPACER	22620D-LHH
9	1	A23751-000	SPACER	22620D-LHH
10	1	A23752-000	SPACER	22620D-LHH
11	1	A25249-000	INDEX DOT	22620D-LHH
12	1	A25250-000	IND KNOB	22620D-LHH
13	1	B20125-001	KNURLED ROLL SHAFT,	22620D-LHH
14	1	B20126-001	KNURLED ROLL	22620D-LHH
15	1	B20137-002	PULL ROLL, 7"	22620D-LHH
16	1	B21614-000	YOKE OUTSIDE PLATE	22620D-LHH
17	1	B21615-000	YOKE INSIDE PLATE	22620D-LHH
18	1	B21616-001	YOKE FILLER BAR	22620D-LHH

REV	DATE	DESCRIPTION	BY
B	19-FEB-2024	UPDATED DRAWING AND BOM	CRT
A	01-OCT-2015	NEW DRAWING	CRT

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X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .0107.030

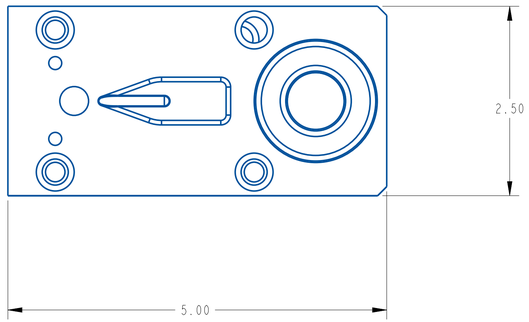
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

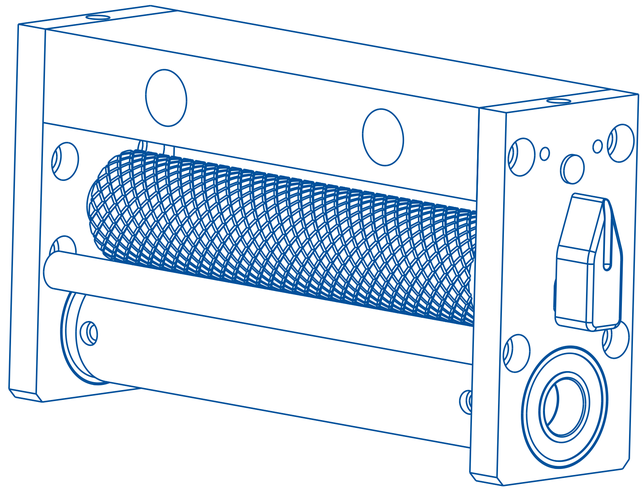
SCALE: 5/8
DATE: 05-OCT-15
DRW BY: CRT
CHK BY:03/26/2024-SEM
APPR BY:

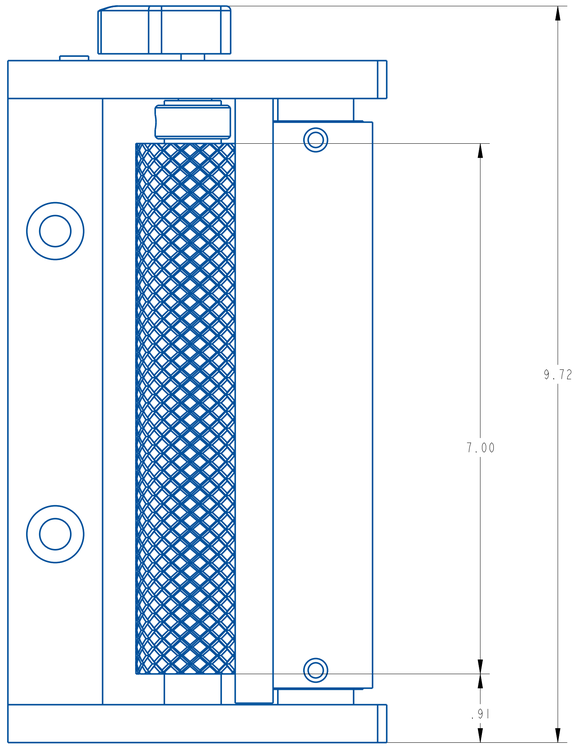
Q120 DRIVE ASSEMBLY, LHH

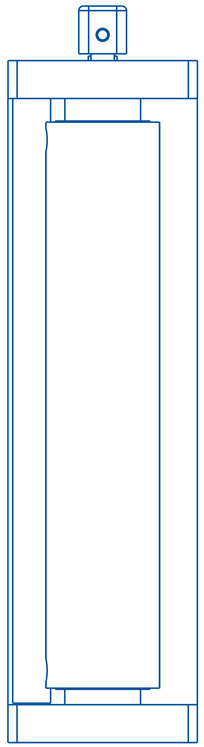
MAT'L 22620D-LHH

22620D-LHH









REV	DATE	DESCRIPTION	BY
A	CRT	NEW DRAWING	

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

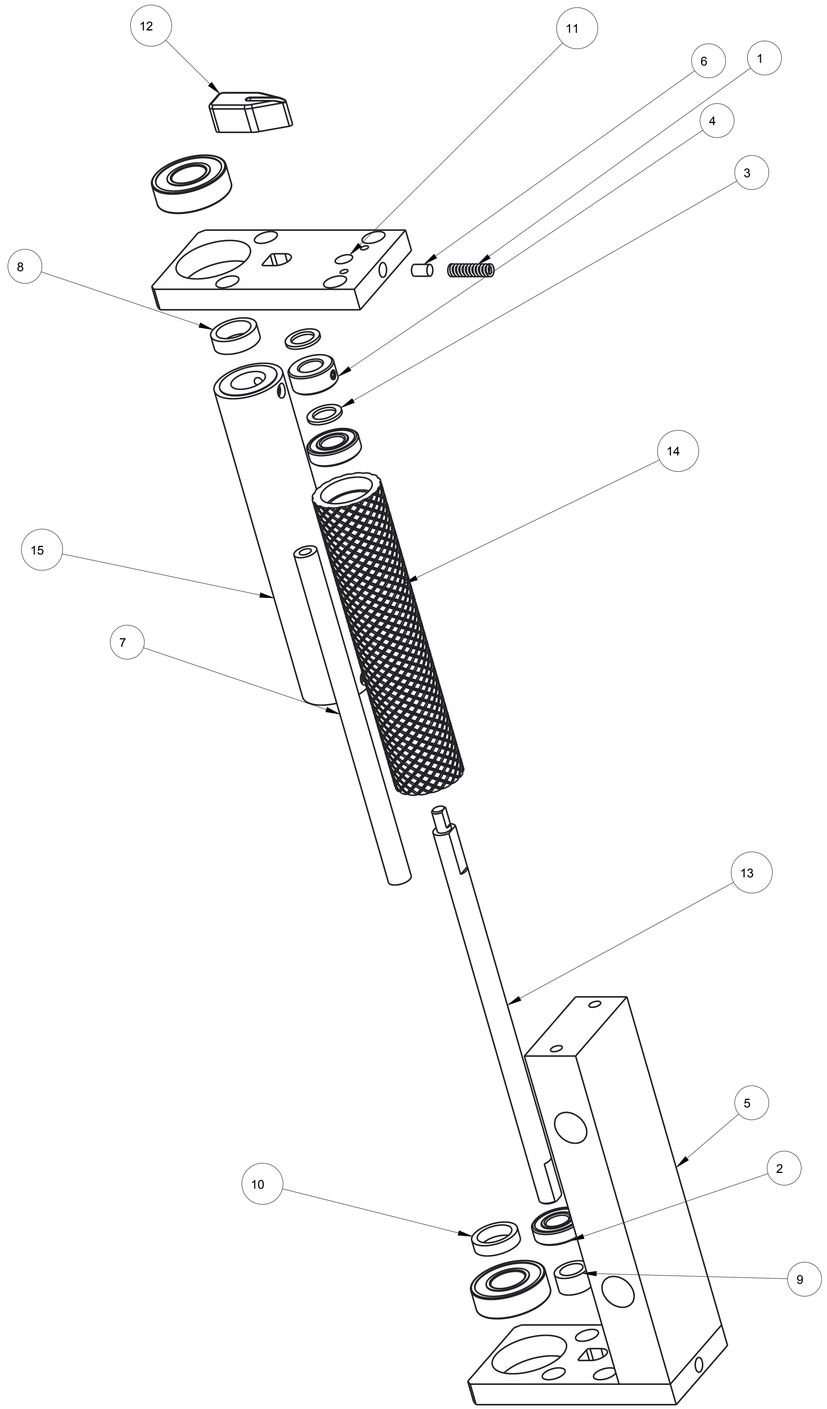
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/1
DATE: 05-OCT-15
DRW BY: CRT
CHK BY:03/26/2024-SEM
APPR BY:

Q120 DRIVE ASSEMBLY, LHH

MAT'L

22620D-LHH



ITEM	QTY	PART NO.	DESCRIPTION
1	2	00301-17	SPRING, .275 x .052 x .94
2	2	111072-000	BEARING, BALL
3	2	151004-000	BEARING, THRUST WASHER
4	1	362161-000	COLLAR, SETSCREW, 1/2 IN. ID
5	1	21700DY-000	
6	2	A20567-000	WHITE NYLON SLUG
7	1	A21750-000	PINCH POINT GUARD ROD
8	1	A23125-000	SPACER
9	1	A23751-000	SPACER
10	1	A23752-000	SPACER
11	1	A25249-000	INDEX DOT
12	1	A25250-000	IND KNOB
13	1	B20125-001	KNURLED ROLL SHAFT,
14	1	B20126-001	KNURLED ROLL
15	1	B20137-002	PULL ROLL, 7"

REV	DATE	DESCRIPTION	BY
A	02-OCT-15	NEW DRAWING	CRT

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DIMENSIONAL TOLERANCE
X± .1
XX± .01
XXX± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

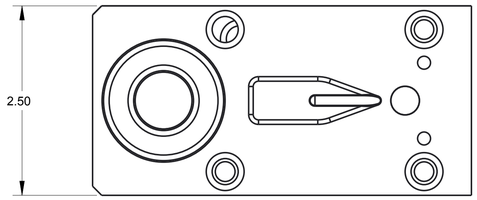
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

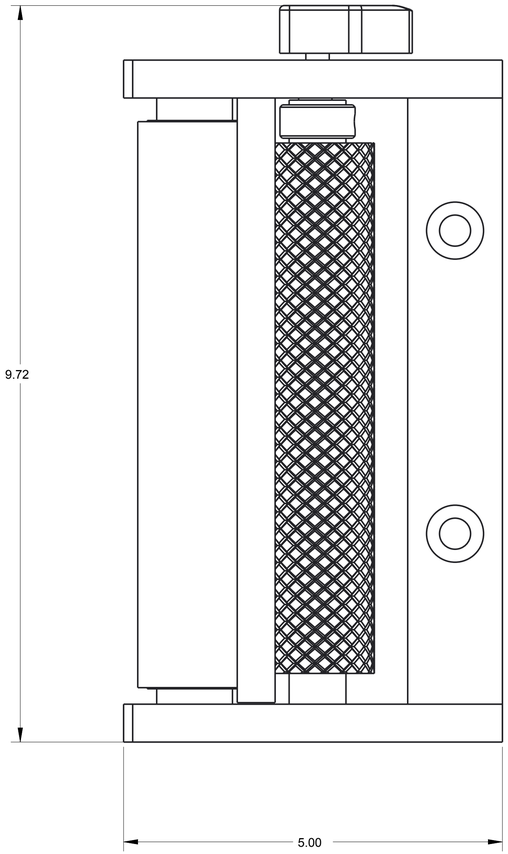
SCALE	5/8
DATE	02-OCT-15
DRAWN BY	CRT

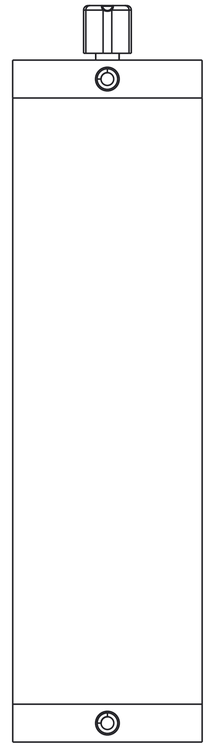
Q60 7" SERVO DRIVE

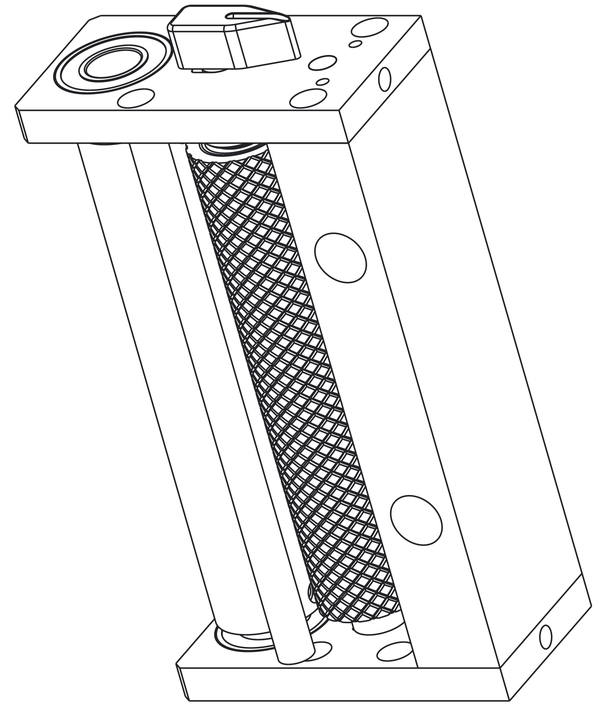
MAT'L 22620D-RHH

22620D-RHH









REV	DATE	DESCRIPTION	BY
A	02-OCT-15	NEW DRAWING	CRT

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X± .1
XX± .01
XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

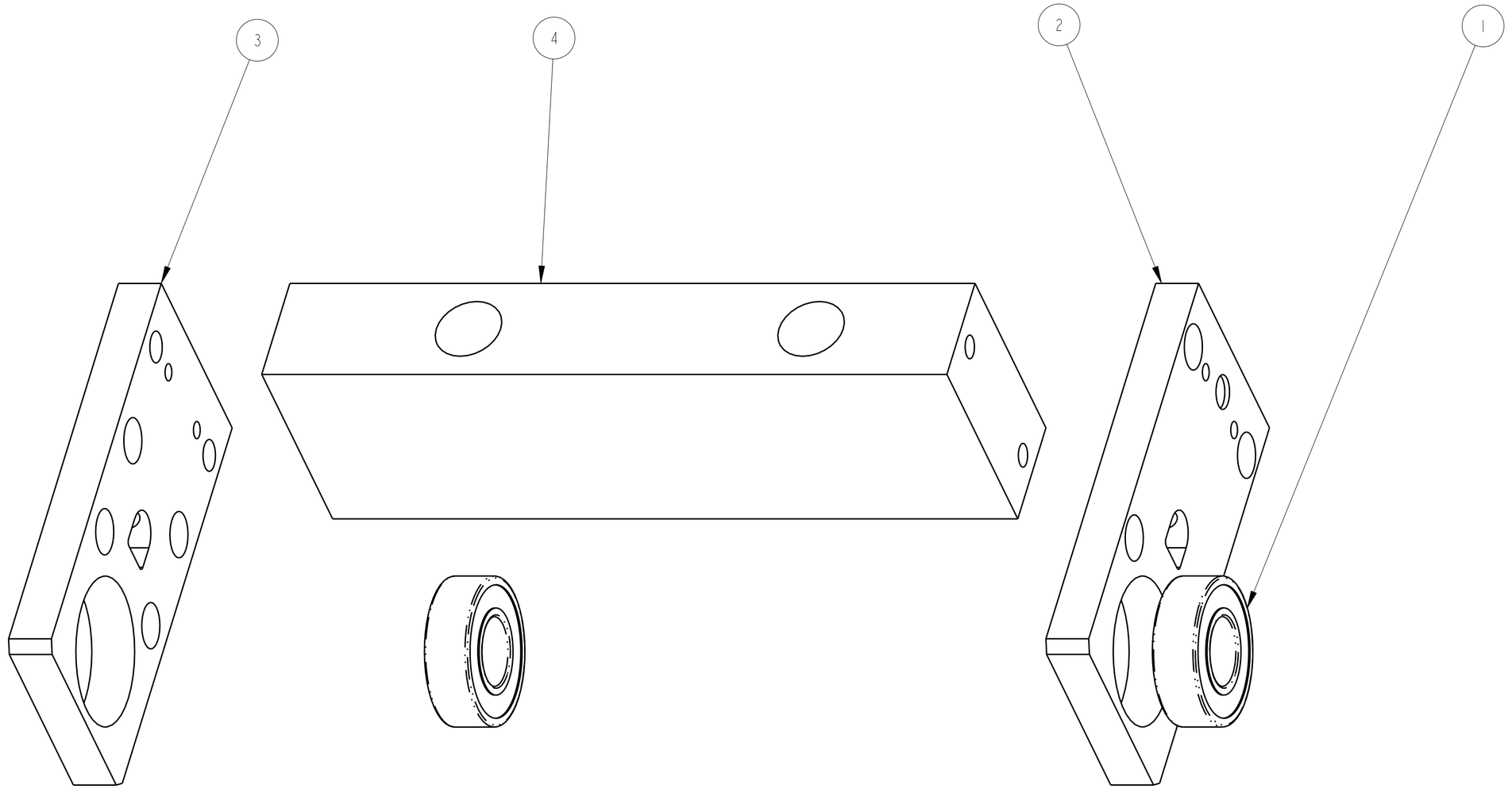
SCALE	1/1
DATE	02-OCT-15
DRAWN BY	CRT

Q60 7" SERVO DRIVE

MAT'L 22620D-RHH

22620D-RHH

ITEM	QTY	PART NO.	DESCRIPTION
1	2	111052-000	BEARING
2	1	B21614-000	YOKE OUTSIDE PLATE
3	1	B21615-000	YOKE INSIDE PLATE
4	1	B21616-001	YOKE FILLER BAR



REV	DATE	DESCRIPTION
A	3-18-08	NEW DRAWING

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .0107.030

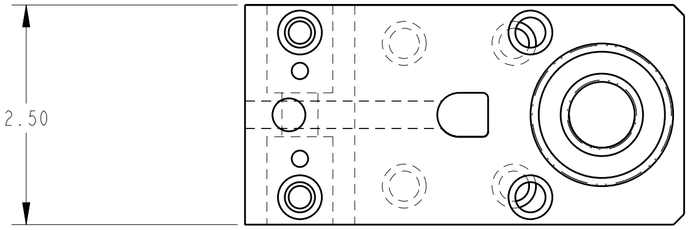
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

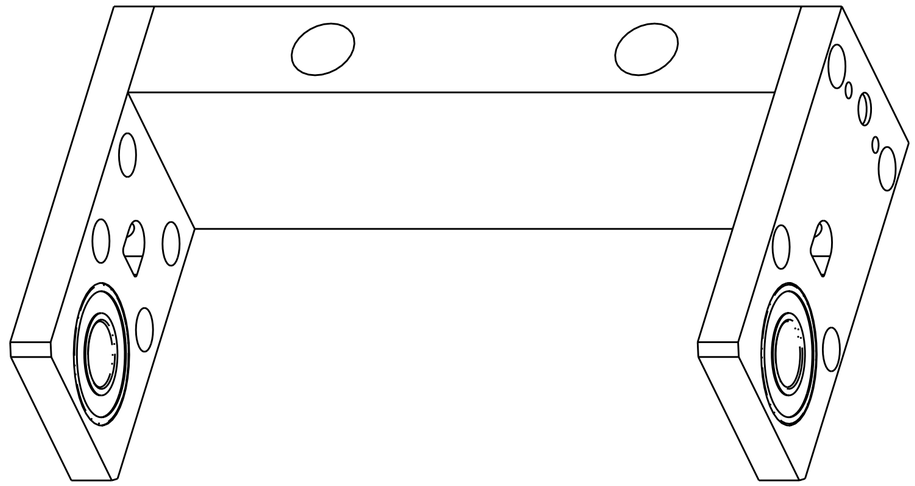
SCALE:	1/1
DATE:	3-18-08
DRW BY:	ATT
CHK BY:	
APPR BY:	

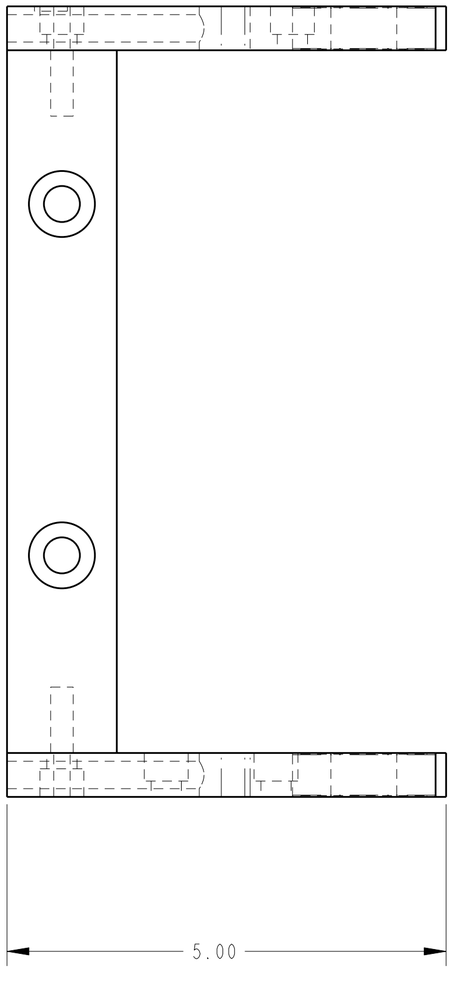
3 PIECE ROLL ASSEMBLY

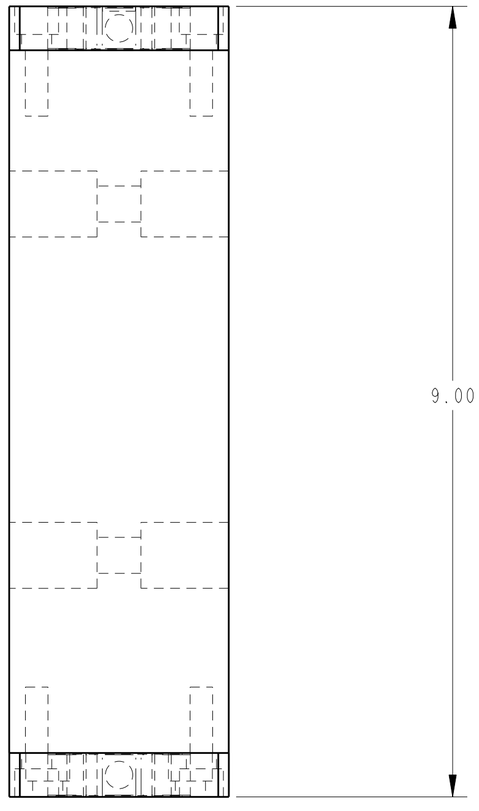
MAT'L: 21700DY-000

C20800-001









REV	DATE	DESCRIPTION
A	3-18-08	NEW DRAWING

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

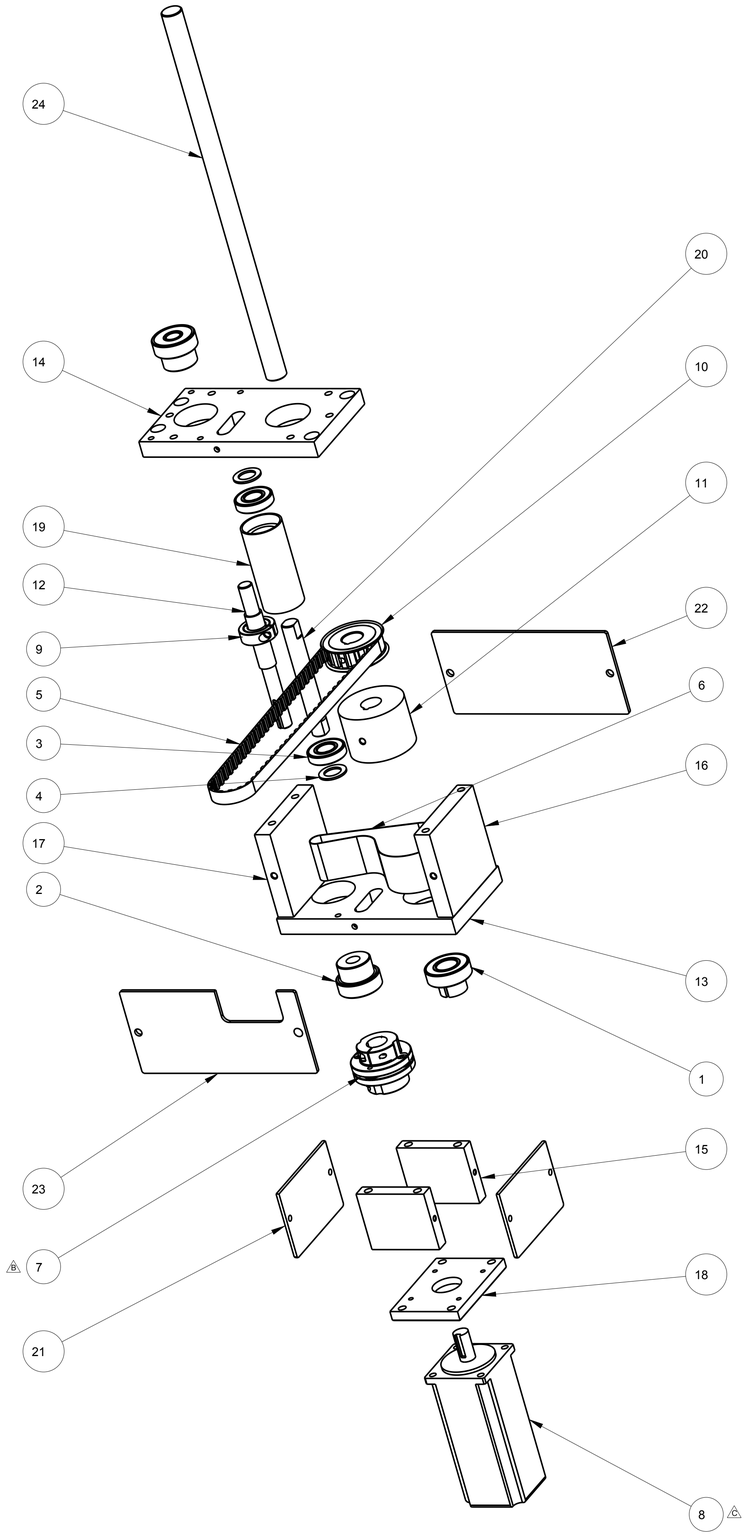
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	3/4
DATE:	3-18-08
DRW BY:	ATT
CHK BY:	
APPR BY:	

3 PIECE ROLL ASSEMBLY

MAT'L: 21700DY-000

C20800-001



ITEM	QTY	PART NO.	DESCRIPTION
1	1	111044-000	BEARING, 3/4 ID CLAMP TYPE
2	2	111072-100	BEARING, BALL
3	2	111075-000	BEARING, BALL
4	2	151008-000	BEARING, THRUST WASHER
5	1	191592-000	BELT, TIMING, 1/2P
6	1	192503-150	TIMING BELT
B 7	1	363159-000	COUPLING
C 8	1	413025-000	SERVO MOTOR
9	1	A20595-120	COLLAR REWORK
10	1	A21421-001	DRIVE PULLEY (MODIFIED)
11	1	A26003-100	DRIVE PULLEY
12	1	A26004-120	SERVO MOTOR PULLEY
13	1	B22842-100	BEARING PLATE
14	1	B22842-101	BEARING PLATE
15	2	B22844-100	SPACER
16	1	B22844-220	SPACER
17	1	B22844-320	SPACER
18	1	B22847-100	MOTOR MOUNTING PLATE
19	1	B22848-120	TENSION ROLLER
20	1	B22849-120	TENSIONER SHAFT
21	2	B22850-100	COVER
22	1	B22850-120	COVER
23	1	B22850-121	COVER
24	1	C20097-120	PULL ROLL DRIVE SHAFT

REV	DATE	DESCRIPTION	
C	Apr-17-18	WAS 412552-000	MW
B	Jun-20-17	WAS 363157-000	MW
A	29-OCT-15	NEW DRAWING	CRT

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X± .1
XX± .01
XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

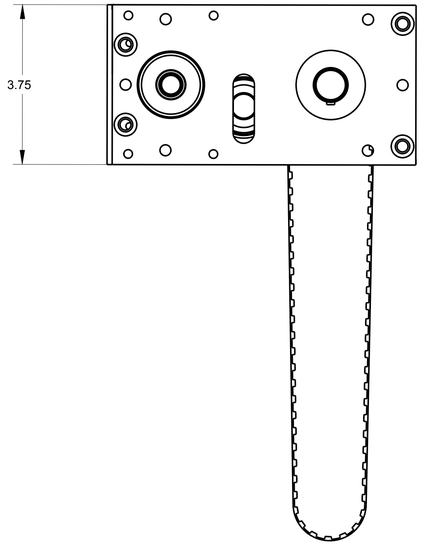
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

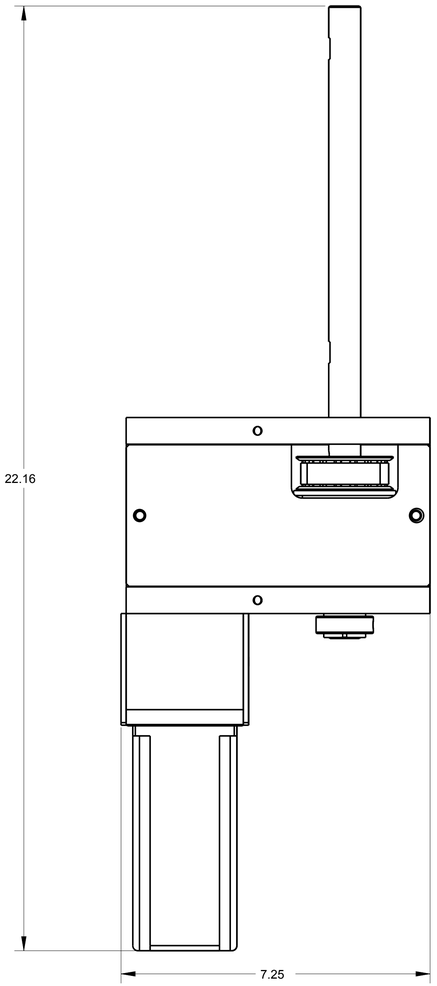
SCALE 3/8
DATE 29-OCT-15
DRAWN BY CRT

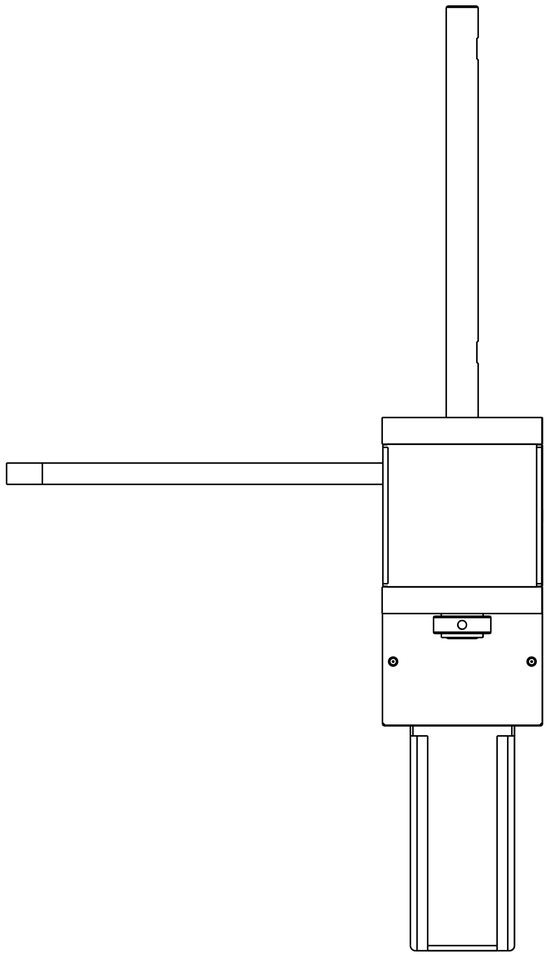
Q120 7" SERVO DRIVE & REWIND, RHH

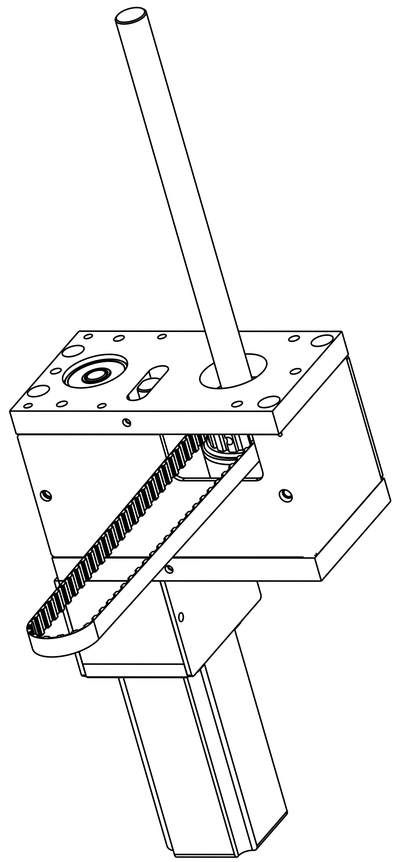
MAT'L 22620DR-RHH

22620DR-RHH









A	06-OCT-15	NEW DRAWING	CRT
REV	DATE	DESCRIPTION	BY

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE

X± .1
XX± .01
XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

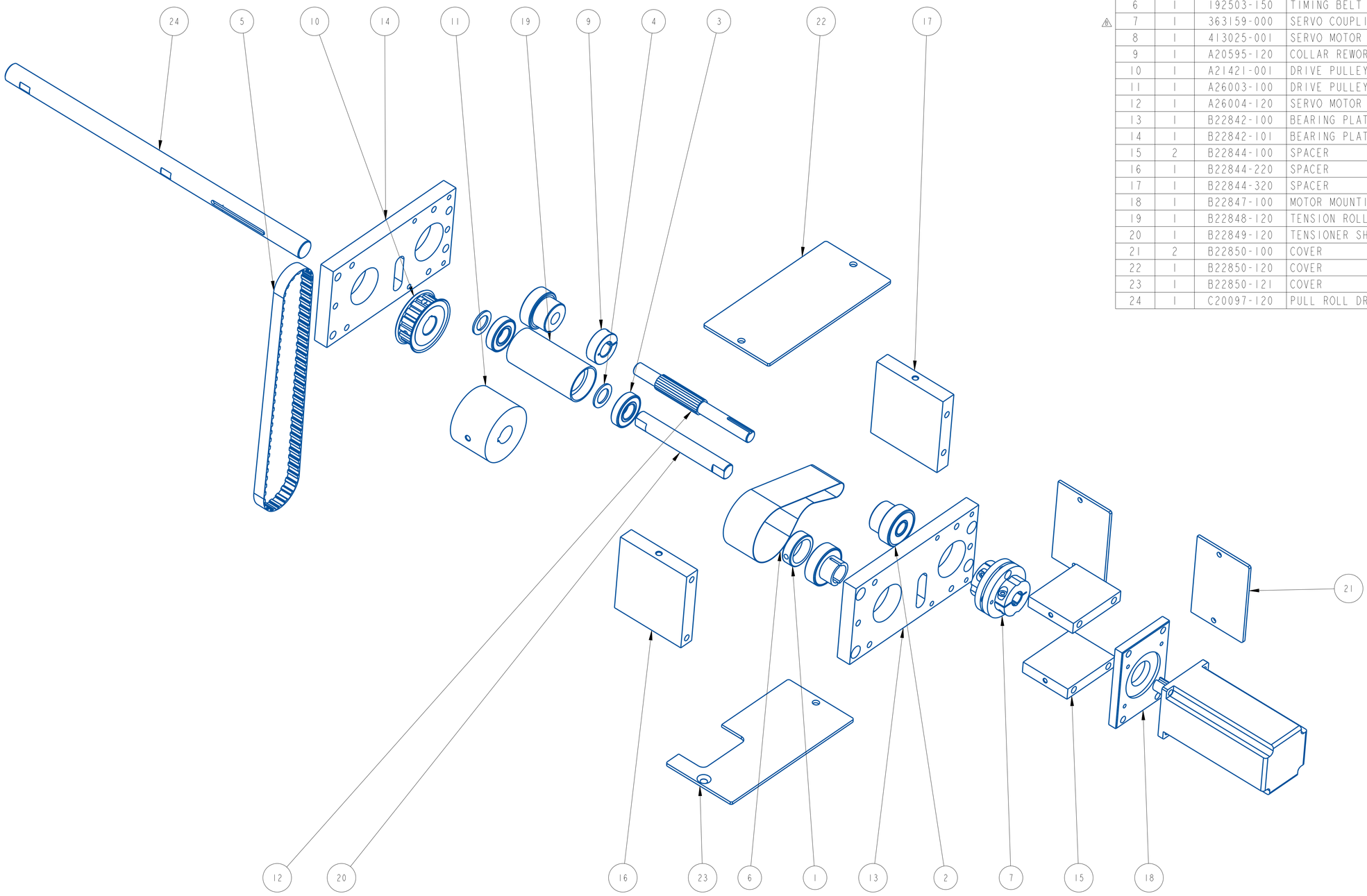
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE	9/16
DATE	06-OCT-15
DRAWN BY	CRT

Q120 7" SERVO DRIVE & REWIND, RHH

MAT'L 22620DR-RHH

22620DR-RHH



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	111044-000	BEARING, 3/4 ID CLAMP TYPE	22620DR-LHH
2	2	111072-100	BEARING BALL, LOCKING COLLAR .5"IDx1.574"OD	22620DR-LHH
3	2	111075-000	BEARING, BALL	22620DR-LHH
4	2	151008-000	BEARING, THRUST WASHER	22620DR-LHH
5	1	191592-000	BELT, TIMING, 1/2P	22620DR-LHH
6	1	192503-150	TIMING BELT	22620DR-LHH
7	1	363159-000	SERVO COUPLING-1/2"BORE & KEY 14 MM BORE	22620DR-LHH
8	1	413025-001	SERVO MOTOR	22620DR-LHH
9	1	A20595-120	COLLAR REWORK	22620DR-LHH
10	1	A21421-001	DRIVE PULLEY (MODIFIED)	22620DR-LHH
11	1	A26003-100	DRIVE PULLEY	22620DR-LHH
12	1	A26004-120	SERVO MOTOR PULLEY	22620DR-LHH
13	1	B22842-100	BEARING PLATE	22620DR-LHH
14	1	B22842-101	BEARING PLATE	22620DR-LHH
15	2	B22844-100	SPACER	22620DR-LHH
16	1	B22844-220	SPACER	22620DR-LHH
17	1	B22844-320	SPACER	22620DR-LHH
18	1	B22847-100	MOTOR MOUNTING PLATE	22620DR-LHH
19	1	B22848-120	TENSION ROLLER	22620DR-LHH
20	1	B22849-120	TENSIONER SHAFT	22620DR-LHH
21	2	B22850-100	COVER	22620DR-LHH
22	1	B22850-120	COVER	22620DR-LHH
23	1	B22850-121	COVER	22620DR-LHH
24	1	C20097-120	PULL ROLL DRIVE SHAFT	22620DR-LHH

REV.	DATE	DESCRIPTION	BY
B	Jun-20-17	WAS 363157-000	MW
A	29-OCT-15	NEW DRAWING	CRT

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .0107.030

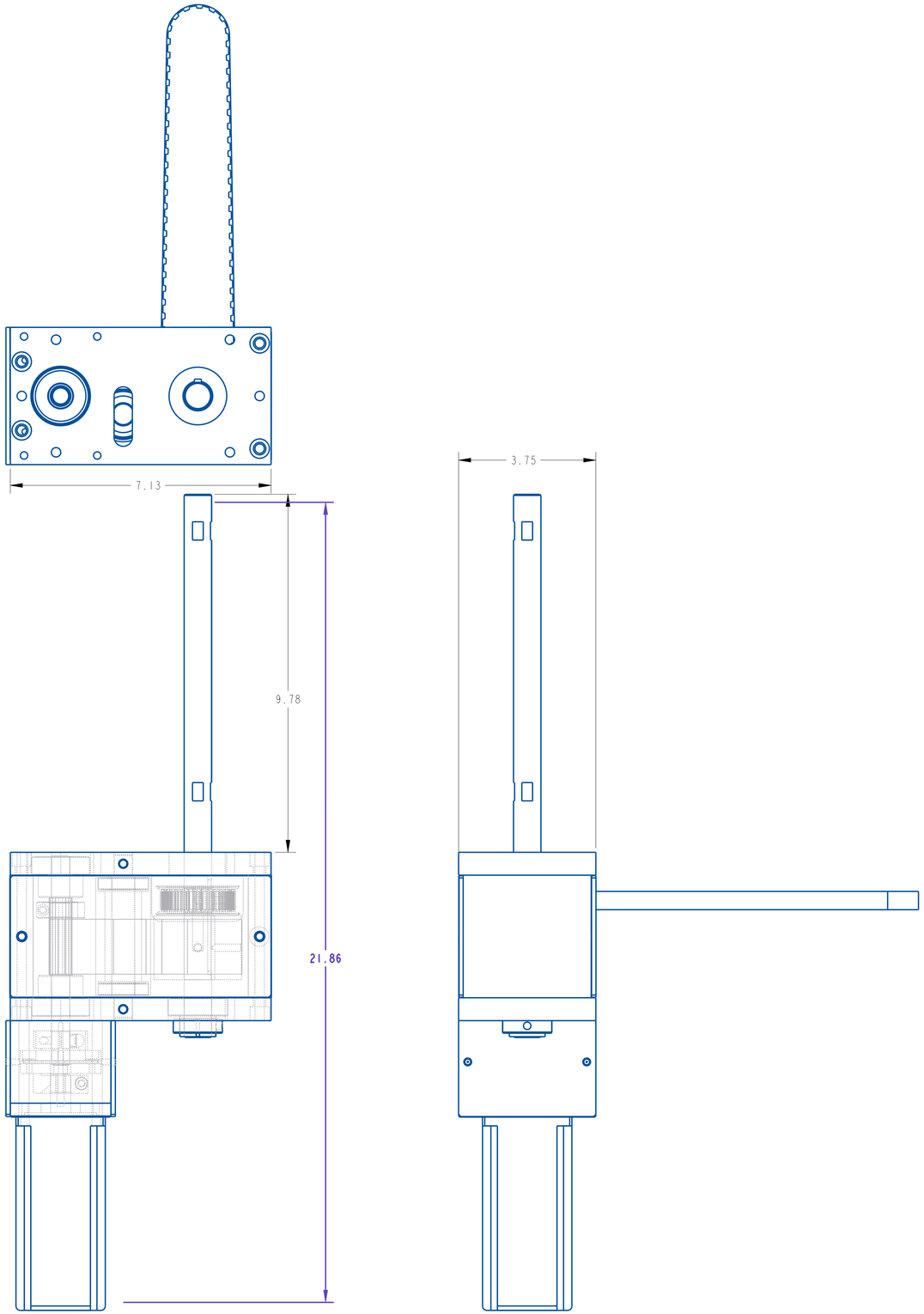
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

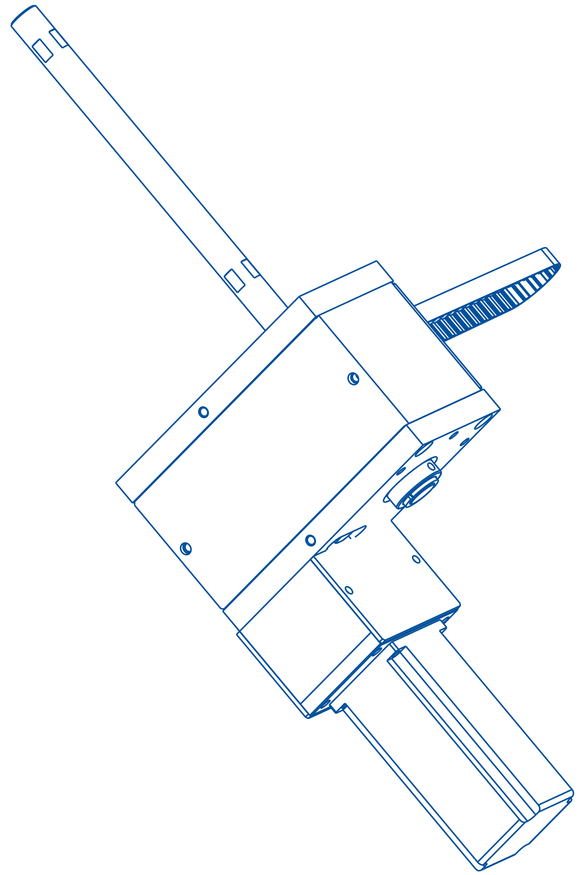
SCALE: 1/2
DATE: 29-OCT-15
DRW BY: CRT
CHK BY:03/26/2024-SEM
APPR BY:

Q120 7" SERVO DRIVE & REWIND, LHH

MAT'L

22620DR-LHH





REV	DATE	DESCRIPTION	BY
A	06-OCT-15	NEW DRAWING	CRT

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	9/16
DATE:	06-OCT-15
DRW BY:	CRT
CHK BY:	03/26/2024-SEM
APPR BY:	

Q120 7" SERVO DRIVE & REWIND, LHH

MAT'L

22620DR-LHH

Servo Belt Removal & Installation

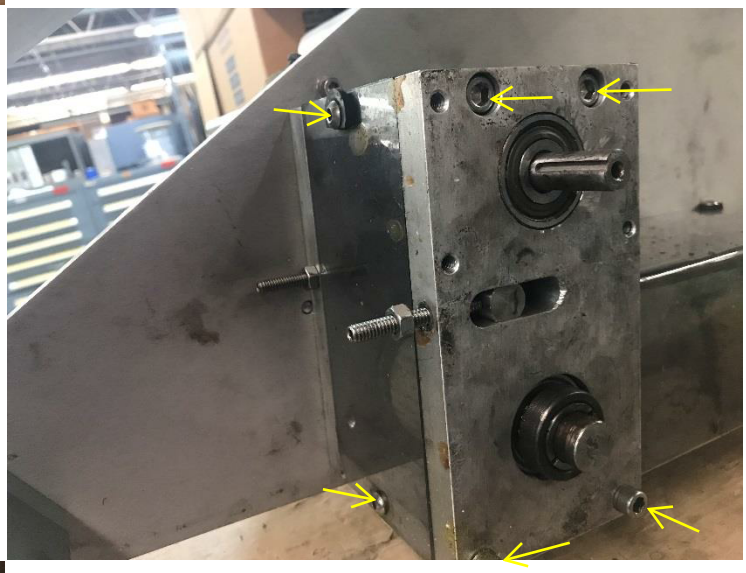
Remove the clear cover on the side of the coupling of the servo motor. Then loosen the 4 5/16-18 socket heads holding the motor mounting plate to the spacer blocks. (Shown in image on the right)

Loosen the 2 bolts on the coupling. Then remove the motor and coupling assembly. (Shown in image on the left)

Loosen the tension on the servo belt by removing loosening the 2 jam nuts on the set screws shown and removing the set screws. (Shown in image on the right)

Loosen set screw in the collar on the end of the drive shaft. Then remove the collar. (Shown in image on the left)

Remove the 4 5/16-18 socket head bolts that hold the bottom plate to the spacer blocks. Then remove the two button head screws holding the lexan cover on and remove cover. (Shown in image on the right)



Remove the set screw on the eccentric collar then spin the collar to loosen from shaft. (Shown in image on the left)

Once the bolts are removed, remove the bottom plate. This may take some prying and finessing, be careful to not bend the plate, shafts, or ruin the bearings during the removal of the plate. Once removed clean the plate and bearings. (Shown in image on the right & bottom)

If Equipped

Remove the cover over the rewind kinetrol and other side of the servo belt. (Shown in image on the left)

Remove the tensioner, belt and smaller diameter shaft with the pulley teeth on it. (Shown in image on the right)

Once removed clean all surfaces shafts bearing and check the rewind belt for cracks or uneven wear. You can use a scotch brite pad the clean up the shafts and ect. (Shown in image on the left)

Check the lock collar on the shaft with the pulley grooves ensure the collar is tight and the stack up is correct. The washer goes on top of the collar and shall be flush with the end of the pulley grooves as shown in the image below. Slide the collar over the end of the shaft as shown. This stack up is extremely important.

Ensure your belt is riding properly on the kinetrol pulley. The belt should be running in the middle of the pulley of as close to centered as you can get. Spin the kinetrol and ensure the belt is tracking well. (Shown below)

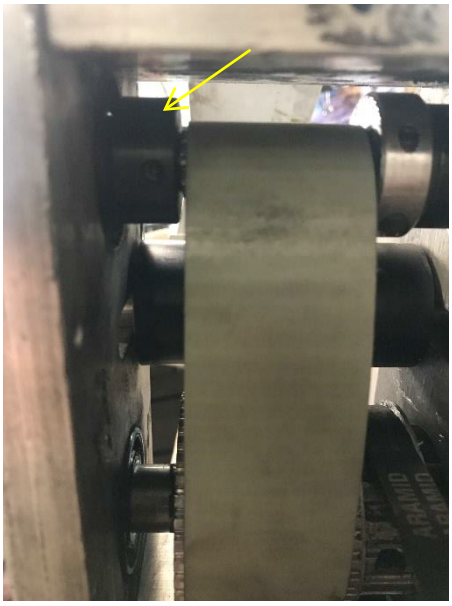
To adjust this rotate the pulley until you see the set screw. Loosen the set screws and slide the pulley accordingly. Slide the larger pulley down or up as well these pulleys should be together. (Shown in image on the right)

After you have cleaned everything up, checked the rewind belt and properly checked alignment of the pulleys. It is now time to re-assemble. Start by putting the belt in then the tensioner. Ensure the idler has the oil lite washers installed on the top and bottom of the idler. (Shown in the image to the left)

NOTE Blue Loctite is recommended on all fasters.

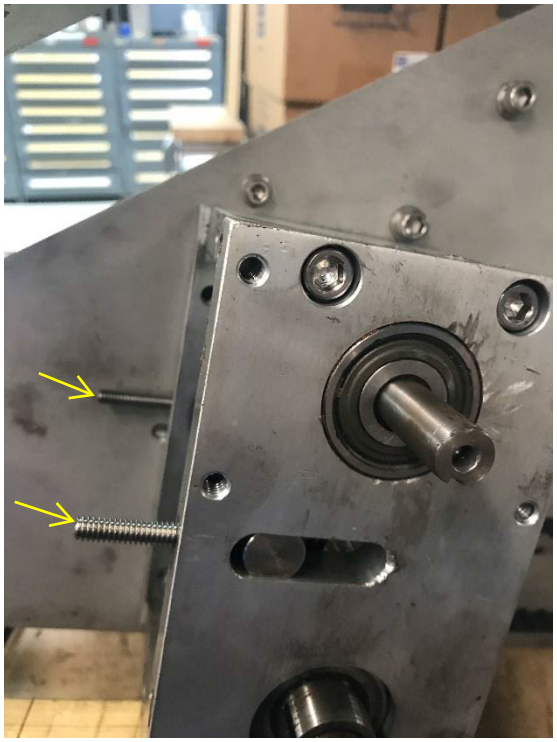
Place the eccentric collar over the smaller diameter shaft and slide the bottom servo plate on. Ensure the tensioner is positioned properly in the slot on the bottom plate with the oil lite washer in place. Fasten the plate to the spacer blocks. Once fastened rotate the eccentric collar to lock it into place make sure it is tight this is very important. Lock into place with set screw. (Shown in image below)

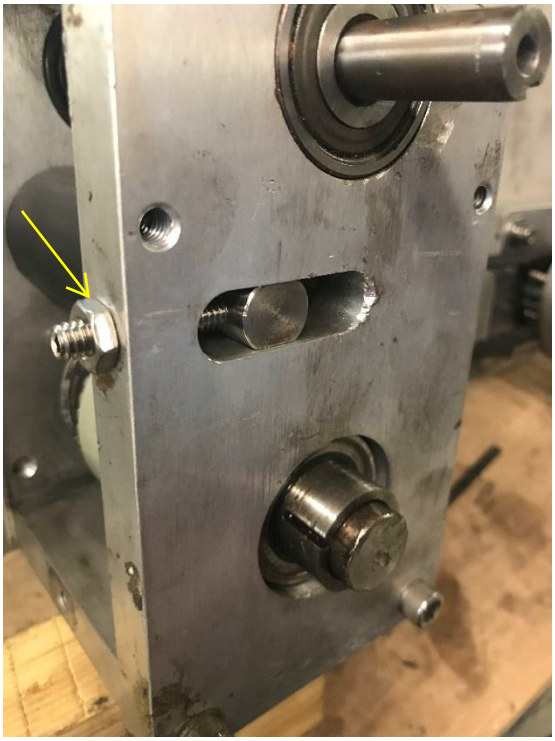
NOTE Blue Loctite is recommended on all fasteners.

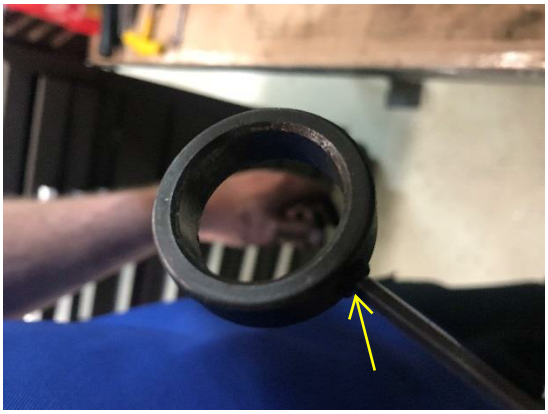


Thread in the set screws evenly to set tension on the belt the belt should not be too tight if you reach around the back you can push against the belt as you tighten it. This is more of a touch setting you do not want the belt to be solid to the touch more like $1/8^{th}$ -$1/4^{th}$ inch of travel when you push on the belt. If it is too loose it can skip teeth. When the tension is set lock into place using the jam nuts. (Shown in image below)

NOTE Do <u>NOT</u> loctite set screws for the tensioner.

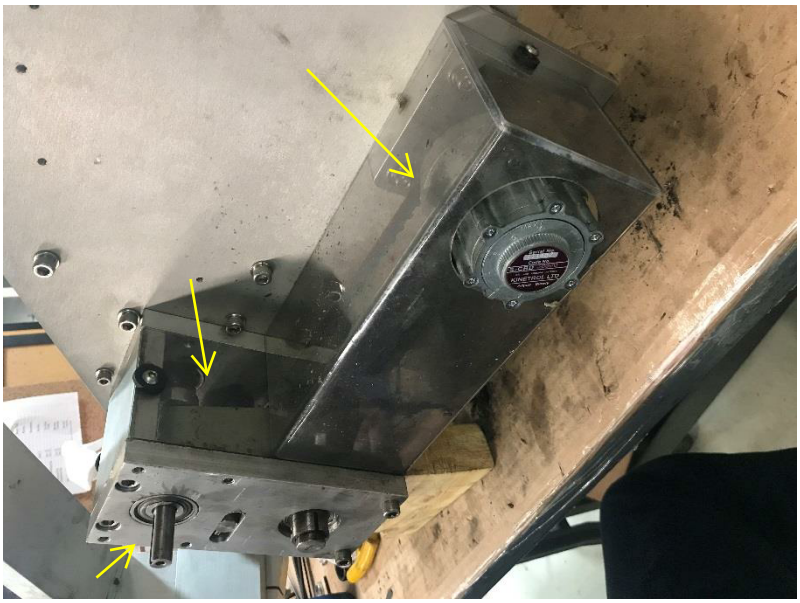






Fasten the collar to the end of the larger diameter shaft as shown.

NOTE Blue Loctite is recommended on all fasters.



Place the lexan covers on the 2 sides of the servo belt assembly and the cover over the rewind kinetrol assembly. Make sure the fasteners has blue Loctite and rubber grommets. (Shown in image on the left)

Place the servo motor coupling over the end of the smaller diameter shaft. Fasten the motor mounting assembly to the bottom plate using blue Loctite. Align the coupling centered between the shafts so the coupling has enough to fasten to on each of the shafts. Fasten the coupling to the shafts. Mount the lexan covers make sure the fasteners has blue Loctite and rubber grommets. (Shown in image on the right)

NOTE Blue Loctite is recommended on all fasters.

ASSEMBLY TITLE: **Q120 REWIND ASSEMBLY**

GENERAL FUNCTION:

- The rewind drum rolls up the liner
- The rewind pin, when pulled out, allows the liner to be released from the rewind drum.
- The rewind flange supports and guides the liner.
- The friction clutch allows for slippage to accommodate for varying speeds between the drive roll and rewind drum.
- The adjusting knob controls the torque adjustment of the drum.

SET UP AND ADJUSTMENTS:

- Position the rewind flange slightly below the web path and lock with the set screw in the hub.
- When threading liner to the rewind, place the liner between the drum and pin.
- Tighten adjusting knob just enough to allow the rewind drum to keep up with the drive roll.

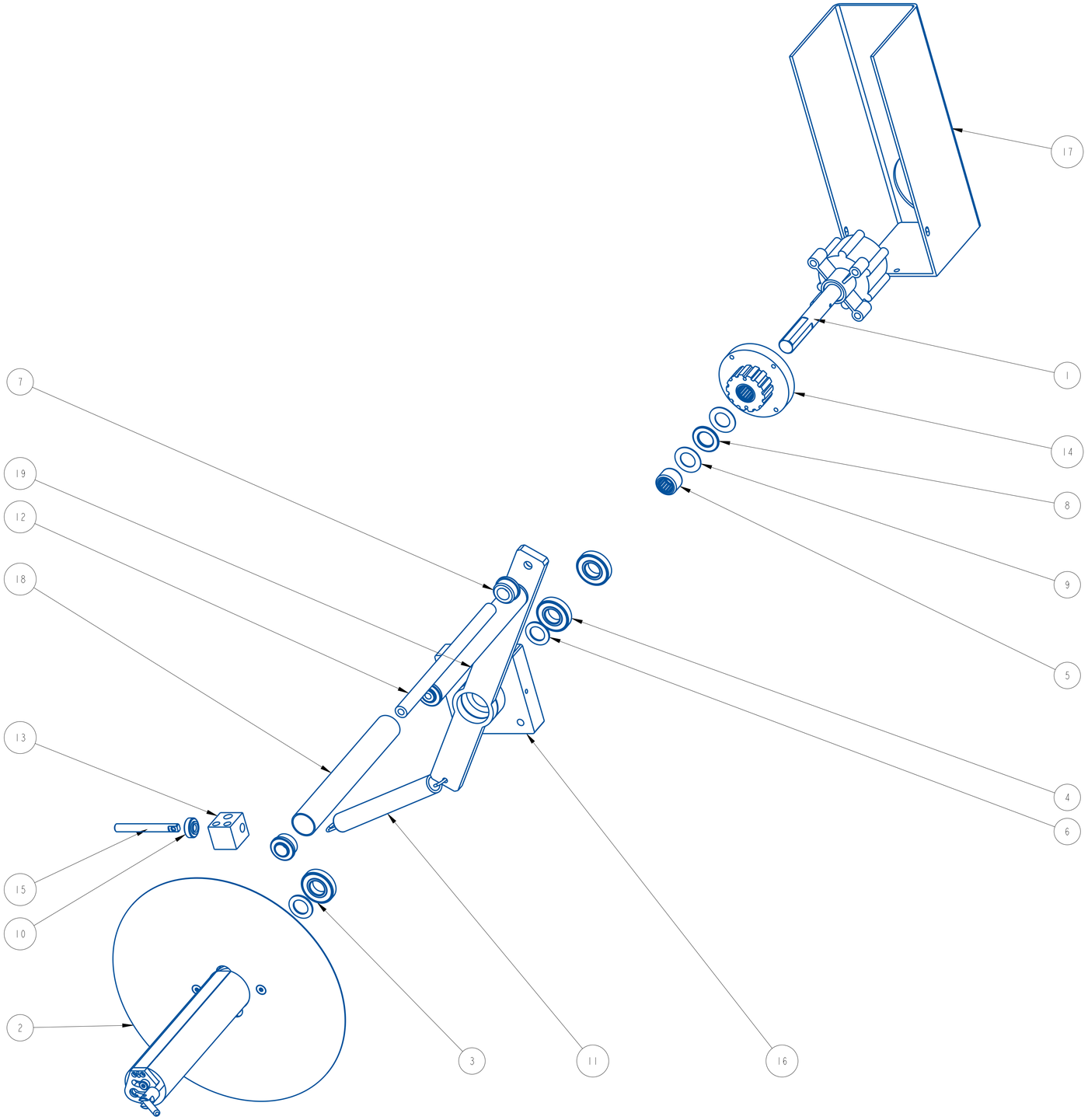
NOTE: Excessive tightening will cause the web to be wound very tight, causing difficulty in removal and possible step motor stall.

MAINTENANCE:

- Clean all parts that have acquired label or glue residue
- Replace friction disc when worn out.

TROUBLESHOOTING:

PROBLEM	**WHAT TO DO**
- Rewind drum not rotating when stepping motor rotates	- Replace timing belt from motor to rewind
- Rewind drum not keeping up with drive roll	- Tighten adjusting knob
- Web winding too tight on hub	- Loosen adjusting knob
- Grinding in rewind hub	- Replace friction disc by removing knob and sliding off rewind drum



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	20499-001	DASHPOT & SHAFT ASSEMBLY	22620R-RHH
2	1	22188-000	7" COLLAPSIBLE REWIND ASSEMBLY	22620R-RHH
3	1	111001-000	BEARING, BALL	22620R-RHH
4	2	111075-000	BEARING, BALL	22620R-RHH
5	1	121067-000	BEARING, NEEDLE	22620R-RHH
6	2	151008-000	BEARING, THRUST WASHER	22620R-RHH
7	4	181063-000	BEARING, ROLL END	22620R-RHH
8	1	181081-000	BEARING, NEEDLE ROLLER	22620R-RHH
9	2	181082-000	BEARING, THRUST WASHER	22620R-RHH
10	1	801601-000	CHECK NUT	22620R-RHH
11	1	811216-000	EXTENSION SPRING, STAINLESS	22620R-RHH
12	2	A20928-002	ROLLER SHAFT	22620R-RHH
13	1	A21479-000	SPRING ADJUSTMENT BLOCK	22620R-RHH
14	1	A22120-000	REWIND PULLEY ASSEMBLY	22620R-RHH
15	1	A23131-000	STUD	22620R-RHH
16	1	B20004-007	REWIND BEARING PLATE	22620R-RHH
17	1	B20005-120	GUARD	22620R-RHH
18	2	B20071-003	IDLER ROLLER (DANCER)	22620R-RHH
19	1	C20894-004	REWIND DANCER ARM	22620R-RHH

REV	DATE	DESCRIPTION	BY
A	06-OCT-15	NEW DRAWING	CRT

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.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

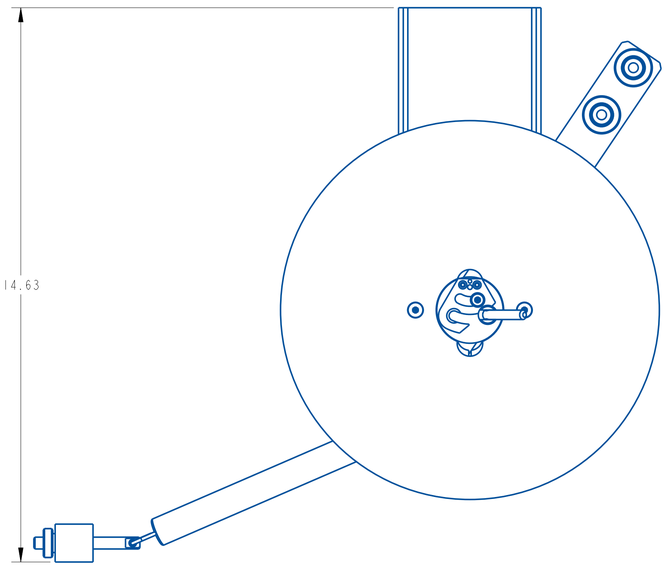
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

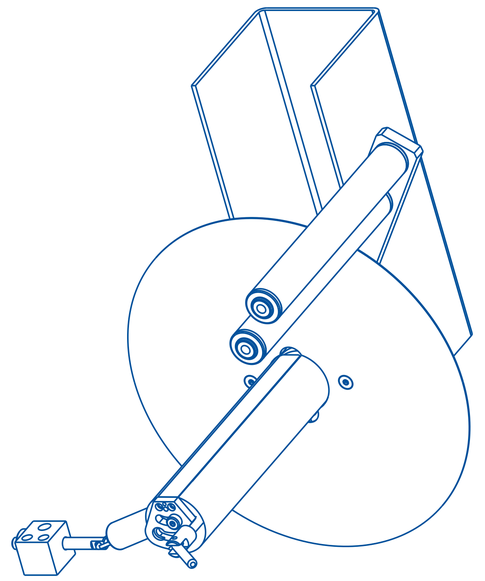
SCALE: 7/16
DATE: 06-OCT-15
DRW BY: CRT
CHK BY: 03/08/2024-SEM
APPR BY:

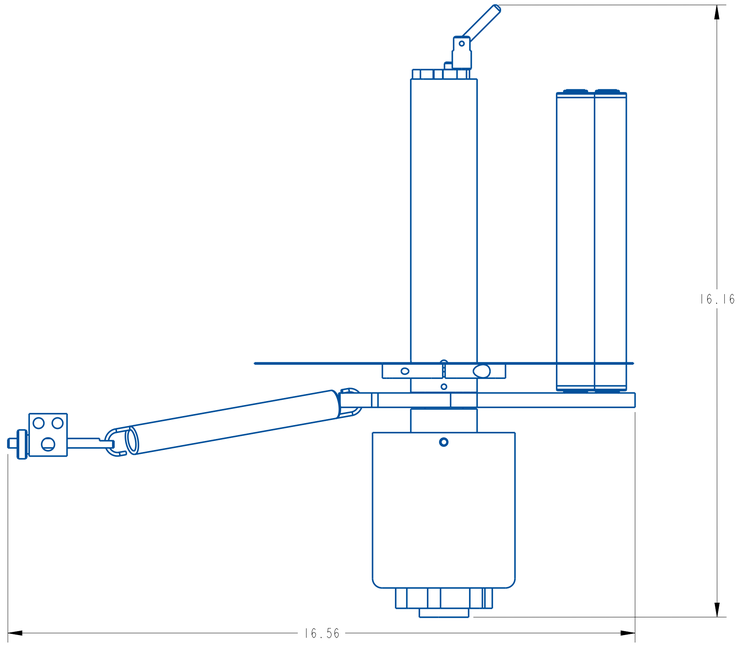
REWIND & DANCER ASSEMBLY w/KINETROL, 7"

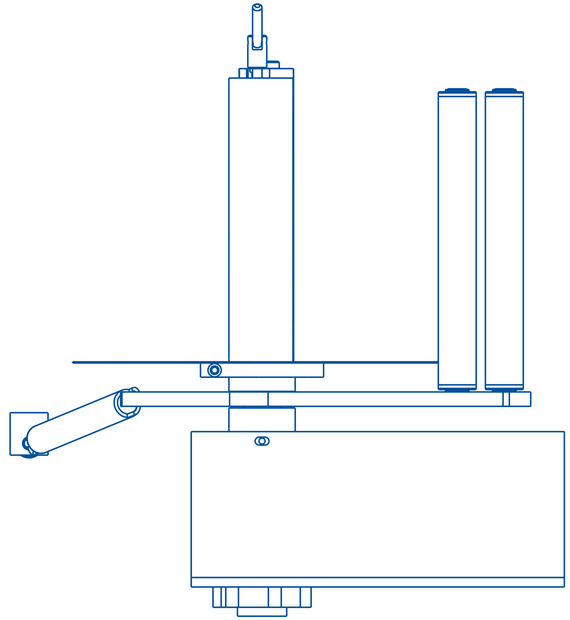
MAT'L 22620R-LHH

22620R-RHH









REV	DATE	DESCRIPTION	BY
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.XX ± .01
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ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

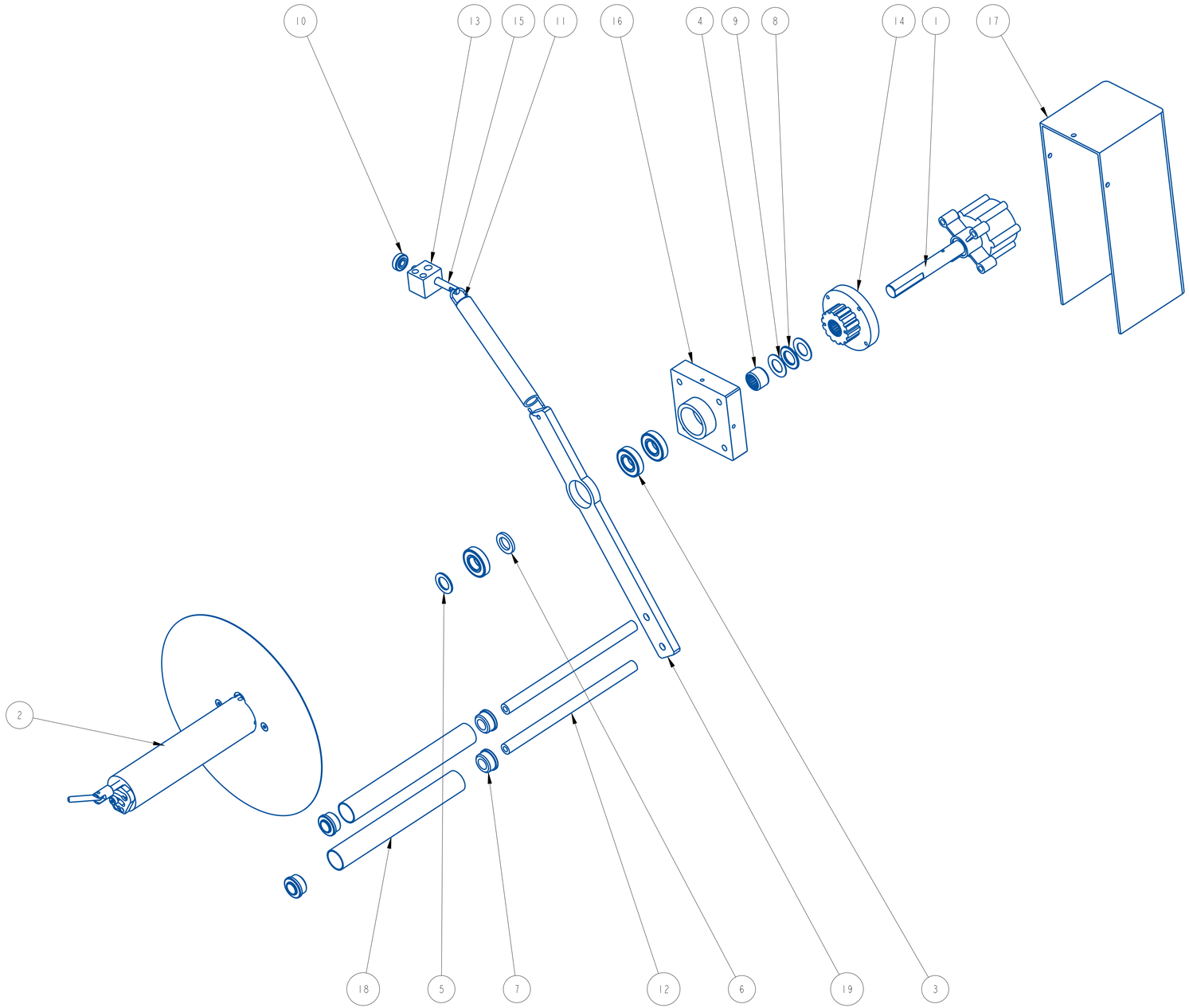
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	1/2
DATE:	06-OCT-15
DRW BY:	CRT
CHK BY:	03/08/2024-SEM
APPR BY:	

REWIND & DANCER ASSEMBLY w/KINETROL, 7"

MAT'L

22620R-RHH



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9	2	181082-000	BEARING, THRUST WASHER	22620R-LHH
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12	2	A20928-002	ROLLER SHAFT	22620R-LHH
13	1	A21479-000	SPRING ADJUSTMENT BLOCK	22620R-LHH
14	1	A22120-000	REWIND PULLEY ASSEMBLY	22620R-LHH
15	1	A23131-000	STUD	22620R-LHH
16	1	B20004-120	REWIND BEARING PLATE	22620R-LHH
17	1	B20005-120	GUARD	22620R-LHH
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XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .0107.030

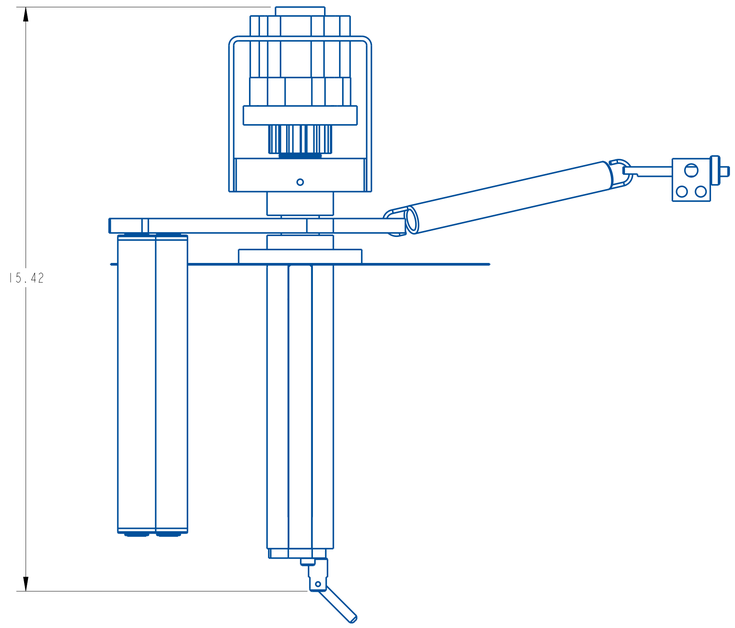
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

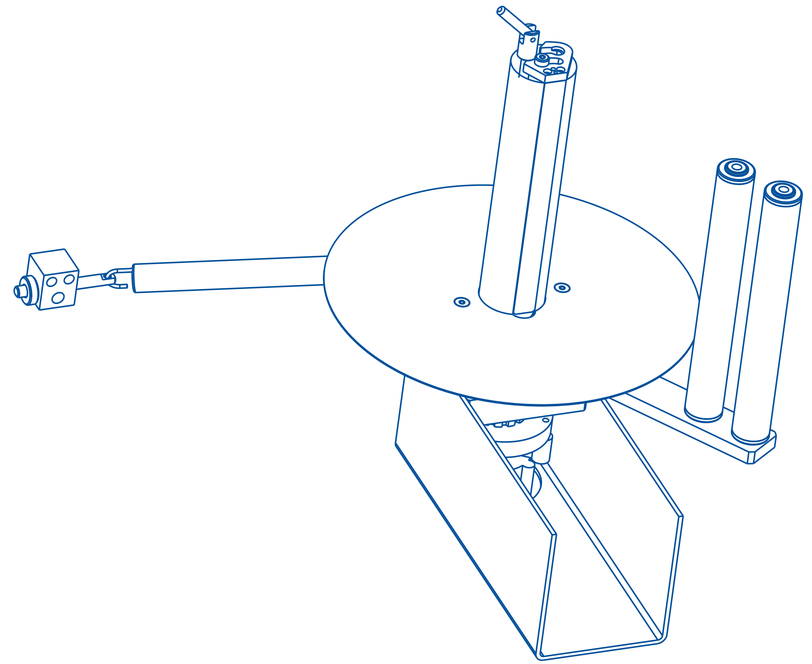
SCALE: 3/8
DATE: 06-OCT-15
DRW BY: CRT
CHK BY: &CREO_CHK
APPR BY:

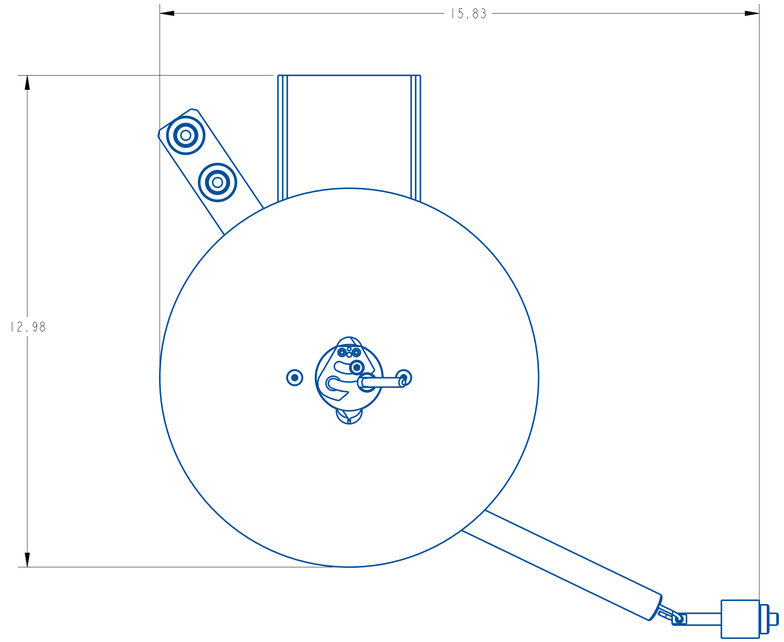
Q60 REWIND & DANCER ASSEMBLY w/KINETROL, 7"

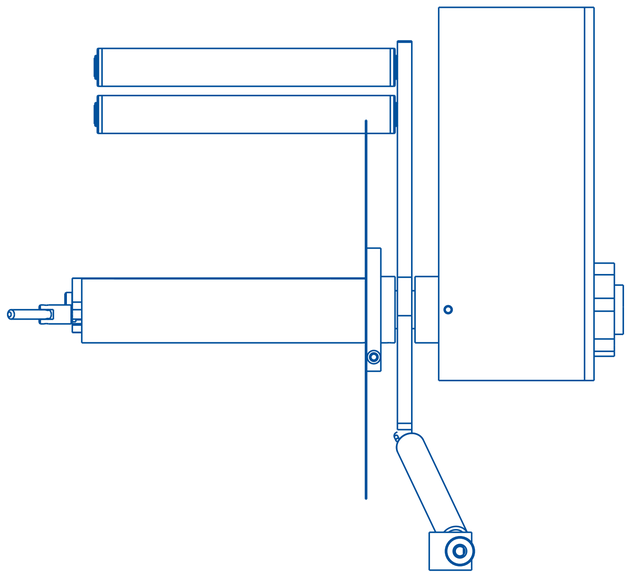
MAT'L

22620R-LHH









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.XX ± .01
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ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

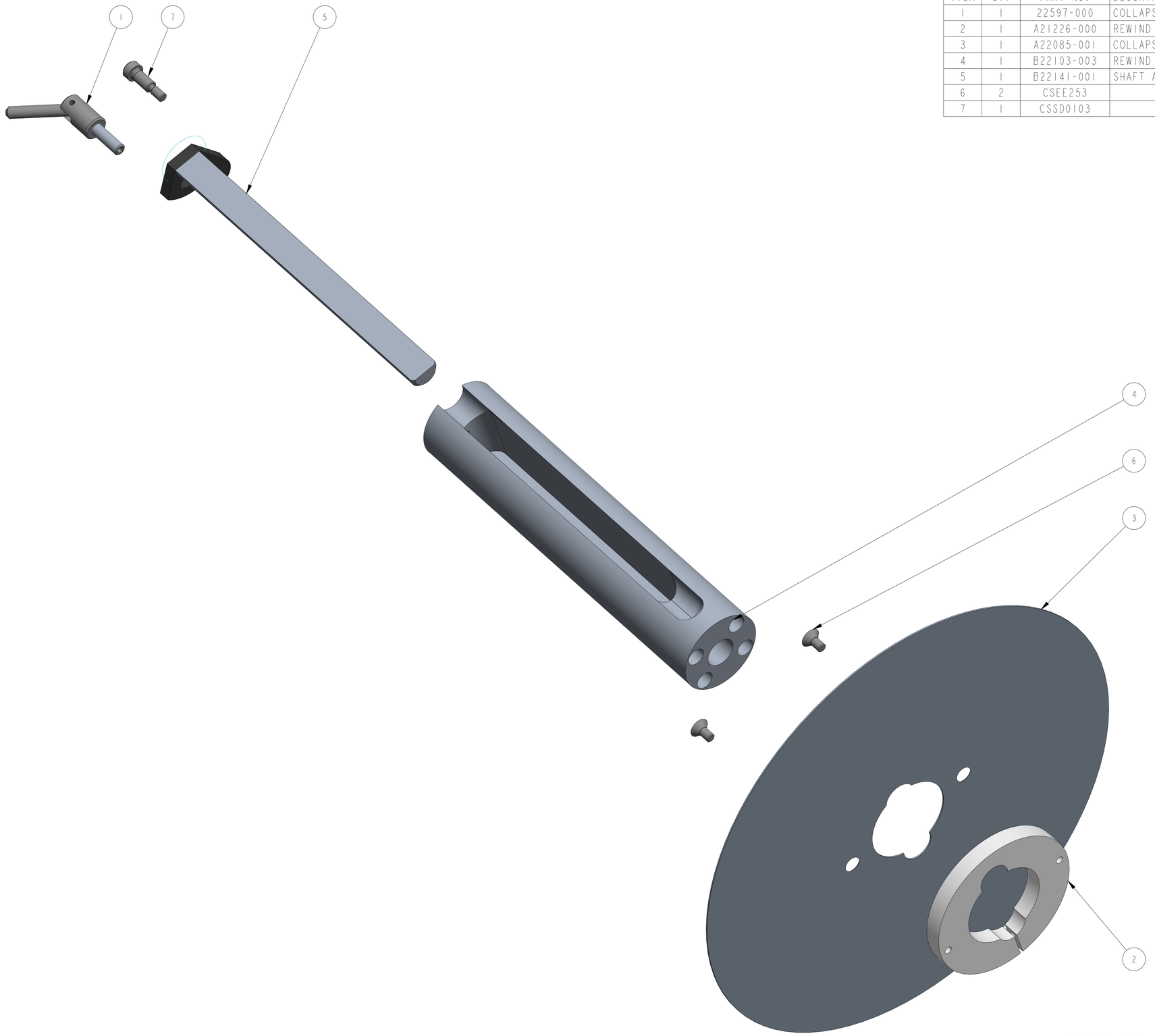
SCALE:	1/2
DATE:	06-OCT-15
DRW BY:	CRT
CHK BY:	03/27/2024-SEM
APPR BY:	

Q60 REWIND & DANCER ASSEMBLY w/KINETROL, 7"

MAT'L

22620R-LHH

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	22597-000	COLLAPSIBLE REWIND LOCKING HANDLE	22188-000
2	1	A21226-000	REWIND FLANGE HUB COLLAR	22188-000
3	1	A22085-001	COLLAPSIBLE REWIND REEL	22188-000
4	1	B22103-003	REWIND HUB 7"	22188-000
5	1	B22141-001	SHAFT ASSEMBLY	22188-000
6	2	CSEE253		22188-000
7	1	CSSD0103		22188-000



REV	DATE	DESCRIPTION	BY
A	MAR-30-21	NEW DRAWING	TJS

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DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

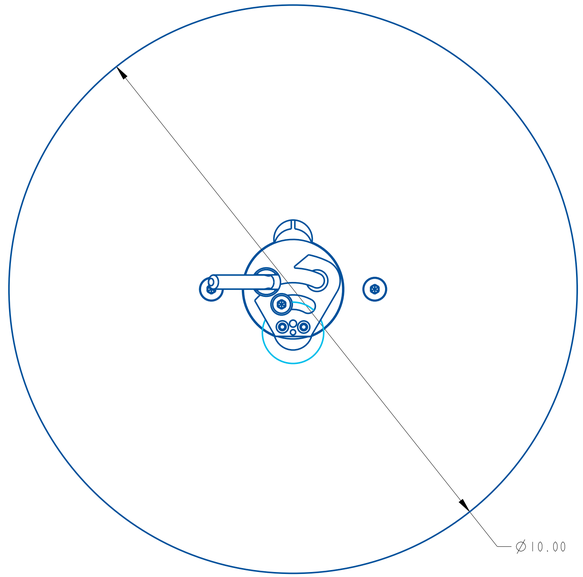
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

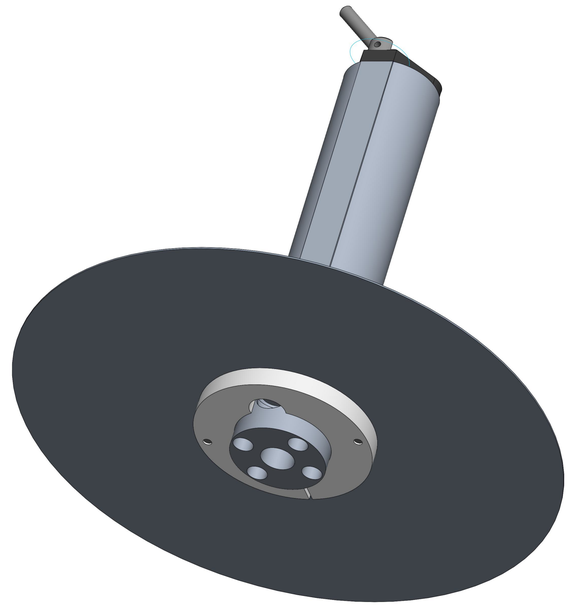
SCALE: 1/1
DATE: MAR-30-21
DRW BY: TJS
CHK BY: 02/29/2024-SEM
APPR BY:

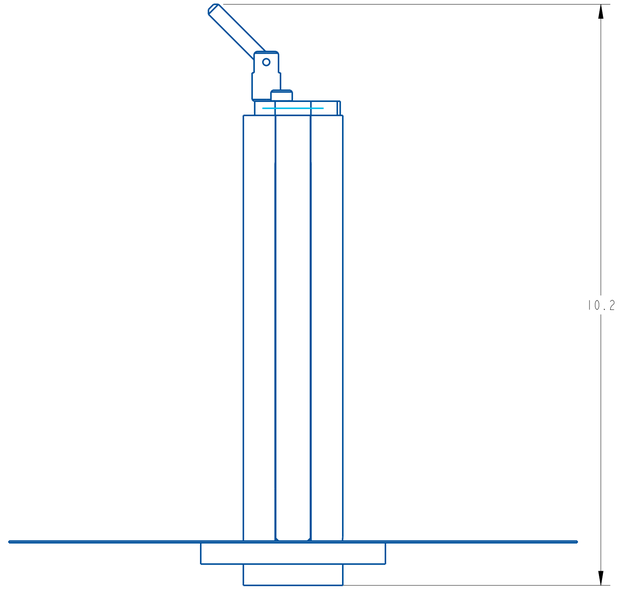
7" COLLAPSIBLE REWIND ASSEMBLY

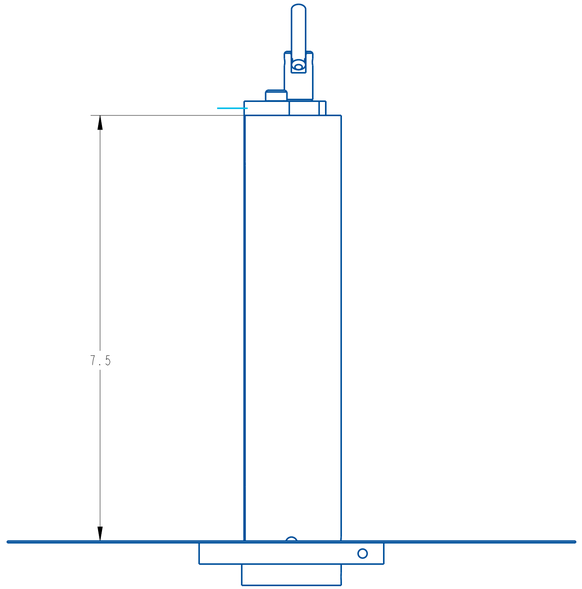
MAT'L
22188-000

22188-000









REV	DATE	DESCRIPTION	BYE
A	MAR-30-21	NEW DRAWING	TJS

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X ± .1
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BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

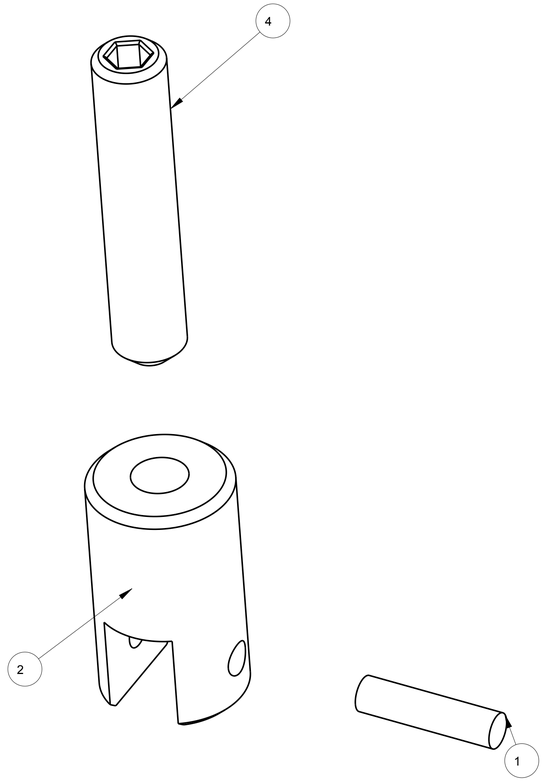
SCALE: 3/4
DATE: MAR-30-21
DRW BY: TJS
CHK BY:02/29/2024-SEM
APPR BY:

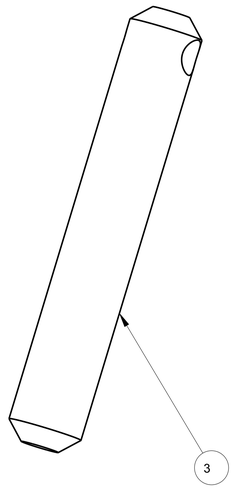
7" COLLAPSIBLE REWIND ASSEMBLY

MAT'L
22188-000

22188-000

ITEM	QTY	PART NO.	DESCRIPTION
1	1	871352-000	DOWELL,PIN 1/8" x 1/2" SS.
2	1	A26128-000	CLEVIS
3	1	A26129-000	HANDLE
4	1	SYE601	1/4-20 X 1-1/4 LG. SET SCREW





REV	DATE	DESCRIPTION	BY
A	12-11-14	NEW DRAWING	

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X± .1
XX± .01
XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

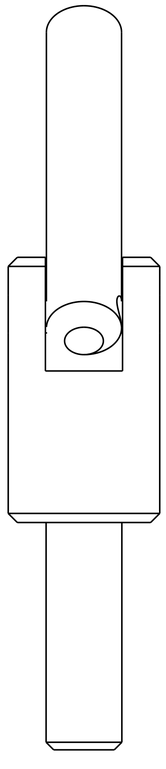
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

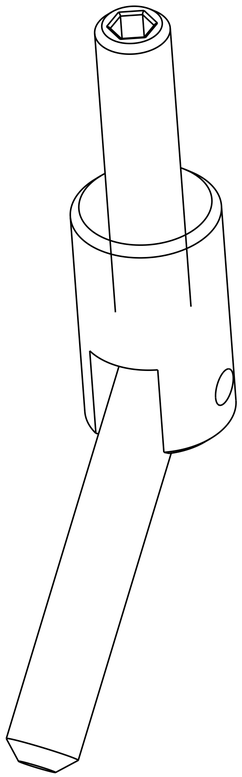
SCALE	4/1
DATE	12-11-14
DRAWN BY	ATT

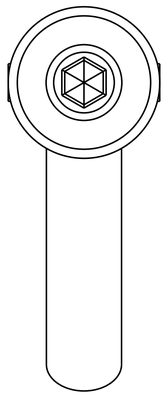
COLLAPSIBLE REWIND LOCKING HANDLE

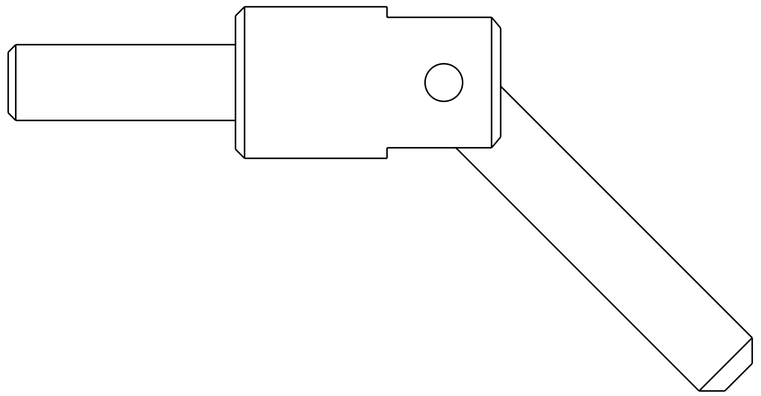
MAT'L 22597-000

22597-000









REV	DATE	DESCRIPTION	BY
A	12-11-14	NEW DRAWING	

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE

X± .1
XX± .01
XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE	4/1
DATE	12-11-14
DRAWN BY	ATT

COLLAPSIBLE REWIND LOCKING HANDLE

MAT'L 22597-000

22597-000

ASSEMBLY TITLE: **Q60 KINETROL REWIND**

GENERAL FUNCTION:

- The rewind drum rolls up the liner
- The collapsible rewind shaft when closed allows the liner to be removed easily. The normal running position for the shaft is in the open position
- The rewind flange supports and guides the liner
- The Kinetrol clutch allows for slippage to accommodate for varying speeds between the drive roll and rewind drum
- The adjusting knob controls the torque adjustment of the drum and is set at the factory.

SET UP AND ADJUSTMENTS:

- Position the rewind flange slightly below the web path and lock with the set screw in the hub
- When threading liner to the rewind, place the liner between the drum and pin
- Tighten adjusting knob just enough to allow the rewind drum to keep up with the drive roll.
- Loosen set screw before adjustment and re-tighten after adjustment

NOTE: Excessive tightening will cause the web to be wound very tight, causing difficulty in removal and possible step motor stall.

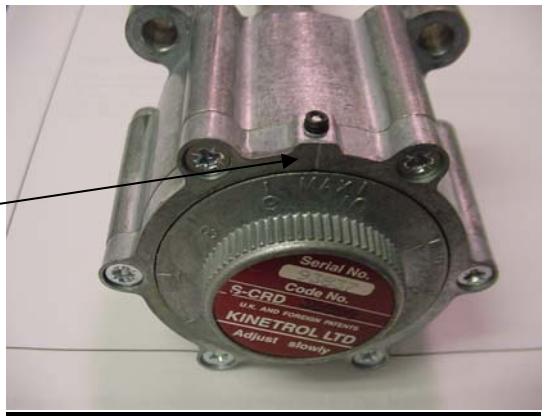
MAINTENANCE:

- Clean all parts that have acquired label or glue residue

TROUBLESHOOTING:

PROBLEM	**WHAT TO DO**
- Rewind drum not rotating when stepping motor rotates	- Replace timing belt from motor to rewind
- Rewind drum not keeping up with drive roll	- Adjust clutch dial (1 being loosest & 10 being tightest)
- Web winding too tight on hub	- Loosen adjusting knob
- Grinding in rewind hub	- Replace Kinetrol

Set screw location



ASSEMBLY TITLE: **SLOT SENSOR ASSEMBLY**

GENERAL FUNCTION:

- The slot sensor detects the separation between labels. This signals the electronics to stop the drive motor.
- The two (2) liner support rods prevent the liner from wearing out the slot sensor.
- The knob and thumbscrew lock the sensor firmly on the mounting rods.
- The male connector provides quick connection to the labeling head.

SET UP AND ADJUSTMENTS:

- See attached cut sheet

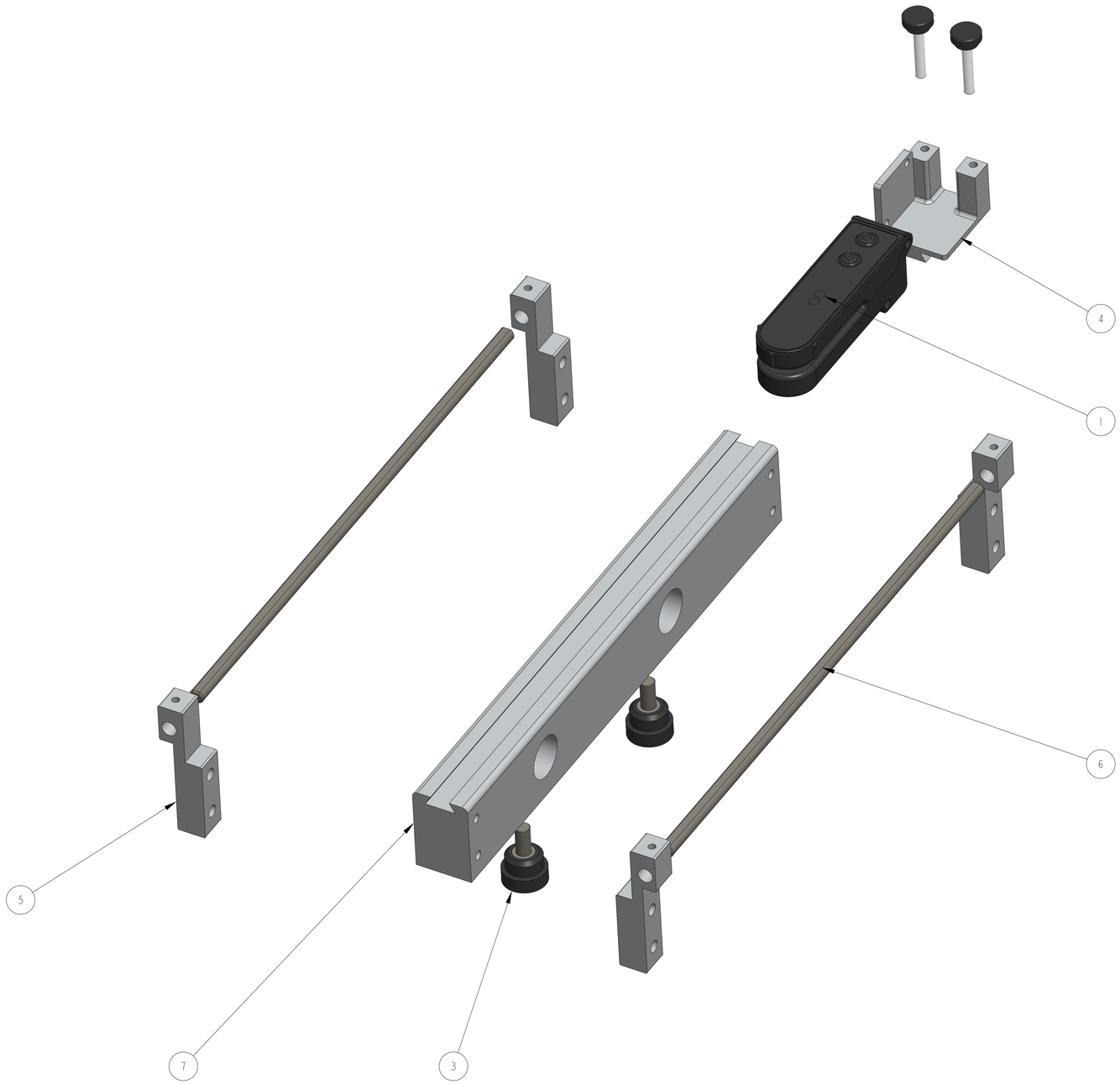
MAINTENANCE:

- Keep the sensor optical area clean from label and glue residue

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- No power to the sensor	- Check male connector and tightly secure connection to the head.
- Liner dragging over the slot	- Loosen knob and rotate slot sensor slot sensor surface liner rests on both support rods
- Too much slack through slot sensor	- Adjust brake brush tension
- Slot sensor moving with web	- Tighten all three (3) adjusting knobs

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	201444-300	TRITRONICS MODEL LERC	20033-300
2	2	801297-000	THUMB SCREW PLSTC HEAD 8-32x1	20033-300
3	2	801299-000	KNOB WITH STUD	20033-300
4	1	A21391-301	SLOT SENSOR ADAPTER	20033-300
5	4	A21749-300	SLOT SENSOR SUPPORT ROD MTG BLOCK	20033-300
6	2	A21770-300	SUPPORT ROD WITH FLAT	20033-300
7	1	B20852-300	7 IN. WEB SLOT SENSOR MTG. BAR	20033-300
8	1	203035-000	CABLE, M8, 4COND	NOT SHOWN



REV	DATE	DESCRIPTION	BY
A	Mar-04-21	NEW DRAWING	TJS

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X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

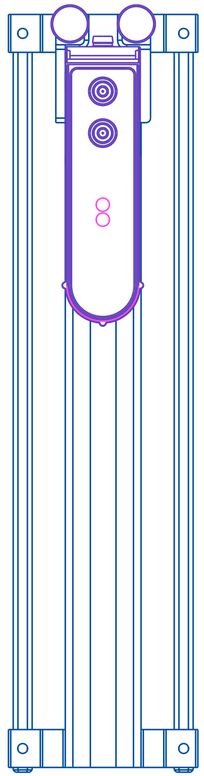
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

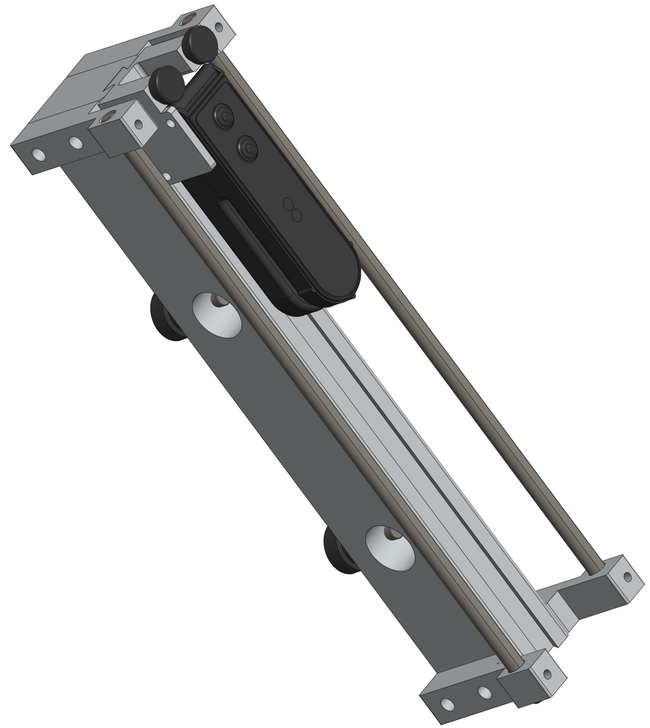
SCALE: 1/1
DATE: Mar-04-21
DRW BY: TJS
CHK BY:02/24/2024-SEM
APPR BY:

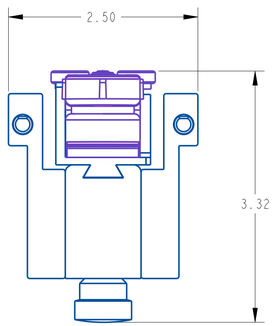
LABEL DETECT ASSEMBLY

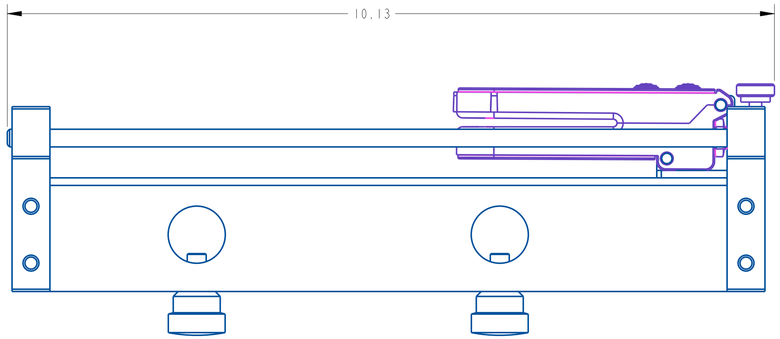
MAT'L

20033-300









REV	DATE	DESCRIPTION	BY
A	Mar-04-21	NEW DRAWING	TJS

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/1
DATE: Mar-04-21
DRW BY: TJS
CHK BY:02/24/2024-SEM
APPR BY:

LABEL DETECT ASSEMBLY

MAT'L

20033-300

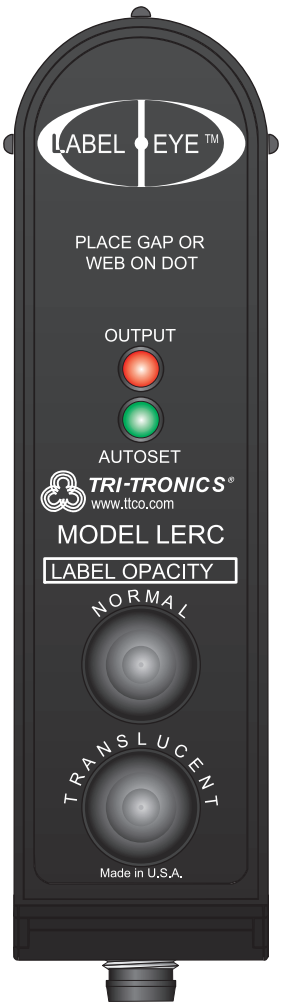
LABEL•EYE
Set-Up Instructions

Standard LABEL•EYE

Normal Label Opacity AUTOSET Button
This category includes most paper or melallized film labels adhering to paper or transparent backing materials. To implement the one button AUTOSET routine, utilize the external alignment guides to position the gap between labels in line with the dot shown in the center of the detection zone. Then push the AUTOSET button marked "Normal."

An alternative set up procedure would be to remove a label and the push the "Normal" AUTOSET button.

On rare occasions, when the light is unable to penetrate the backing materials, both the red and green led indicators will blink four times. When this indication occurs, the sensor will be unable to detect the presence of the labels.



Translucent Label Opacity AUTOSET Button
This category includes translucent labels adhering to transparent or paper backing materials. To implement the one button AUTOSET routine, utilize the external alignment guides to position the gap between labels in line with the dot shown in the center of the detection zone. Then push the AUTOSET button marked "Translucent".
Note: This sensor cannot detect transparent labels.

INVERT OUTPUT: The status of the red LED and output transistors can be inverted by pressing both buttons simultaneously. When the output status has been inverted, the red LED and the output transistors will turn off when the label comes into view.

TRI-TRONICS®

SPECIFICATIONS

SUPPLY VOLTAGE
- 10 to 30Vdc
- Polarity Protected
- Intended for use in class two circuits

CURRENT REQUIREMENTS
- 45 milliamps (exclusive of load)

OUTPUT TRANSISTORS
- (1) NPN and (1) PNP output transistors
- Sensor outputs can sink or source up to 150 milliamps (current limit)
- All outputs are continuously short circuit protected

REMOTE AUTOSET INPUT
- opto isolated momentary sinking input (10 milliamps)

Note: Remote models only

RESPONSE TIME
- Light state response = 100 microseconds
- Dark state response = 100 microseconds

LED LIGHT SOURCE
- High intensity red LED
- Pulse modulated

PUSH BUTTON CONTROL
- Automatic set-up routines based on web opacity
- One push button set-up
- Simultaneously pushing both buttons inverts the output

HYSTERESIS
- Minimal hysteresis promotes the detection between the backing material and the label depending on the settings

LIGHT IMMUNITY
- Responds to sensor's pulsed modulated light source … immune to most ambient light

INDICATORS
- Green LED flashes when AUTOSET routine is activated and stays illuminated when AUTOSET is completed
- Red LED illuminates when sensors output transistors are ON. *Note: The status of the output transistors can be inverted by pushing both buttons simultaneously. If Output LED flashes, a short circuit condition exists.*

AMBIENT TEMPERATURE
- -40°C to 70°C (-40°F to 158°F)

RUGGED CONSTRUCTION
- Chemical resistance to harsh cleaners such as detergents, alcohols, and ketones
- Type 1 Enclosure
- Conforms to heavy industry grade CE and UL requirements

RoHS Compliant
Product subject to change without notice.

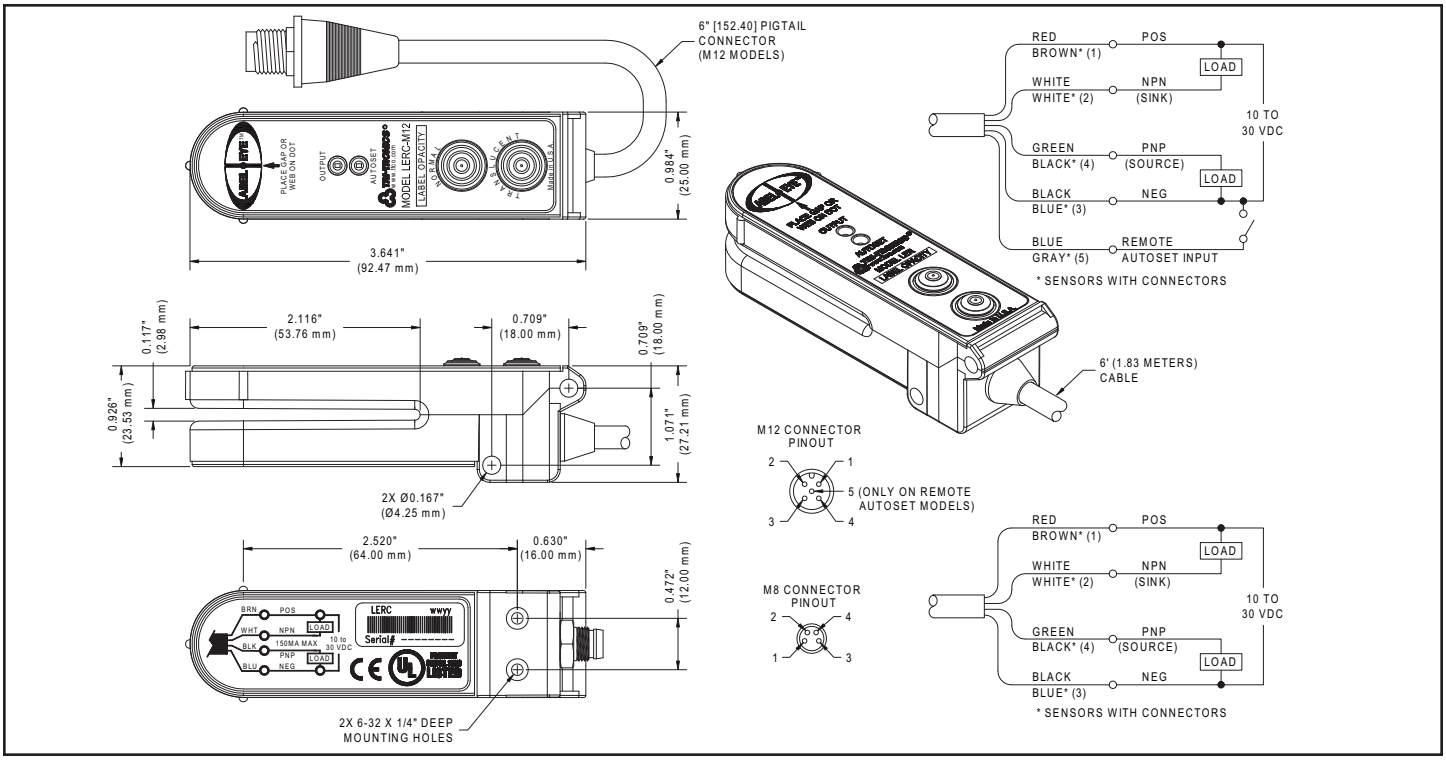
Model Numbers:

Label•Eye	Description
LER	Red LED, 4 Conductor 6ft Cable
LERC	Red LED, 4-pin M8 Connector
LERR	Red LED, 5 Conductor, 6ft Cable
LERRC-M12	Red LED, 5-Pin M12 Pigtail Connector
LERC-M12	Red LED, 4-Pin M12 Pigtail Connector

Nano Cable (M8) Selection Guide

P/N	Length	Thread Coupling
GEC-6	6ft (1.8m	Straight Female
GEC-15	15ft (4.6m)	Straight Female
RGEC-6	6ft (1.8m)	90° Female
RGEC-15	15ft (4.6m)	90° Female

DIMENSIONS



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ttco.com / info@ttco.com

ASSEMBLY TITLE: **LOW LABEL FAULT ASSEMBLY**

DRAWING NO.:

GENERAL FUNCTION:

- The low label supply fault indicates a depleting supply of labels. It consists of a fiber optic sensor that is set at the desired position on the roll of labels.
- When the label supply passes below the sensor range, a signal is generated this will light the yellow stack lamp and enunciate a low label condition on the operator's touch screen display.
- The male connector provides quick connection to the labeling head.

SET UP AND ADJUSTMENTS:

- Set the sensor eye just before the cardboard inner core, approximately ¼" below the supply reel flange and lined up with the sensing hole in the flange.

MAINTENANCE:

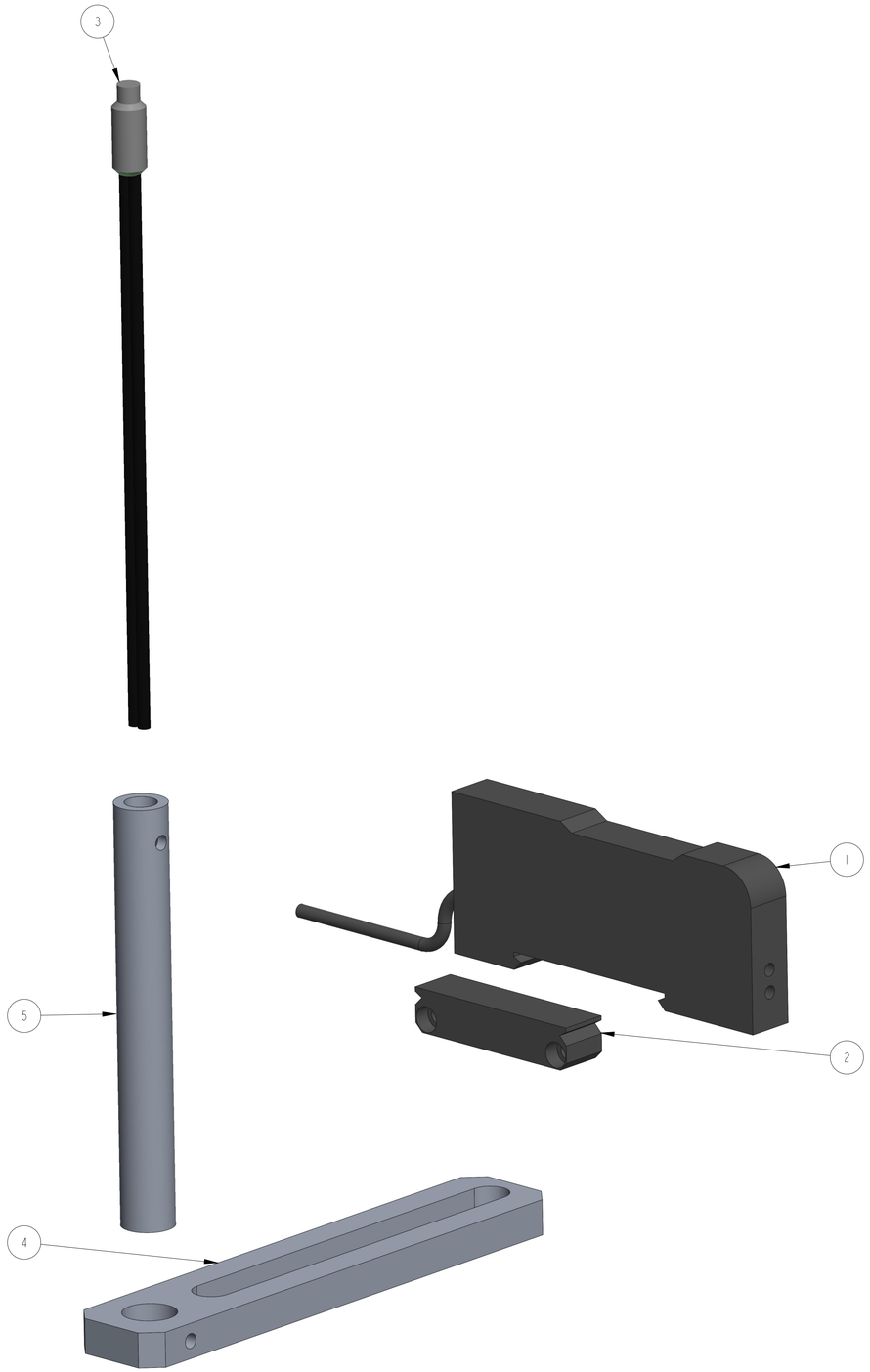
- Keep the sensor optical area clean from label and glue residue

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- No power to the sensor	- Check male connector and tightly secure connection to the head.

NOTE: The labeler will continue to operate until the operator pauses the labeler or the label supply completely depletes past the broken web sensor.

To reset the fault condition, replenish the label supply and press the labeler run button from run to pause and back to run.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	202201-000	DUAL DIGITAL FIBER AMPLIFIER	20776-006
2	1	202201-001	DUAL DIGITAL FIBER AMPLIFIER	20776-006
3	1	203170-000	CABLE,FIBER , REFLECTIVE, KEYENCE #FU-67V	20776-006
4	1	A23727-000	LOW LEVEL BRACKET	20776-006
5	1	A23728-000	LOW LEVEL SENSOR TUBE	20776-006

*NOT SHOWN
252019-000 CONNECTOR

REV	DATE	DESCRIPTION	BY
A	Apr-07-21	NEW DRAWING	TJS

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DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

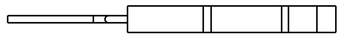
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

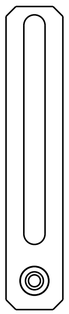
SCALE	2/1
DATE	Apr-07-21
DRAWN BY	TJS

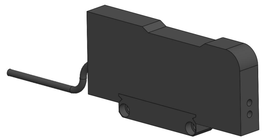
LOW LABEL

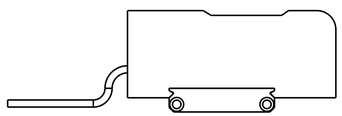
MAT'L 20776-006 & 20776-006P

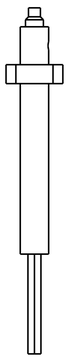
20776-006

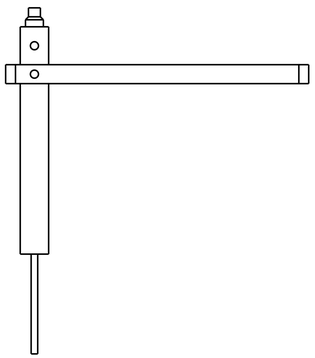


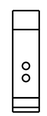












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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE	1/1
DATE	Apr-07-21
DRAWN BY	TJS

LOW LABEL

MAT'L 20776-006 & 20776-006P

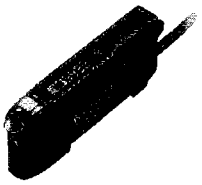
20776-006

KEYENCE

96M14746

* 9 6 M 1 4 7 4 6 - 2 *

Digital Fiberoptic Sensor
FS-N40 Series
Instruction Manual



Read this manual before using the product in order to achieve maximum performance.
Keep this manual in a safe place after reading it so that it can be used at any time.

For detailed FS-N40 Series setting methods and for details on the functions of the FS-N40 Series, see the "FS-N40 Series User's Manual".

■ Symbols

The following symbols are used in this instruction manual to enable the recognition of important information at a glance. Be sure to read these messages carefully.

DANGER	**It indicates a hazardous situation which, if not avoided, will result in death or serious injury.**
WARNING	**It indicates a hazardous situation which, if not avoided, could result in death or serious injury.**
CAUTION	**It indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.**
NOTICE	**It indicates a situation which, if not avoided, could result in product damage as well as property damage.**

1 Before Operation

Safety Precautions

DANGER	• This product is only intended to detect objects. Do not use this product for the purpose of protecting a human body or a part of a human body. • This product is not intended for use as an explosion-proof product. Do not use this product in a hazardous location and/or potentially explosive atmosphere.
WARNING	• This is a direct current (DC) power supply type sensor. Application of an alternating current may result in explosion or fire.
NOTICE	• Use separate conduits for power lines and high-voltage lines. Use of a common conduit may result in device malfunction due to noise or damage to the sensor. • Always ground the frame ground terminal when using an off-the-shelf switching regulator. • Do not use this product outdoors.

Precautions on Regulations and Standards

■ CE Marking

KEYENCE Corporation has confirmed, on the basis of the following specifications, that this product complies with the essential requirements of the applicable EU Directive(s). Be sure to consider the following specifications when using this product in the member states of the European Union.

● EMC Directive, applicable standard: EN60947-5-2, Class A

Ensure that the cable length is 30 meters or less.
These specifications do not give any guarantee that the end-product with this product incorporated complies with the essential requirements of the EMC Directive. The manufacturer of the end-product is solely responsible for confirming the compliance of the end-product itself according to the EMC Directive.

■ UL Certificate

This product is a UL/c-UL certified product.
- UL File No.: E301717
- Category: NRKH/NRKH7(NRKH2/NRKH8: FS-N42N(P))
- Enclosure Type 1 (based on UL50)

Be sure to consider the following specifications when using this product as a UL/c-UL certified product.
- Use a power supply with Class 2 output defined in NFPA70 (NEC: National Electrical Code).
- Connect the power supply, external input, and control output to a single power supply with Class 2 output.
- Use OP-73864, OP-73865 or OP-85498 cable with FS-N41C when the field wiring is required.

■ FCC Regulations

This product complies with the following regulations specified by the FCC.
- Applicable regulation FCC Part 15 Subpart B Class A
- This device complies with part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interface, and (2) this device must accept any interference received, including interference that may cause undesired operation.
- FCC Caution

Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

Package Contents

- Main unit
- Instruction manual

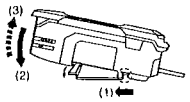
2 Installation and Wiring

Mounting the Main Unit

■ Mounting the Main Unit on a DIN rail

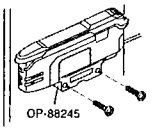
1 **Align the claw at the bottom of the main unit with the DIN rail, as shown in the figure. While pushing the main body in the direction of arrow 1, push down in the direction of arrow 2.**

2 **To remove the sensor, raise the main body in the direction of arrow 3 while pushing the main body in the direction of arrow 1.**



■ Installation on a wall (main unit only)

1 **Attach the main unit to the optional mounting adapter (OP-88245), and then insert M3 screws into the two locations shown in the figure to secure the main unit in place.**

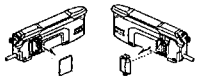


Connecting Multiple Amplifiers

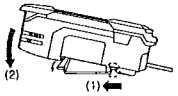
Up to 16 expansion units can be connected to 1 main unit. However, each dual output type will be treated as 2 expansion units.

CAUTION	**When connecting to multiple amplifiers or when mounting main units together, mount the units on a DIN rail installed on a metal surface.**
NOTICE	**• Be sure to turn the power off before connecting multiple expansion units. • Do not touch the expansion connector.**

1 **Remove the protection covers from the main unit and expansion unit(s).**



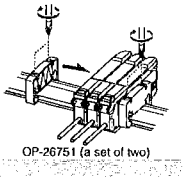
2 **Install the amplifiers on the DIN rail one at a time.**



3 **Slide the main unit and expansion unit(s) together. Mate the two claws of the expansion unit with the recesses on the main unit side until a click is heard/felt.**

4 **Attach the end units (optional, sold separately: OP-26751) to the DIN rail on both sides of the amplifiers in the same way as step (2).**

5 **Secure the amplifiers between the end units. Tighten the screws from the top (two screws x two units) with a Phillips screwdriver to fix the end units in place.**



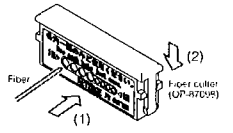
OP-26751 (a set of two)

Fiber Unit Installation

■ Using a fiber cutter

1 **Insert the fiber into the cutter hole.**

2 **Bring down the blade in a single, swift motion to cut the fiber. (Do not use a hole that has already been used.)**



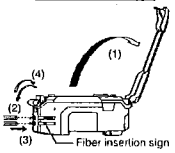
Always insert fiber from the side with writing

■ Connecting to the amplifier unit

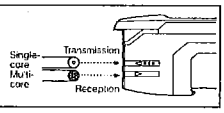
1 **Open the cover (1), and then lower the lever in the direction indicated by (2).**

2 **Insert the fiber unit into the installation holes (approximately 14 mm). (3)**

3 **Move the lever back in the direction indicated by (4).**

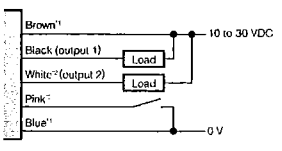


NOTICE	**When installing a coaxial reflective fiber in the main unit, install the single-core fiber in the transmission installation hole and the multi-core fiber in the reception installation hole.**



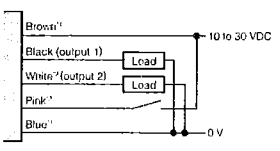
Wiring (Cable Type)

● FS-N41N/N42N/N43N/N44N



*1 FS-N41N/N43N only
*2 FS-N43N/N44N only

● FS-N41P/N42P/N43P/N44P



*1 FS-N41P/N43P only
*2 FS-N43P/N44P only

Wiring (M8 Connector Type: FS-N41C)

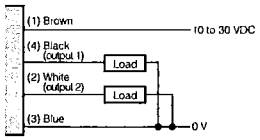
Select NPN or PNP and the function of I/O pin (2) during the initial settings.

Sensor pin layout 

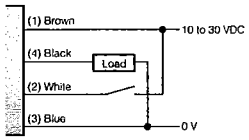
FS-N41C supports "IO-Link: Specification V.1.1/COM2 (38.4 kbps)". The setting file (IODD) can be downloaded from Keyence's web site (http://www.keyence.com).

● When using the sensor in PNP mode

OUT1 + OUT2

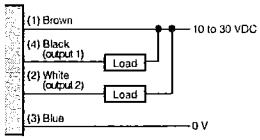


OUT1 + INPUT

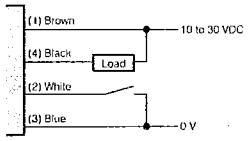


● When using the sensor in NPN mode

OUT1 + OUT2



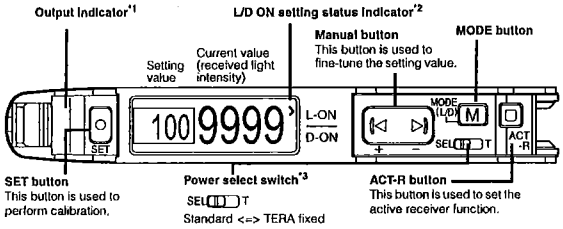
OUT1 + INPUT



The wire colors indicate the colors when using an OP-73864/73865 M8 connector cable (sold separately).

3 Basic Settings

■ Names and functions



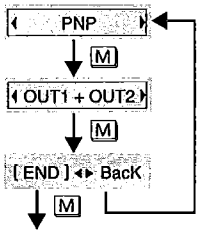
*1 On dual output types (including the FS-N41C), the indicator operates according to the output channel selected with the output channel selection switch.

*2 On dual output types (including the FS-N41C), this becomes the output indicator. It displays the current output status of channels 1 and 2.

*3 On dual output types (including the FS-N41C), this becomes the output channel selection switch. It is not present on zero line types (FS-N40).

■ Initial settings (FS-N41C only)

When turning on the sensor for the first time, or when the sensor has been initialized, select the initial settings shown below.



Settings complete

Use [◁ ▷] to select PNP or NPN.

Use [◁ ▷] to select the I/O. (OUT1 + OUT2/OUT1 + INPUT)

Use [◁ ▷] to select this item.

After completion, if these setting need to be changed again, perform initialization (page 3).

■ Basic settings

● Switching the output style (Light ON/Dark ON)

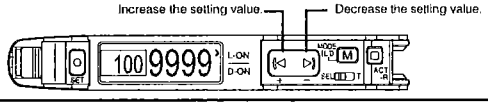
1 Press [M] once. Switch L-On/D-On
2 Use [◁ ▷] to switch the output style.
3 Press [M] three times.

● Switching the display language

1 Press [M] twice. Language / 语言
2 Use [◁ ▷] to select the language.
3 Press [M] twice.

● Fine-tuning the setting value (threshold)

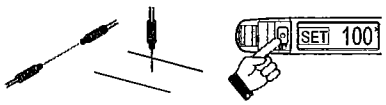
Use [◁ ▷] to adjust the value. Hold down the button to make adjustments more quickly.



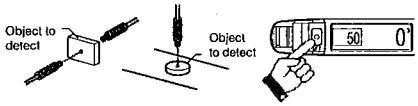
■ Basic calibration methods

● 2-point calibration (the most basic setting method)

1 Press [SET] with no object to detect present.



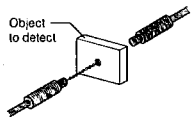
2 Press [SET] with an object to detect present.



This sets the setting value to the midpoint between the received light intensities of points 1 and 2. If "---" blinks for 2 seconds on the display, the difference between the received light intensities is small, and detection may be unstable.

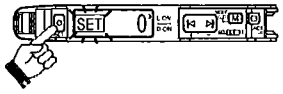
● Maximum sensitivity calibration

Thrubeam model: With an object to detect present



Reflective model: With no object to detect present

1 With the items arranged as shown in the figures on the left, hold down [SET] for 3 seconds or more. When SET blinks, release this button.



The setting value is set slightly higher than the received light intensity when the setting was configured.

4 Useful Functions

● Initialization

Initialize all the settings and return the sensor to its factory default state.

1 Hold down SET and ACT-R for 3 seconds or more. Initialize

2 Press M once. Back

3 Press ◀ ▶ once. Execute

4 Press M once.

● Key lock

Disable button operations.

1 Hold down M and ◀ ▶ for 3 seconds or more.

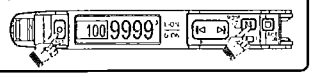
Cancel: Use the same procedure.

● Saturation avoidance function

Use this function when the received light intensity does not change from the maximum displayed value.

1 Press M and SET simultaneously.

Cancel: Use the same procedure.

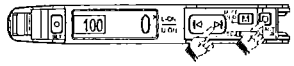


● Zero shift function

Use this function to change the received light intensity display to zero.

1 Press ACT-R and ◀ ▶ simultaneously.

Cancel: Hold down ACT-R and ◀ ▶ for 3 seconds or more.



● Active receiver (ACT-R)

This function makes the fiber unit's receiver blink in green.

Operation when the sensor is shipped from the factory

When the sensor output is ON, the fiber unit's receiver lights in green. (This is linked to the output.)

To change the normal lighting status of the receiver (change the settings)

1 Press ACT-R three times. Active Rec. Set

2 Use ◀ ▶ to select the status from those shown below.

Output Link: The receiver will light when the output is ON.
Reversed Op: The receiver will light when the output is OFF.
Always On: The receiver will be lit always.
Disable: The receiver will be off always.

3 Press ACT-R twice to return to the normal status.

To force the receiver to blink in green (pairing mode)

1 Press ACT-R once. ACT-R Blinking

2 Press ◀ ▶.

3 The light-receiving side blinks in green.

4 Press ACT-R four times to return to the normal status.

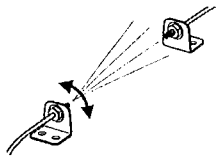
To make it easy to perform optical-axis alignment (optical-axis alignment assist mode)

1 Press ACT-R twice. Opt Axis Assist

2 Press ◀ ▶ to make the light-receiving side blink in green.

3 Move the tip of the fiber unit within the movable range.

The light-receiving side lights in green near the peak light intensity within the range in which the tip moved.
Align the optical axis within the middle of the range in which the light-receiving side lights.



4 When you finish the alignment, press ACT-R three times.

The sensor returns to the normal status.

5 Specifications

The response times are listed on the following page.

Model	NPN output	FS-N41N	FS-N42N	FS-N43N	FS-N44N	FS-N41C*1	FS-N40
	PNP output	FS-N41P	FS-N42P	FS-N43P	FS-N44P	(selectable output)	
Cable/connector		Cable				M8 connector*2	-
Main unit/expansion unit		Main unit	Expansion unit	Main unit	Expansion unit	Main unit	Expansion unit
Number of control outputs		1	1	2	2	2*3	None*4
Number of external inputs		-	-	1	1	1*3	-
Light source LED		Transmitter side: Red, four-element LED (wavelength: 660 nm)					
Control output		Open-collector, 30 V or less 100 mA or less per output, 100 mA or less total for 2 outputs (when used as a solitary unit)/ 20 mA (when used as an expansion unit)					-
	Residual voltage	NPN 1.4 V or less (output current: 10 mA or less)/ 2 V or less (output current: 10 to 100 mA) PNP 1.6 V or less (output current: 10 mA or less)/ 2.2 V or less (output current: 10 to 100 mA)					-
External input		Input time: 2 ms (ON)/20 ms (OFF) or longer*5					
Unit expansion (excluding the FS-N41C)		Up to 16 units (17 units connected in total including the main unit). However, each two output type will be treated as two expansion units.					
Protection circuit		Protection against reverse power connection, output overcurrent, output surge, and reverse output connection					
Mutual interference prevention		S-HSPD/HSPD: 0 units, FINE: 4 units, TURBO/SUPER/ULTRA/MEGA/TERA: 8 units (The mutual interference prevention values are twice those shown here when Double is set.)					
Power supply	Power supply voltage	10 to 30 VDC (including 10% ripple (P-P) or less), class 2 or LPS*6					
	Power consumption*7 NPN FS-N40	During normal operation: 870 mW or less (34 mA or less at 24 V/62 mA or less at 12 V) ECO ON: 800 mW or less (31 mA or less at 24 V/56 mA or less at 12 V) ECO FULL: 710 mW or less (28 mA or less at 24 V/49 mA or less at 12 V)					
	Power consumption*7 PNP FS-N41C	One output type (FS-N41P/N42P) and FS-N41C During normal operation: 910 mW or less (36 mA or less at 24 V/65 mA or less at 12 V) ECO ON: 840 mW or less (33 mA or less at 24 V/60 mA or less at 12 V) ECO FULL: 750 mW or less (30 mA or less at 24 V/52 mA or less at 12 V)					
		Two output type (FS-N43P/N44P) During normal operation: 990 mW or less (39 mA or less at 24 V/72 mA or less at 12 V) ECO ON: 920 mW or less (36 mA or less at 24 V/66 mA or less at 12 V) ECO FULL: 830 mW or less (33 mA or less at 24 V/59 mA or less at 12 V)					
Ambient light		Incandescent lamp: 20,000 lx or less, sunlight: 30,000 lx or less					
Ambient temperature		-20°C to +55°C (no freezing)*8					
Vibration resistance		10 to 55 Hz; double amplitude 1.5 mm, 2 hours each for X, Y, and Z axes					
Shock resistance		500 m/s², 3 times each for X, Y, and Z axes					
Case material		Main unit and cover: polycarbonate					
Weight		Approx. 78 g	Approx. 48 g	Approx. 83 g	Approx. 73 g	Approx. 25 g	Approx. 23 g

*1 IO-Link Specification V1.1/COM2 (38.4 kbps) is supported.
*2 Ensure the cable length is 30 m or less for the M8 connector type. In case of connecting with IO-Link, set it to 20 m or less.
*3 Output 2 and the external input are selectable.
*4 This counts as 1 output when connecting multiple units to the FS-MCBN/P, NU Series.
*5 The input time becomes 25 ms (ON)/25 ms (OFF) when external calibration input is selected.
*6 When expanding the system to 9 or more units, use a power supply voltage of 12 V or higher.
*7 The load current is excluded. The power consumption including the load when the maximum number of units are connected is 38 W max.
*8 When expanded by 1 to 2 units: -20°C to +55°C. When expanded by 3 to 10 units: -20°C to +50°C.
When expanded by 11 to 16 units: -20°C to +45°C. When using 2 outputs, 1 unit is counted as 2 units.
Note that all the temperature prescriptions assume that the sensor has been mounted on a DIN rail installed on a metal surface.
Exercise special care when installing the product in an airtight space.

E 1101-3

6 Detailed Settings

Hold down [M] for 3 seconds or more to enter the settings menu. Then, press [M] to change the item and press [◀ ▶] to switch the setting value.
Press [M] + [▲ ▶] when an item is being set to return to the previous item.

A Power Modes Press [◀ ▶] to select the value.

[M] Select from eight power modes. The initial setting is FINE.

Mode	S-HSPD*1	HSPD	FINE	TURBO
Response time	23 µs	50 µs	250 µs	500 µs
Maximum displayable light intensity	9999			

Mode	SUPER	ULTRA	MEGA	TERA
Response time	1 ms	4 ms	16 ms	64 ms
Maximum displayable light intensity	9999		99999*2	

B Switch L-on/D-on Press [◀ ▶] to select the value.
• Light ON • Dark ON

C Display Bar Press [◀ ▶] to select the value.
• OFF • ON

[END] ◀ ▶ ADVANCE Press [◀ ▶] to select the value.

End [M] ADVANCE
Settings complete

D Detection Mode *3 Press [◀ ▶] to select the value.

[M] Select from the following operation modes.
• Standard • Preset • Percent
• Zeroshift • Area detection • Area % Mode
• DATUM • Rising edge • Falling edge

E Output timer *4 Press [◀ ▶] to select the value.

F Ext. Input Press [◀ ▶] to select the value.

[M] This can only be used on types that support an external input. It is possible to select from the following values.
• OFF • External Set • Zero shift
• Reset • LED OFF • Pause
• Sleep
When connected to the multi-output unit FS-MC8N/P or the communication unit NU Series, this setting can be configured on types that do not support an external input.

G Saturate Cancel Press [◀ ▶] to select the value.

H Attenuation Press [◀ ▶] to select the value.

I Zero Shift Press [◀ ▶] to select the value.

J Limit Detection *4 Press [◀ ▶] to select the value.

[M] If Limit Detection is set to ON, a notification of a drop in light intensity is shown on the display when the light intensity drops due to factors such as dirt.
With dual output types, it is also possible to output alarms to an external device.
When connected to the multi-output unit FS-MC8N/P, it is possible to output alarms from the "common output" of the FS-MC8N/P even for types that do not support the alarm output.

K Auto Power Press [◀ ▶] to select the value.

L Hysteresis Press [◀ ▶] to select the value.

M Language Press [◀ ▶] to select the value.

[M] Select from English (initial setting), Japanese, Chinese, and German.

N Flip Display Press [◀ ▶] to select the value.

O Sub Display Press [◀ ▶] to select the value.

P ACT-R Press [◀ ▶] to select the value.

Q Brightness Press [◀ ▶] to select the value.

R ECO *6 Press [◀ ▶] to select the value.

S Initialize Press [◀ ▶] to select the value.

T Custom Setting Press [◀ ▶] to select the value.

U Interference *5 *7 Press [◀ ▶] to select the value.

V Key Lock Method Press [◀ ▶] to select the value.

W Display Gain *5 Press [◀ ▶] to select the value.

X IO-Link Mode *8 Press [◀ ▶] to select the value.

Y IO Data Format *8 Press [◀ ▶] to select the value.

Z I/O Selection *8 Press [◀ ▶] to select the value.

END

Settings complete

■ Output 2 setting

1 ⊏□⊐ 2 When using a dual output type, if the output channel selection switch is set to the "2" side, output 2 can be set.

Hold down [M] for 3 seconds or more to enter setup mode.

a Second Output Press [◀ ▶] to select the value.

b Switch L-On/D-On Press [◀ ▶] to select the value.

c Output timer 2 Press [◀ ▶] to select the value.

END

Settings complete

*1 When S-HSPD is selected for Power Modes
Output 2 of dual output types is fixed to OFF.
IO-Link communication cannot be used (FS-N41C).
*2 This is 65535 when connected to an NU Series unit.
*3 When S-HSPD is selected for Power Modes
Area detection, Area % Mode, DATUM, Rising edge, or Falling edge cannot be selected.
*4 This cannot be used when S-HSPD is selected for Power Modes.
*5 This cannot be used when S-HSPD or HSPD is selected for Power Modes.
*6 When S-HSPD is selected for Power Modes, FULL cannot be selected for the ECO function.
The IO-Link communication cannot be used when FULL is selected for ECO (FS-N41C).
*7 This item is not displayed on the FS-N41C.
*8 This item is only displayed on the FS-N41C.

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Specifications are subject to change without notice. A6WW1-MAN-1097

14746E 1127-2a [96M14746] Printed in Japan

ASSEMBLY TITLE: **BROKEN WEB / END OF WEB**

DRAWING NO:

GENERAL FUNCTION:

- The broken web fault indicates that the labeler label stock has broken after the labeler pull roll. It consists of a reflective sensor and a reflector. The sensor is capable of reading clear or opaque label liner.

-When the broken web passes through the sensor, a signal is generated, that signal will shut the conveyor system down and light the red lamp on the stack lamp assembly.

-To reset the fault condition, rethread labels and press labeler run/pause to turn off the red light and place the labeler in run mode. The conveyor will restart and the labeling process will continue.

SET-UP AND ADJUSTMENTS:

- The sensor is set in light on operation mode. It is a retro-reflective operation. To set the sensor, refer to the following manufacture's instruction sheet.

- Ensure that all label material is removed from the sensor and reflector area for proper set up.

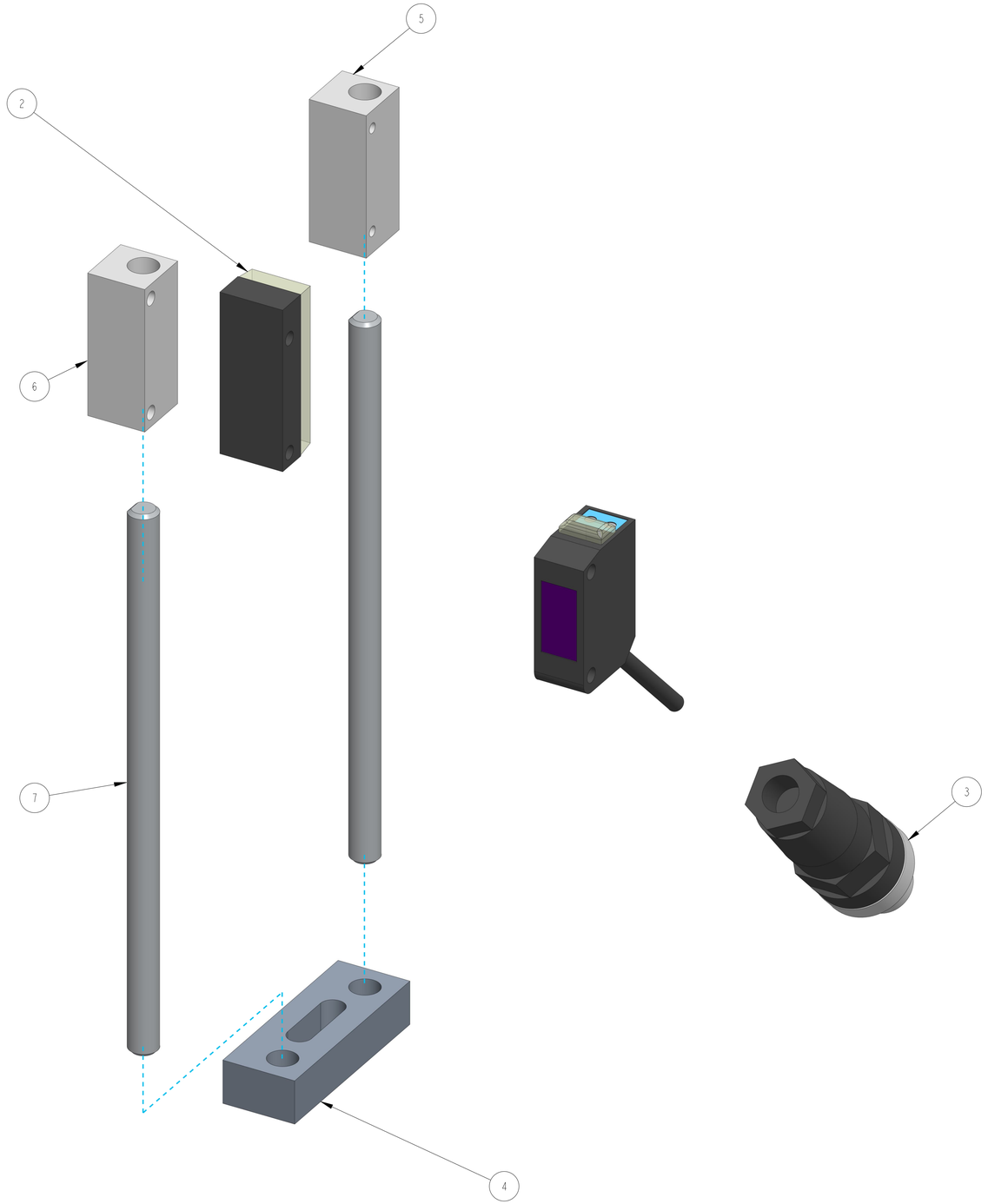
MAINTENANCE:

- See Maintenance Section

TROUBLESHOOTING:

- See Troubleshooting Section

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	202192-002	CLEAR PRODUCT SENSOR	21606-013
2	1	203161-000	REFLECTOR	21606-013
3	1	252019-000	4 PIN MALE CONNECTOR	21606-013
4	1	A24241-000	MOUNTING BLOCK	21606-013
5	1	A24242-000	SENSOR MTG. BLOCK	21606-013
6	1	A24243-000	REFLECTOR MTG. BLOCK	21606-013
7	2	A24244-000	SUPPORT ROD WITH FLAT	21606-013



REV	DATE	DESCRIPTION	BY
A	11/11/24	NEW DRAWING	SEM

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

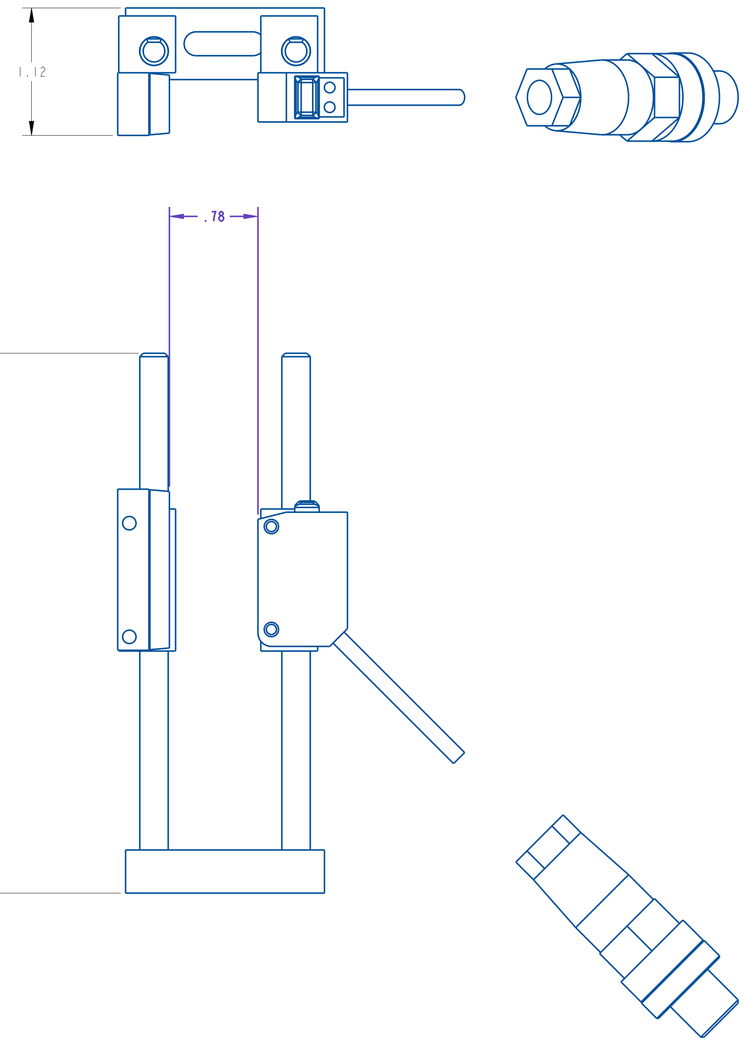
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

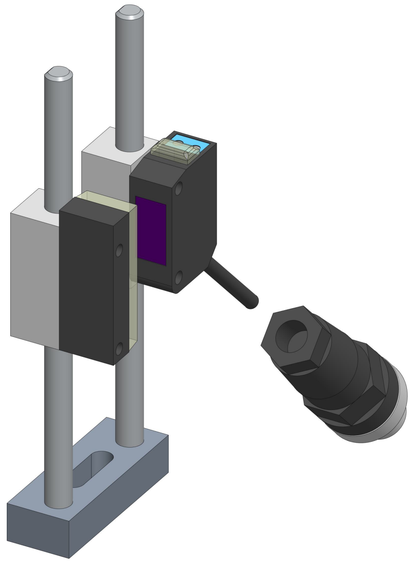
SCALE: 2/1
DATE: 11/11/24
DRW BY: SEM
CHK BY: &CREO_CHK
APPR BY:

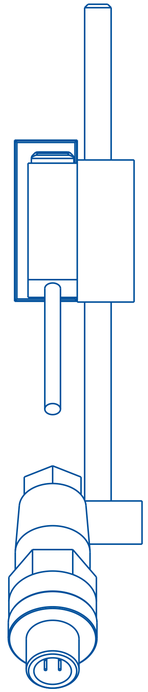
BROKEN WEB/END OF WEB, PNP SINGLE BASE, USE PZ-G62P

MAT'L

21606-013







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DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	3/2
DATE:	11/11/24
DRW BY:	SEM
CHK BY:	CREO_CHK
APPR BY:	

BROKEN WEB/END OF WEB, PNP SINGLE BASE, USE PZ-G62P

MAT'L -

21606-013

KEYENCE

96M11227

Self-contained
Photoelectric Sensor

PZ-G Series
Instruction Manual

Read this manual thoroughly before using the product.
Keep this manual readily available for future reference.

■ Safety precautions

- Avoid running the PZ-G cable along with power and high voltage lines, as this may cause interference and/or permanent damage.
- When using a commercially available switching regulator, ground its chassis grounding and earth grounding terminals.
- Do not use in locations where direct ambient light or external light directly shines on the light receiving surface.
- With retro-reflective type sensors, when detecting highly reflective materials (such as mirrored surfaces), stabilization may be difficult. To correct this, change the angle of the sensor head, or adjust the sensitivity.
- Avoid using power which exceeds the specifications for ripple (10% max)
- Avoid using excess force when rotating the operation mode selector switch (Light-on, Dark-on) and the sensitivity adjustment trimmer.
- This product is just intended to detect the object(s). Do not use this product for the purpose to protect a human body or a part of human body.
- This product is not intended for use as explosion-proof product. Do not use this product in a hazardous location and/or potentially explosive atmosphere.

Precautions on Regulations and Standards

■ UL Certificate

This product is an UL/C-UL Listed product.

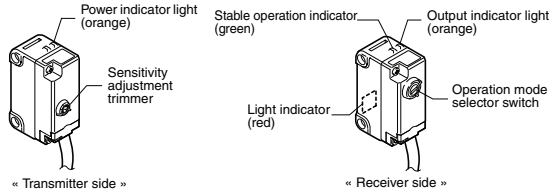
- UL File No. E301717
- Category NRKH,NRKH7
- Enclosure Type 1 (Based on UL50)

Be sure to consider the following specifications when using this product as an UL/C-UL Listed Product.

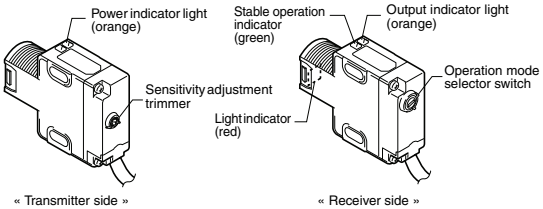
- Use the power supply with Class 2 output defined in NFPA70 (NEC: National Electrical Code).
- Power supply/ Control input/ Control output circuits shall be connected to a single Class 2 source only.
- Use with the over current protection device which is rated 30V or more and not more than 1A.

Part Names

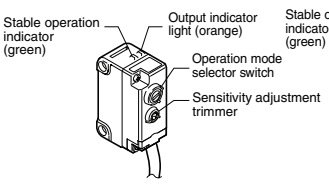
● **PZ-G5xN/G5xP**



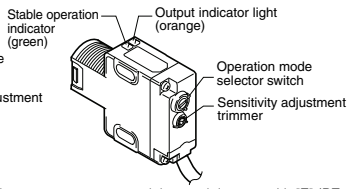
● **PZ-G5xB**



● **PZ-G4xN/G4xP/G10xN/ G10xP/G6xN/G6xP**



● **PZ-G4xB/G10xB/G6xB**

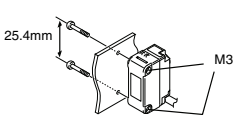


* The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

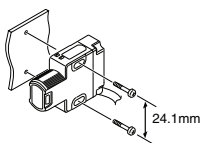
Mounting Method

■ Side Mounting (Prepare M3 screws)

Tightening torque: 0.5 N·m or less

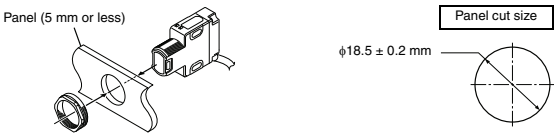


Tightening torque: 0.5 N·m or less



■ Mounting with the M18 nut (includes nut type)

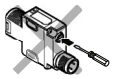
The M18 nut is also available separately as OP-84225 (2 pcs. supplied).
Tightening torque:1.0 N·m or less



Note

- Mount the M18 nut (supplied) straight in. If mounted at an angle it cannot be tightened properly.
- When tightening the M18 nut (supplied), firmly hold the main body down. The case of the main body may be damaged if held in place with a tool such as pliers.
- When tightening the M18 nut (supplied), if excess force is applied to the nut with a tool such as pliers, it may bend it out of shape. Therefore, do not apply excess force.

Sensitivity Adjustment Method

Caution ⚠	Avoid using excess force when rotating the sensitivity adjustment trimmer and operation mode selector switch as it may cause damage.	

■ Operation mode selector switch

With the operation mode selector switch, you can select either the LIGHT-ON mode (L) or the DARK-ON (D) mode.

LIGHT-ON setting

DARK-ON setting

■ Reflective type (PZ-G41/G42/G101/G102/G10R/G10G/G10B Series)

The following assumes LIGHT-ON (L) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Position target in place. Slowly rotate the sensitivity trimmer from the MIN position towards the MAX position until the (orange) output indicator turns on (Position "A"). If the output indicator does not turn off, even at MIN, then MIN is considered Position "A".	
②	Remove the target. Adjust the sensitivity trimmer from MIN towards MAX until the (orange) output indicator turns on (Position "B"). If the output indicator does not light up, the MAX position is considered Position "B".	
③	Adjust the sensitivity trimmer to the midpoint between "A" and "B". Verify that the (green) stable operation light turns on with and without a target in place.	

Reference To use the sensor in DARK-ON mode, adjust the mode selector switch to "D".

■ Thrubeam type (PZ-G51/G52 Series) / Retro-reflective type (PZ-G61/G62 Series)

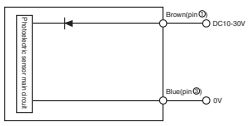
The following assumes DARK-ON (D) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Remove the target. Adjust the sensitivity trimmer to MAX. Mount the sensor heads in place so the (orange) output indicator turns off (on thrubeam models, the red light on the receiver face will turn on)	
②	Position target in place. Verify that the orange output indicator turns on (on thrubeam models, the red light on the receiver face will turn off). Adjust sensitivity lower if the output indicator does not turn on (or if the red light on the receiver face does not turn off on thrubeam models)	

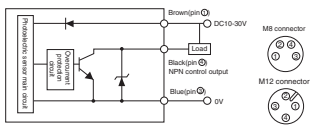
Reference To use the sensor in LIGHT-ON mode, adjust the mode selector switch to "L".

I/O Circuit Diagram

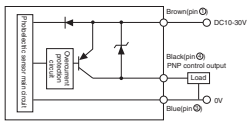
● **PZ-G5xN/G5xP/G5xB (Transmitter side)**



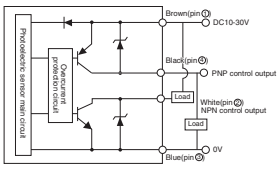
● **PZ-G5xN (Receiver side)/ G4xN/G10xN/G6xN**



● **PZ-G5xP (Receiver side)/ G4xP/G10xP/G6xP**



● **PZ-G5xB (Receiver side)/ G4xB/G10xB/G6xB**



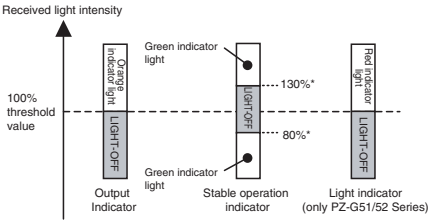
* The pin numbers represent those of the connector type / pigtail quick disconnect type. The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

PZ-GxxCN/GxxCP..... M8 connector
PZ-GxxCB/GxxEN/GxxEP..... M12 connector

■ Indicators

The following describes each ON/OFF condition of indicator when LIGHT-ON (L) is set.

Reference When the DARK-ON (D) is set, the output indicator ON/OFF will reverse.



* For PZ-G62, the upper limit is 107% and the lower limit is 93%.

If the stable operation indicator turns off during operation, readjust or fine-adjust the sensitivity.

■ Mutual interference

- For reflective type / retro-reflective type sensors, mutual interference protection can be set for up to 2 units. However, when the sensors are mounted facing each other, change the angle of the sensor head to prevent light being emitted into each unit.(The mark detection type does not include the mutual interference function.)
- Mutual interference prevention can be set when mounting a polarizing filter attachment (optional with thrubeam type sensors) (If operation is unstable even after mounting the polarizing filter, slightly lower the sensitivity.)
- For more detailed information about mutual interference or attachment, see the PZ-G Series catalog or contact your nearest KEYENCE office.

Specifications

Type			Thrubeam		Reflective				Retro-reflective		Mark detection		
Configuration	Cable shape	Output mode	Normal	High-power	Diffuse-reflective Long-detecting distance	Diffuse-reflective Short-detecting distance	Narrow-view reflective	Definite reflective	Long detecting distance (with P.R.O. function)	Transparent target detection (without P.R.O. function)	Red	Green	Blue
Rectangular	Cable	NPN	PZ-G51N	PZ-G52N	PZ-G41N	PZ-G42N	PZ-G101N	PZ-G102N	PZ-G61N	PZ-G62N	-		
		PNP	PZ-G51P	PZ-G52P	PZ-G41P	PZ-G42P	PZ-G101P	PZ-G102P	PZ-G61P	PZ-G62P			
	M8 connector	NPN	PZ-G51CN	PZ-G52CN	PZ-G41CN	PZ-G42CN	PZ-G101CN	PZ-G102CN	PZ-G61CN	PZ-G62CN	PZ-G10RCN	PZ-G10GCN	PZ-G10BCN
		PNP	PZ-G51CP	PZ-G52CP	PZ-G41CP	PZ-G42CP	PZ-G101CP	PZ-G102CP	PZ-G61CP	PZ-G62CP	PZ-G10RCP	PZ-G10GCP	PZ-G10BCP
	M12 pigtail quick disconnect	NPN	PZ-G51EN	PZ-G52EN	PZ-G41EN	PZ-G42EN	PZ-G101EN	PZ-G102EN	PZ-G61EN	PZ-G62EN	-		
		PNP	PZ-G51EP	PZ-G52EP	PZ-G41EP	PZ-G42EP	PZ-G101EP	PZ-G102EP	PZ-G61EP	PZ-G62EP			
Nut	Cable	Bipolar (NPN+PNP)	PZ-G51B	PZ-G52B	PZ-G41B	PZ-G42B	PZ-G101B	PZ-G102B	PZ-G61B	PZ-G62B			
	M12 connector		PZ-G51CB	PZ-G52CB	PZ-G41CB	PZ-G42CB	PZ-G101CB	PZ-G102CB	PZ-G61CB	PZ-G62CB			
Detecting distance*1			20 m	40 m	1 m (30 × 30 cm white mat paper)	300 mm (10 × 10 cm white mat paper)	200 mm	5 to 45 mm	0.1 to 4.2 m (when R-2L reflector is used)	0.1 to 1 m (when R-2L reflector is used)	8 to 15 mm		
Spot diameter			-	-	-	-	Approx. ϕ 5 mm (when the detecting distance is 100 mm)	Approx. ϕ 2 mm (when the detecting distance is 40 mm)	-	-	Approx. 1.5 × 4 mm (when the detecting distance is 10 mm)		
Light source (LED)			Red LED	Infrared LED × 2	Red LED					Infrared LED	Red LED	Green LED	Blue LED
Sensitivity adjustment			1-turn trimmer (230 degrees)										
Response time			500 µs								50 µs		
Operation mode			LIGHT-ON/DARK-ON, trimmer-selectable										
Indicator (LED)			Transmitter: power (orange) Receiver: output (orange), stable operation (green), light (red)		Output (orange), stable operation (green)								
Control output			Open-collector 100 mA max. (30 V max.), Residual voltage 1 V max.										
Protection circuit			Reverse-polarity protection, over-current protection, output surge absorber										
Ratings	Power voltage		10 to 30 VDC, Ripple (P-P): ±10% max, Class 2.										
	Current consumption		Transmitter: 20 mA max. Receiver: 28 mA max.	Transmitter: 25 mA max. Receiver: 28 mA max.	34 mA max.								
Environmental resistance	Enclosure rating		IEC,JEM: IP67 / NEMA: 4X,6,12 / DIN: IP69K										
	Ambient light		Incandescent lamp: 5,000 (lx) max, Sunlight: 20,000 (lx) max.										
	Ambient temperature		-20 °C to +55°C (No freezing)										
	Relative humidity		35 to 85 % RH (No condensation)										
	Vibration resistance		10 to 55 Hz, 1.5 mm double amplitude in X, Y, Z directions, 2 hours each										
	Shock resistance		1000 m/s^2 in X, Y, Z directions, 6 times each										
Interference prevention			2 units (when polarizing filter attachment is used)		2 units (with the automatic different cycle function)						-		
Material			Case, M18 nut (nut type only): reinforced glass polybutylene terephthalate (PBT), Trimmer: reinforced glass polyamide (PA) Cable (Cable type / pigtail quick disconnect type only): Polyvinyl chloride (PVC), Screw (Case connection): Steel, zinc-nickel plated, Packing (Case connection): Nitrile-butadiene rubber (NBR) Connector (pigtail quick disconnect type only): Brass-nickel plated, Polybutyleneterephtalate (PBT), Polyvinyl chloride (PVC)										
	Lens cover		Polyarylate (PAR)						Acrylic plastic (PMMA)	Polyarylate (PAR)			
Tightening torque			Rectangular type (side screw part): 0.5 N·m max. Nut type (front M18 part): 1.0 N·m max., (side slot part): 0.5 N·m max.										
Accessory*2			Instruction manual, M18 nut x 2 (nut thrubeam type), M18 nut x 1 (other nut types)										
Weight			Rectangular cable type: Approx. 60 g (Approx. 50 g for thrubeam transmitter), Rectangular M8 connector type: Approx 10 g, rectangular M12 pigtail quick disconnect type: Approx. 30 g Nut type cable type: Approx. 65 g (Approx. 55 g for thrubeam transmitter), Nut type M12 connector type: Approx 15 g										

*1 The detection distance is measured with the maximum sensitivity.
*2 The cable for the connector type / pigtail quick disconnect type is sold separately. The reflector for the retro-reflective type is sold separately.

WARRANTY

KEYENCE products are strictly factory-inspected. However, in the event of a failure, contact your nearest KEYENCE office with details of the failure.

1. WARRANTY PERIOD

The warranty period shall be for one year from the date that the product has been delivered to the location specified by the purchaser.

2. WARRANTY SCOPE

(1) If a failure attributable to KEYENCE occurs within the abovementioned warranty period, we will repair the product, free of charge. However, the following cases shall be excluded from the warranty scope.
- Any failure resulting from improper conditions, improper environments, improper handling, or improper usage other than described in the instruction manual, the user's manual, or the specifications specifically arranged between the purchaser and KEYENCE.
- Any failure resulting from factors other than a defect of our product, such as the purchaser's equipment or the design of the purchaser's software.
- Any failure resulting from modifications or repairs carried out by any person other than KEYENCE staff.
- Any failure that can certainly be prevented when the expendable part(s) is maintained or replaced correctly as described in the instruction manual, the user's manual, etc.
- Any failure caused by a factor that cannot be foreseen at a scientific/technical level at the time when the product has been shipped from KEYENCE.
- Any disaster such as fire, earthquake, and flood, or any other external factor, such as abnormal voltage, for which we are not liable.

(2) The warranty scope is limited to the extent set forth in item (1), and KEYENCE assumes no liability for any purchaser's secondary damage (damage of equipment, loss of opportunities, loss of profits, etc.) or any other damage resulting from a failure of our product.

3. PRODUCT APPLICABILITY

KEYENCE products are designed and manufactured as general-purpose products for general industries.

Therefore, our products are not intended for the applications below and are not applicable to them. If, however, the purchaser consults with us in advance regarding the employment of our product, understands the specifications, ratings, and performance of the product on their own responsibility, and takes necessary safety measures, the product may be applied. In this case, the warranty scope shall be the same as above.
- Facilities where the product may greatly affect human life or property, such as nuclear power plants, aviation, railroads, ships, motor vehicles, or medical equipment
- Public utilities such as electricity, gas, or water services
- Usage outdoors, under similar conditions or in similar environments

E 1040-1

KEYENCE CORPORATION

1-3-14, Higashi-Nakajima, Higashi-Yodogawa-ku,
Osaka, 533-8555, Japan
PHONE: +81-6-6379-2211 www.keyence.com

11227E 1070-1 96M11227
Printed in Japan

ASSEMBLY TITLE: **BROKEN WEB / END OF WEB**

DRAWING NO:

GENERAL FUNCTION:

- The broken web fault indicates that the labeler label stock has broken after the labeler pull roll. It consists of a reflective sensor and a reflector. The sensor is capable of reading clear or opaque label liner.

-When the broken web passes through the sensor, a signal is generated, that signal will shut the conveyor system down and light the red lamp on the stack lamp assembly.

-To reset the fault condition, rethread labels and press labeler run/pause to turn off the red light and place the labeler in run mode. The conveyor will restart and the labeling process will continue.

SET-UP AND ADJUSTMENTS:

- The sensor is set in light on operation mode. It is a retro-reflective operation. To set the sensor, refer to the following manufacture's instruction sheet.

- Ensure that all label material is removed from the sensor and reflector area for proper set up.

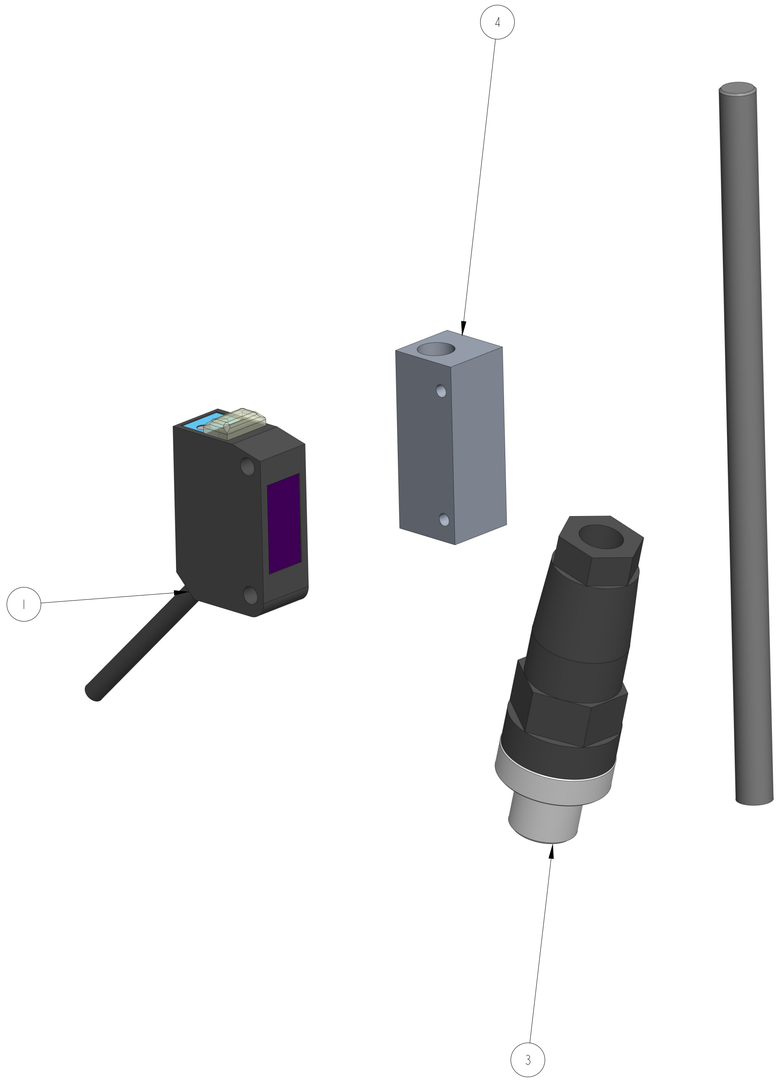
MAINTENANCE:

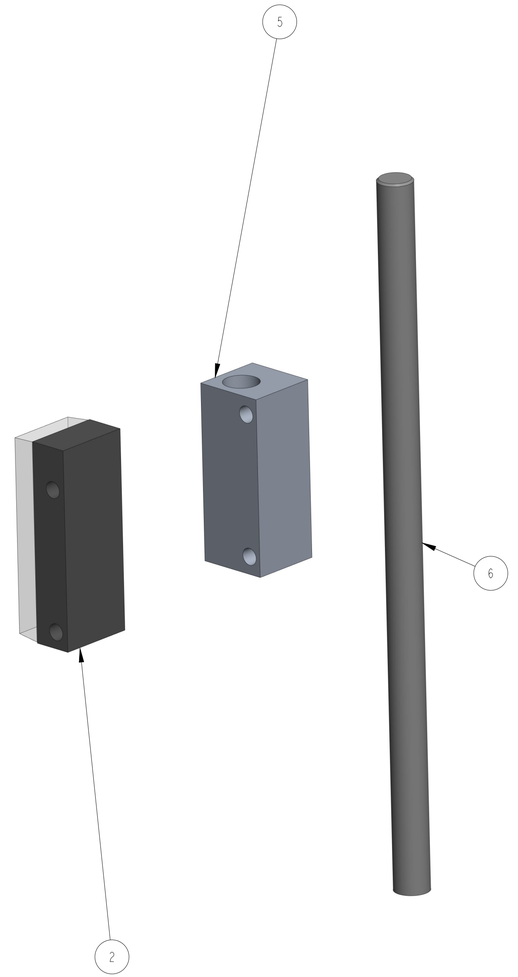
- See Maintenance Section

TROUBLESHOOTING:

- See Troubleshooting Section

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	202192-002	CLEAR PRODUCT SENSOR	21606-012
2	1	203161-000	REFLECTOR	21606-012
3	1	252019-000	4 PIN MALE CONNECTOR	21606-012
4	1	A24242-000	SENSOR MTG. BLOCK	21606-012
5	1	A24243-000	REFLECTOR MTG. BLOCK	21606-012
6	2	A25772-000	POST, SENSOR	21606-012





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SURFACE FINISH 125
BREAK ALL EDGES .005/.015
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QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 2/1
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BROKEN WEB/END OF WEB, PNP DUAL POSTS, USE PZ-G62P

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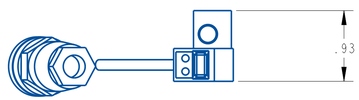

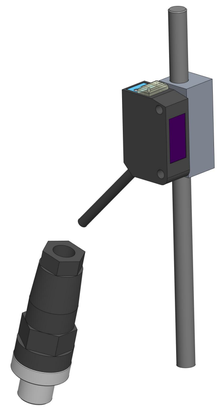

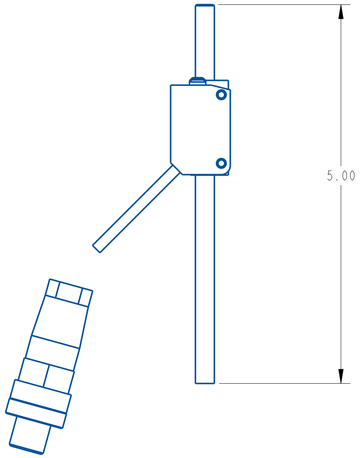

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- When using a commercially available switching regulator, ground its chassis grounding and earth grounding terminals.
- Do not use in locations where direct ambient light or external light directly shines on the light receiving surface.
- With retro-reflective type sensors, when detecting highly reflective materials (such as mirrored surfaces), stabilization may be difficult. To correct this, change the angle of the sensor head, or adjust the sensitivity.
- Avoid using power which exceeds the specifications for ripple (10% max)
- Avoid using excess force when rotating the operation mode selector switch (Light-on, Dark-on) and the sensitivity adjustment trimmer.
- This product is just intended to detect the object(s). Do not use this product for the purpose to protect a human body or a part of human body.
- This product is not intended for use as explosion-proof product. Do not use this product in a hazardous location and/or potentially explosive atmosphere.

Precautions on Regulations and Standards

■ UL Certificate

This product is an UL/C-UL Listed product.

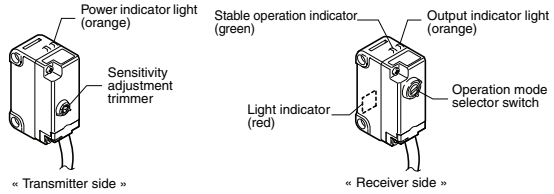
- UL File No. E301717
- Category NRKH,NRKH7
- Enclosure Type 1 (Based on UL50)

Be sure to consider the following specifications when using this product as an UL/C-UL Listed Product.

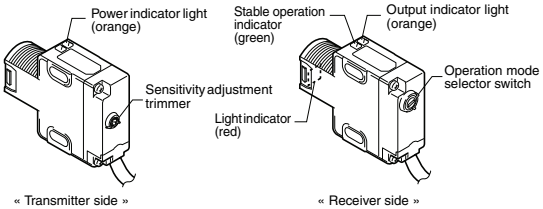
- Use the power supply with Class 2 output defined in NFPA70 (NEC: National Electrical Code).
- Power supply/ Control input/ Control output circuits shall be connected to a single Class 2 source only.
- Use with the over current protection device which is rated 30V or more and not more than 1A.

Part Names

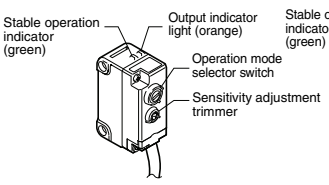
● **PZ-G5xN/G5xP**



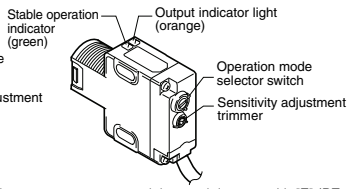
● **PZ-G5xB**



● **PZ-G4xN/G4xP/G10xN/ G10xP/G6xN/G6xP**



● **PZ-G4xB/G10xB/G6xB**

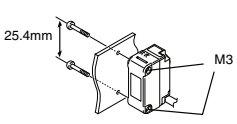


* The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

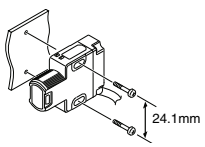
Mounting Method

■ Side Mounting (Prepare M3 screws)

Tightening torque: 0.5 N·m or less

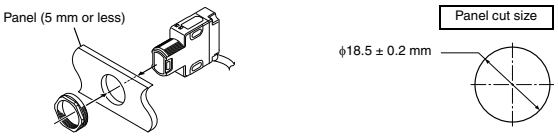


Tightening torque: 0.5 N·m or less



■ Mounting with the M18 nut (includes nut type)

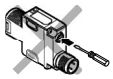
The M18 nut is also available separately as OP-84225 (2 pcs. supplied).
Tightening torque:1.0 N·m or less



Note

- Mount the M18 nut (supplied) straight in. If mounted at an angle it cannot be tightened properly.
- When tightening the M18 nut (supplied), firmly hold the main body down. The case of the main body may be damaged if held in place with a tool such as pliers.
- When tightening the M18 nut (supplied), if excess force is applied to the nut with a tool such as pliers, it may bend it out of shape. Therefore, do not apply excess force.

Sensitivity Adjustment Method

Caution ⚠	Avoid using excess force when rotating the sensitivity adjustment trimmer and operation mode selector switch as it may cause damage.	

■ Operation mode selector switch

With the operation mode selector switch, you can select either the LIGHT-ON mode (L) or the DARK-ON (D) mode.

LIGHT-ON setting

DARK-ON setting

■ Reflective type (PZ-G41/G42/G101/G102/G10R/G10G/G10B Series)

The following assumes LIGHT-ON (L) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Position target in place. Slowly rotate the sensitivity trimmer from the MIN position towards the MAX position until the (orange) output indicator turns on (Position "A"). If the output indicator does not turn off, even at MIN, then MIN is considered Position "A".	
②	Remove the target. Adjust the sensitivity trimmer from MIN towards MAX until the (orange) output indicator turns on (Position "B"). If the output indicator does not light up, the MAX position is considered Position "B".	
③	Adjust the sensitivity trimmer to the midpoint between "A" and "B". Verify that the (green) stable operation light turns on with and without a target in place.	

Reference To use the sensor in DARK-ON mode, adjust the mode selector switch to "D".

■ Thrubeam type (PZ-G51/G52 Series) / Retro-reflective type (PZ-G61/G62 Series)

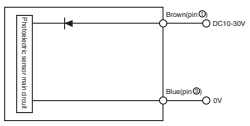
The following assumes DARK-ON (D) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Remove the target. Adjust the sensitivity trimmer to MAX. Mount the sensor heads in place so the (orange) output indicator turns off (on thrubeam models, the red light on the receiver face will turn on)	
②	Position target in place. Verify that the orange output indicator turns on (on thrubeam models, the red light on the receiver face will turn off). Adjust sensitivity lower if the output indicator does not turn on (or if the red light on the receiver face does not turn off on thrubeam models)	

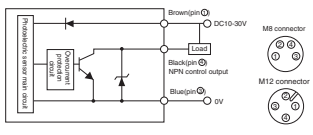
Reference To use the sensor in LIGHT-ON mode, adjust the mode selector switch to "L".

I/O Circuit Diagram

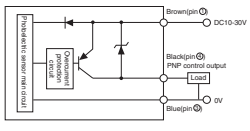
● **PZ-G5xN/G5xP/G5xB (Transmitter side)**



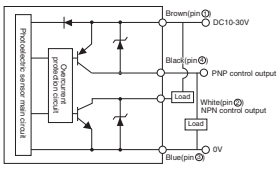
● **PZ-G5xN (Receiver side)/ G4xN/G10xN/G6xN**



● **PZ-G5xP (Receiver side)/ G4xP/G10xP/G6xP**



● **PZ-G5xB (Receiver side)/ G4xB/G10xB/G6xB**



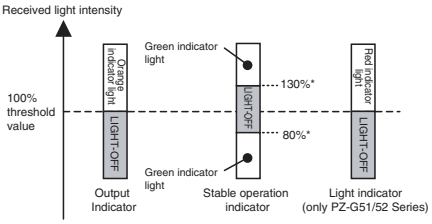
* The pin numbers represent those of the connector type / pigtail quick disconnect type. The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

PZ-GxxCN/GxxCP..... M8 connector
PZ-GxxCB/GxxEN/GxxEP..... M12 connector

■ Indicators

The following describes each ON/OFF condition of indicator when LIGHT-ON (L) is set.

Reference When the DARK-ON (D) is set, the output indicator ON/OFF will reverse.



* For PZ-G62, the upper limit is 107% and the lower limit is 93%.

If the stable operation indicator turns off during operation, readjust or fine-adjust the sensitivity.

■ Mutual interference

- For reflective type / retro-reflective type sensors, mutual interference protection can be set for up to 2 units. However, when the sensors are mounted facing each other, change the angle of the sensor head to prevent light being emitted into each unit.(The mark detection type does not include the mutual interference function.)
- Mutual interference prevention can be set when mounting a polarizing filter attachment (optional with thrubeam type sensors) (If operation is unstable even after mounting the polarizing filter, slightly lower the sensitivity.)
- For more detailed information about mutual interference or attachment, see the PZ-G Series catalog or contact your nearest KEYENCE office.

Specifications

Type			Thrubeam		Reflective				Retro-reflective		Mark detection		
Configuration	Cable shape	Output mode	Normal	High-power	Diffuse-reflective Long-detecting distance	Diffuse-reflective Short-detecting distance	Narrow-view reflective	Definite reflective	Long detecting distance (with P.R.O. function)	Transparent target detection (without P.R.O. function)	Red	Green	Blue
Rectangular	Cable	NPN	PZ-G51N	PZ-G52N	PZ-G41N	PZ-G42N	PZ-G101N	PZ-G102N	PZ-G61N	PZ-G62N	-		
		PNP	PZ-G51P	PZ-G52P	PZ-G41P	PZ-G42P	PZ-G101P	PZ-G102P	PZ-G61P	PZ-G62P			
	M8 connector	NPN	PZ-G51CN	PZ-G52CN	PZ-G41CN	PZ-G42CN	PZ-G101CN	PZ-G102CN	PZ-G61CN	PZ-G62CN	PZ-G10RCN	PZ-G10GCN	PZ-G10BCN
		PNP	PZ-G51CP	PZ-G52CP	PZ-G41CP	PZ-G42CP	PZ-G101CP	PZ-G102CP	PZ-G61CP	PZ-G62CP	PZ-G10RCP	PZ-G10GCP	PZ-G10BCP
	M12 pigtail quick disconnect	NPN	PZ-G51EN	PZ-G52EN	PZ-G41EN	PZ-G42EN	PZ-G101EN	PZ-G102EN	PZ-G61EN	PZ-G62EN	-		
		PNP	PZ-G51EP	PZ-G52EP	PZ-G41EP	PZ-G42EP	PZ-G101EP	PZ-G102EP	PZ-G61EP	PZ-G62EP			
Nut	Cable	Bipolar (NPN+PNP)	PZ-G51B	PZ-G52B	PZ-G41B	PZ-G42B	PZ-G101B	PZ-G102B	PZ-G61B	PZ-G62B			
	M12 connector		PZ-G51CB	PZ-G52CB	PZ-G41CB	PZ-G42CB	PZ-G101CB	PZ-G102CB	PZ-G61CB	PZ-G62CB			
Detecting distance*1			20 m	40 m	1 m (30 × 30 cm white mat paper)	300 mm (10 × 10 cm white mat paper)	200 mm	5 to 45 mm	0.1 to 4.2 m (when R-2L reflector is used)	0.1 to 1 m (when R-2L reflector is used)	8 to 15 mm		
Spot diameter			-	-	-	-	Approx. ϕ 5 mm (when the detecting distance is 100 mm)	Approx. ϕ 2 mm (when the detecting distance is 40 mm)	-	-	Approx. 1.5 × 4 mm (when the detecting distance is 10 mm)		
Light source (LED)			Red LED	Infrared LED × 2	Red LED					Infrared LED	Red LED	Green LED	Blue LED
Sensitivity adjustment			1-turn trimmer (230 degrees)										
Response time			500 µs								50 µs		
Operation mode			LIGHT-ON/DARK-ON, trimmer-selectable										
Indicator (LED)			Transmitter: power (orange) Receiver: output (orange), stable operation (green), light (red)		Output (orange), stable operation (green)								
Control output			Open-collector 100 mA max. (30 V max.), Residual voltage 1 V max.										
Protection circuit			Reverse-polarity protection, over-current protection, output surge absorber										
Ratings	Power voltage		10 to 30 VDC, Ripple (P-P): ±10% max, Class 2.										
	Current consumption		Transmitter: 20 mA max. Receiver: 28 mA max.	Transmitter: 25 mA max. Receiver: 28 mA max.	34 mA max.								
Environmental resistance	Enclosure rating		IEC,JEM: IP67 / NEMA: 4X,6,12 / DIN: IP69K										
	Ambient light		Incandescent lamp: 5,000 (lx) max, Sunlight: 20,000 (lx) max.										
	Ambient temperature		-20 °C to +55°C (No freezing)										
	Relative humidity		35 to 85 % RH (No condensation)										
	Vibration resistance		10 to 55 Hz, 1.5 mm double amplitude in X, Y, Z directions, 2 hours each										
	Shock resistance		1000 m/s^2 in X, Y, Z directions, 6 times each										
Interference prevention			2 units (when polarizing filter attachment is used)		2 units (with the automatic different cycle function)						-		
Material			Case, M18 nut (nut type only): reinforced glass polybutylene terephthalate (PBT), Trimmer: reinforced glass polyamide (PA) Cable (Cable type / pigtail quick disconnect type only): Polyvinyl chloride (PVC), Screw (Case connection): Steel, zinc-nickel plated, Packing (Case connection): Nitrile-butadiene rubber (NBR) Connector (pigtail quick disconnect type only): Brass-nickel plated, Polybutyleneterephtalate (PBT), Polyvinyl chloride (PVC)										
	Lens cover		Polyarylate (PAR)						Acrylic plastic (PMMA)	Polyarylate (PAR)			
Tightening torque			Rectangular type (side screw part): 0.5 N·m max. Nut type (front M18 part): 1.0 N·m max., (side slot part): 0.5 N·m max.										
Accessory*2			Instruction manual, M18 nut x 2 (nut thrubeam type), M18 nut x 1 (other nut types)										
Weight			Rectangular cable type: Approx. 60 g (Approx. 50 g for thrubeam transmitter), Rectangular M8 connector type: Approx 10 g, rectangular M12 pigtail quick disconnect type: Approx. 30 g Nut type cable type: Approx. 65 g (Approx. 55 g for thrubeam transmitter), Nut type M12 connector type: Approx 15 g										

*1 The detection distance is measured with the maximum sensitivity.
*2 The cable for the connector type / pigtail quick disconnect type is sold separately. The reflector for the retro-reflective type is sold separately.

WARRANTY

KEYENCE products are strictly factory-inspected. However, in the event of a failure, contact your nearest KEYENCE office with details of the failure.

1. WARRANTY PERIOD

The warranty period shall be for one year from the date that the product has been delivered to the location specified by the purchaser.

2. WARRANTY SCOPE

(1) If a failure attributable to KEYENCE occurs within the abovementioned warranty period, we will repair the product, free of charge. However, the following cases shall be excluded from the warranty scope.
- Any failure resulting from improper conditions, improper environments, improper handling, or improper usage other than described in the instruction manual, the user's manual, or the specifications specifically arranged between the purchaser and KEYENCE.
- Any failure resulting from factors other than a defect of our product, such as the purchaser's equipment or the design of the purchaser's software.
- Any failure resulting from modifications or repairs carried out by any person other than KEYENCE staff.
- Any failure that can certainly be prevented when the expendable part(s) is maintained or replaced correctly as described in the instruction manual, the user's manual, etc.
- Any failure caused by a factor that cannot be foreseen at a scientific/technical level at the time when the product has been shipped from KEYENCE.
- Any disaster such as fire, earthquake, and flood, or any other external factor, such as abnormal voltage, for which we are not liable.

(2) The warranty scope is limited to the extent set forth in item (1), and KEYENCE assumes no liability for any purchaser's secondary damage (damage of equipment, loss of opportunities, loss of profits, etc.) or any other damage resulting from a failure of our product.

3. PRODUCT APPLICABILITY

KEYENCE products are designed and manufactured as general-purpose products for general industries.

Therefore, our products are not intended for the applications below and are not applicable to them. If, however, the purchaser consults with us in advance regarding the employment of our product, understands the specifications, ratings, and performance of the product on their own responsibility, and takes necessary safety measures, the product may be applied. In this case, the warranty scope shall be the same as above.
- Facilities where the product may greatly affect human life or property, such as nuclear power plants, aviation, railroads, ships, motor vehicles, or medical equipment
- Public utilities such as electricity, gas, or water services
- Usage outdoors, under similar conditions or in similar environments

E 1040-1

KEYENCE CORPORATION

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11227E 1070-1 96M11227
Printed in Japan


System

ASSEMBLY TITLE: **FRAME ASSEMBLY**

GENERAL FUNCTION:

- Provides solid mounting for labeling head if not installed on a system that allows for vertical and horizontal adjustment.
- Allows for vertical and horizontal adjustment in the setup of the labeling head operation.

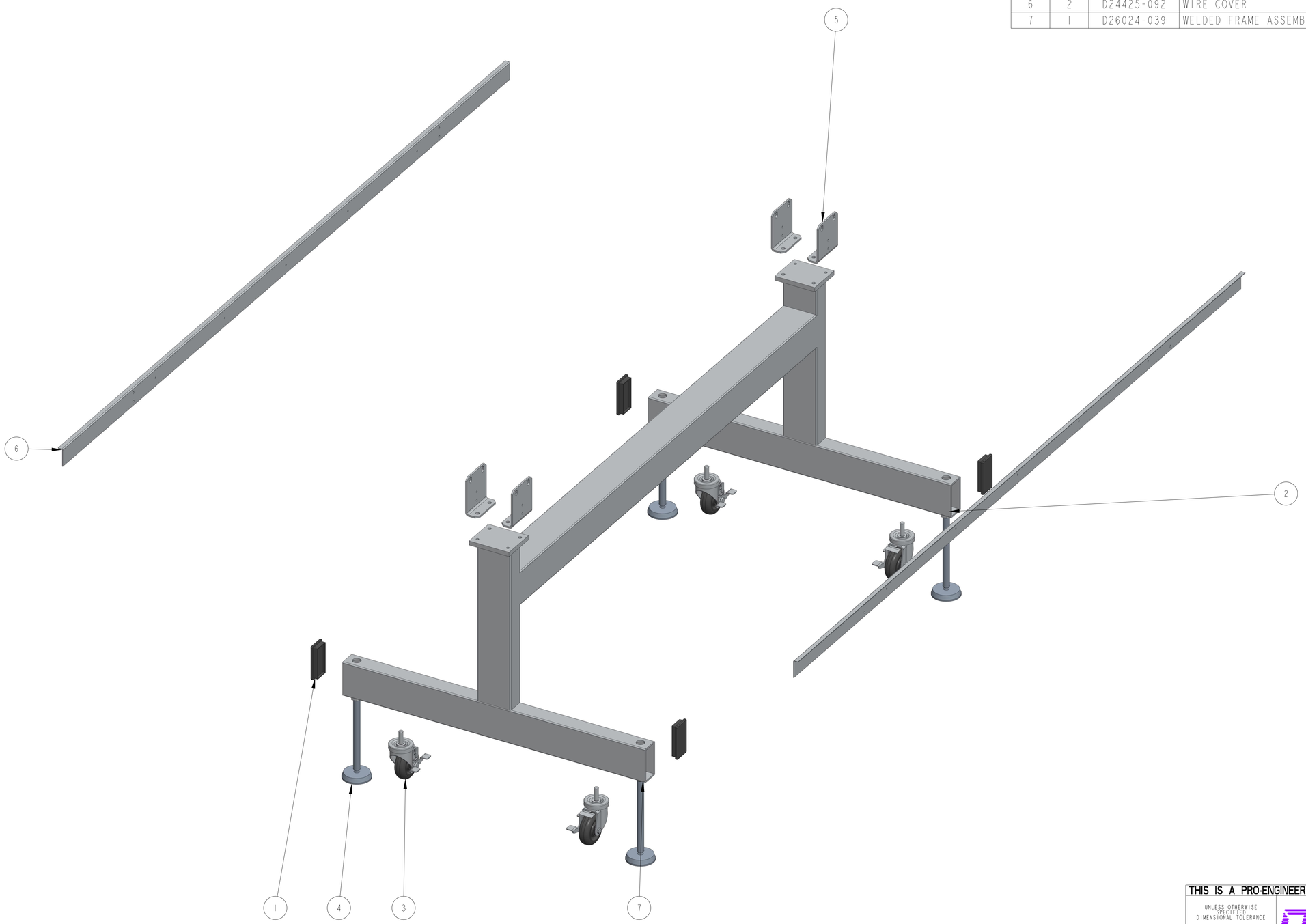
SET-UP AND ADJUSTMENTS:

- Rotate leveling pads to appropriate position. Secure locknut when proper height is achieved.
- Using ratchet handle, adjust labeling head vertical and horizontal position.

MAINTENANCE:

- Clean wipe down rails with clean cloth.

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	4	729006-000	CAP INSERT FOR 2 X 4 TUBE	22731-039
2	4	791436-000	CAP, 3/4" HIGH X 5/8" I.D.	22731-039
3	4	791449-000	SWIVEL CASTER	22731-039
4	4	793020-000	LEVELING MOUNT	22731-039
5	4	B22787-000	CONVEYOR RISER	22731-039
6	2	D24425-092	WIRE COVER	22731-039
7	1	D26024-039	WELDED FRAME ASSEMBLY	22731-039



REV	DATE	DESCRIPTION	BY
A	09/22/25	NEW DRAWING	SEM

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30°
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

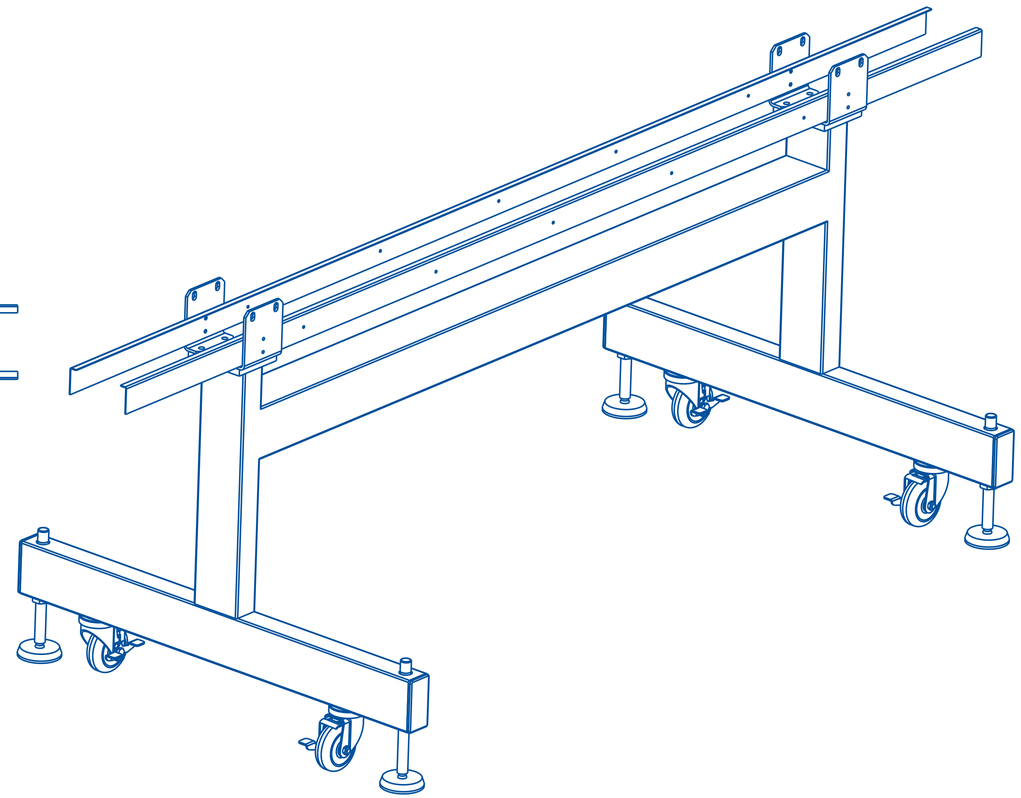
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

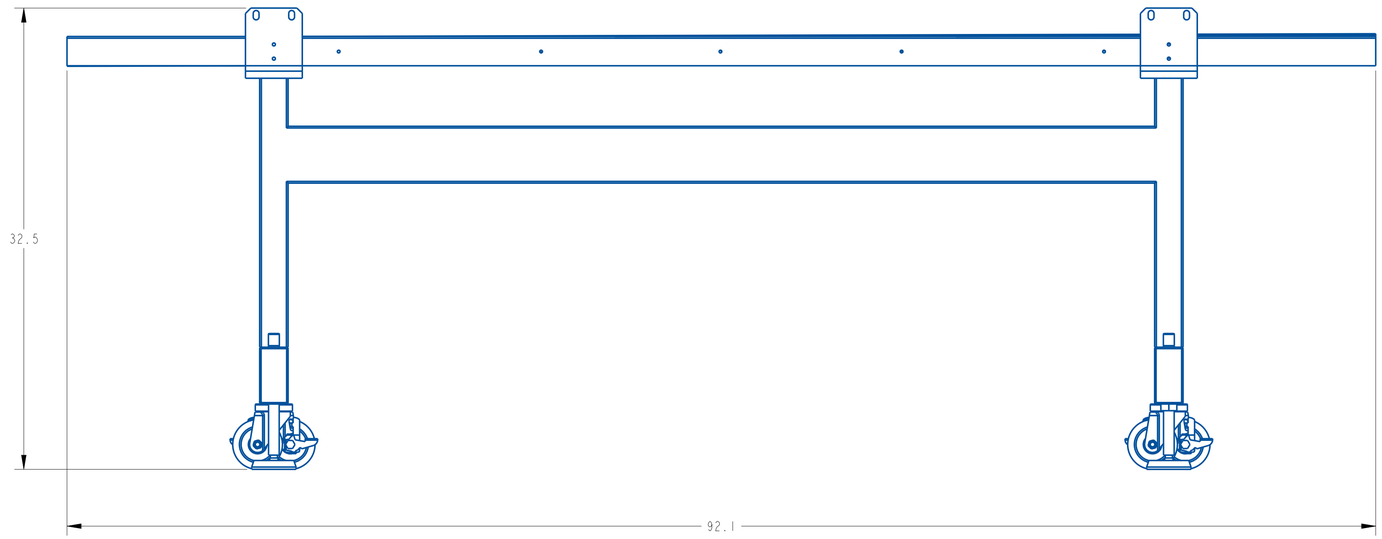
SCALE: 3/16
DATE: 09/22/25
DRW BY:
CHK BY:09/22/2025-SEM
APPR BY:

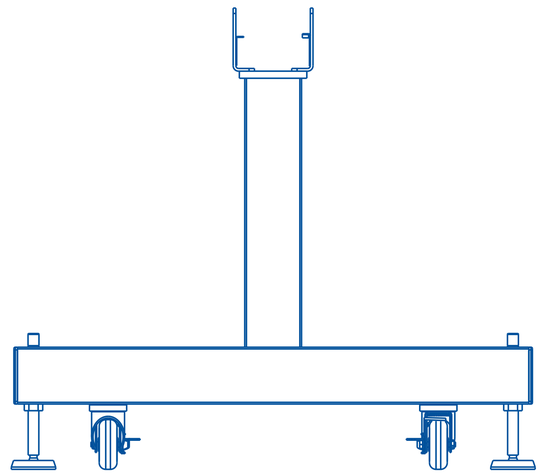
CONVEYOR MTG FRAME

MAT'L 22529-039S

22731-039







REV	DATE	DESCRIPTION	BY
A	Sep-22-25	NEW DRAWING	TAZ

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UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 3/16
DATE: Sep-22-25
DRW BY: TAZ
CHK BY:09/22/2025-SEM
APPR BY:

CONVEYOR MTG FRAME

MAT'L
22731-039

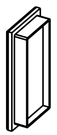
22731-039

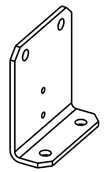
SHEET 2 OF 2

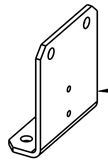
NOTES:

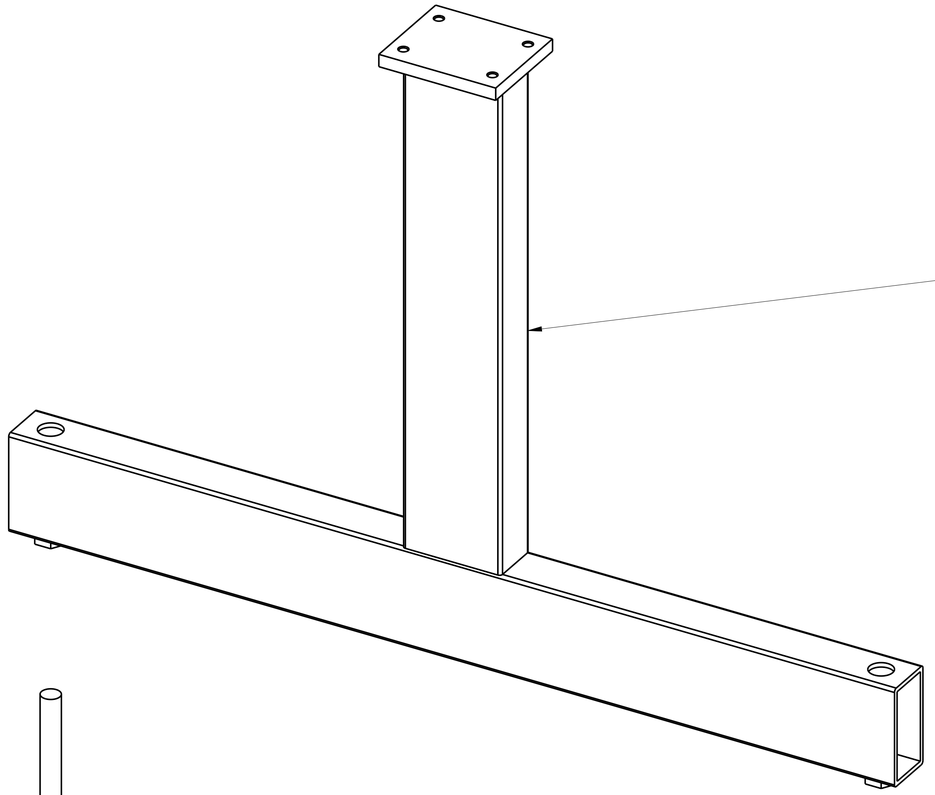
1. DRILL ONE Ø.41 HOLE THROUGH EACH 793020-000 TO ALLOW THE CONVEYOR TO BE SECURED TO THE FLOOR.

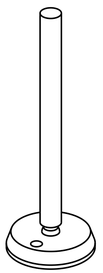
ITEM	QTY	PART NO.	DESCRIPTION
1	2	729006-000	CAP INSERT FOR 2 X 4 TUBE
2	2	791449-000	SWIVEL CASTER
3	2	793020-000	LEVELING MOUNT
4	2	B22787-000	CONVEYOR RISER
5	1	D25009-039S	WELDED FRAME ASSEMBLY

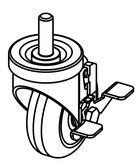


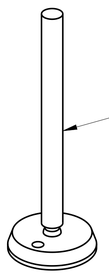


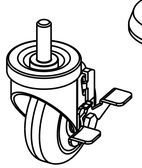












REV	DATE	DESCRIPTION	BY
A	10-22-19	NEW DRAWING	

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

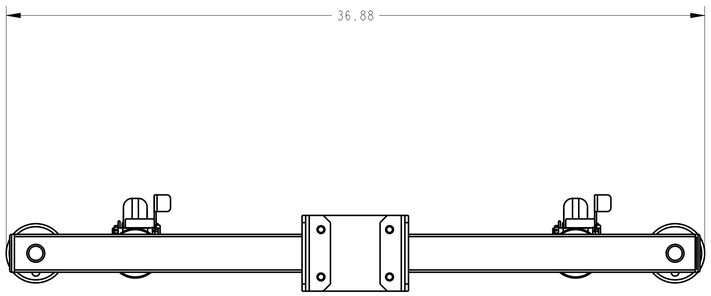
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

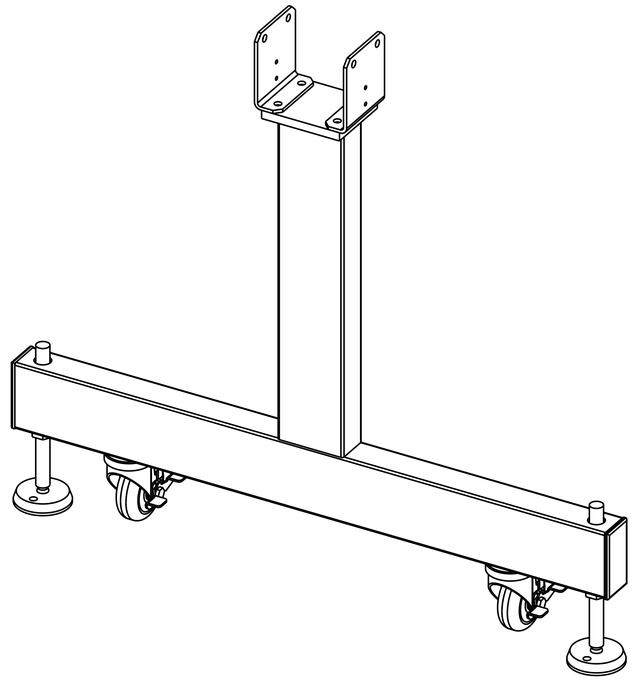
SCALE	3/8
DATE	10-22-19
DRAWN BY	ATT

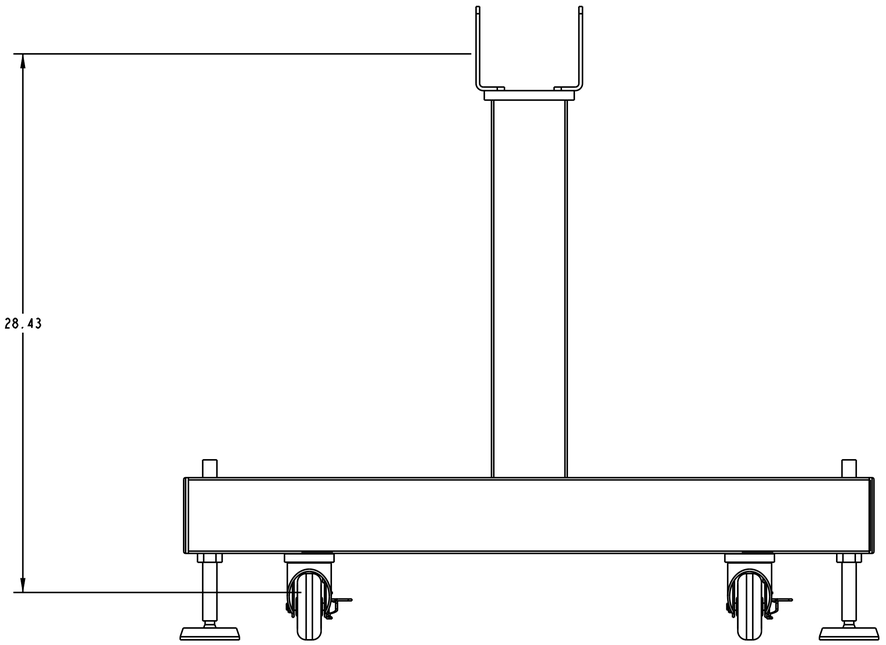
CONVEYOR SUPPORT

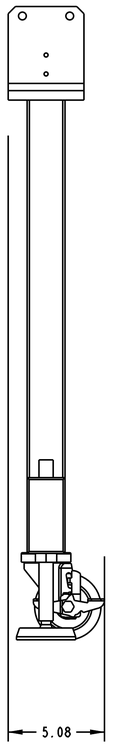
MAT'L 22614-039S

22614-039S









REV	DATE	DESCRIPTION	BY
A	10-22-19	NEW DRAWING	

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DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .0107.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE	1/4
DATE	10-22-19
DRAWN BY	ATT

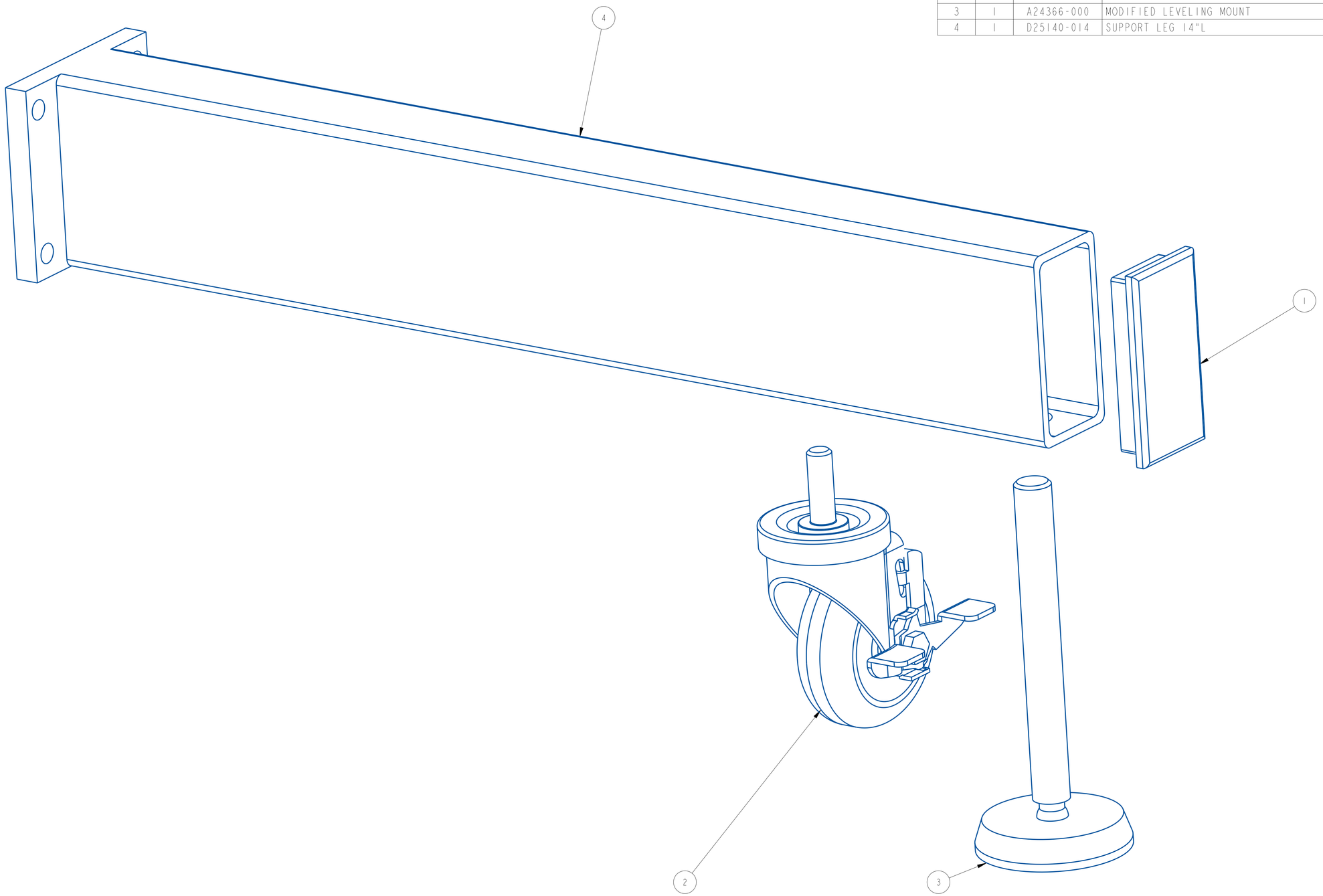
CONVEYOR SUPPORT

MAT'L

22614-039S

22614-039S

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	729006-000	CAP INSERT FOR 2 X 4 TUBE	22615-014
2	1	791449-000	SWIVEL CASTER	22615-014
3	1	A24366-000	MODIFIED LEVELING MOUNT	22615-014
4	1	D25140-014	SUPPORT LEG 14"L	22615-014



REV	DATE	DESCRIPTION	BY
A	AUG-19-22	NEW DRAWING	TJS

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UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

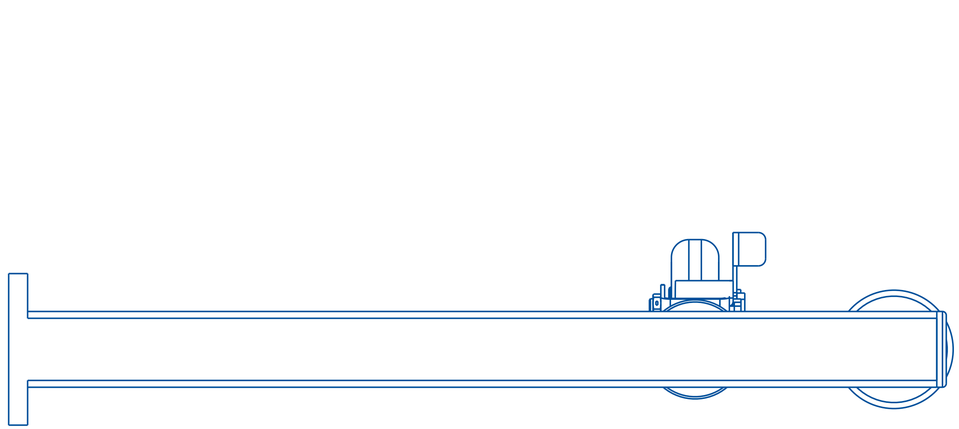
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

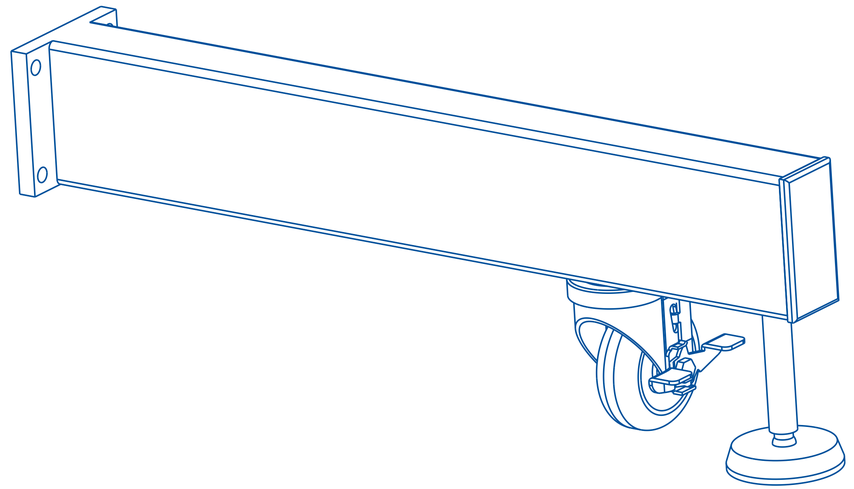
SCALE: 1/1
DATE: AUG-19-22
DRW BY: TJS
CHK BY:03/08/2024-SEM
APPR BY:

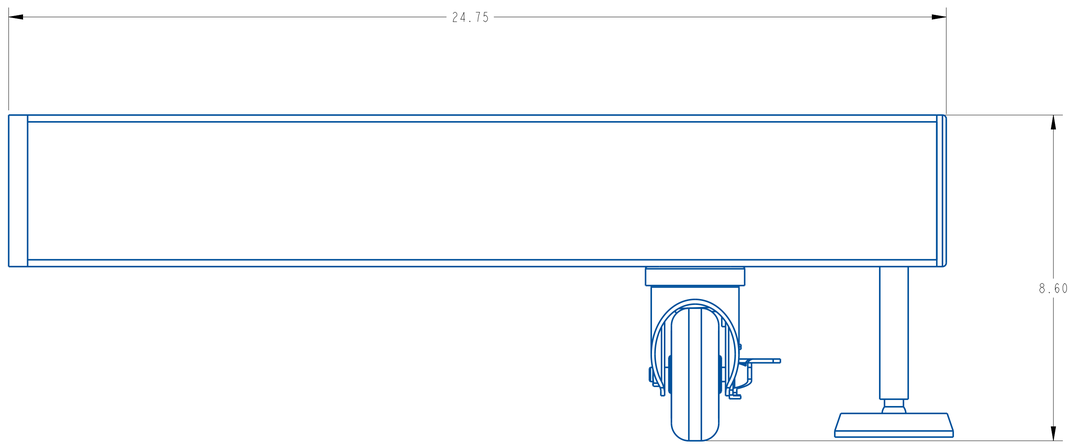
ELECTRICAL BOX SUPPORT LEG

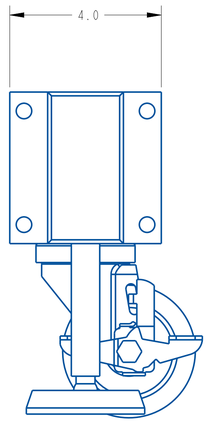
MAT'L

22615-014









REV	DATE	DESCRIPTION	BYE
A	AUG-19-22	NEW DRAWING	TJS

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DIMENSIONAL TOLERANCE
X ± .1
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XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: AUG-19-22
DRW BY: TJS
CHK BY:03/08/2024-SEM
APPR BY:

ELECTRICAL BOX SUPPORT LEG

MAT'L

22615-014

ASSEMBLY TITLE: **NON-INTEGRATED CONVEYOR**

GENERAL FUNCTION:

- To transfer the product to the labeling heads at a predetermined speed.
- To provide retention for the head support and guide rails.

SET-UP AND ADJUSTMENTS:

- Adjust conveyor to proper working height by rotating leveling pads to appropriate position. Secure locknut when proper height is achieved.
- Using ratchet handles, adjust guide rails to the product.
- Adjust conveyor speed by means of conveyor speed potentiometer (if applicable) located in the remote electronics enclosure mounted to the conveyor, or through the operator's touchscreen if provided.

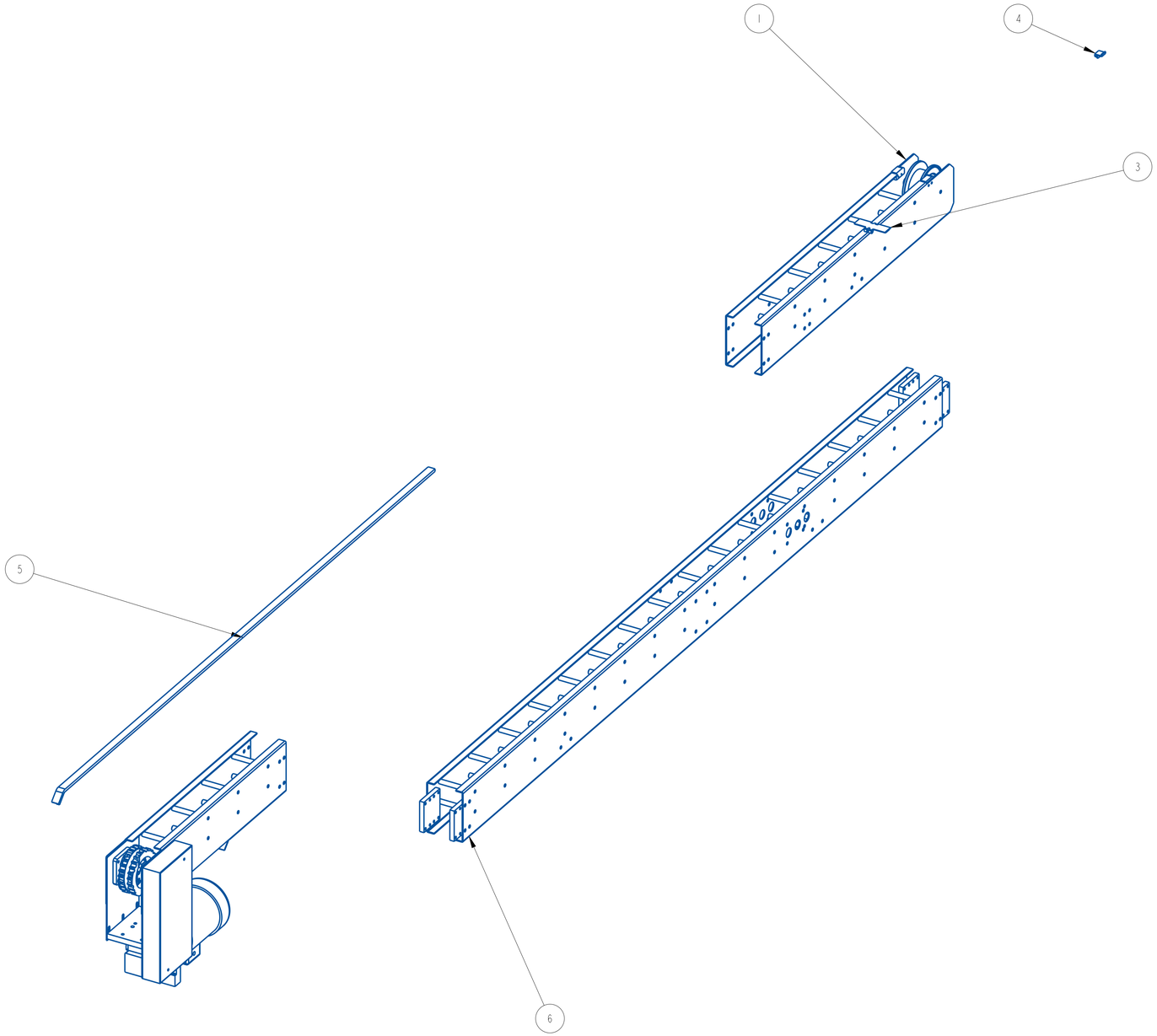
MAINTENANCE:

- The conveyor drive chain must be greased with white lithium grease.
- Do not allow chain and sprockets to run dry, lubricate periodically.
- The gear motor gearbox should be checked quarterly and filled with Synthetic based Tivela Oil SC320 or an ISO320 Gear Lube lubricant.
- Grease flange bearings often to prevent them from running dry.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Excessive Noise	- Realign sprocket. - Check if chain and sprockets are lubricated. If dry, lubricate as discussed above.
- Chain too loose	- Slide gear motor downward to create more tension on chain.
- Uneven wear on sprockets.	- Realign sprockets.
- Shaft not running concentric	- Replace flange bearing.

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	22612-048	CONVEYOR INFEED 48"	84219C-000
2	1	22613-84219		84219C-000
3	1	361174-000	TABLE TOP CHAIN LINK	84219C-000
4	1	791884-000	WEAR STRIP, FLAT BAR CLIP-ON	84219C-000
5	1	792361-00R	WEAR STRIP, FLAT BAR CLIP-ON (6ft)	84219C-000
6	1	84219C-MID	CONVEYOR 10' EXTENSION SECTION	84219C-000



REV	DATE	DESCRIPTION	BY
A	Sep-22-25	NEW DRAWING	TAZ

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

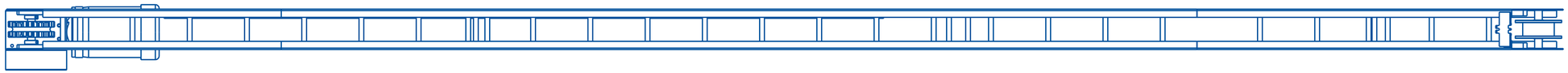
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

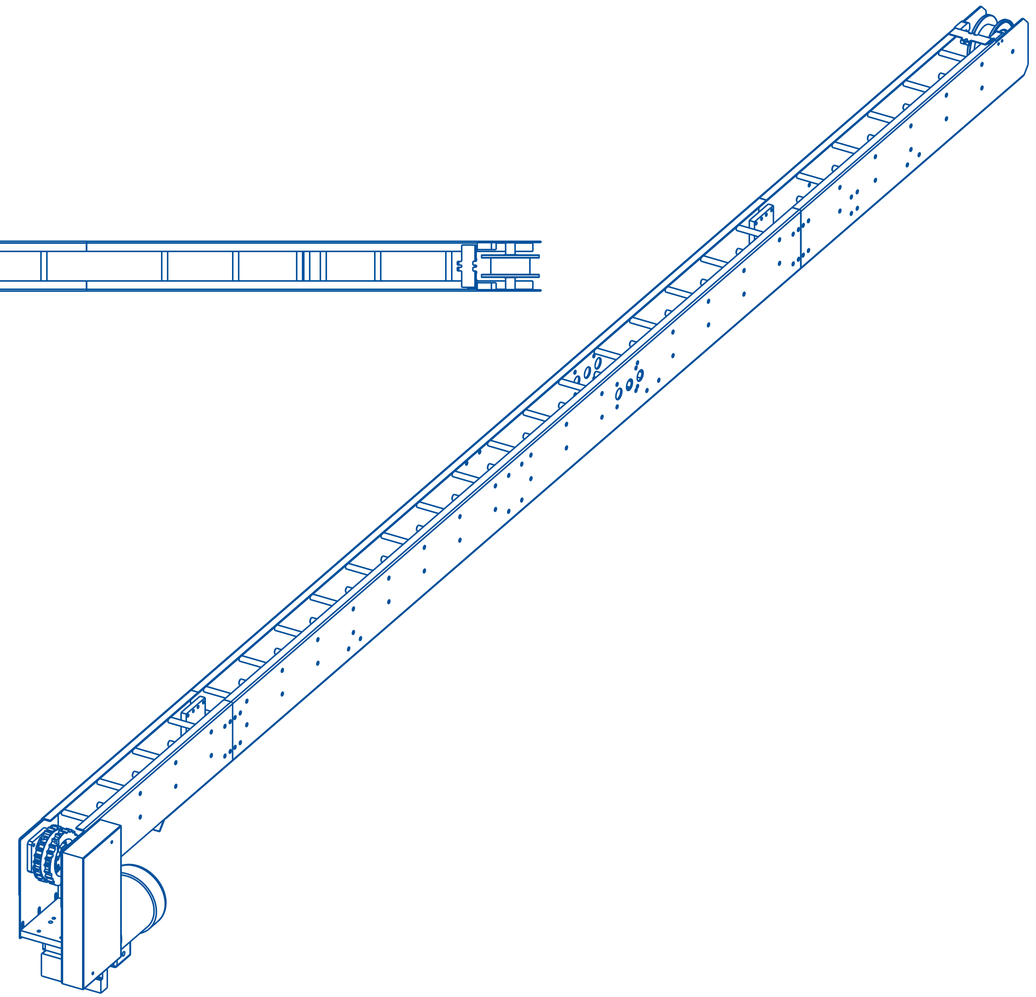
SCALE: 1/8
DATE: Sep-22-25
DRW BY: TAZ
CHK BY:
APPR BY:

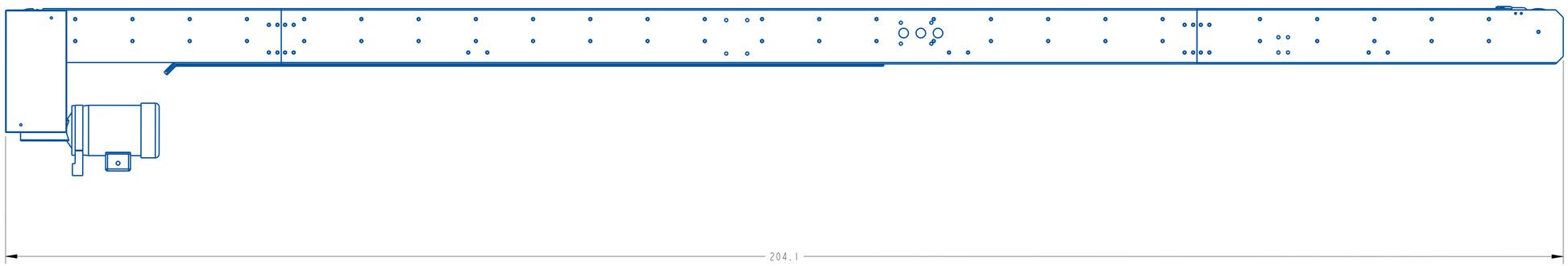
17' CONVEYOR

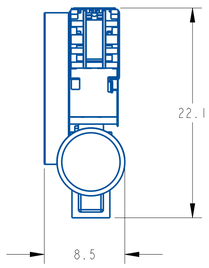
MAT'L: 84219C-000

84219C-000









REV	DATE	DESCRIPTION	BY
A	Sep-22-25	NEW DRAWING	TAZ

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ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/8
DATE: Sep-22-25
DRW BY: TAZ
CHK BY:
APPR BY:

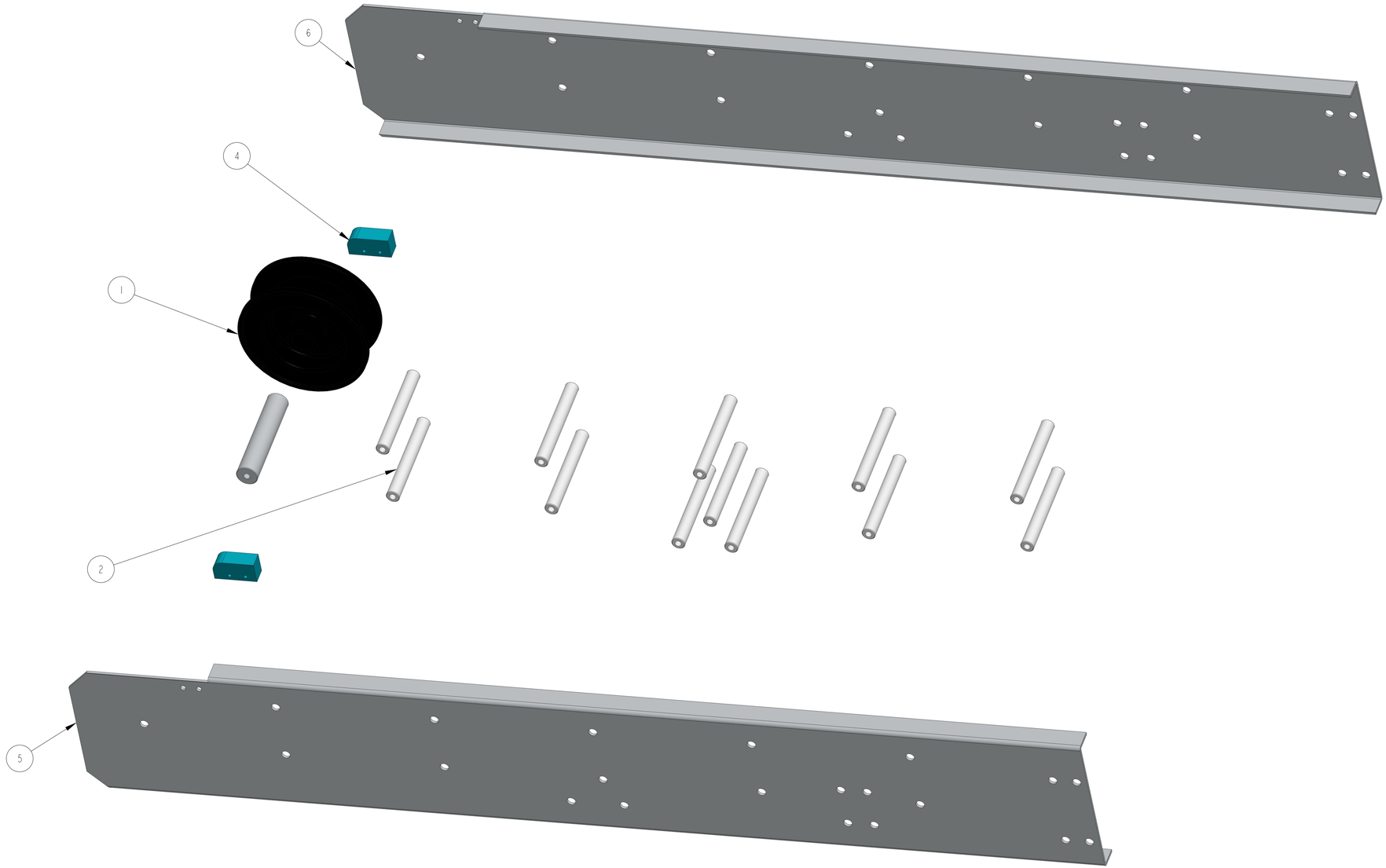
17' CONVEYOR

MAT'L 84219C-000

84219C-000

SHEET 2 OF 2

ITEM	QTY	PART NO.	DESCRIPTION
1	1	342018-000	IDLER WHEEL
2	12	791838-000	SPACER
3	1	A23098-000	IDLER SHAFT
4	2	A23099-000	CHAIN BELT GUIDE
5	1	D25007-048	SIDE WALL EXTENTION INFEED
6	1	D25007-049	SIDE WALL EXTENSION INFEED



REV	DATE	DESCRIPTION	BY
A	6-3-15	NEW DRAWING	CRT

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DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

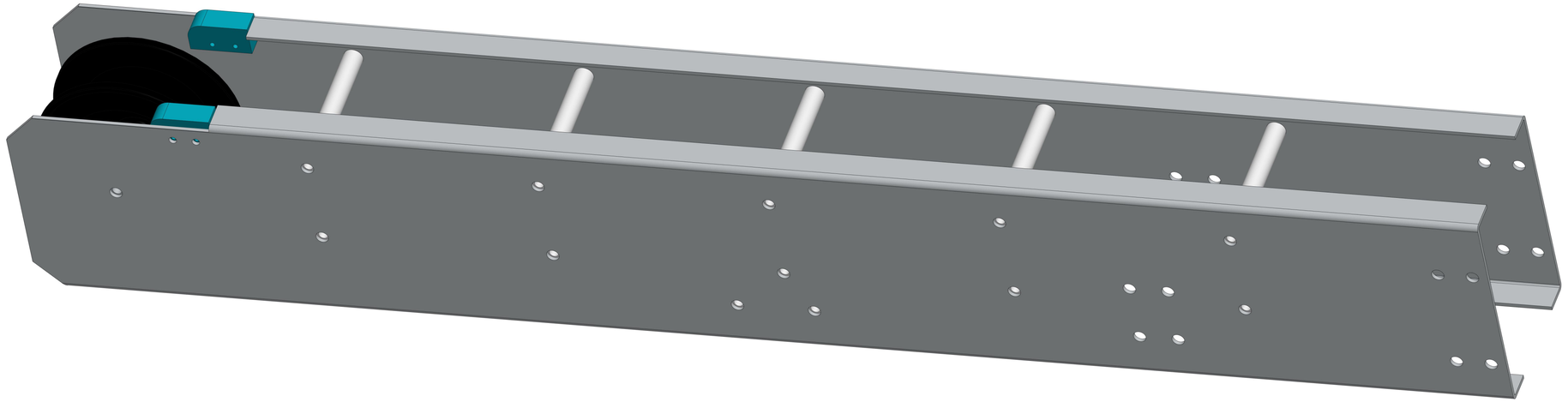
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

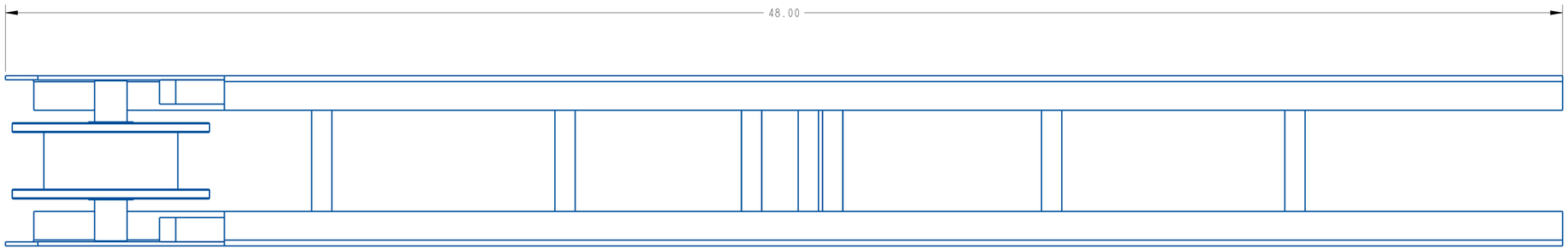
SCALE: 3/8
DATE: 6-3-15
DRW BY: CRT
CHK BY:07/23/2025-SEM
APPR BY:

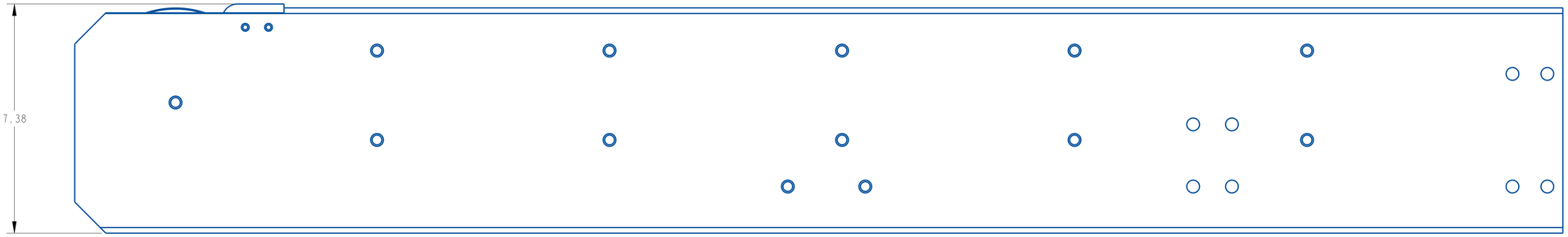
CONVEYOR INFEED 48"

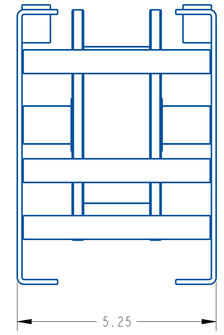
MAT'L

22612-048









REV	DATE	DESCRIPTION	BY
A	6-3-15	NEW DRAWING	CRT

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ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

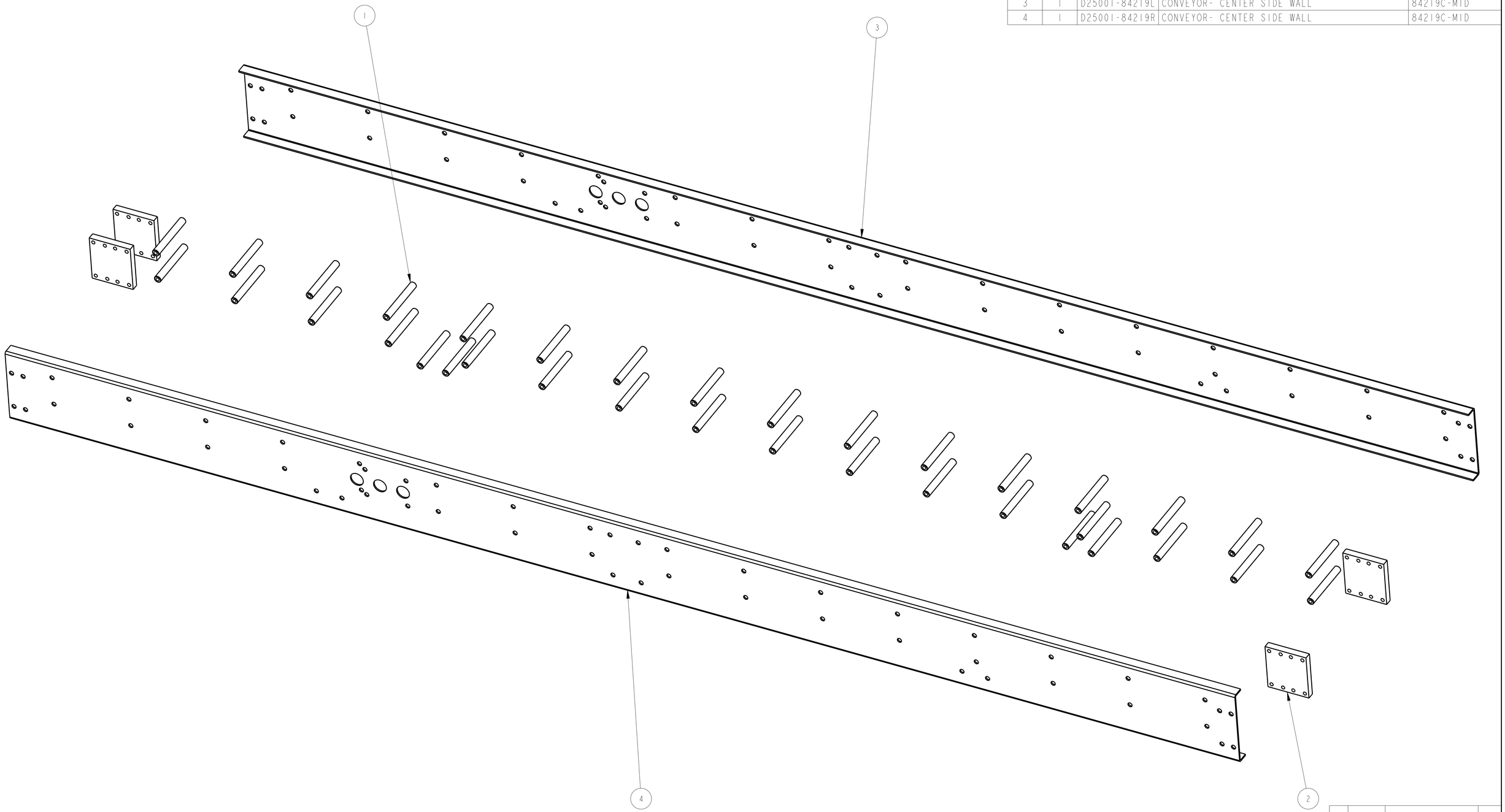
SCALE: 1/2
DATE: 6-3-15
DRW BY: CRT
CHK BY:07/23/2025-SEM
APPR BY:

CONVEYOR INFEED 48"

MAT'L

22612-048

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	36	791838-000	SPACER	84219C-MID
2	4	B22558-004	SPLICE PLATE	84219C-MID
3	1	D25001-84219L	CONVEYOR- CENTER SIDE WALL	84219C-MID
4	1	D25001-84219R	CONVEYOR- CENTER SIDE WALL	84219C-MID



REV	DATE	DESCRIPTION	BY
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ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
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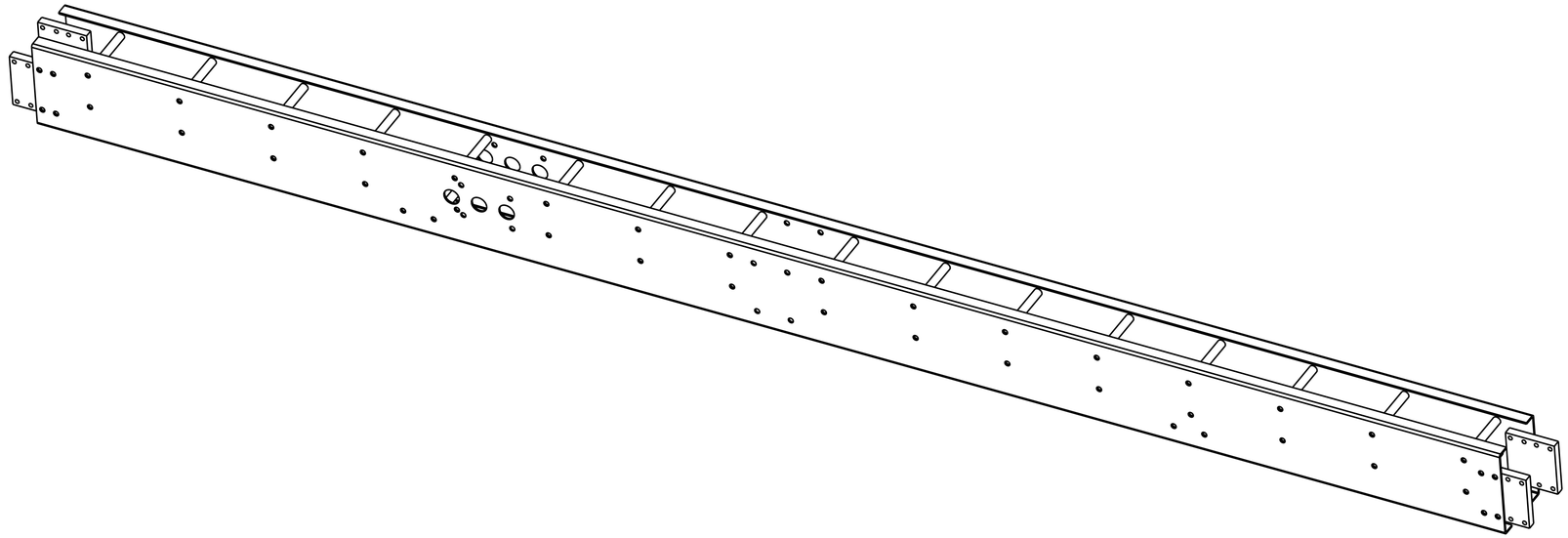
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

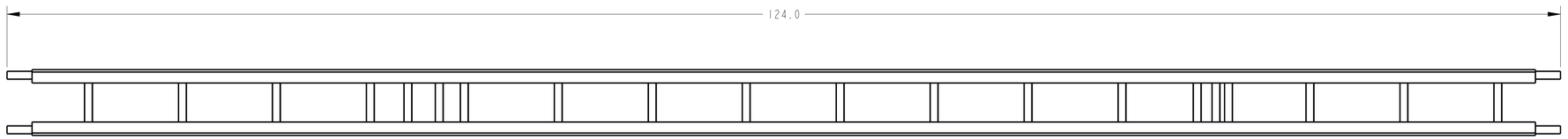
SCALE: 1/4
DATE: Sep-22-25
DRW BY: TAZ
CHK BY: 09/23/2025-SEM
APPR BY:

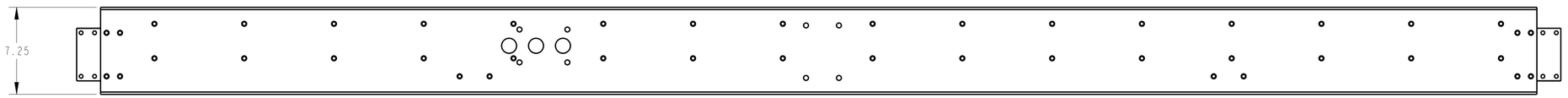
CONVEYOR 10' EXTENSION SECTION

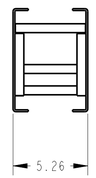
MAT'L

84219C-MID









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CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

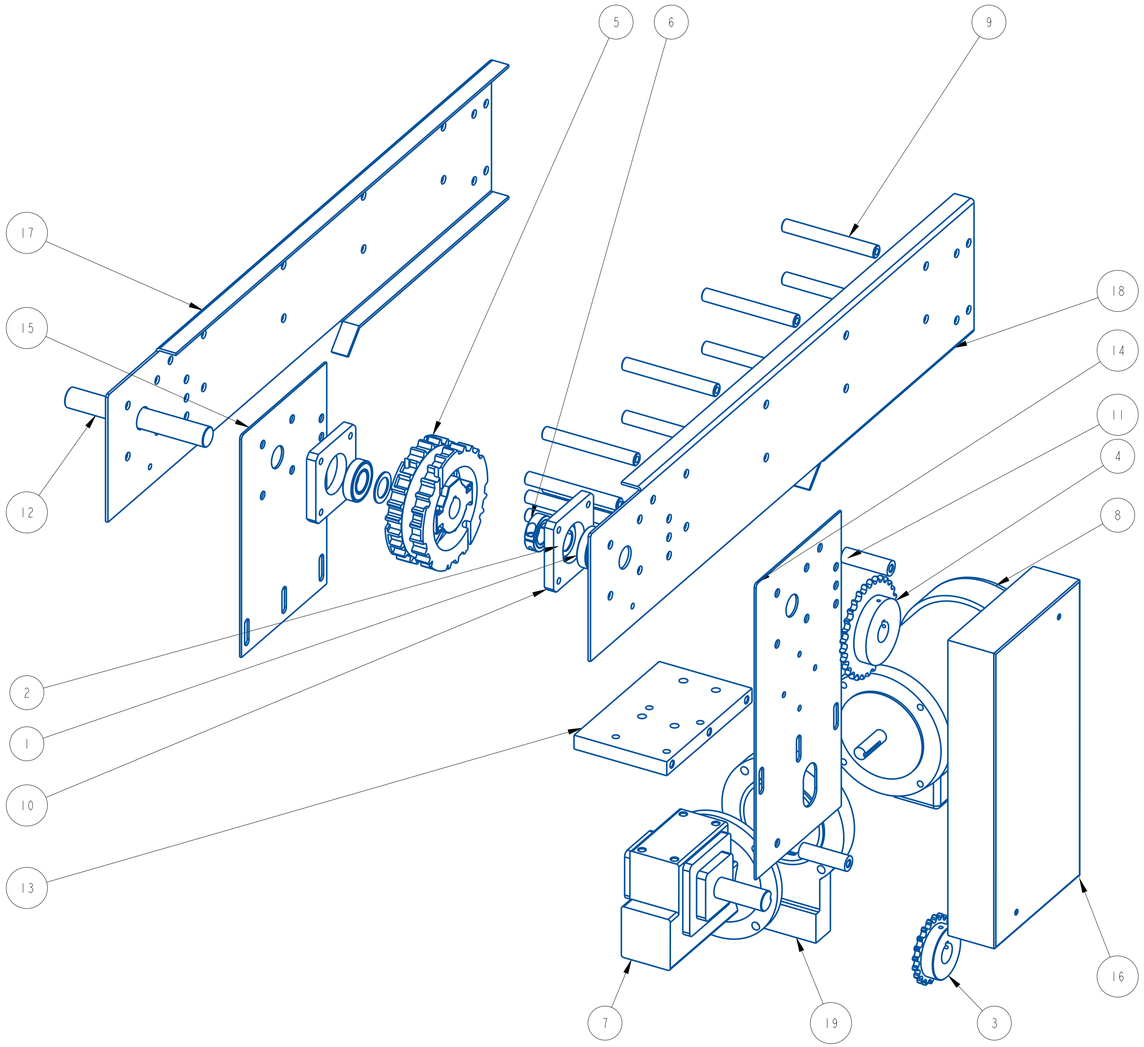
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	3/16
DATE:	Sep-22-25
DRW BY:	TAZ
CHK BY:	09/23/2025-SEM
APPR BY:	

CONVEYOR 10' EXTENSION SECTION

MAT'L

84219C-MID



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	111064-000	BEARING, BANDED THRUST BALL	22613-84219
2	2	151038-000	BEARING, THRUST WASHER	22613-84219
3	1	322104-000	SPROCKET, 20 TOOTH, 1" BORE	22613-84219
4	1	322172-000	SPROCKET, 30 TEETH	22613-84219
5	1	342019-000	DRIVE SPROCKET, MODULINE	22613-84219
6	2	361170-000	COLLAR, 1 IN. ID ONE-PIECE CLAMP	22613-84219
7	1	412529-120	GEARBOX 20:1 RH	22613-84219
8	1	413005-000	MOTOR, 1 HP, 3 PHASE WASHGUARD	22613-84219
9	11	791838-000	SPACER	22613-84219
10	2	A21846-000	INTERNAL CONVEYOR BEARING BLOCK	22613-84219
11	2	A25452-012	GUARD STAND OFF	22613-84219
12	1	B20883-003	CONVEYOR DRIVE SHAFT	22613-84219
13	1	B22283-002	GEAR BOX MOUNTING PLATE	22613-84219
14	1	C20448-015	OUTFEED CONVEYOR CAP	22613-84219
15	1	C20478-004	OUTFEED CONVEYOR CAP	22613-84219
16	1	C21126-011	CONVEYOR DRIVE GUARD	22613-84219
17	1	D25008-36P	OUTFEED CONVEYOR SIDE WALL, 36"	22613-84219
18	1	D25008-37P	OUTFEED CONVEYOR SIDE WALL, 36"	22613-84219
19	1	203328-000	ENCODER	22613-84219

NOT SHOWN:

203355-000 ENCODER CONNECTOR

REV	DATE	DESCRIPTION	BY
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XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

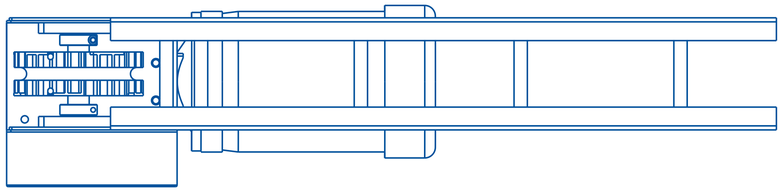
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

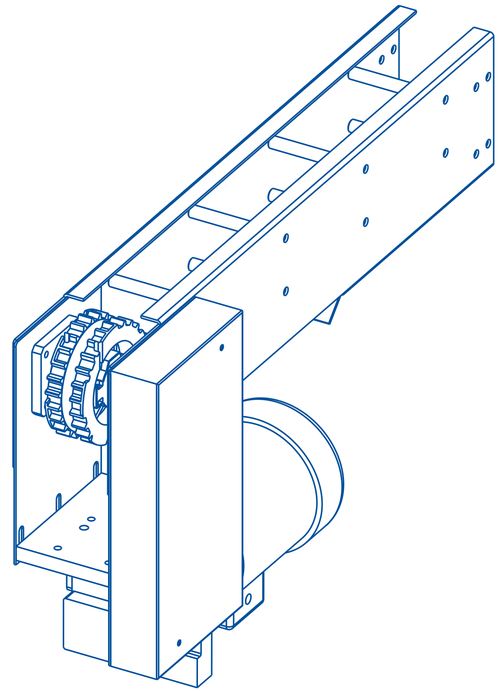
SCALE:	9/32
DATE:	Sep-22-25
DRW BY:	TAZ
CHK BY:	
APPR BY:	

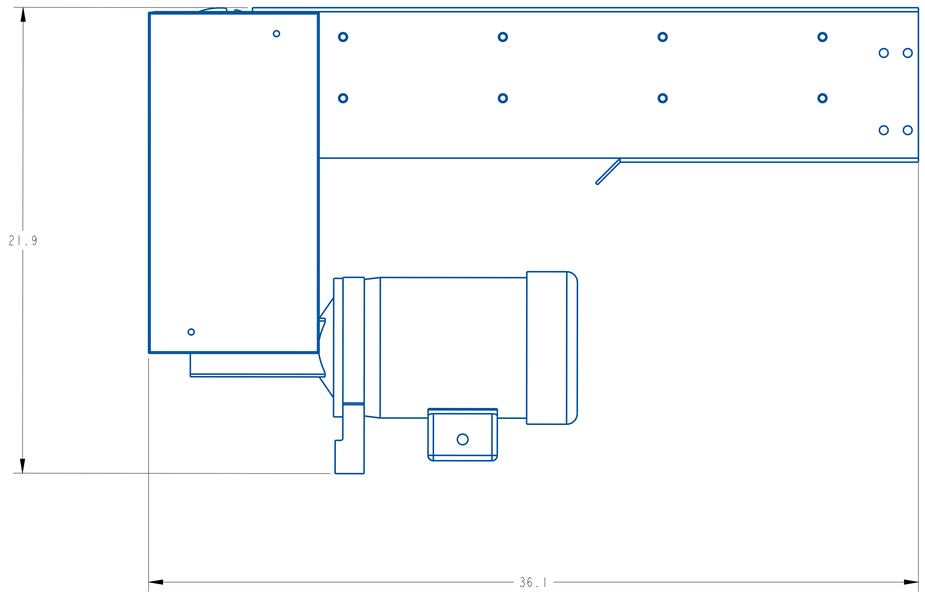
3' CONVEYOR OUTFEED SECTION

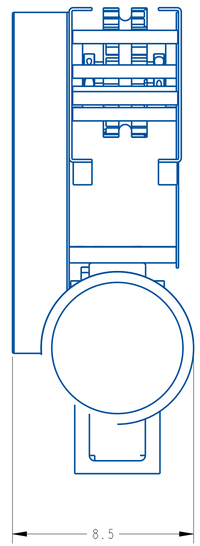
MAT'L: 22613-84219

22613-84219









REV	DATE	DESCRIPTION	BY
A	Sep-22-25	NEW DRAWING	TAZ

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UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 9/32
DATE: Sep-22-25
DRW BY: TAZ
CHK BY:
APPR BY:

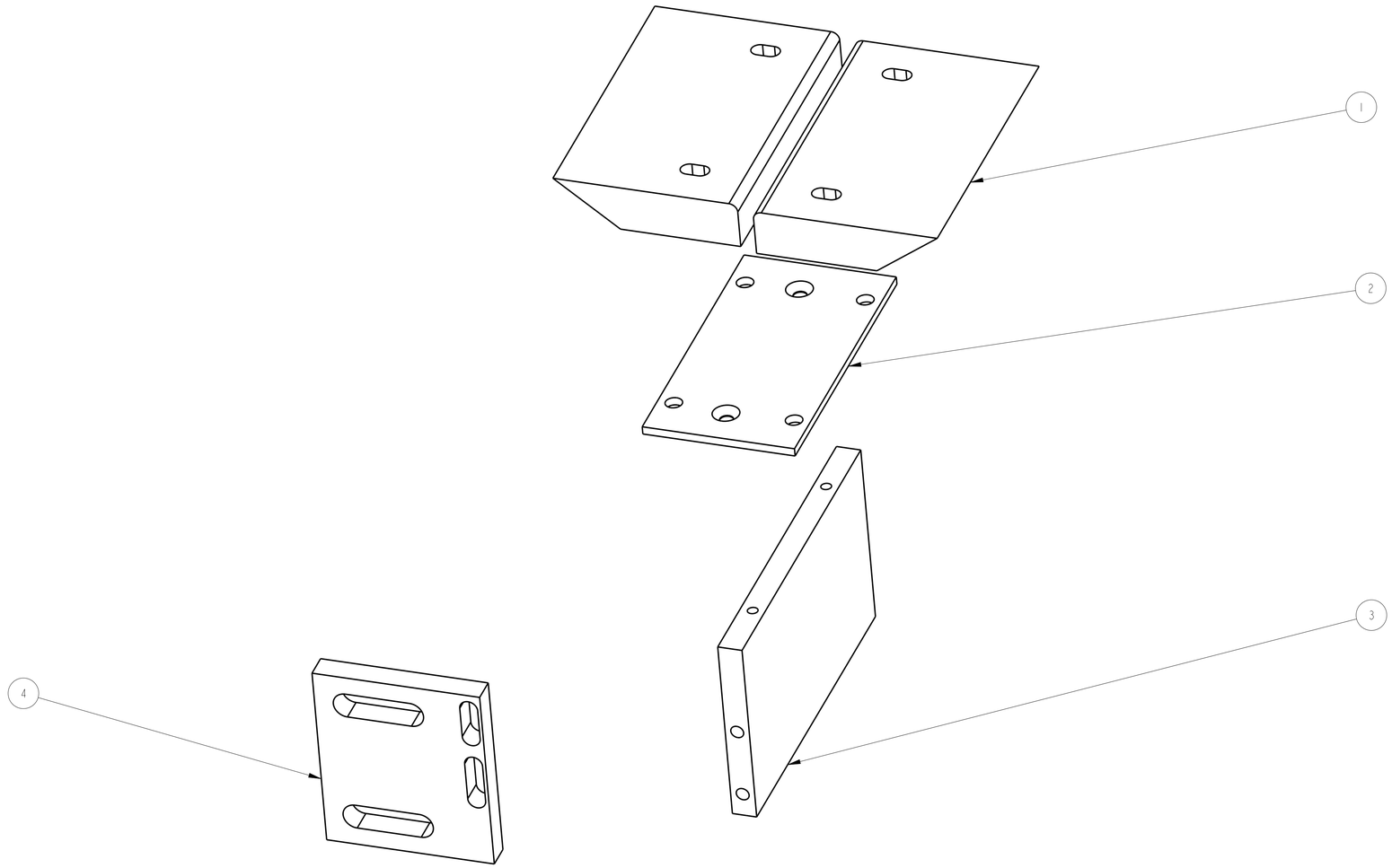
3' CONVEYOR OUTFEED SECTION

MAT'L
22613-84219

22613-84219

SHEET 2 OF 2

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	792190-000	TRANSFER ROLLERS	22831-000
2	1	B21924-003	TRANSFER ROLLER MOUNTING PLATE	22831-000
3	1	B21925-005	TRANSFER SUPPORT PLATE	22831-000
4	1	B21926-003	TRANSFER CONNECTING PLATE	22831-000



REV	DATE	DESCRIPTION	BY
A	3-8-24	NEW DRAWING	ATT

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DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/1
DATE: 3-8-24
DRW BY: ATT
CHK BY:
APPR BY:

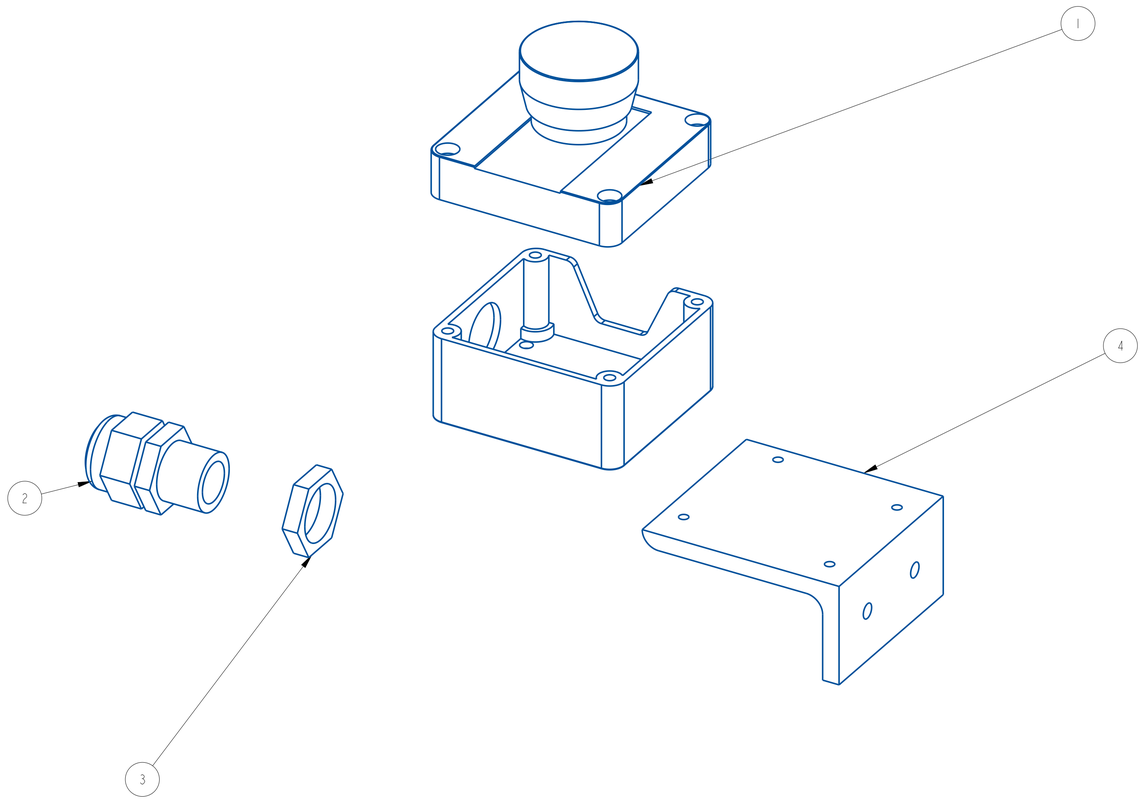
ROLLER END TRANSFER, 4.50"

MAT'L: 22831-000

22831-000

SHEET 1 OF 2

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	221152-005	ENCLOSURE, E-STOP W/ BUTTON	20789-000
2	1	241780-000	STRAIN RELIEF, CABLE	20789-000
3	1	241780-001	STRAIN RELIEF, CABLE PANEL	20789-000
4	1	A25719-000	CYLINDER MOUNTING ANGLE	20789-000



REV	DATE	DESCRIPTION	BY
A	8-29-16	NEW DRAWING	TJS

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.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

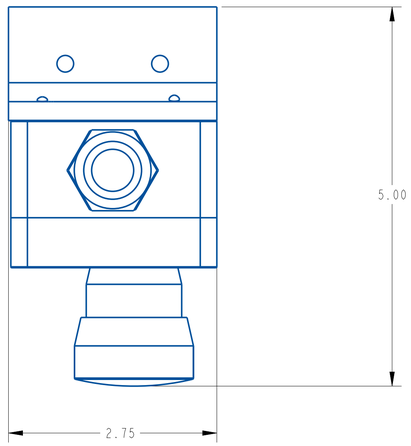
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

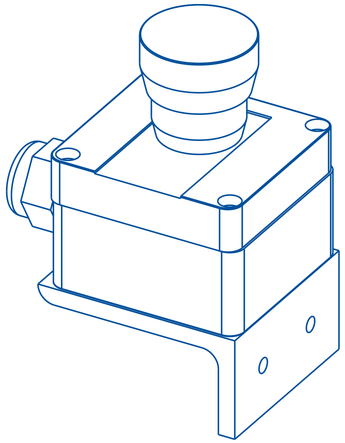
SCALE: 1/1
DATE: 8-29-16
DRW BY: TJS
CHK BY: 03/08/2024-SEM
APPR BY:

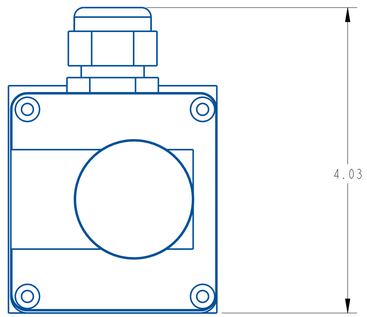
EMERGENCY STOP ASSEMBLY

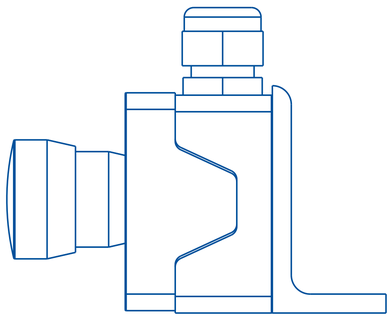
MAT'L

20789-000









REV	DATE	DESCRIPTION	BY
A	8-29-16	NEW DRAWING	TJS

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ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

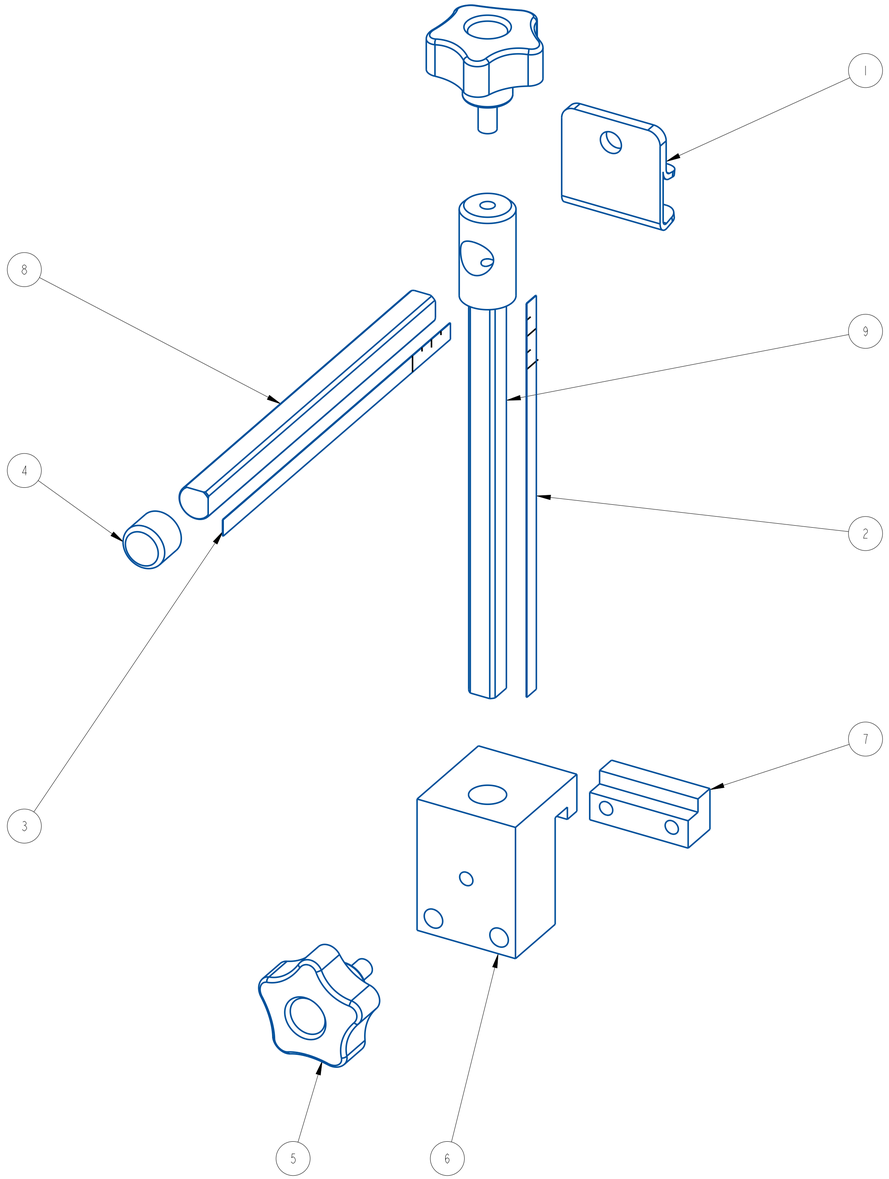
SCALE: 1/1
DATE: 8-29-16
DRW BY: TJS
CHK BY:03/08/2024-SEM
APPR BY:

EMERGENCY STOP ASSEMBLY

MAT'L

20789-000

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	791732-000	CLAMP FOR CONICAL SIDE GUIDE	22435-034
2	1	791914-002_06	MYLAR SCALE, QUADREL LOGO	22435-034
3	1	791914-003_06	MYLAR SCALE, QUADREL LOGO, 6" LG.	22435-034
4	1	792711-000	CAP, ORANGE	22435-034
5	2	801308-000	KNOB W/ 1/4-20 STUD	22435-034
6	1	A20875-000	RETAINER BLOCK, CONV. RAIL	22435-034
7	1	A20876-000	RETAINER BLOCK	22435-034
8	1	A21198-199	ADJUSTMENT ROD	22435-034
9	1	A28000-000	CLAMPING ROD ASSEMBLY 6"	22435-034



REV	DATE	DESCRIPTION	BY
A	Aug-07-25	NEW DRAWING	TAZ

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.X ± .1
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ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
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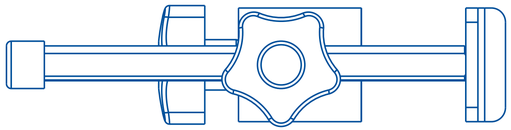
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

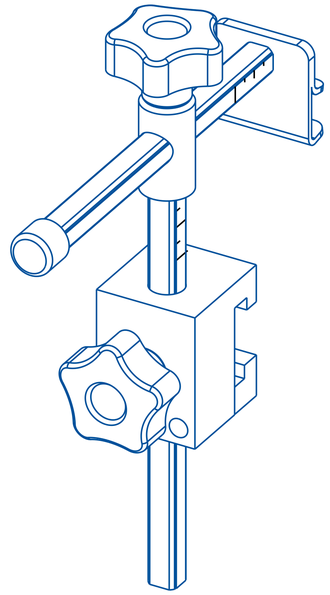
SCALE: 1/1
DATE: Aug-07-25
DRW BY: TAZ
CHK BY:08/28/2025-SEM
APPR BY:

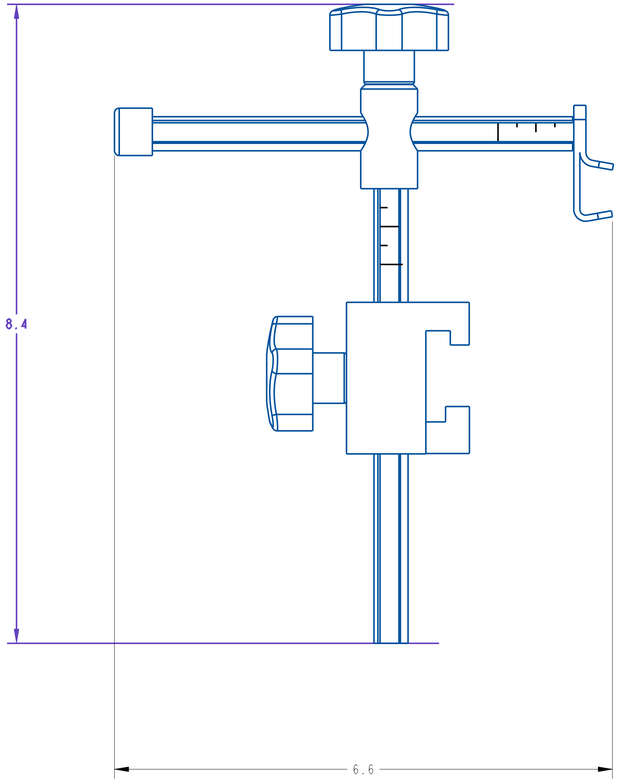
RAIL KIT WITH SCALES

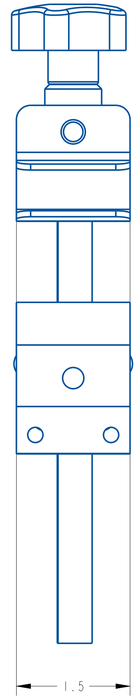
MAT'L

22435-034









REV	DATE	DESCRIPTION	BY
A	Aug-07-25	NEW DRAWING	TAZ

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ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/1
DATE: Aug-07-25
DRW BY: TAZ
CHK BY:08/28/2025-SEM
APPR BY:

RAIL KIT WITH SCALES

MAT'L

22435-034

ASSEMBLY TITLE: HEAD SUPPORT ASSEMBLY

GENERAL FUNCTION:

The head support assembly keeps the labeling head in a “locked position” and prevents head vibration and wobbling as the label motor is engaged. The head support assembly is also used to set the camber or front/back tilt of the head.

SETUP AND ADJUSTMENTS:

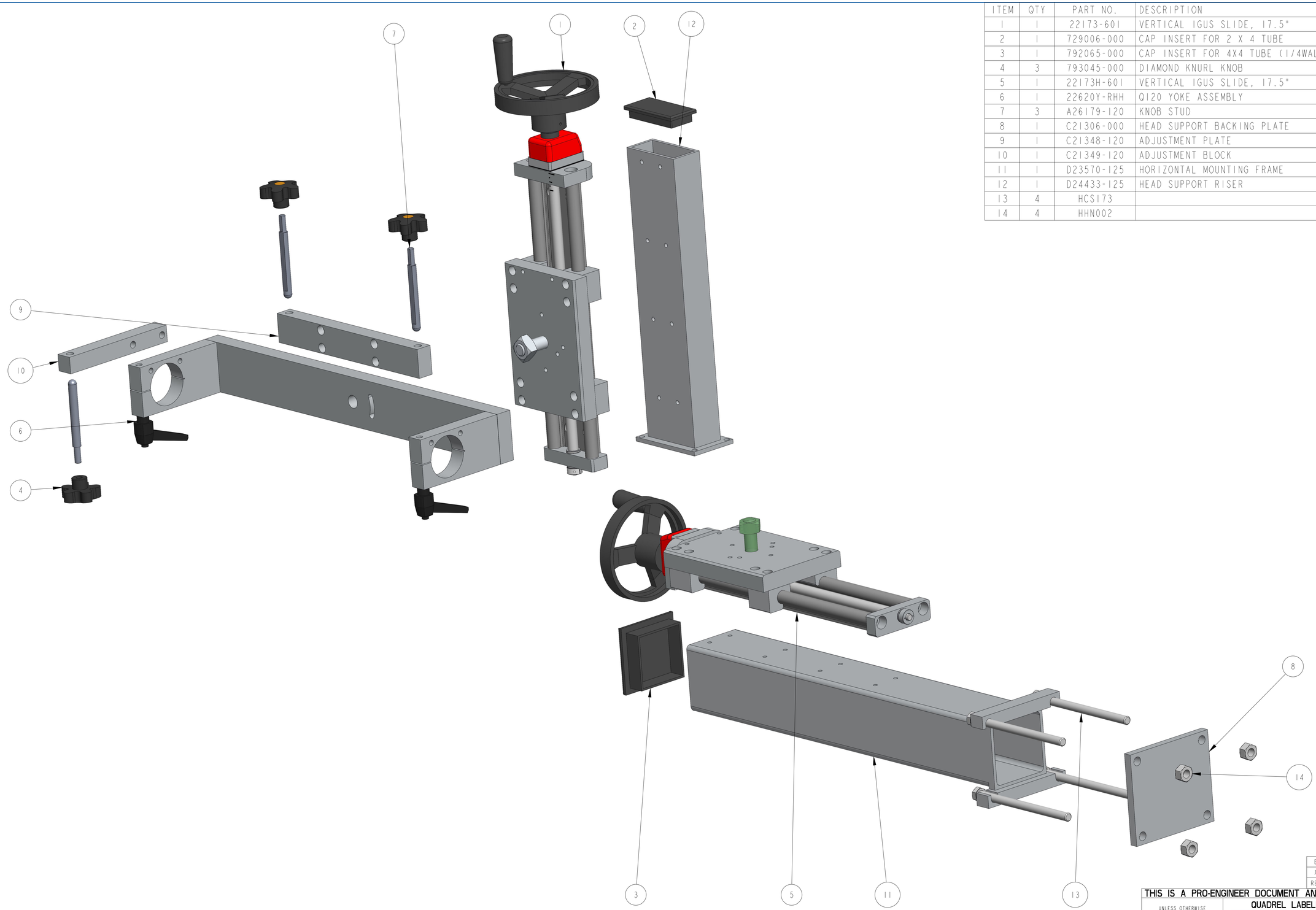
HORIZONTAL ADJUSTMENT: To set the horizontal position of the labeling head, use the side mount wheel handle (some older systems may feature the ratcheted handle). Turn the handle clockwise to move the head towards the conveyor. Turn it counter clockwise to move the head away from the conveyor.

VERTICAL ADJUSTMENT: Using the lower wheel handle to set the vertical position of the labeling head. Turn the wheel clockwise to lower labeling head. Turn the wheel counter clockwise to raise the labeling head.

MAINTENANCE:

No scheduled maintenance is required for this assembly. Always keep the drive areas free of label flash and debris.

TROUBLESHOOTING: None this section.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	22173-601	VERTICAL IGUS SLIDE, 17.5"	22530-220-RH
2	1	729006-000	CAP INSERT FOR 2 X 4 TUBE	22530-220-RH
3	1	792065-000	CAP INSERT FOR 4X4 TUBE (1/4WALL)	22530-220-RH
4	3	793045-000	DIAMOND KNURL KNOB	22530-220-RH
5	1	22173H-601	VERTICAL IGUS SLIDE, 17.5"	22530-220-RH
6	1	22620Y-RHH	Q120 YOKE ASSEMBLY	22530-220-RH
7	3	A26179-120	KNOB STUD	22530-220-RH
8	1	C21306-000	HEAD SUPPORT BACKING PLATE	22530-220-RH
9	1	C21348-120	ADJUSTMENT PLATE	22530-220-RH
10	1	C21349-120	ADJUSTMENT BLOCK	22530-220-RH
11	1	D23570-125	HORIZONTAL MOUNTING FRAME	22530-220-RH
12	1	D24433-125	HEAD SUPPORT RISER	22530-220-RH
13	4	HCSI73		22530-220-RH
14	4	HHN002		22530-220-RH

REV	DATE	DESCRIPTION	BY
B	20-FEB-2024	UPDATE THE DRAWING AND BOM	CRT
A	OCT-27-22	NEW DRAWING	TJS

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.X ± .1
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.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

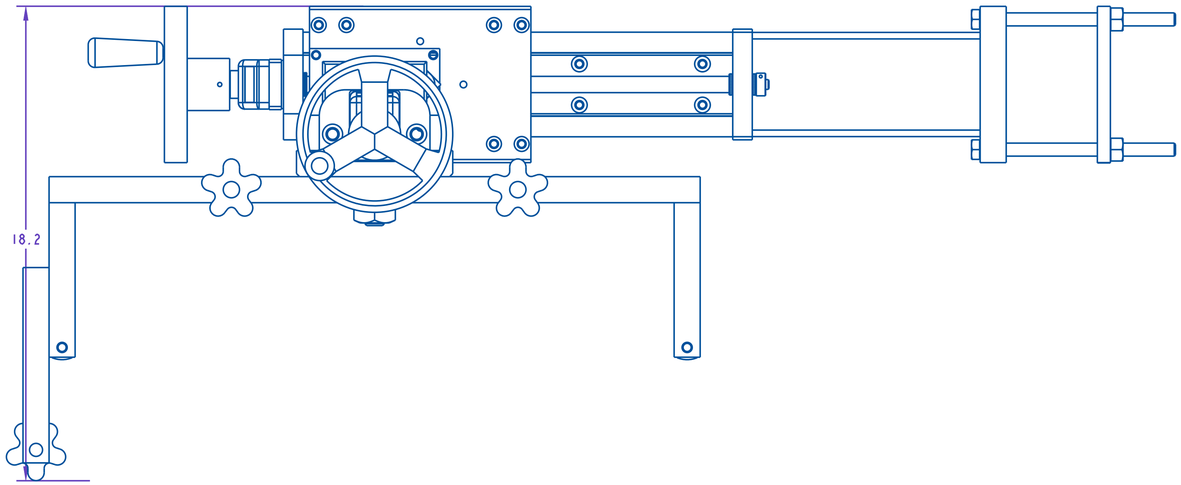
SCALE: 3/8
DATE: Oct-27-22
DRW BY: TJS
CHK BY:03/07/2024-SEM
APPR BY:

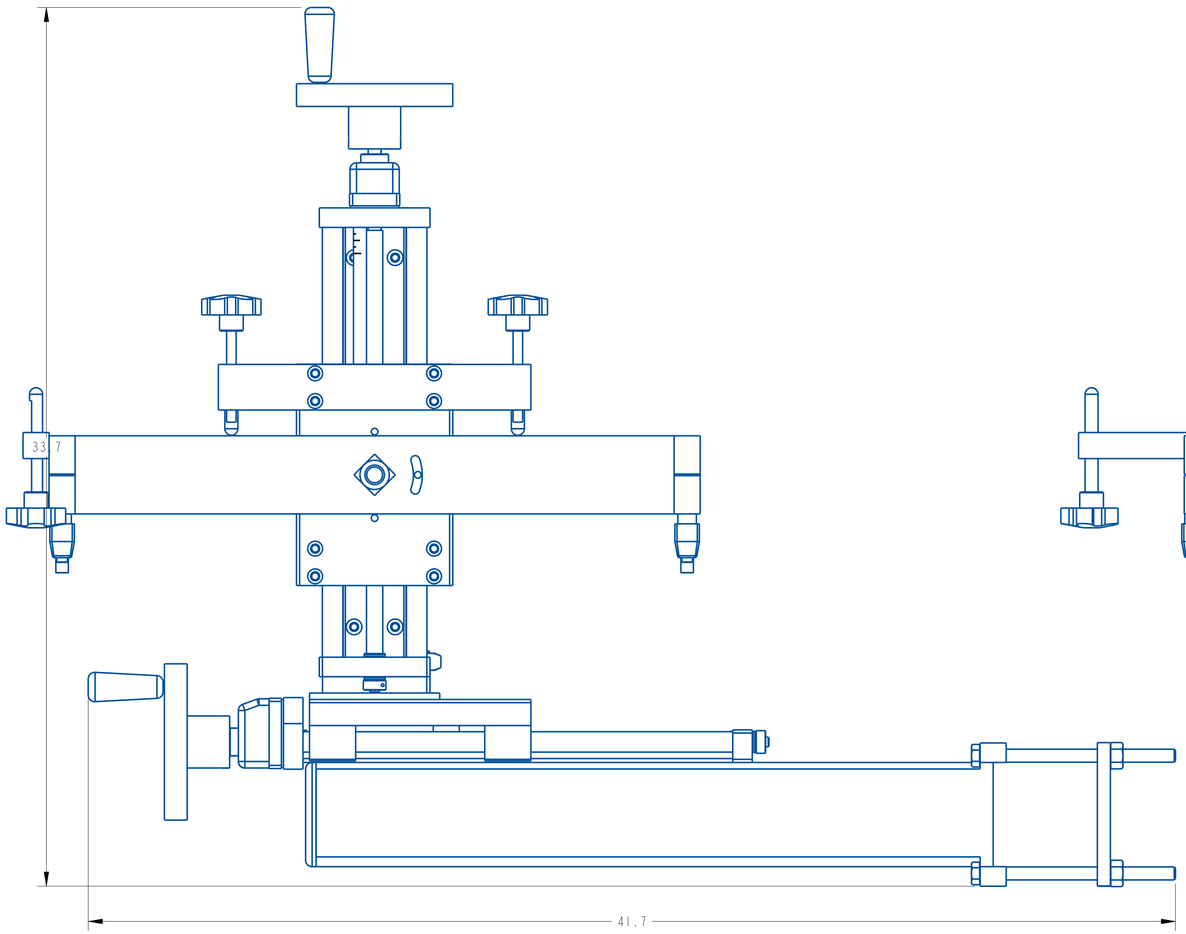
OPENLINE HEAD SUPPORT FOR Q120 W/ SIKO

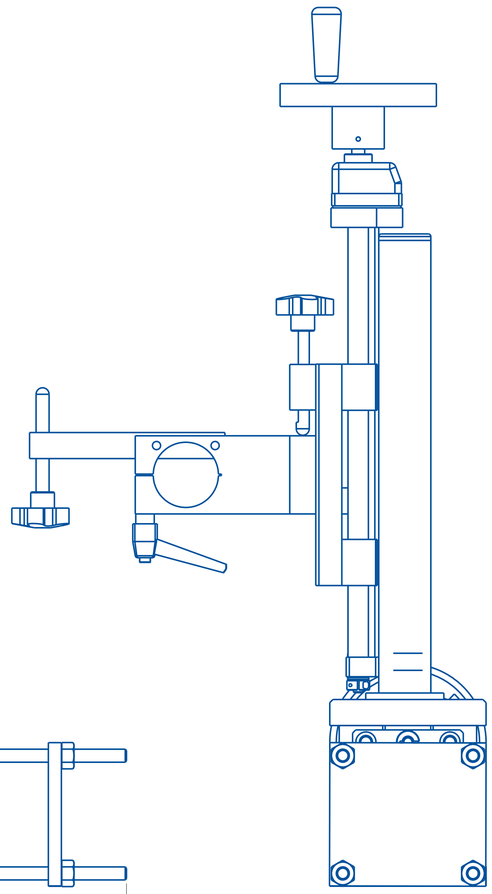
MAT'L

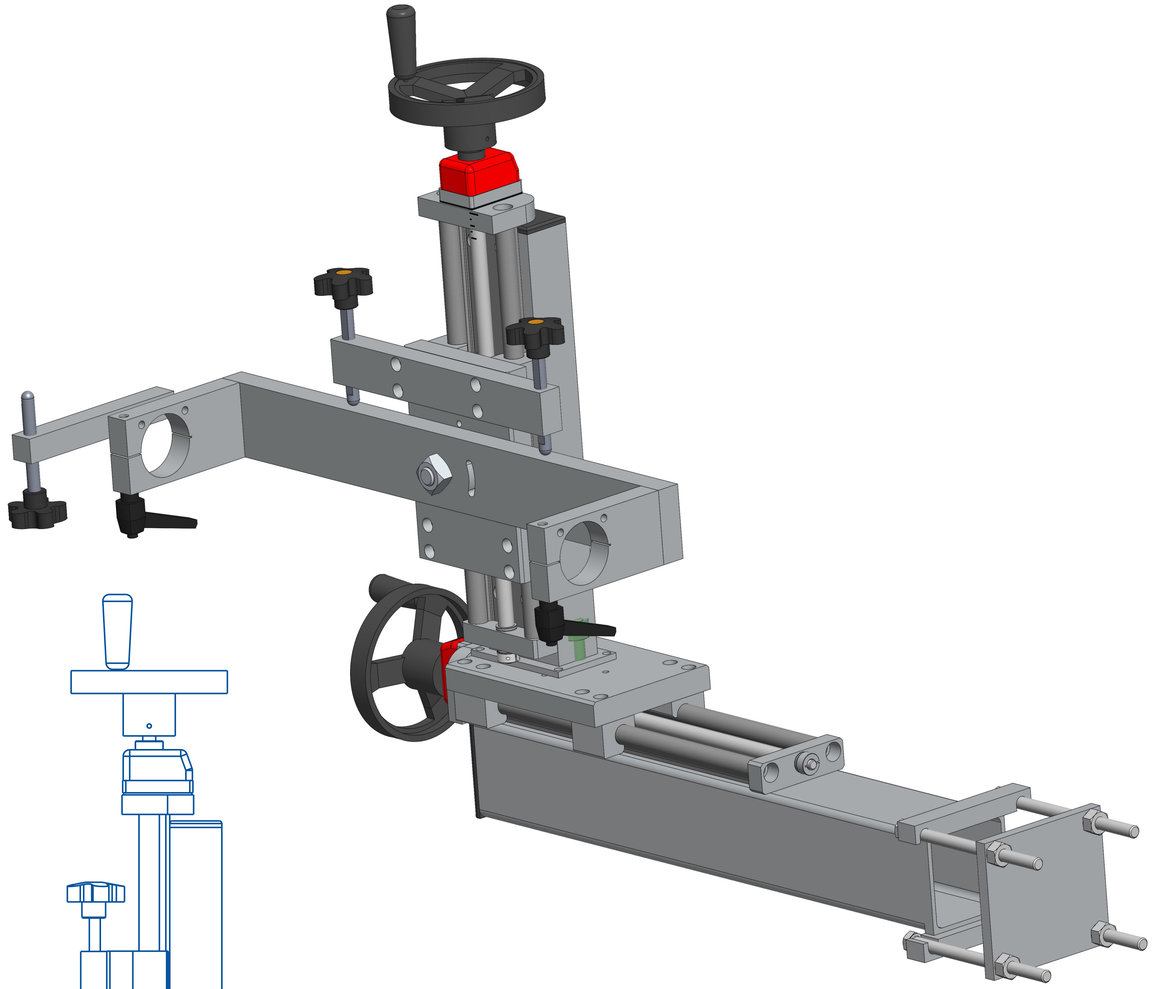
22530-220-RH

SHEET 1 OF 2









REV	DATE	DESCRIPTION	BY
A	Oct-27-22	NEW DRAWING	TJS

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SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

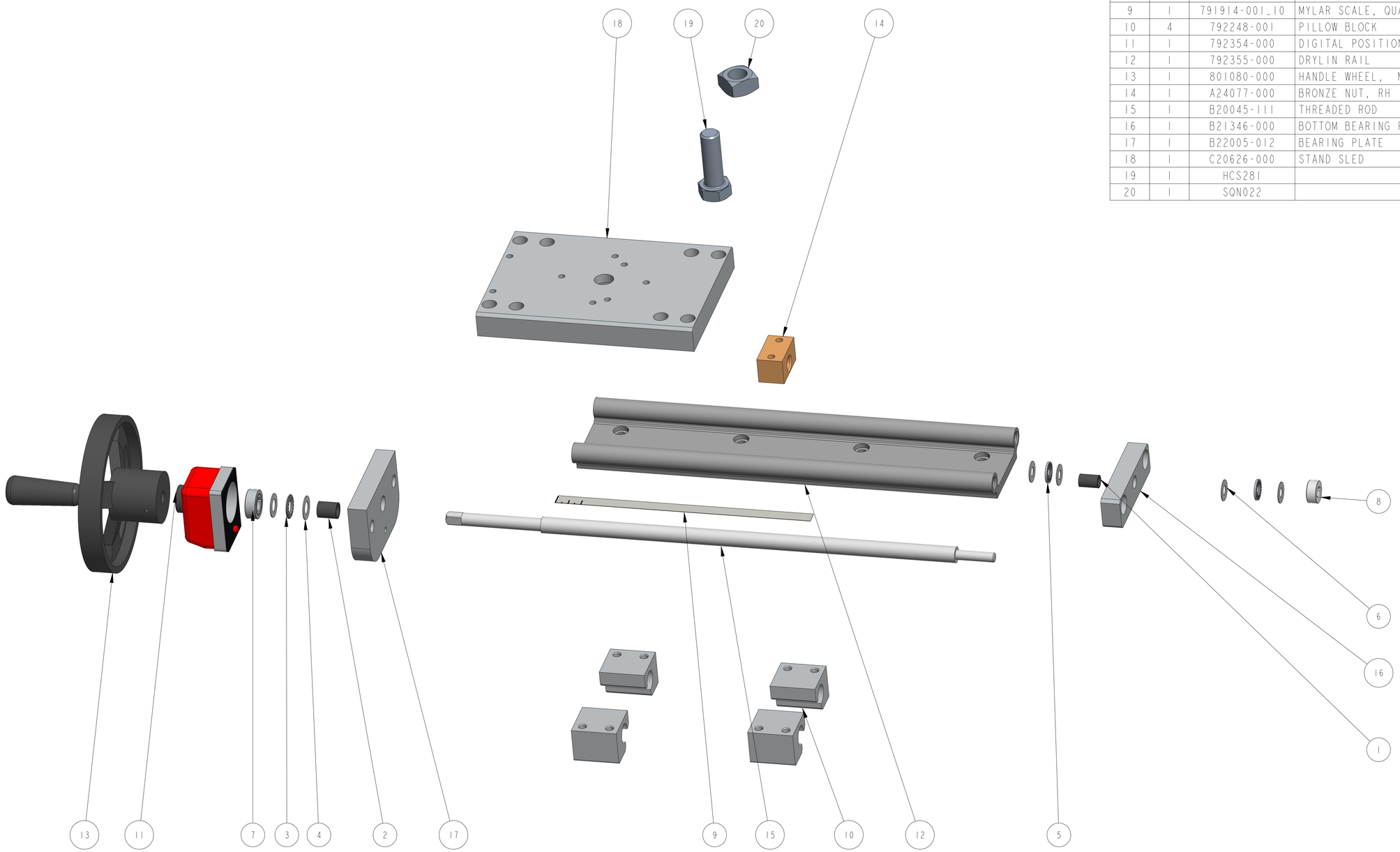
SCALE:	1/32
DATE:	Oct-27-22
DRW BY:	TJS
CHK BY:	03/07/2024-SEM
APPR BY:	

OPENLINE HEAD SUPPORT FOR Q120 W/ SIKO

MAT'L

22530-220-RH

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	141172-000	SLEEVE BEARING, 1/2OD. x 3/8ID. x 3/4LNG	22173-601
2	1	141177-000	SLEEVE BEARING, 5/8OD. x 1/2ID. x 3/4LNG	22173-601
3	1	181079-000	BEARING, NEEDLE ROLLER	22173-601
4	2	181080-000	BEARING, THRUST WASHER	22173-601
5	2	181108-000	BEARING, NEEDLE ROLLER	22173-601
6	4	181111-000	THRUST WASHER	22173-601
7	1	361169-000	COLLAR, 1/2 IN. ID ONE-PIECE CLAMP	22173-601
8	1	362186-000	COLLAR, 3/8 IN. ID ONE-PIECE CLAMP	22173-601
9	1	791914-001_10	MYLAR SCALE, QUADREL LOGO	22173-601
10	4	792248-001	PILLOW BLOCK	22173-601
11	1	792354-000	DIGITAL POSITION INDICATOR	22173-601
12	1	792355-000	DRYLIN RAIL	22173-601
13	1	801080-000	HANDLE WHEEL, MODIFIED	22173-601
14	1	A24077-000	BRONZE NUT, RH	22173-601
15	1	B20045-111	THREADED ROD	22173-601
16	1	B21346-000	BOTTOM BEARING PLATE	22173-601
17	1	B22005-012	BEARING PLATE	22173-601
18	1	C20626-000	STAND SLED	22173-601
19	1	HCS281		22173-601
20	1	SQN022		22173-601



REV	DATE	DESCRIPTION	BY
A	3-25-20	NEW DRAWING	ATT

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SURFACE FINISH 125
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CORNER RADIUS .010/.030

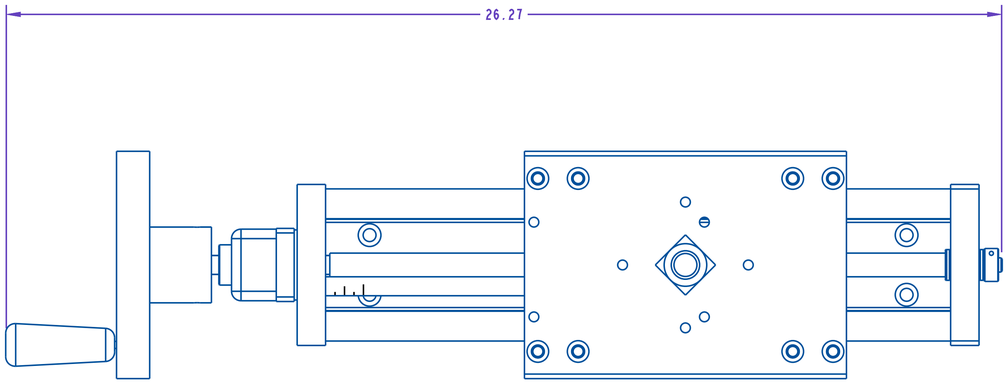
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

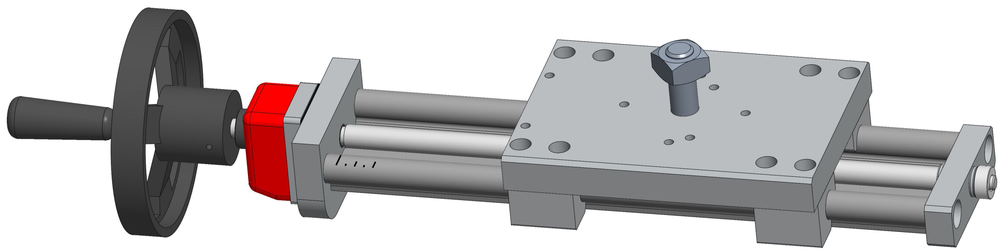
SCALE: 1/2
DATE: 3-25-20
DRW BY: ATT
CHK BY: 03/02/24-SEM
APPR BY:

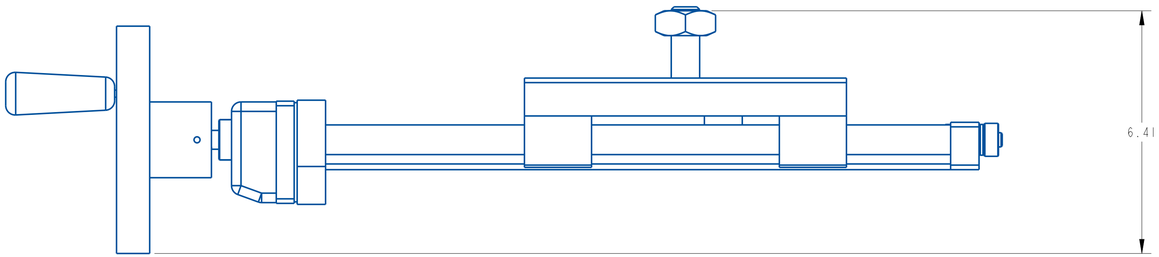
VERTICAL IGUS SLIDE, 17.5"

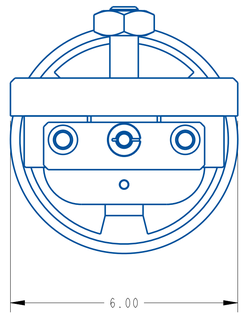
MAT'L 22173-000

22173-601









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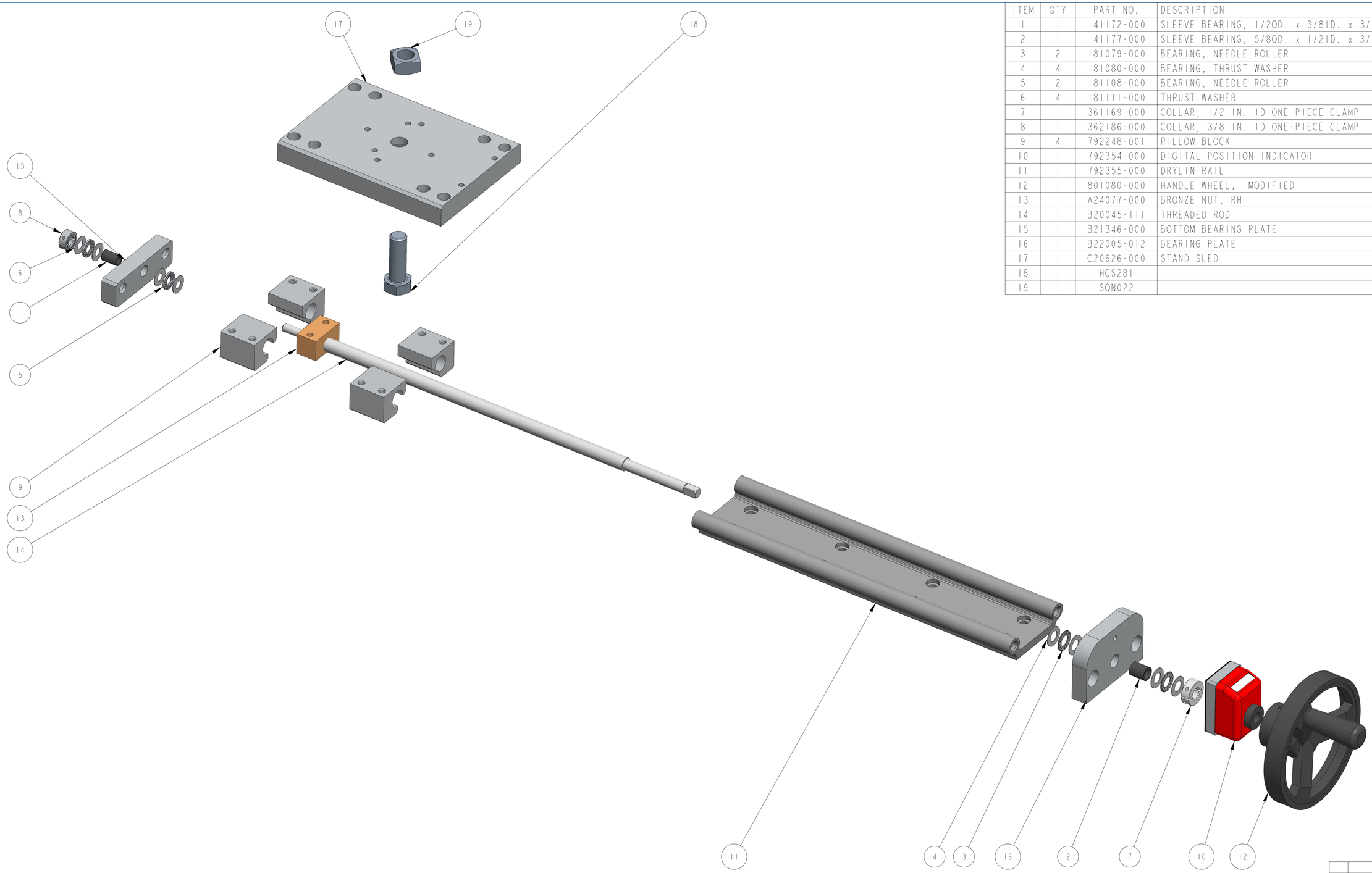
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 3-25-20
DRW BY: ATT
CHK BY: 03/02/24-SEM
APPR BY:

VERTICAL IGUS SLIDE, 17.5"

MAT'L: 22173-000

22173-601



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	141172-000	SLEEVE BEARING, 1/2OD. x 3/8ID. x 3/4LNG	22173H-601
2	1	141177-000	SLEEVE BEARING, 5/8OD. x 1/2ID. x 3/4LNG	22173H-601
3	2	181079-000	BEARING, NEEDLE ROLLER	22173H-601
4	4	181080-000	BEARING, THRUST WASHER	22173H-601
5	2	181108-000	BEARING, NEEDLE ROLLER	22173H-601
6	4	181111-000	THRUST WASHER	22173H-601
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10	1	792354-000	DIGITAL POSITION INDICATOR	22173H-601
11	1	792355-000	DRYLIN RAIL	22173H-601
12	1	801080-000	HANDLE WHEEL, MODIFIED	22173H-601
13	1	A24077-000	BRONZE NUT, RH	22173H-601
14	1	B20045-111	THREADED ROD	22173H-601
15	1	B21346-000	BOTTOM BEARING PLATE	22173H-601
16	1	B22005-012	BEARING PLATE	22173H-601
17	1	C20626-000	STAND SLED	22173H-601
18	1	HCS281		22173H-601
19	1	SQN022		22173H-601

REV	DATE	DESCRIPTION	BY
A	2-24-20	NEW DRAWING	TJS

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ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

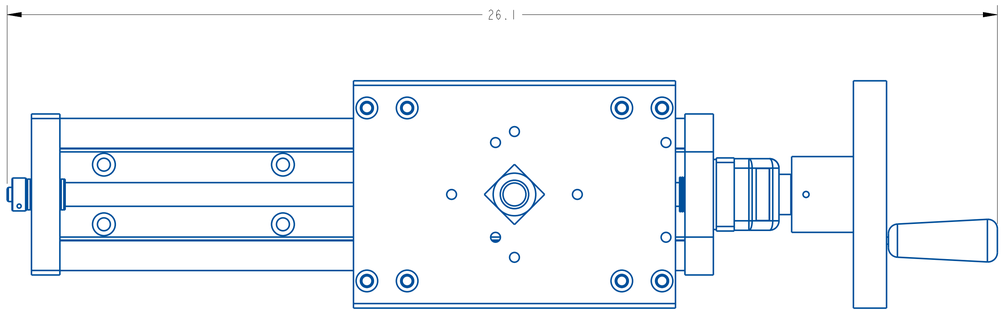
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

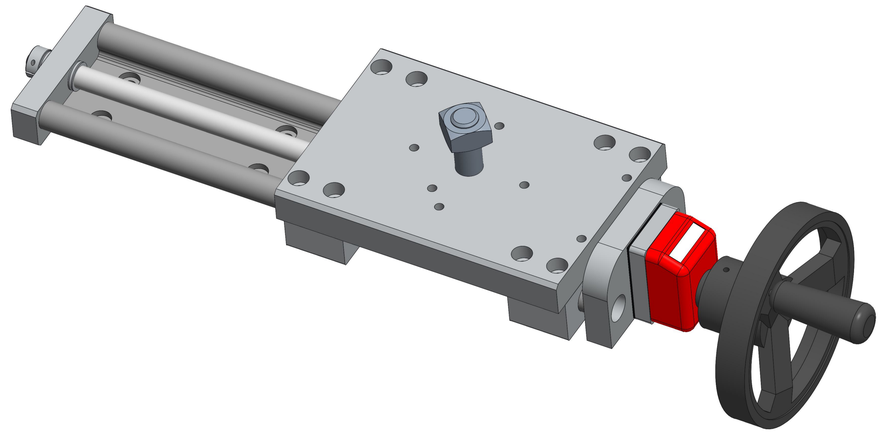
SCALE: 1/2
DATE: 2-24-20
DRW BY: TJS
CHK BY: 03/02/24-SEM
APPR BY:

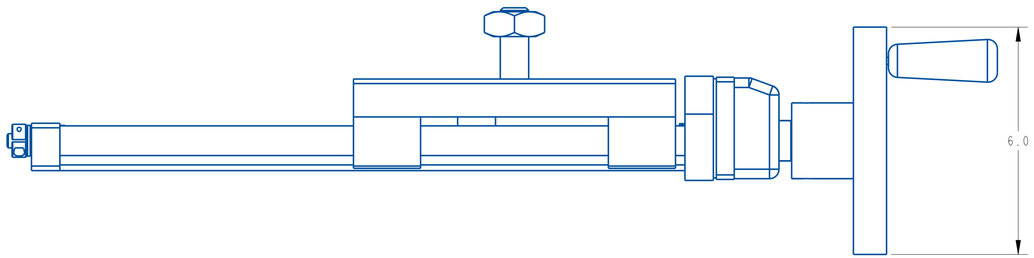
VERTICAL IGUS SLIDE, 17.5"

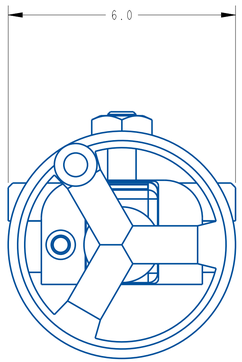
MAT'L

22173H-601









REV	DATE	DESCRIPTION	BY
A	2-24-20	NEW DRAWING	TJS

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UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 2-24-20
DRW BY: TJS
CHK BY: 03/02/24-SEM
APPR BY:

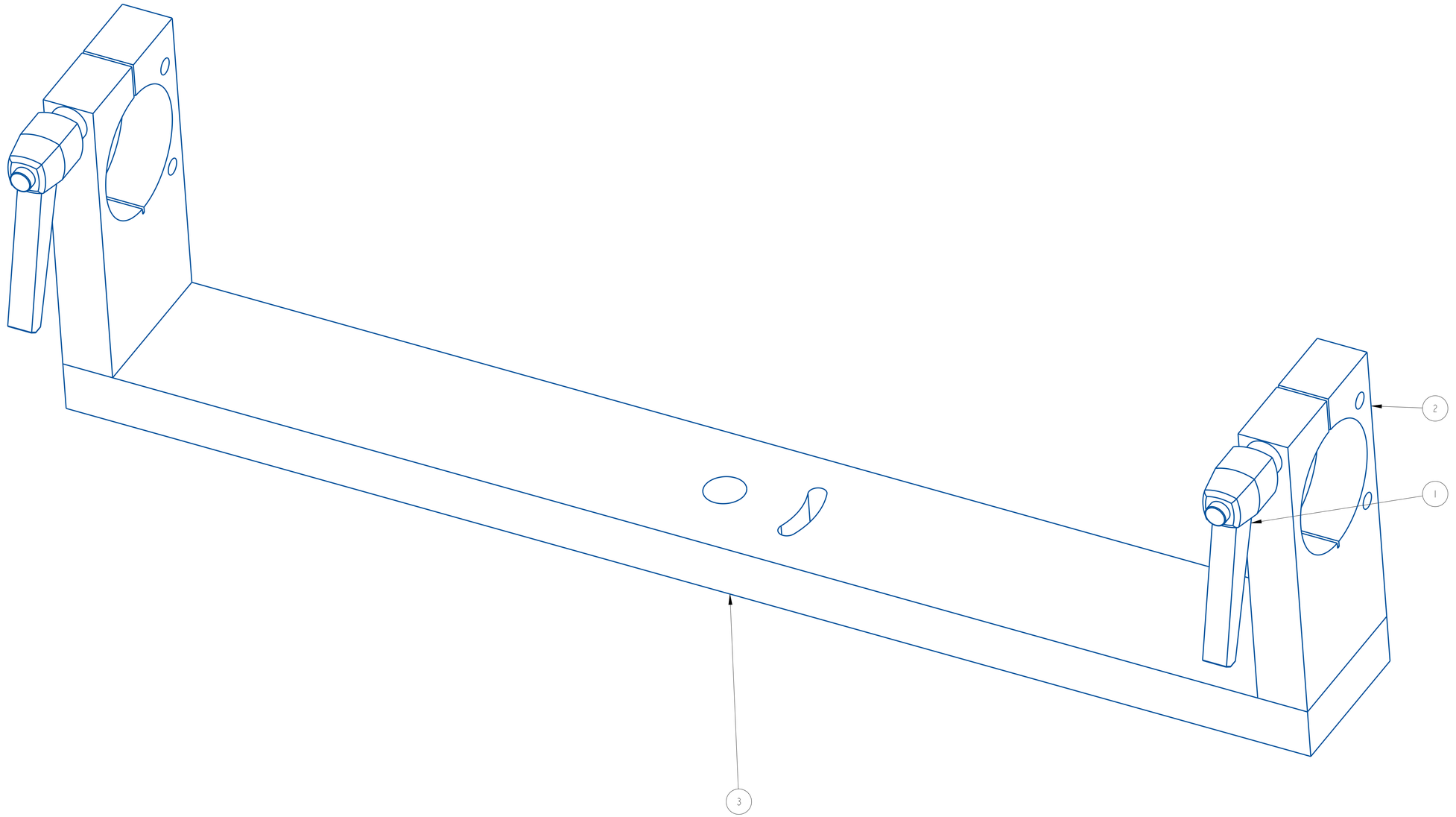
VERTICAL IGUS SLIDE, 17.5"

MAT'L

22173H-601

SHEET 2 OF 2

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	801850-000	CLAMPING LEVER	22620Y-RHH
2	2	B21190-114	YOKE SIDE PLATE	22620Y-RHH
3	1	B21555-000	MTG YOKE BACK PLATE	22620Y-RHH



REV	DATE	DESCRIPTION	BY
A	11-26-13	NEW DRAWING	ATT

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.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

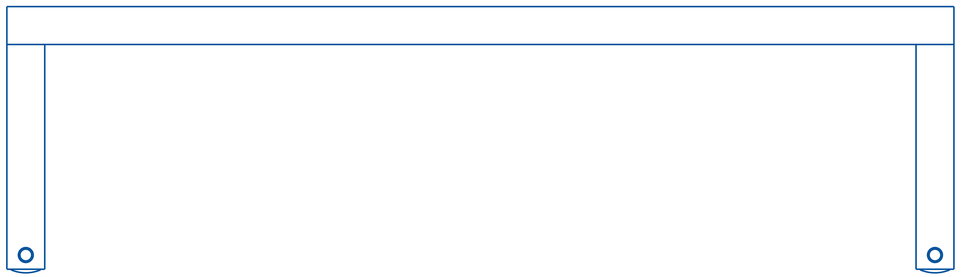
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

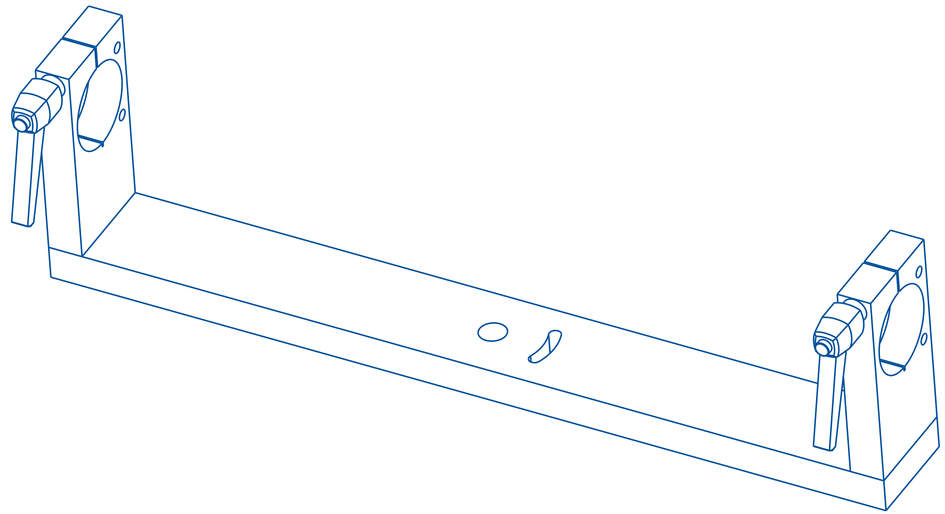
SCALE:	1/1
DATE:	11-26-13
DRW BY:	ATT
CHK BY:	03/07/2024-SEM
APPR BY:	

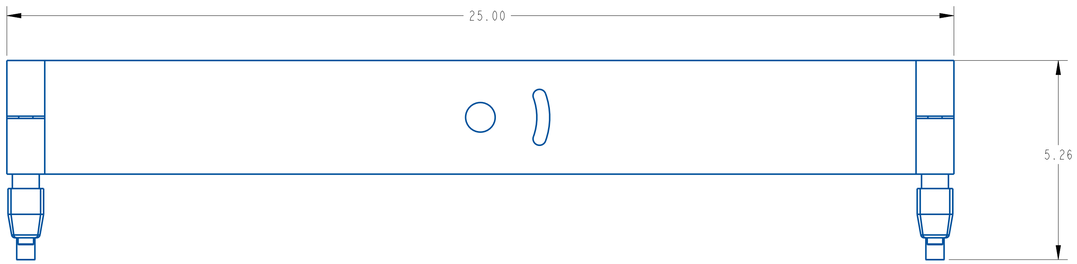
Q120 YOKE ASSEMBLY

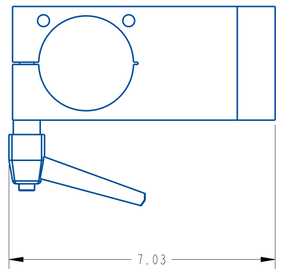
MAT'L

22620Y-RHH









REV	DATE	DESCRIPTION	BY
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ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 11-26-13
DRW BY: ATT
CHK BY:03/07/2024-SEM
APPR BY:

Q120 YOKE ASSEMBLY

MAT'L

22620Y-RHH

ASSEMBLY TITLE: HEAD SUPPORT ASSEMBLY

GENERAL FUNCTION:

The head support assembly keeps the labeling head in a “locked position” and prevents head vibration and wobbling as the label motor is engaged. The head support assembly is also used to set the camber or front/back tilt of the head.

SETUP AND ADJUSTMENTS:

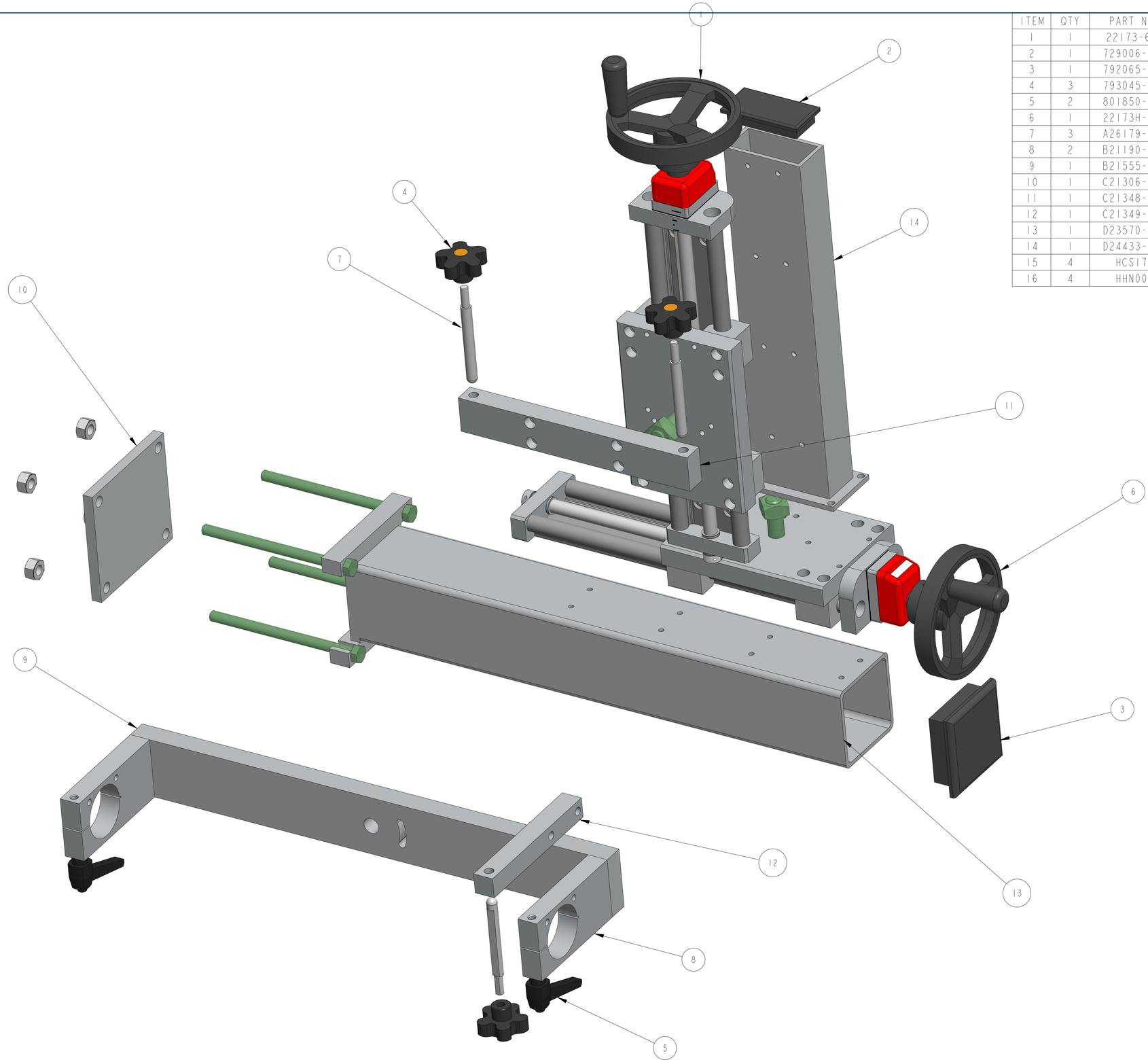
HORIZONTAL ADJUSTMENT: To set the horizontal position of the labeling head, use the side mount wheel handle (some older systems may feature the ratcheted handle). Turn the handle clockwise to move the head towards the conveyor. Turn it counter clockwise to move the head away from the conveyor.

VERTICAL ADJUSTMENT: Using the lower wheel handle to set the vertical position of the labeling head. Turn the wheel clockwise to lower labeling head. Turn the wheel counter clockwise to raise the labeling head.

MAINTENANCE:

No scheduled maintenance is required for this assembly. Always keep the drive areas free of label flash and debris.

TROUBLESHOOTING: None this section.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	22173-601	VERTICAL IGUS SLIDE, 17.5"	22530-220-LH
2	1	729006-000	CAP INSERT FOR 2 X 4 TUBE	22530-220-LH
3	1	792065-000	CAP INSERT FOR 4X4 TUBE (1/4WALL)	22530-220-LH
4	3	793045-000	DIAMOND KNURL KNOB	22530-220-LH
5	2	801850-000	CLAMPING LEVER	22530-220-LH
6	1	22173H-601	VERTICAL IGUS SLIDE, 17.5"	22530-220-LH
7	3	A26179-120	KNOB STUD	22530-220-LH
8	2	B21190-114	YOKE SIDE PLATE	22530-220-LH
9	1	B21555-000	MTG YOKE BACK PLATE	22530-220-LH
10	1	C21306-000	HEAD SUPPORT BACKING PLATE	22530-220-LH
11	1	C21348-120	ADJUSTMENT PLATE	22530-220-LH
12	1	C21349-120	ADJUSTMENT BLOCK	22530-220-LH
13	1	D23570-125	HORIZONTAL MOUNTING FRAME	22530-220-LH
14	1	D24433-125	HEAD SUPPORT RISER	22530-220-LH
15	4	HCS173		22530-220-LH
16	4	HHN002		22530-220-LH

REV	DATE	DESCRIPTION	BY
B	20-FEB-2024	UPDATED THE DRAWING AND BOM	CRT
A	OCT-27-22	NEW DRAWING	TJS

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

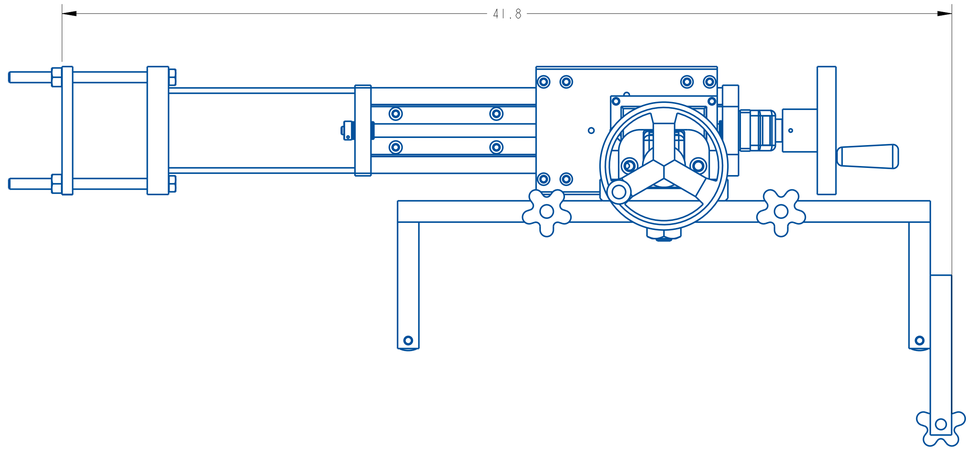
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

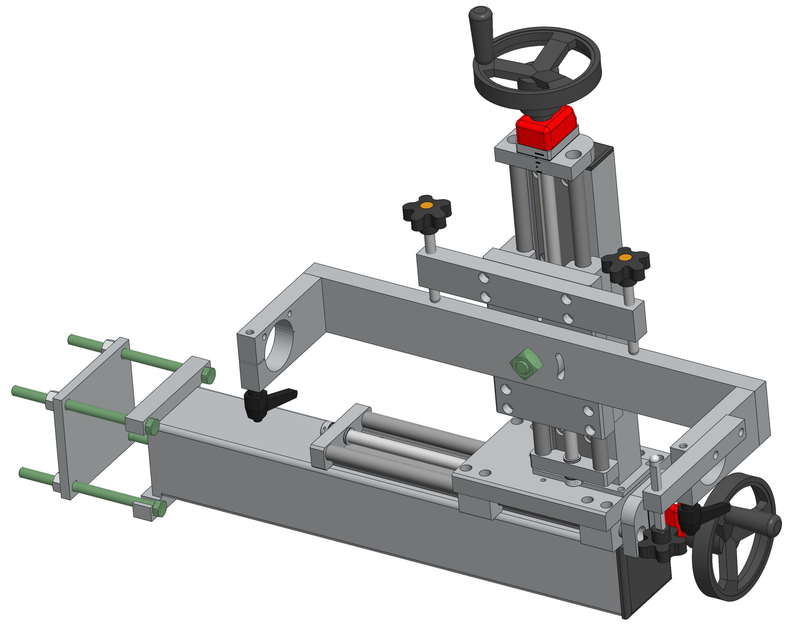
SCALE: 7/16
DATE: OCT-27-22
DRW BY: TJS
CHK BY: 03/02/24-SEM
APPR BY:

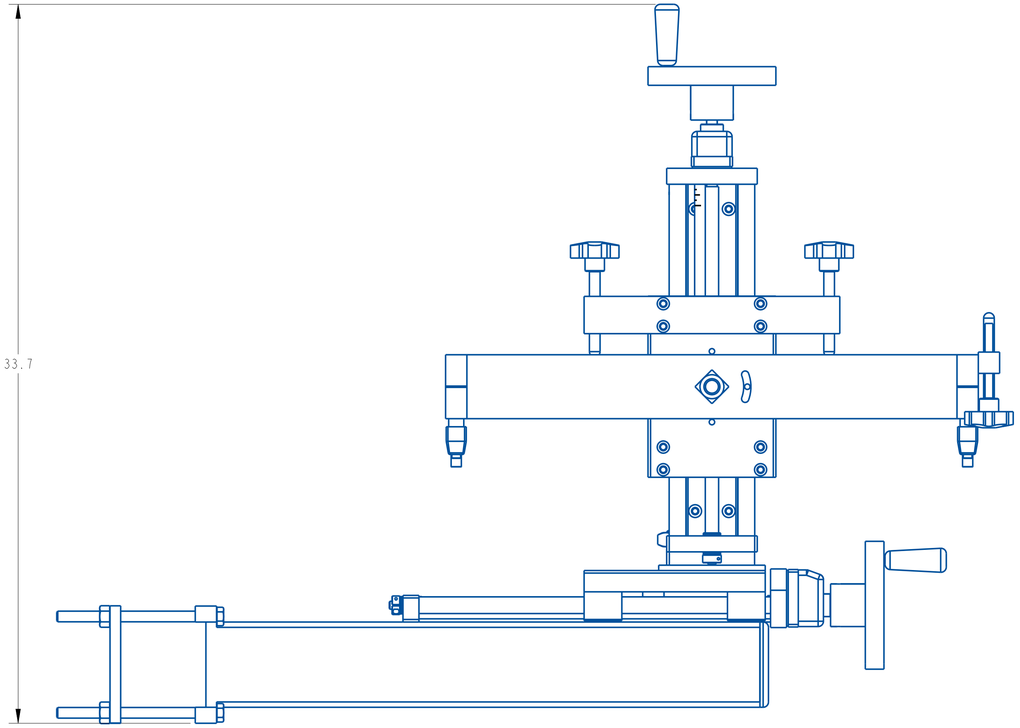
OPENLINE HEAD SUPPORT FOR Q120 W/ SIKO

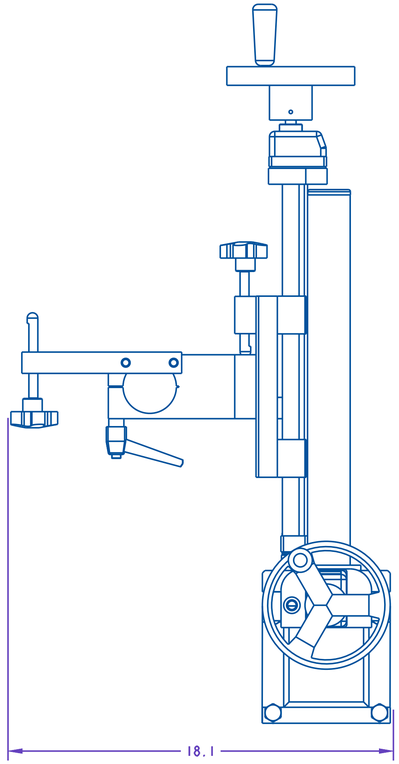
MAT'L 22530-220-LH

22530-220-LH









REV	DATE	DESCRIPTION	BY
B	20-FEB-2024	UPDATE THE DRAWING AND BOM	CRT
A	OCT-27-22	NEW DRAWING	TJS

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SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

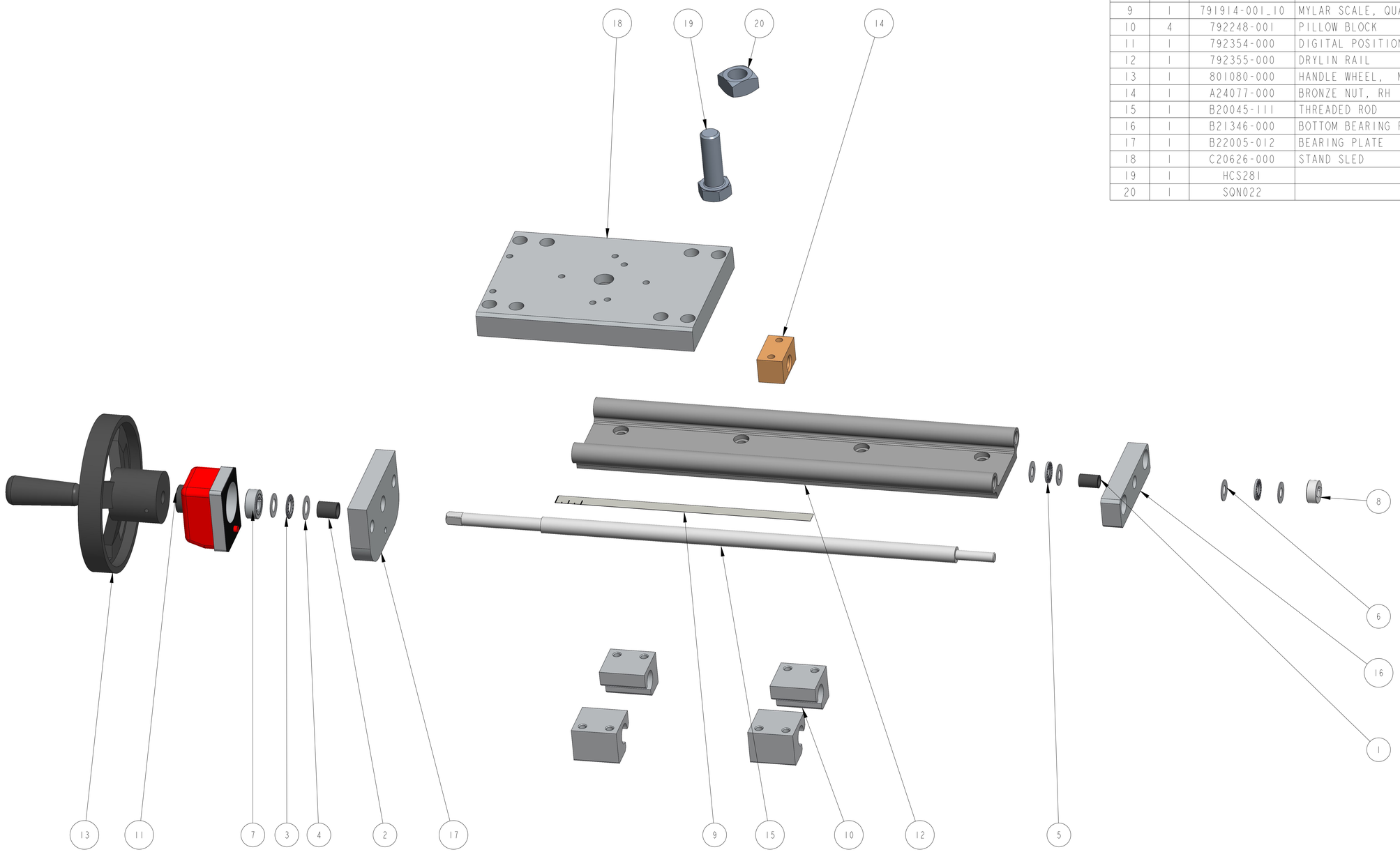
SCALE: 9/32
DATE: OCT-27-22
DRW BY: TJS
CHK BY: 03/02/24-SEM
APPR BY:

OPENLINE HEAD SUPPORT FOR Q120 W/ SIKO

MAT'L 22530-220-LH

22530-220-LH

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	141172-000	SLEEVE BEARING, 1/2OD. x 3/8ID. x 3/4LNG	22173-601
2	1	141177-000	SLEEVE BEARING, 5/8OD. x 1/2ID. x 3/4LNG	22173-601
3	1	181079-000	BEARING, NEEDLE ROLLER	22173-601
4	2	181080-000	BEARING, THRUST WASHER	22173-601
5	2	181108-000	BEARING, NEEDLE ROLLER	22173-601
6	4	181111-000	THRUST WASHER	22173-601
7	1	361169-000	COLLAR, 1/2 IN. ID ONE-PIECE CLAMP	22173-601
8	1	362186-000	COLLAR, 3/8 IN. ID ONE-PIECE CLAMP	22173-601
9	1	791914-001_10	MYLAR SCALE, QUADREL LOGO	22173-601
10	4	792248-001	PILLOW BLOCK	22173-601
11	1	792354-000	DIGITAL POSITION INDICATOR	22173-601
12	1	792355-000	DRYLIN RAIL	22173-601
13	1	801080-000	HANDLE WHEEL, MODIFIED	22173-601
14	1	A24077-000	BRONZE NUT, RH	22173-601
15	1	B20045-111	THREADED ROD	22173-601
16	1	B21346-000	BOTTOM BEARING PLATE	22173-601
17	1	B22005-012	BEARING PLATE	22173-601
18	1	C20626-000	STAND SLED	22173-601
19	1	HCS281		22173-601
20	1	SQN022		22173-601



REV	DATE	DESCRIPTION	BY
A	3-25-20	NEW DRAWING	ATT

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DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

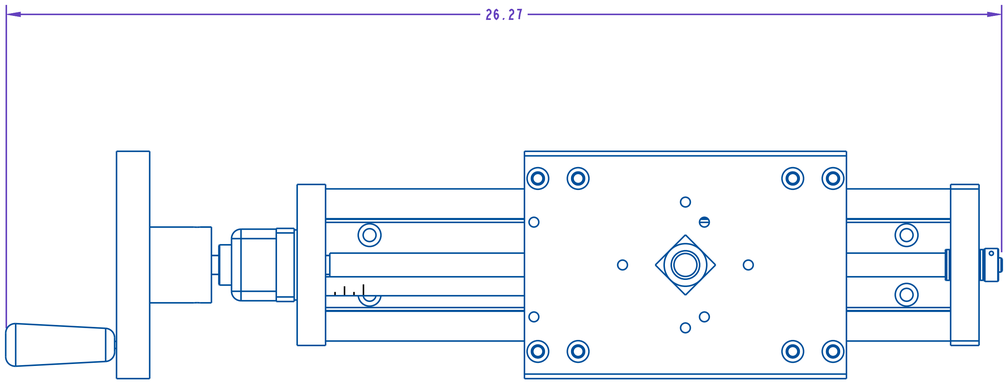
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

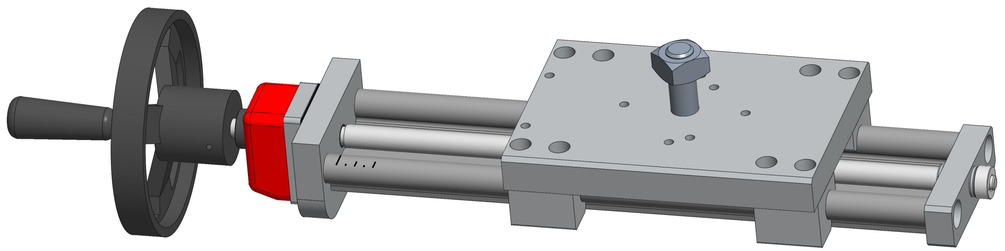
SCALE: 1/2
DATE: 3-25-20
DRW BY: ATT
CHK BY: 03/02/24-SEM
APPR BY:

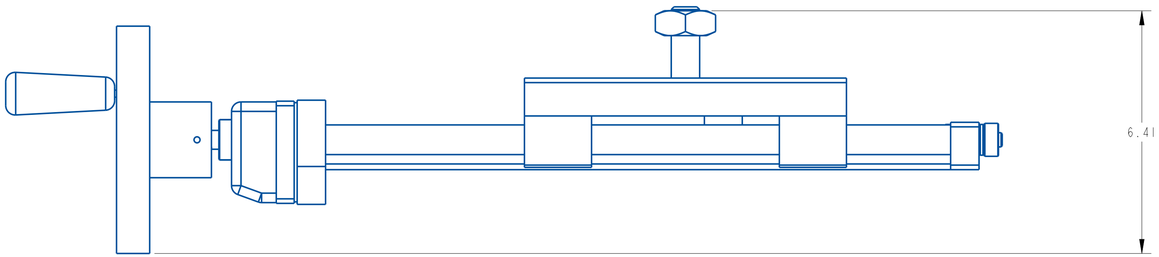
VERTICAL IGUS SLIDE, 17.5"

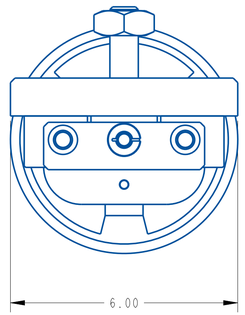
MAT'L 22173-000

22173-601









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ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

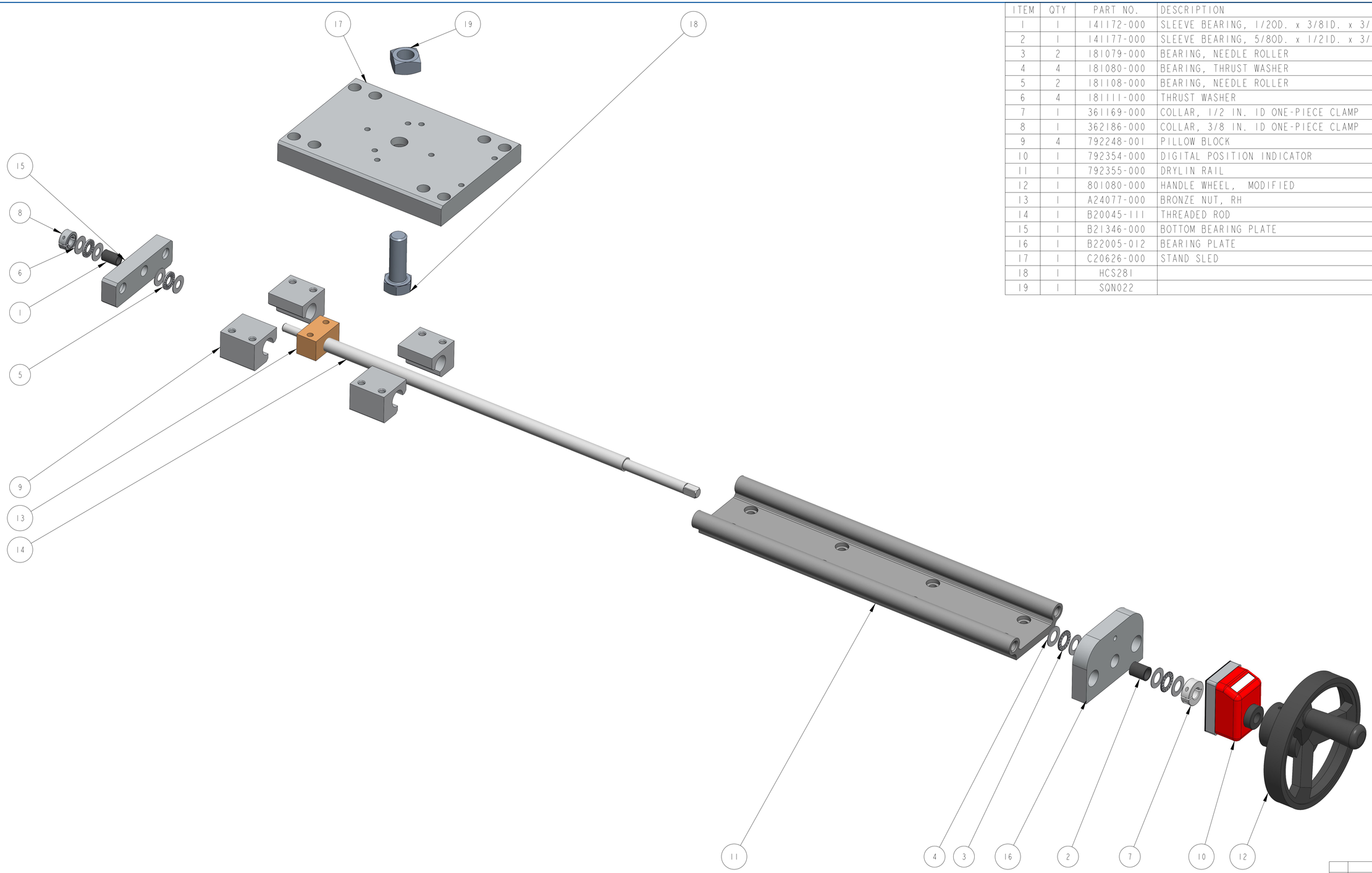
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 3-25-20
DRW BY: ATT
CHK BY: 03/02/24-SEM
APPR BY:

VERTICAL IGUS SLIDE, 17.5"

MAT'L: 22173-000

22173-601



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4	4	181080-000	BEARING, THRUST WASHER	22173H-601
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13	1	A24077-000	BRONZE NUT, RH	22173H-601
14	1	B20045-111	THREADED ROD	22173H-601
15	1	B21346-000	BOTTOM BEARING PLATE	22173H-601
16	1	B22005-012	BEARING PLATE	22173H-601
17	1	C20626-000	STAND SLED	22173H-601
18	1	HCS281		22173H-601
19	1	SQN022		22173H-601

REV	DATE	DESCRIPTION	BY
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ANGLES ± 30'

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QUADREL LABELING SYSTEMS
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MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
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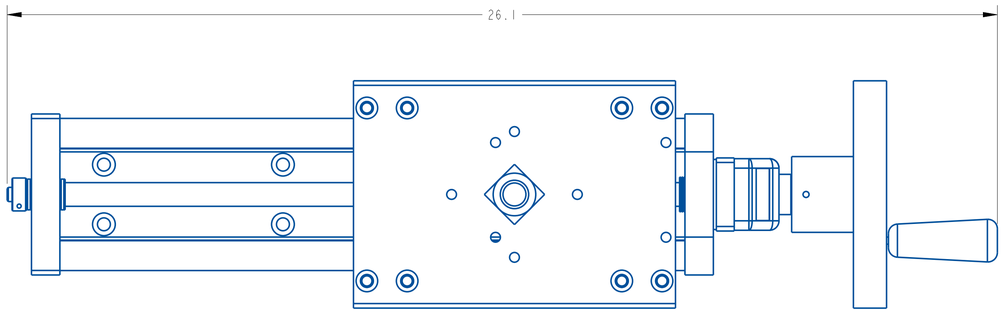
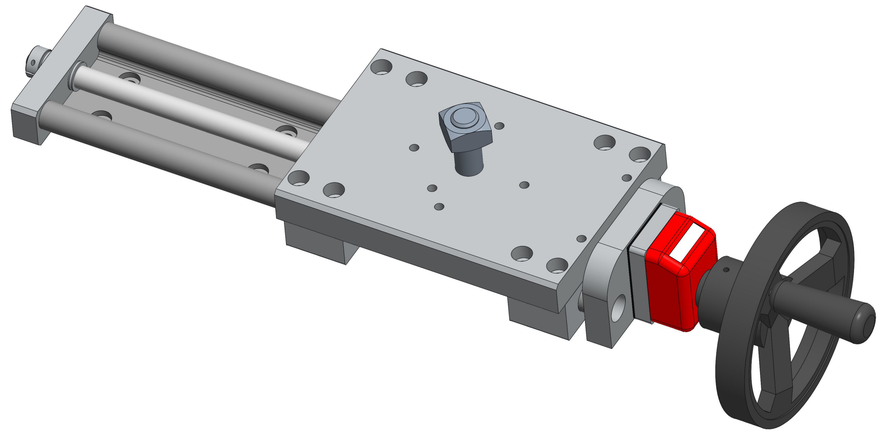
APPR BY:

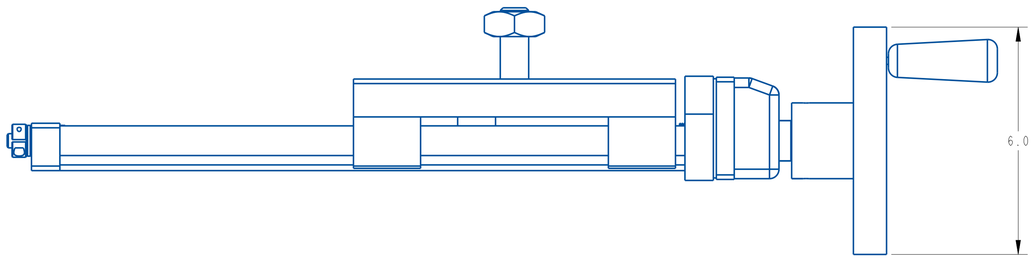
VERTICAL IGUS SLIDE, 17.5"

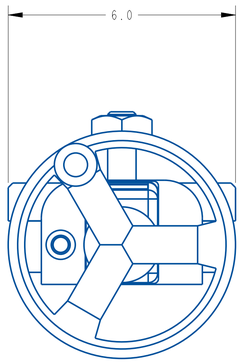
MAT'L

22173H-601









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QUADREL LABELING SYSTEMS
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(440) 602-4700

SCALE: 1/2
DATE: 2-24-20
DRW BY: TJS
CHK BY: 03/02/24-SEM
APPR BY:

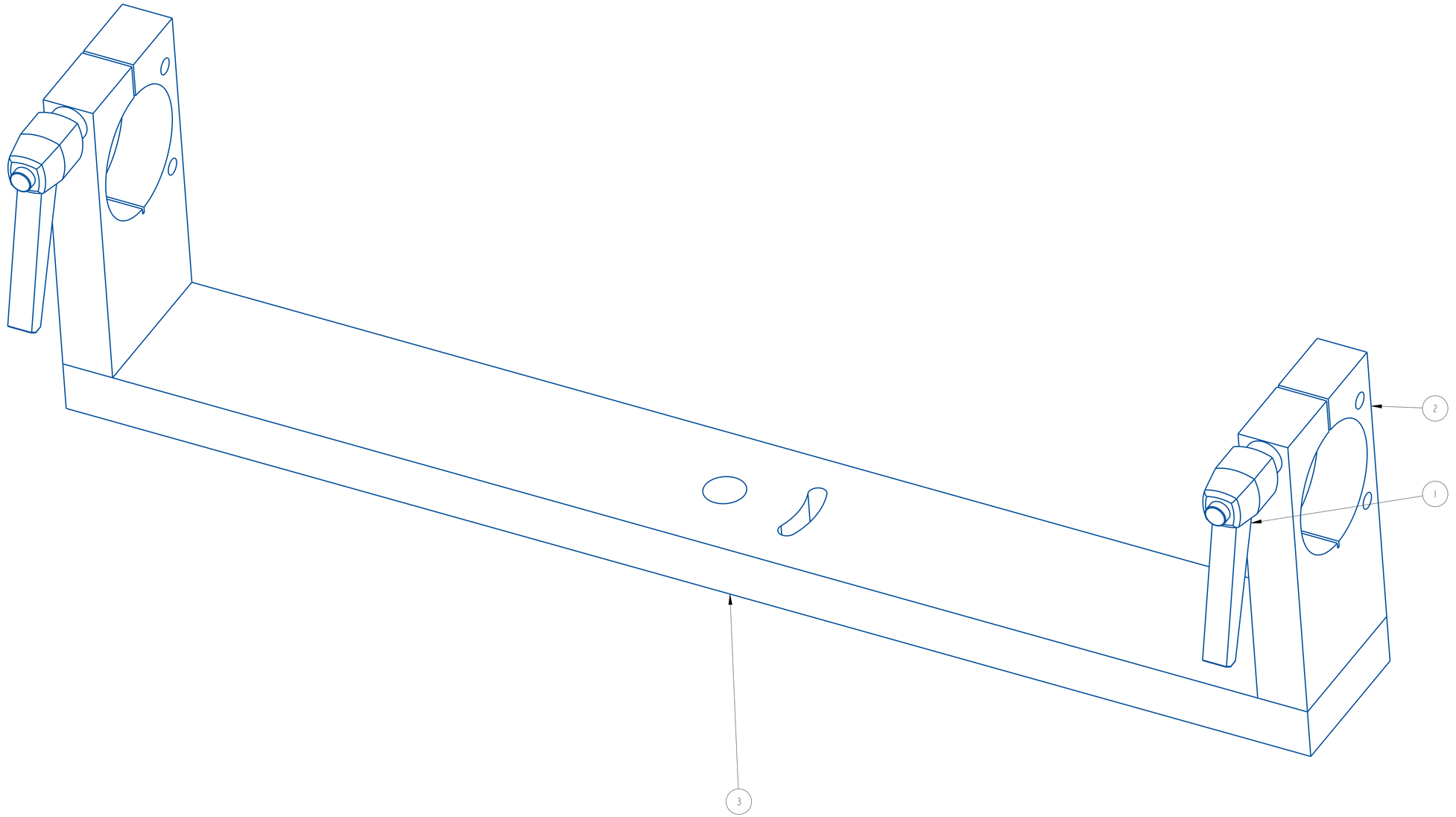
VERTICAL IGUS SLIDE, 17.5"

MAT'L

22173H-601

SHEET 2 OF 2

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	801850-000	CLAMPING LEVER	22620Y-RHH
2	2	B21190-114	YOKE SIDE PLATE	22620Y-RHH
3	1	B21555-000	MTG YOKE BACK PLATE	22620Y-RHH



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QUADREL LABELING SYSTEMS
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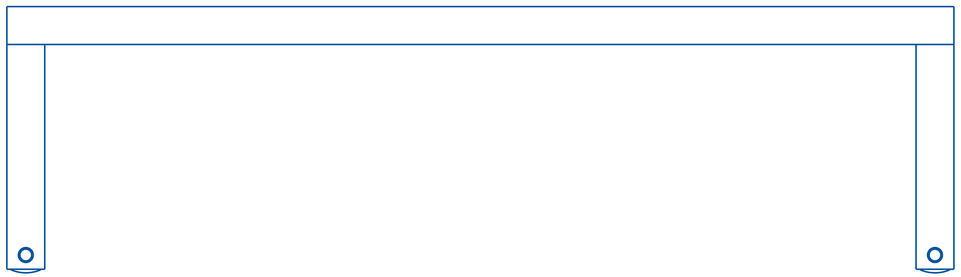
MENTOR, OHIO 44060
(440) 602-4700

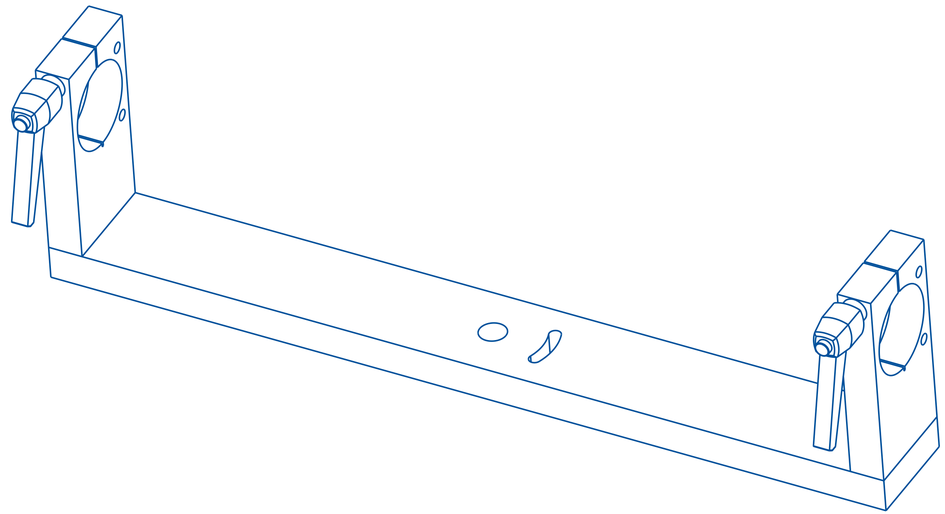
SCALE:	1/1
DATE:	11-26-13
DRW BY:	ATT
CHK BY:	03/07/2024-SEM
APPR BY:	

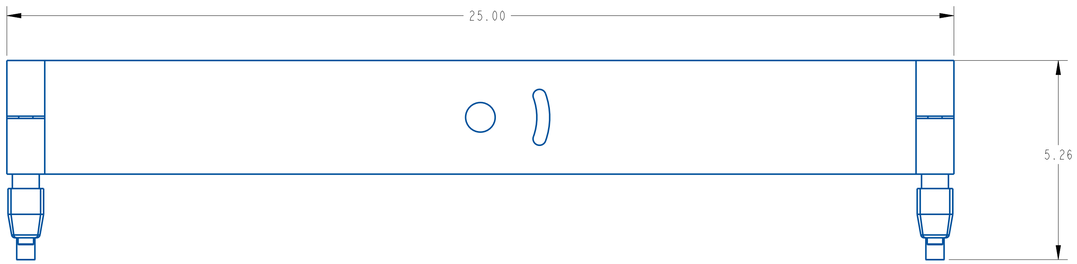
Q120 YOKE ASSEMBLY

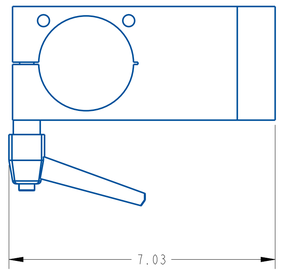
MAT'L

22620Y-RHH









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ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 11-26-13
DRW BY: ATT
CHK BY:03/07/2024-SEM
APPR BY:

Q120 YOKE ASSEMBLY

MAT'L

22620Y-RHH

7.4 PACING WHEEL / BELT ASSEMBLY

7.4.1 GENERAL INFORMATION

The pacing wheel/belt are an optional module that is generally placed at the entrance of the conveyor to allow adequate spacing of products as they travel towards the labeling head. The speed of the wheel/belt will vary how much spacing is created between the products. It is controlled by a DC motor and DC drive located in the electrical enclosure.

7.4.2 ADJUSTMENTS

The adjustments for both assemblies are fairly straight forward. The pacing wheel assembly has a pivoting in and out adjustment and height adjustment. The pivot in and out adjustment is made by loosening the ratcheting handle on the mount and rotating the assembly as needed.

The vertical adjustment for the pacing wheel is achieved by loosening the collar on the shaft then loosening the ratchet handle and manually pull up or push down as needed. The height is locked in place with the lock collar. Tighten the ratchet handle when finished.

⚠ **CAUTION** **Do not make any adjustments when assembly or conveyor are running.**

The pacing belt assembly has both vertical and horizontal adjustments. To adjust vertically loosen the 2 3/8-16 bolts and pull up on the assembly. To adjust horizontally (in and out) loosen the 2 ratchet handles under the assembly and slide in and out as needed.

ASSEMBLY TITLE: **PACING WRAP ASSEMBLY**

DRAWING NO: **D21938-000**

GENERAL FUNCTION:

The product pacing wrap is offsets each product a variable distance from the preceding product and guarantees adequate product separation.

SETUP AND ADJUSTMENTS:

- Adjust the brackets so that the pacing belt slightly presses the product against the back rail. Lock into place using the adjustment knobs.

- The speed of the pacing belt is controlled by a potentiometer located in the remote enclosure mounted on the conveyor riser.

MAINTENANCE:

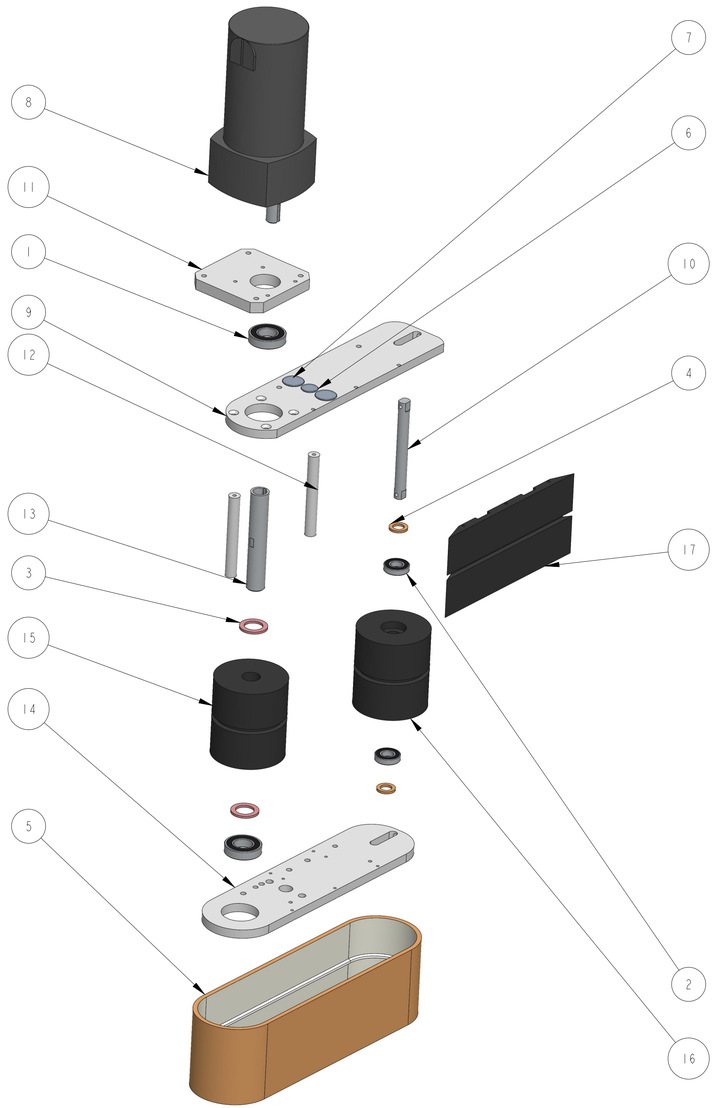
No scheduled maintenance is required for this assembly. Always keep the drive areas free of label flash and debris.

CAUTION:

Before performing any maintenance or cleaning make sure the system is powered down.

TROUBLESHOOTING:

PROBLEM:	WHAT TO DO:
- Product spaced to close	- Reduce the speed of the pacing wheel.
- Product spaced too far apart	- Increase the speed of the pacing wheel.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	111064-000	BEARING, BANDED THRUST BALL	21978-000
2	2	111075-000	BEARING, BALL	21978-000
3	2	151011-000	BEARING, THRUST WASHER	21978-000
4	2	151017-000	BEARING, THRUST WASHER	21978-000
5	1	193366-000	BELT, WRAP RUFTEX W/V-GUIDE	21978-000
6	1	261823-000	PLUG BUTTON, 3/4 DIA	21978-000
7	2	262883-000	PLUG BUTTON	21978-000
8	1	411380-000	MOTOR, DC	21978-000
9	1	A21277-000	LOWER PLATE (MODULINE WRAP)	21978-000
10	1	A21743-000	IDLER SHAFT	21978-000
11	1	A23731-000	MOTOR MTG. PLATE (MODULINE)	21978-000
12	2	A25302-007	SPACER	21978-000
13	1	B20776-000	DRIVE SHAFT	21978-000
14	1	B21200-001	UPPER PLATE (MODULINE WRAP)	21978-000
15	1	B21968-000	DRIVE ROLL W/GROOVE	21978-000
16	1	B21969-000	IDLER ROLL W/GROOVE	21978-000
17	1	D21857-000	BACK-UP PLATE W/ V-GROOVE SLOT	21978-000

REV	DATE	DESCRIPTION	BY
A	APR-26-21	NEW DRAWING	TJS

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30°

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIOS .0107.030

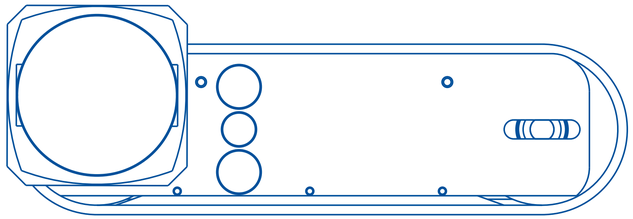
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

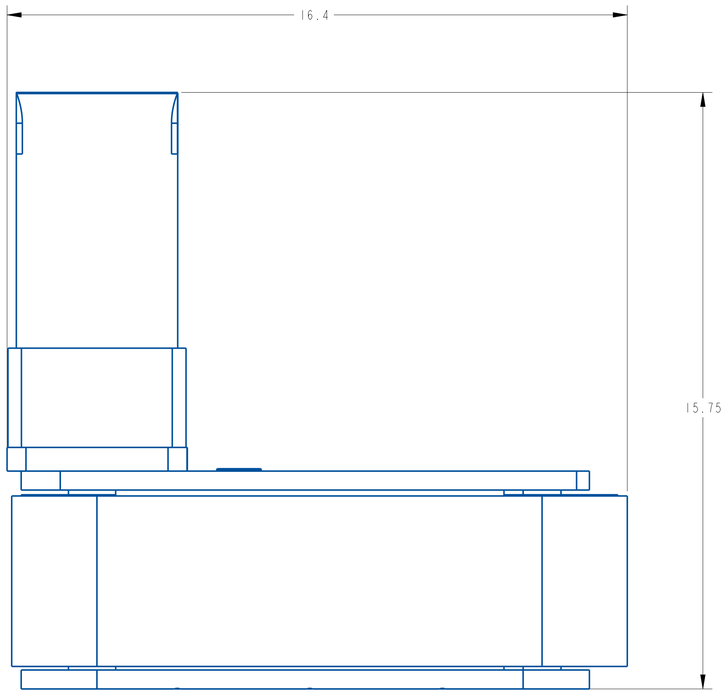
SCALE: 1/4
DATE: APR-26-21
DRW BY: TJS
CHK BY: 03/12/2024-SEM
APPR BY:

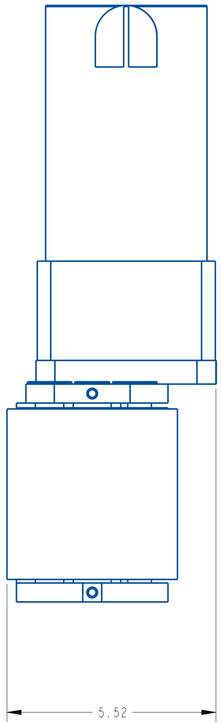
4 x 12 PACING WRAP

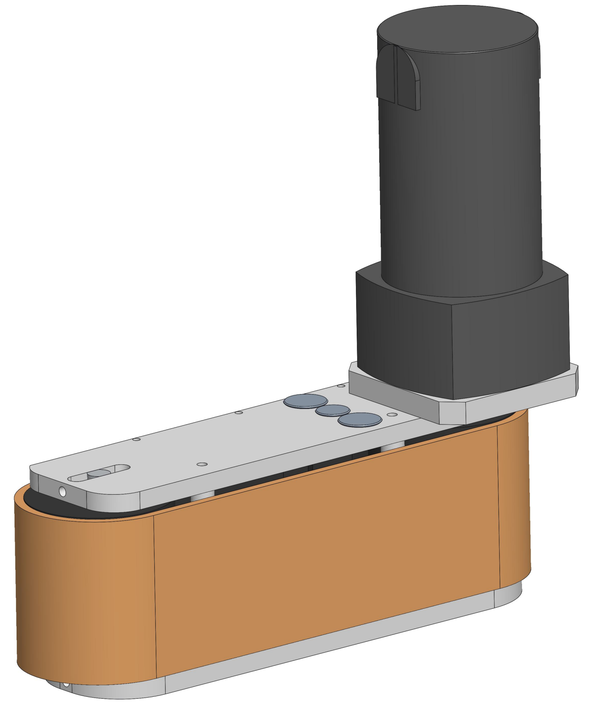
MAT'L

21978-000









REV	DATE	DESCRIPTION	BY
A	Apr-26-21	NEW DRAWING	TJS

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	1/2
DATE:	Apr-26-21
DRW BY:	TJS
CHK BY:	03/12/2024-SEM
APPR BY:	

4 x 12 PACING WRAP

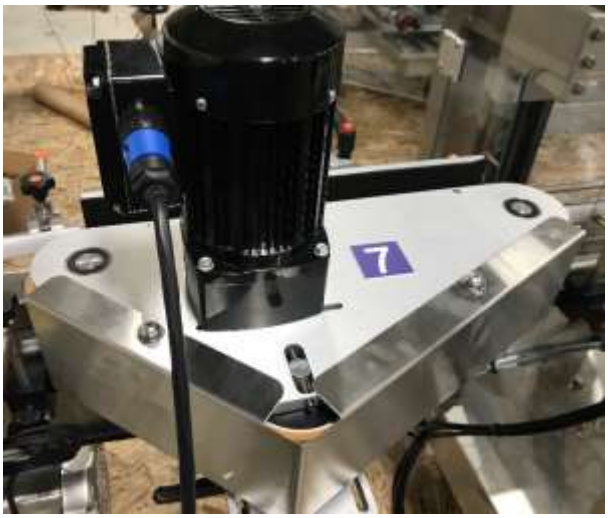
MAT'L

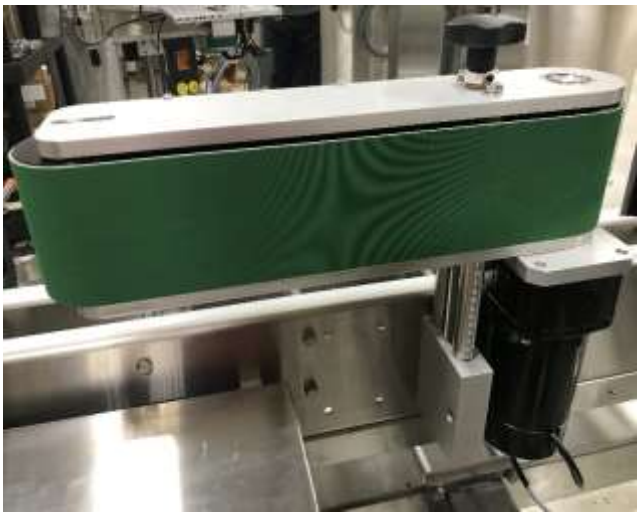
21978-000

7.5 WRAP STATION ASSEMBLY

7.5.1 GENERAL INFORMATION

The wrap station is generally positioned near the labeler and is made up of a belt/roller assembly activated by a DC motor (with encoder), and AC motor, or servo motor coupled to a gear box and adjusting plate. The wrap station paired with a foam back plate assembly is used for cylindrical products to ensure impression 360 degrees around the container. There are two wrap styles depending on your specific application. A triangle wrap station (pictured on the left) is used primarily in “flag and wrap” applications where the wrap station is positioned after the top hold down. Our direct wrap or rectangle wrap station (pictured on the right) is positioned directly after the peel plate. This wrap station comes with a dc motor with an encoder to ensure absolute synchrony with the labeling head.





7.5.2 ADJUSTMENTS

Depending on the height of your product and placment of your label you may need to adjust the height of the wrap station. Adjusting the hieght on your wrap station is very simple. On a triangle wrap station rotate the handwheel counter clockwise or clockwise to raise and lower the wrap station.

On a rectangle wrap station locate the handle on the mount for the wrap station. loosen the ratchet handle, then simply turn the knob on top of the wrap station clockwise and counter clockwise to raise and lower the wrap station. This is the only adjustment for the rectangle wrap station on this mount.

The triangle wrap station has the ability to travel in and out. This adjustment is used in applications with skinnier products, or a cituation where you need to move the wrap out of the way. To achieve this adjustment loosen both ratchet handles und the wrap station. Tighten when in place.

⚠ **CAUTION** **Do not make this adjustment when the wrap station is running.**

In more difficult applications such as tapered containers you may need to adjust the tilt of the wrap station to match the products taper (If the taper is too great other methods are used). To adjust the tilt or to square the wrap station to the conveyor or container locate the 4 set screws on the wrap mount loosen the jam nuts and tighten or loosen the set screws to tilt the wrap station as desired.

ASSEMBLY TITLE: **WRAP ASSEMBLY**

DRAWING: **D23201-000**

GENERAL FUNCTION:

The wrap station is used in conjunction with a single labeling head to apply a label around a cylindrical product. The wrap station length will vary with respect to the maximum length of label being applied.

SET UP AND ADJUSTMENTS:

The wrap station is attached to mounting blocks which clamp to mounting rails affixed to the conveyor side plate. The wrap station can be moved by loosening the locking levers holding the wrap station in place. Position as needed and retighten locking levers.

Set the speed of the wrap station with the manual speed control mounted in the drive/disconnect enclosure.

The final wrap speed should be set from 1.5 to 2 times (1½-2x) the rate of the conveyor. All line compensation systems will automatically adjust the labeling head speed with respect to the speed of the wrap station.

MAINTENANCE:

Keep the wrap belt free of label adhesive and debris. This will prevent jamming and web tears.

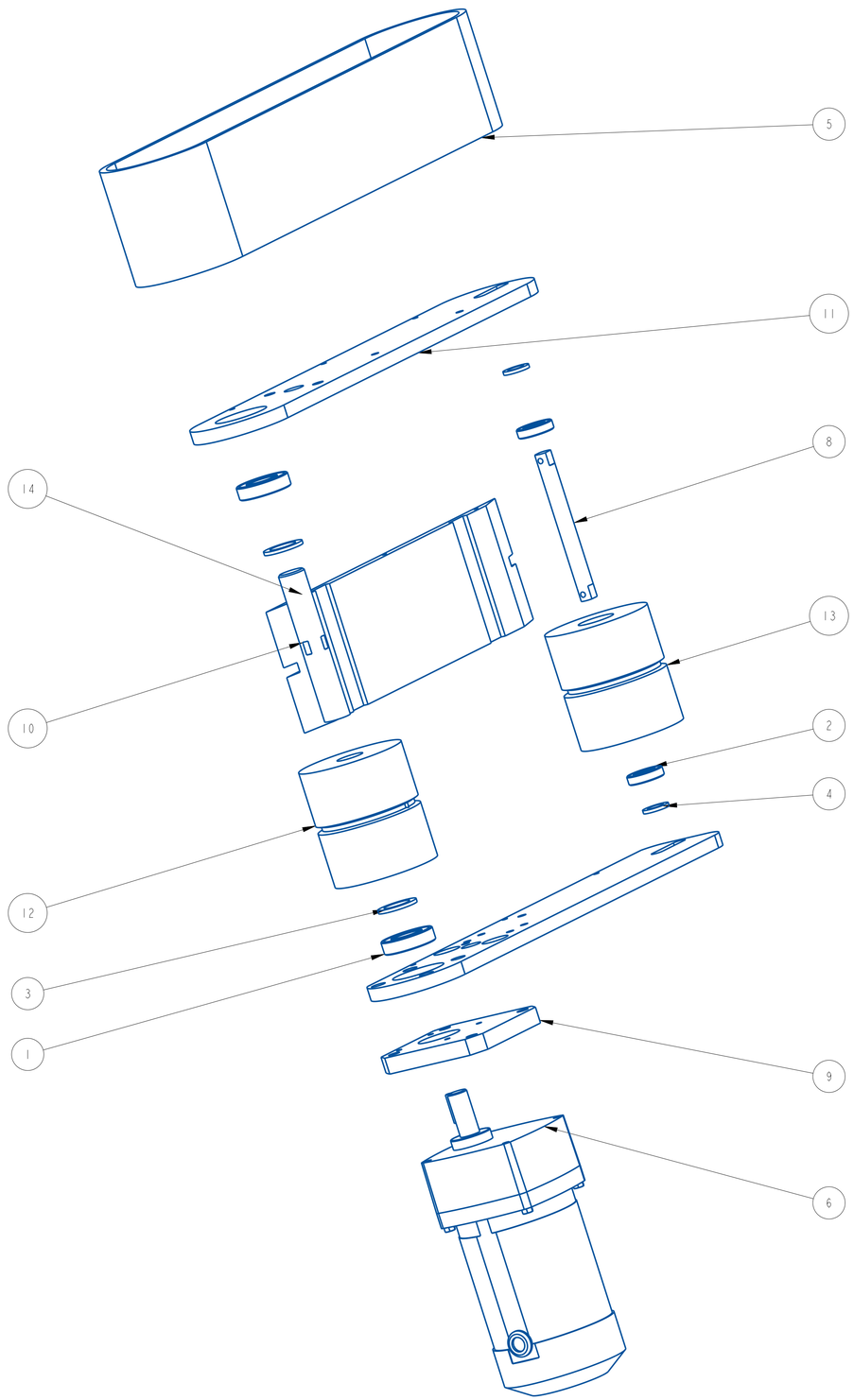
Periodically check belt tension. Use the setscrew adjustment at each end to control belt tension.

CAUTION:

Before performing any maintenance or cleaning make sure the system is powered down.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Belt not fully engaged	Increase tension on belt by adjusting tensioner set screws.
- Wrap station not feeding the label correctly	Adjust wrap station inward.
- Speed set incorrectly	Reset speed as necessary.
- Belt Jam	Speed set incorrectly, reset speed as necessary.
- Tension too stiff	Relieve tension.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	111064-000	BEARING, BANDED THRUST BALL	22358-014
2	2	111075-000	BEARING, BALL	22358-014
3	2	151011-000	BEARING, THRUST WASHER	22358-014
4	2	151017-000	BEARING, THRUST WASHER	22358-014
5	1	193372-000	BELT, WRAP W/V-GUIDE	22358-014
6	1	412173-000	GEARMOTOR; 3/8 HP 170RPM 3PH AC	22358-014
7	1	A21278-003	LOWER PLATE (MODULINE WRAP)	22358-014
8	1	A21743-000	IDLER SHAFT	22358-014
9	1	A23731-000	MOTOR MTG. PLATE (MODULINE)	22358-014
10	1	B20776-000	DRIVE SHAFT	22358-014
11	1	B21206-000	UPPER PLATE (MODULINE WRAP)	22358-014
12	1	B21968-000	DRIVE ROLL W/GROOVE	22358-014
13	1	B21969-000	IDLER ROLL W/GROOVE	22358-014
14	1	D21858-000	BACK-UP PLATE W/ GROOVE	22358-014

NOT SHOWN:

A23858-093 CUT DOWN BELT TO 3.125"

REV	DATE	DESCRIPTION	BY
A	Sep-22-25	NEW DRAWING	TAZ

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DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

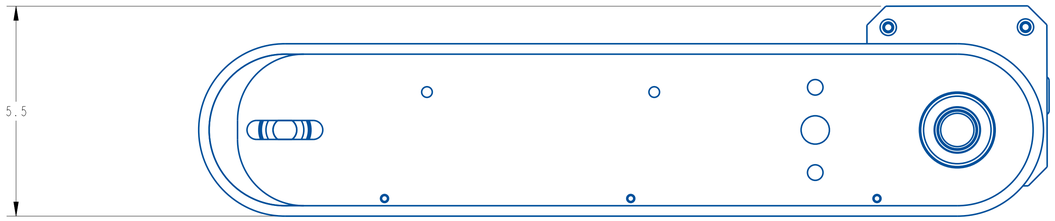
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

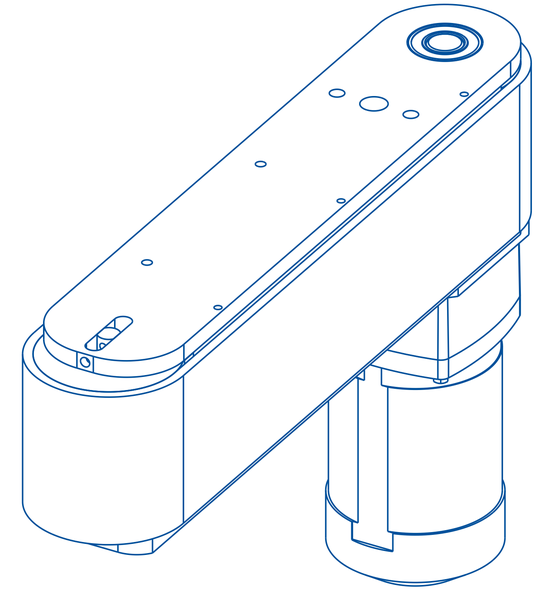
SCALE: 3/8
DATE: Sep-22-25
DRW BY: TAZ
CHK BY:
APPR BY:

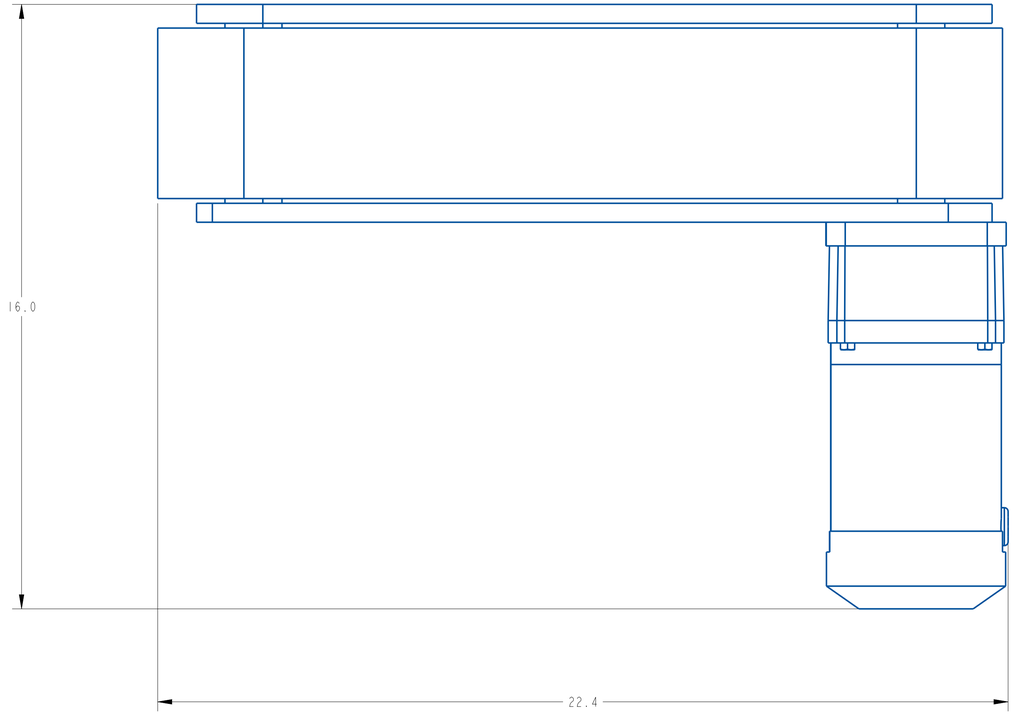
4 x 18 WRAP W/V-GUIDE

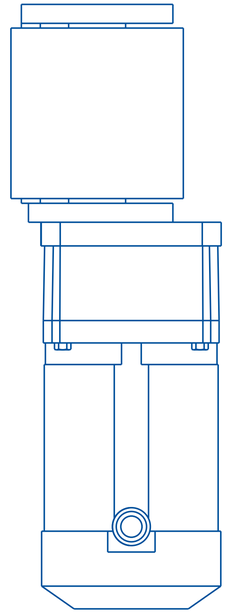
MAT'L 22358-014

22358-014









REV	DATE	DESCRIPTION	BY
A	Sep-22-25	NEW DRAWING	TAZ

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DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

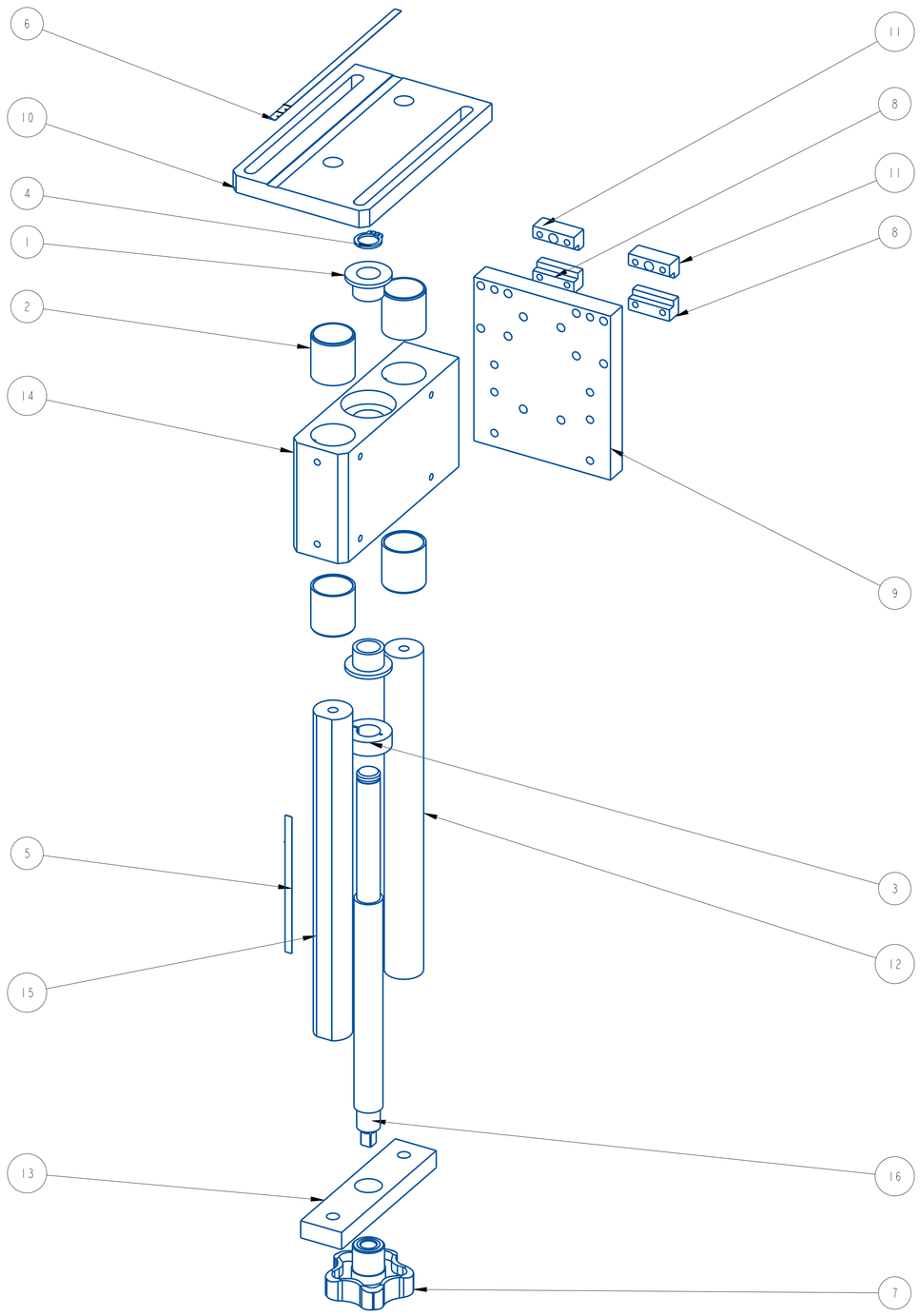
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	1/2
DATE:	Sep-22-25
DRW BY:	TAZ
CHK BY:	&CREO_CHK
APPR BY:	

4 x 18 WRAP W/V-GUIDE

MAT'L 22358-014

22358-014



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	131076-000	BEARING, FLANGED	20306-110
2	4	141193-000	SLEEVE BEARING	20306-110
3	1	361183-000	COLLAR, 3/4 ID ONE PIECE- S.S.	20306-110
4	1	791790-000	EXTERNAL RETAINING RING	20306-110
5	1	791914-002_05	MYLAR SCALE, QUADREL LOGO	20306-110
6	1	791914-002_08	MYLAR SCALE, QUADREL LOGO	20306-110
7	1	801332-000	LOBE KNOB W/ ORANGE CENTER	20306-110
8	2	A20876-000	RETAINER BLOCK	20306-110
9	1	A21031-000	CONVEYOR MOUNTING PLATE	20306-110
10	1	A21034-000	ADJUSTMENT ROD MOUNTING PLATE	20306-110
11	2	A21367-000	RETAINER BLOCK	20306-110
12	1	A21552-002	GUIDE ROD	20306-110
13	1	A21553-000	BEARING PLATE	20306-110
14	1	A21588-100	BEARING MOUNTING BLOCK	20306-110
15	1	A23903-002	GUIDE ROD WITH FLAT	20306-110
16	1	B21299-002	VERTICAL ADJ. SCREW	20306-110

REV	DATE	DESCRIPTION	BY
A	2-6-20	NEW DRAWING	ATT

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X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30°
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

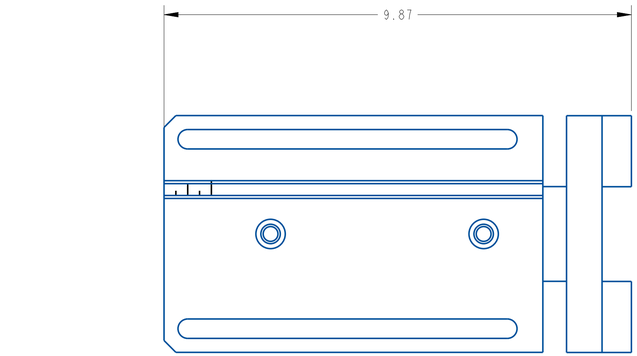
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

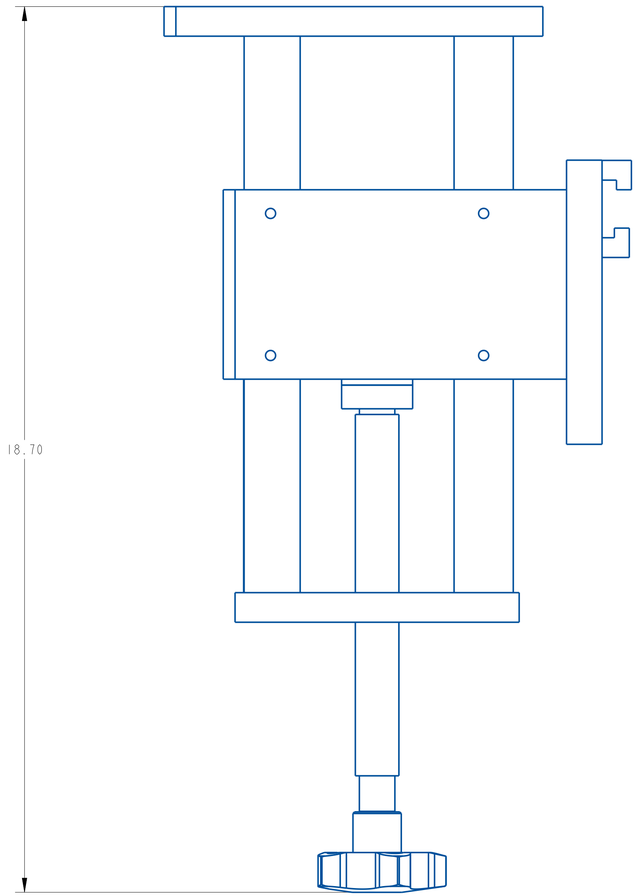
SCALE: 1/16
DATE: 2-6-20
DRW BY: ATT
CHK BY: 06/04/2024-SEM
APPR BY:

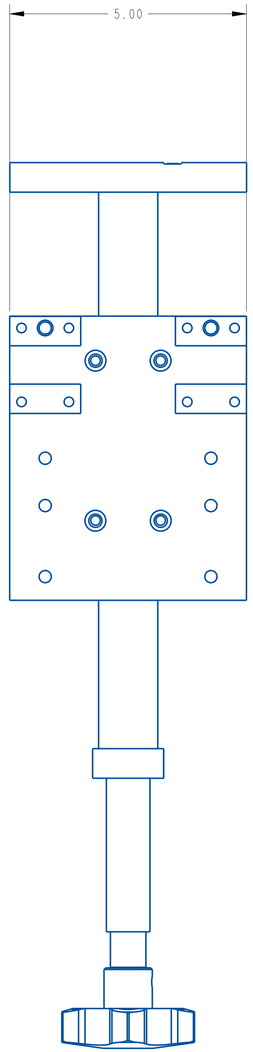
VERSALINE WRAP MOUNTING ASSEMBLY

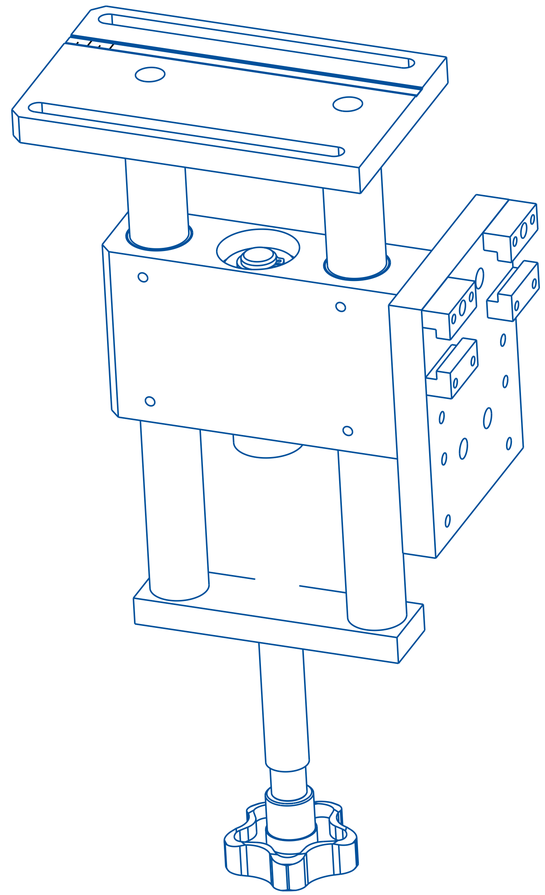
MAT'L

20306-110









REV	DATE	DESCRIPTION	BY
A	2-6-20	NEW DRAWING	ATT

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X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 5/8
DATE: 2-6-20
DRW BY: ATT
CHK BY:06/04/2024-SEM
APPR BY:

VERSALINE WRAP MOUNTING ASSEMBLY

MAT'L

20306-110

7.6 BACK UP PLATE ASSEMBLY

7.6.1 GENERAL INFORMATION

The back up plate assembly paired with the wrap station applies pressure to cylindrical containers to apply labels.

7.6.2 ADJUSTMENTS

The back up plate assembly has a variety of adjustments. To adjust vertically loosen the 2 ratchet handles in the main mounting blocks and pull up or push down. To make adjustments left or right loosen the 8 socket head bolts and slide the assembly along the black rail towards the infeed or outfeed of the conveyor.

Moving the back up plate assembly in and out is achieved by loosening the 2 ratchet handles on the top of the assembly and turning the knob clockwise or counter clockwise. To tilt the back up plate assembly to accommodate a tapered container loosen the 2 5/16-18 bolts at the end of the shafts tilt the plate as needed and retighten the bolts.

ASSEMBLY TITLE: **BACK-UP PLATE ASSEMBLY**

DRAWING NO: **21485-100**

GENERAL FUNCTION:

The back up plate assembly is mounted opposite the wrap station. The assembly provides the pressure to rotate the product plus impression of the label to the product. The back up plate must cover the entire label width and length to ensure complete impression. Certain products may require the use of different size plates to impress into recessed areas of the product.

SET-UP AND ADJUSTMENTS:

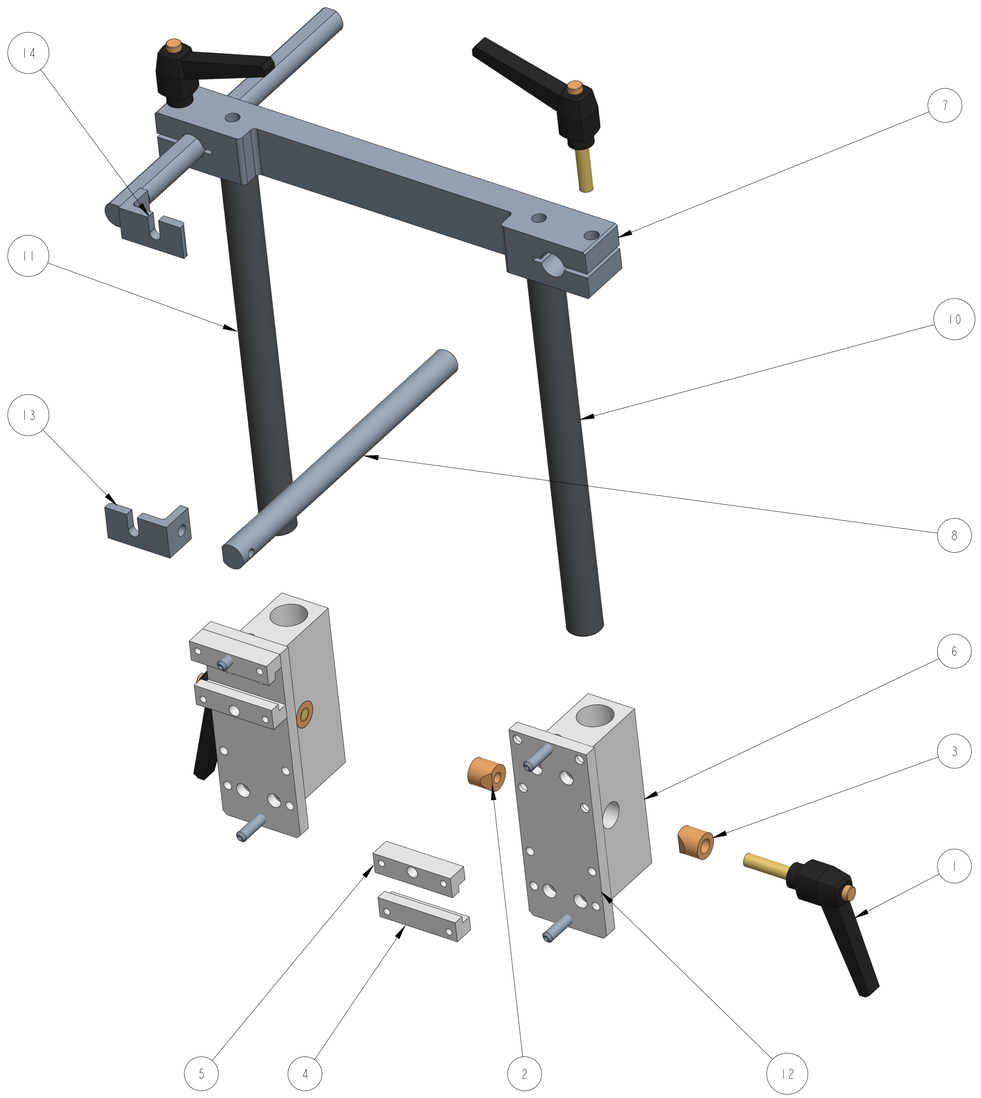
The only adjustment necessary is to ensure the horizontal pressure is sufficient to rotate the product completely and provide complete impression of the label. Place three products in wrap station area, one in the center of the wrap station, the other two at the in-feed and out-feed ends. Loosen knobs and slide backup plate close to the wrap station in order to apply light pressure to products. Retighten knobs when correct pressure is achieved.

MAINTENANCE:

- Clean all the parts that may acquire labels or glue residue.
- Exercise caution when removing bad labels from foam. Careless removal can result in torn foam which may leave the labeler inoperable until the roller is replaced.

TROUBLESHOOTING:

- none this section



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	4	801805-000	CLAMPING LEVER	21485-100
2	2	A20688-000	LOCKING CLAMP	21485-100
3	2	A20689-000	LOCKING CLAMP	21485-100
4	2	A20844-000	GUIDE RAIL CLAMP BAR	21485-100
5	2	A20845-000	GUIDE RAIL CLAMP BAR	21485-100
6	2	A21691-000	MOUNTING BLOCK	21485-100
7	1	A23474-602	DUAL HOLE TRAVEL PLATE	21485-100
8	1	A23475-000	HORIZONTAL ADJUST ROD	21485-100
9	1	A23476-000	HORIZONTAL ADJUST ROD W/ FLAT	21485-100
10	1	A23478-003	VERTICAL ADJUSTMENT ROD	21485-100
11	1	A23479-003	VERTICAL ADJUSTMENT ROD W/ FLAT	21485-100
12	2	A23483-000	MOUNTING PLATE	21485-100
13	1	A23853-010	BACK-UP MOUNTING ANGLE	21485-100
14	1	A23853-011	BACK-UP MOUNTING ANGLE	21485-100

NOT SHOWN:

C20537-036 BACK UP PLATE - 3.5" X 20"
C20537-009 BACK UP PLATE - 5" X 20"

REV	DATE	DESCRIPTION	BY
B	04-APR-2024	UPDATED DRAWING AND BOM	CRT
A	8-30-16	NEW DRAWING	TJS

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.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

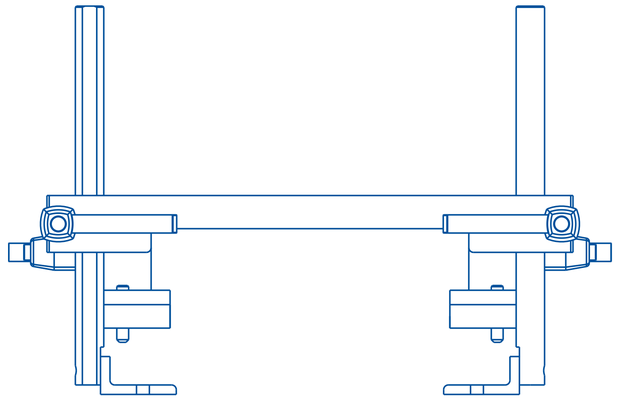
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

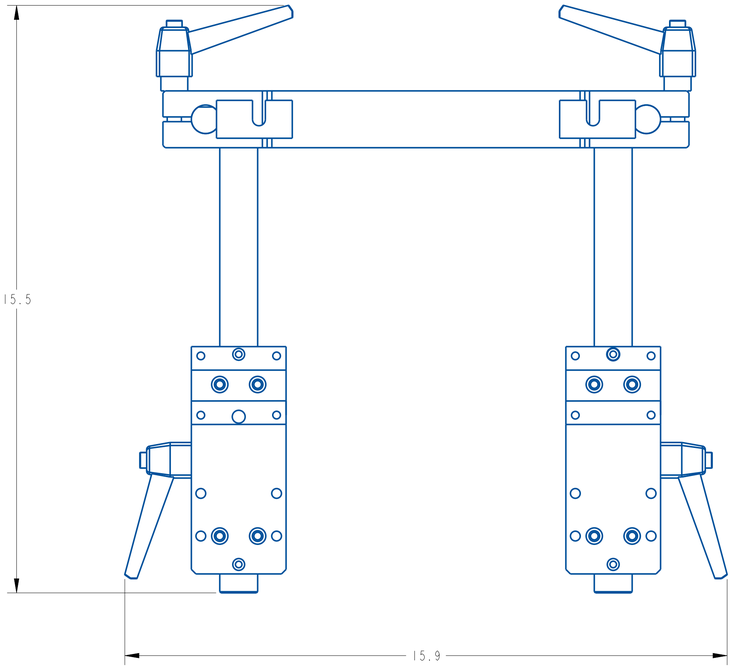
SCALE: 1/2
DATE: 8-30-16
DRW BY: TJS
CHK BY: 04/24/2024-SEM
APPR BY:

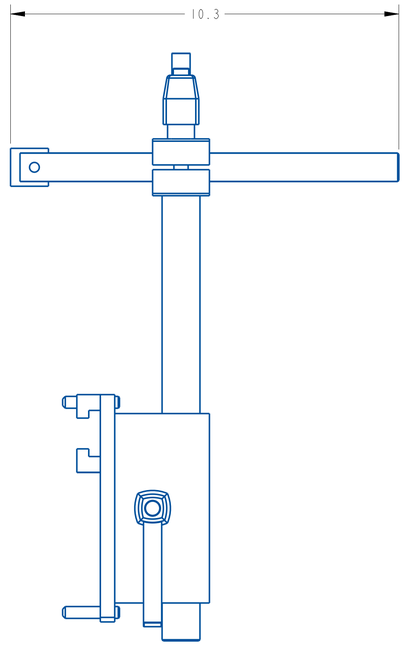
VERSALINE ADJUSTABLE BACK-UP PLATE

MAT'L 21485-100

21485-100







REV	DATE	DESCRIPTION	BY
B	04-APR-2024	UPDATED DRAWING AND BOM	CRT
A	8-30-16	NEW DRAWING	TJS

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UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

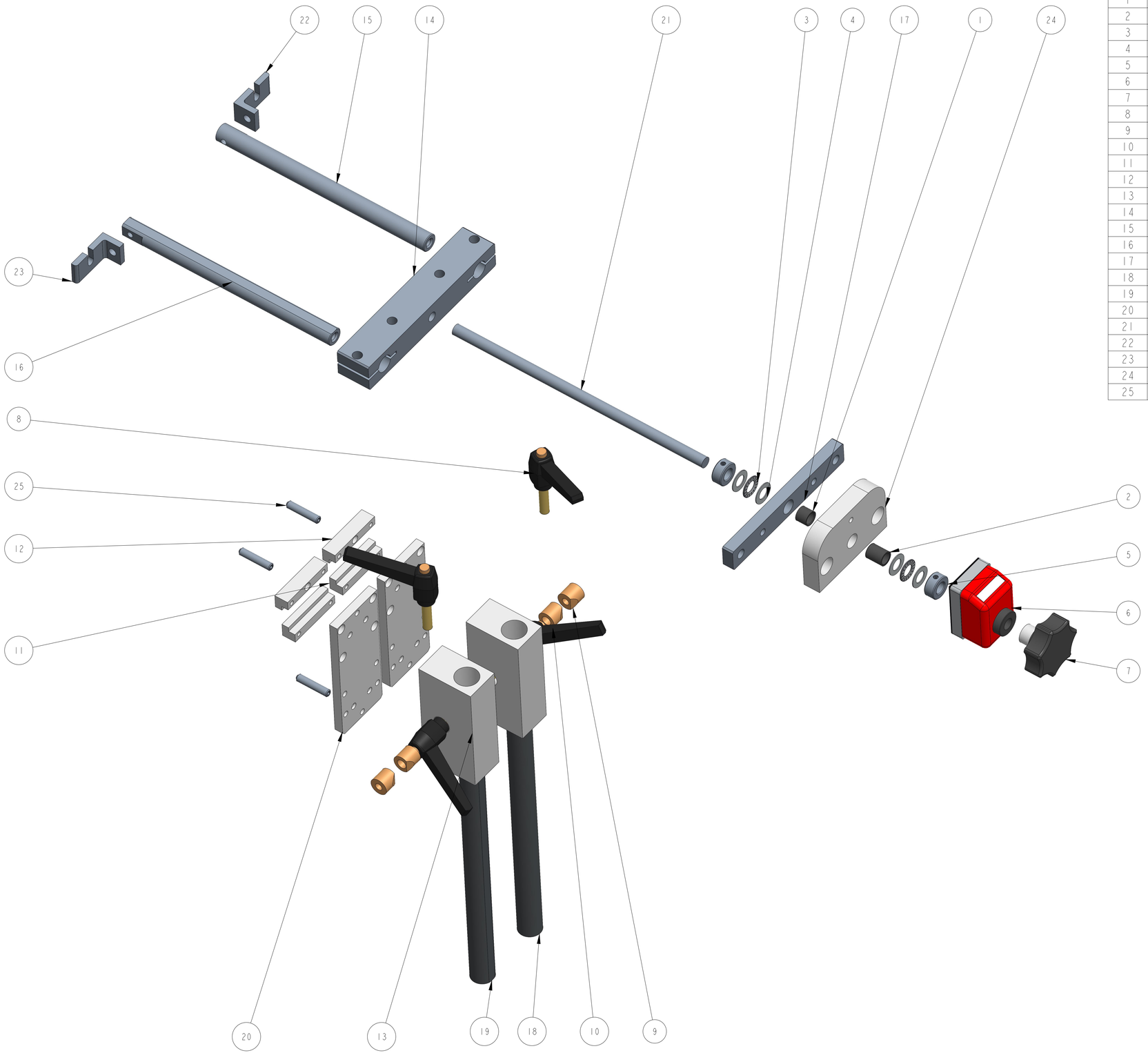
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: 8-30-16
DRW BY: TJS
CHK BY:04/24/2024-SEM
APPR BY:

VERSALINE ADJUSTABLE BACK-UP PLATE

MAT'L 21485-100

21485-100



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
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2	1	141177-000	SLEEVE BEARING, 5/80D. x 1/21D. x 3/4LNG	21485-002-S
3	2	181079-000	BEARING, NEEDLE ROLLER	21485-002-S
4	4	181080-000	BEARING, THRUST WASHER	21485-002-S
5	2	362161-000	COLLAR, SETSCREW, 1/2 IN. ID	21485-002-S
6	1	792354-000	DIGITAL POSITION INDICATOR	21485-002-S
7	1	801320-000	HAND KNOB	21485-002-S
8	4	801805-000	CLAMPING LEVER	21485-002-S
9	2	A20688-000	LOCKING CLAMP	21485-002-S
10	2	A20689-000	LOCKING CLAMP	21485-002-S
11	2	A20844-000	GUIDE RAIL CLAMP BAR	21485-002-S
12	2	A20845-000	GUIDE RAIL CLAMP BAR	21485-002-S
13	2	A21691-000	MOUNTING BLOCK	21485-002-S
14	1	A23474-000	TRAVEL PLATE	21485-002-S
15	1	A23475-000	HORIZONTAL ADJUST ROD	21485-002-S
16	1	A23476-000	HORIZONTAL ADJUST ROD W/ FLAT	21485-002-S
17	1	A23477-003	ADJUSTMENT PLATE	21485-002-S
18	1	A23478-003	VERTICAL ADJUSTMENT ROD	21485-002-S
19	1	A23479-003	VERTICAL ADJUSTMENT ROD W/ FLAT	21485-002-S
20	2	A23483-000	MOUNTING PLATE	21485-002-S
21	1	A23490-004	THREADED ROD	21485-002-S
22	1	A23853-010	BACK-UP MOUNTING ANGLE	21485-002-S
23	1	A23853-011	BACK-UP MOUNTING ANGLE	21485-002-S
24	1	B22005-012	BEARING PLATE	21485-002-S
25	4	SYE612		21485-002-S

REV	DATE	DESCRIPTION	BY
A	May-06-20	NEW DRAWING	TJS

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.X ± .1
.XX ± .01
.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

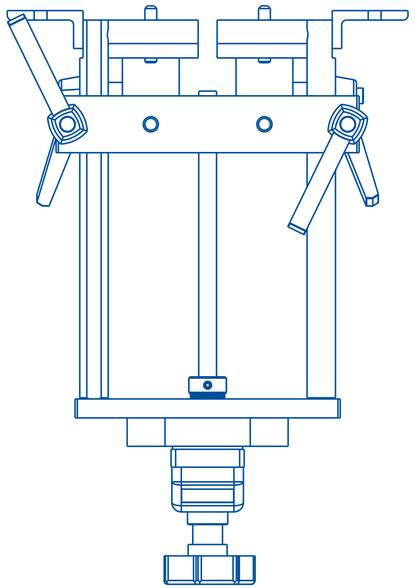
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

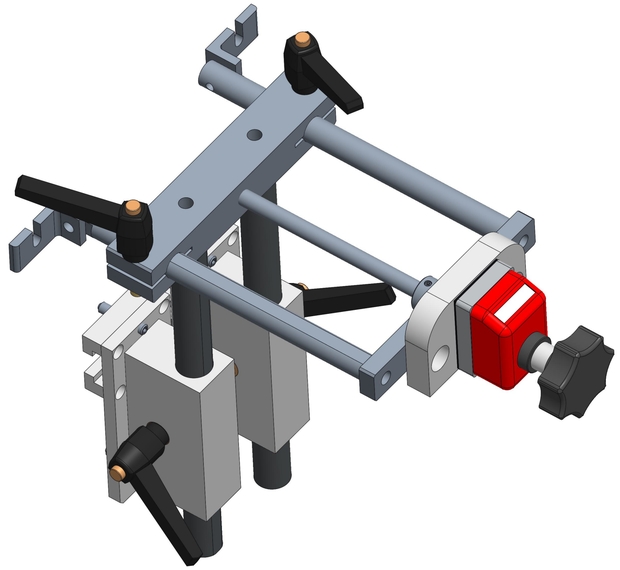
SCALE: 1/2
DATE: May-06-20
DRW BY: TJS
CHK BY: 03/09/2024-SEM
APPR BY:

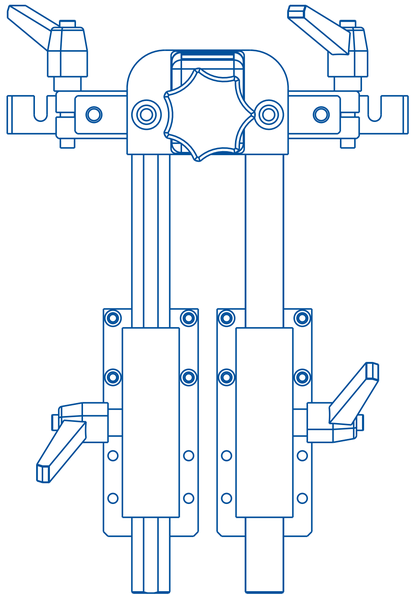
ADJUSTABLE BACK-UP PLATE ASSEMBLY W/SIKO

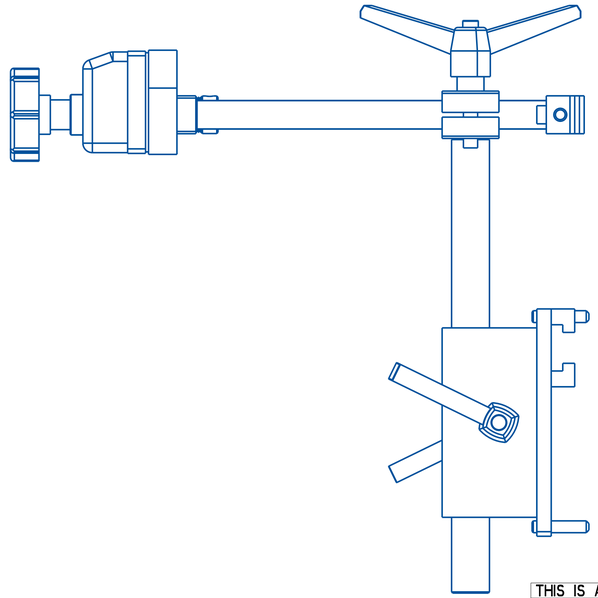
MAT'L 21485-002

21485-002-S









REV	DATE	DESCRIPTION	BY
A	May-06-20	NEW DRAWING	TJS

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DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	1/2
DATE:	May-06-20
DRW BY:	&CREO_CHK
CHK BY:	TJS
APPR BY:	

ADJUSTABLE BACK-UP PLATE ASSEMBLY W/SIKO

MAT'L
21485-002

21485-002-S

7.7 TOP HOLD DOWN ASSEMBLY

7.7.1 GENERAL INFORMATION

The top hold down module is a motor driven spring loaded belt that applies overhead pressure to the containers and enables the product to remain stable as the label is applied. This assembly is powered by an AC motor or servo motor. Ideal for front / back or single side applications.

7.7.2 ADJUSTMENTS

Adjusting the height of the top hold down is achieved by turning the hand wheel on the top of the assembly counter clockwise or clockwise.

ASSEMBLY TITLE: **TOP TRAP ASSEMBLY**

GENERAL FUNCTION:

- As a product enters the label application area near the labeling head, it needs additional support to prevent it from being upset as a label is applied. A product hold down conveyor or more commonly known as a "top trap" is used to provide product support.

  The speed of the top trap is set to match the speed of the conveyor and is encoder matched to follow conveyor speed changes.

SETUP AND ADJUSTMENTS:

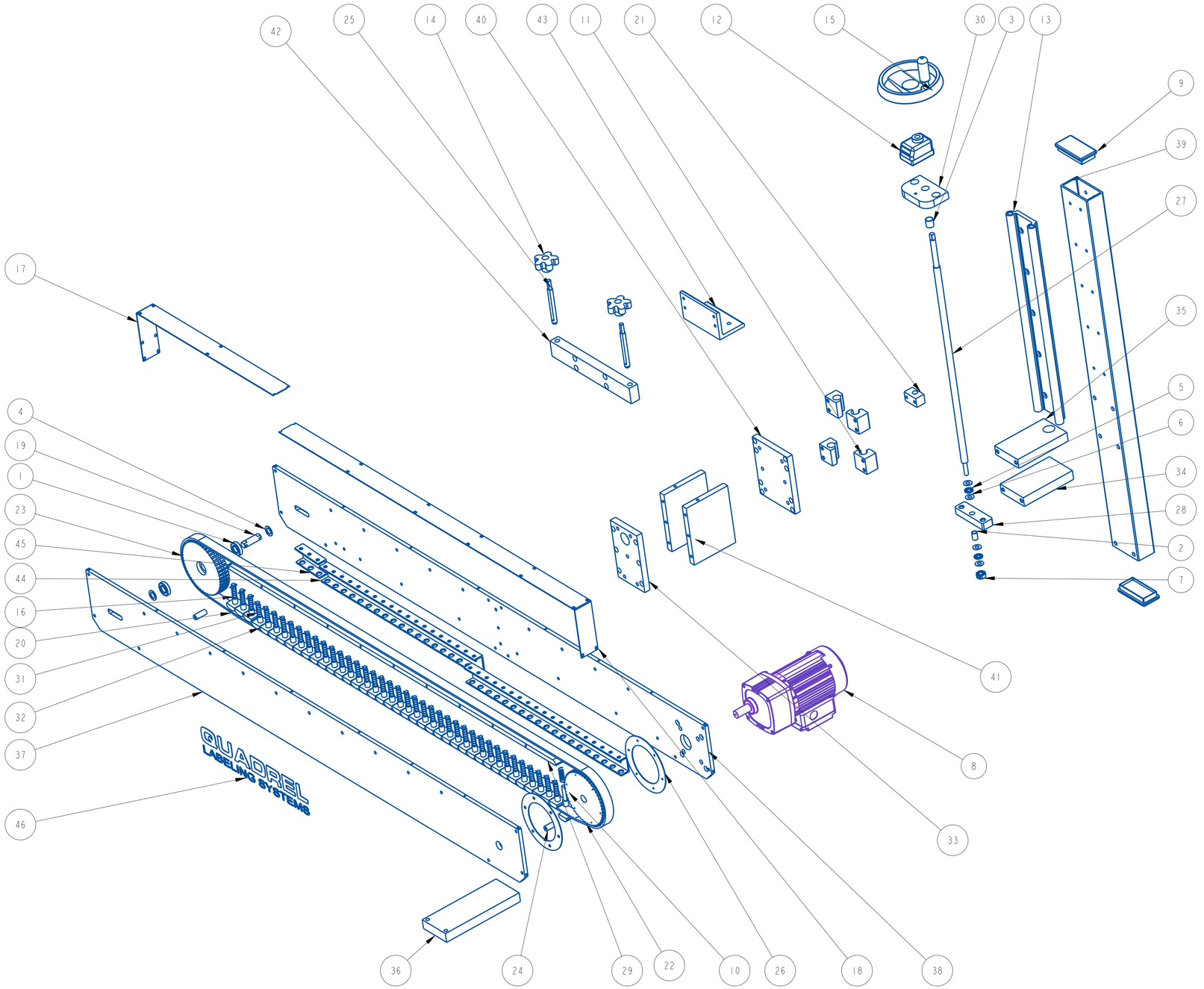
- Place the product to be labeled under the top trap. Loosen clamp lever and turn the hand wheel so that the rubber belt of the top trap compresses the product slightly.
- When the desired height is achieved, tighten the clamp lever.
- The top trap is spring loaded to accommodate products that vary in height slightly.
- Top trap belt tension can be adjusted by tightening or loosening the set screws at the infeed end of the top trap.

MAINTENANCE:

- No maintenance is required except for an occasional belt replacement.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
- Top trap jumping teeth	- Tighten top trap belt
- Too much pressure on product	- Raise top trap
- Top trap not moving	- Check drive belts and replace if broken.
- Top trap swaying under load.	- Tighten clamp lever. Tighten pulleys and shafts.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	111075-000	BEARING, BALL	22730-00R
2	1	141172-000	SLEEVE BEARING, 1/2OD. x 3/8ID. x 3/4LNG	22730-00R
3	1	141173-000	SLEEVE BEARING, 23/32OD. x 5/8ID. x 3/4LNG	22730-00R
4	2	151008-000	BEARING, THRUST WASHER	22730-00R
5	2	181108-000	BEARING, NEEDLE ROLLER	22730-00R
6	4	181111-000	THRUST WASHER	22730-00R
7	1	362186-000	COLLAR, 3/8 IN. ID ONE-PIECE CLAMP	22730-00R
8	1	413016-000	GEARMOTOR-3/8HP-57 RPM 3PHASE	22730-00R
9	2	729006-000	CAP INSERT FOR 2 X 4 TUBE	22730-00R
10	41	791975-001	R-CLIP	22730-00R
11	4	792248-001	PILLOW BLOCK	22730-00R
12	1	792354-002	DIGITAL POSITION INDICATOR	22730-00R
13	1	793035-001	DRYLIN RAIL	22730-00R
14	2	793045-000	DIAMOND KNURL KNOB	22730-00R
15	1	801080-000	6" HANDWHEEL	22730-00R
16	41	811256-000	COMPRESSION SPRING	22730-00R
17	1	A21578-040	TOP TRAP COVER PLATE	22730-00R
18	1	A21578-141	TOP TRAP COVER PLATE	22730-00R
19	1	A21823-000	IDLER SHAFT	22730-00R
20	1	A21830-600_TT	ENDLESS BELT	22730-00R
21	1	A24077-000	BRONZE NUT, RH	22730-00R
22	1	A25122-600	DRIVE PULLEY	22730-00R
23	1	A25122-602	IDLER PULLEY	22730-00R
24	2	A26053-000	SPACER	22730-00R
25	2	A26179-120	KNOB STUD	22730-00R
26	2	A26197-000	PULLEY FLANGE	22730-00R
27	1	B20045-200	THREADED ROD	22730-00R
28	1	B21346-000	BOTTOM BEARING PLATE	22730-00R
29	1	B21769-020	TOP TRAP SPACER	22730-00R
30	1	B22005-006	BEARING PLATE,	22730-00R
31	41	B22784-000	SPRING BLOCK STEM	22730-00R
32	41	B22785-000	SPRING BLOCK PLATE	22730-00R
33	1	B22790-002	TOP PACING CONNECTOR PLATE	22730-00R
34	1	B22791-010	TOP TRAP SPACER	22730-00R
35	1	B22791-011	TOP TRAP SPACER	22730-00R
36	1	B22791-012	TOP TRAP SPACER	22730-00R
37	1	C21268-141	INSIDE TOP TRAP PLATE	22730-00R
38	1	C21268-340	INSIDE TOP TRAP PLATE	22730-00R
39	1	C21292-001	TOP TRAP RISER	22730-00R
40	1	C21293-001	TOP TRAP MOUNTING PLATE	22730-00R
41	2	C21293-83516	MOUNTING PLATE	22730-00R
42	1	C21348-120	ADJUSTMENT PLATE	22730-00R
43	1	C21348-83516	ADJUSTMENT PLATE	22730-00R
44	2	D24415-000	SPRING BLOCK MOUNTING CHANNEL	22730-00R
45	1	D24415-001	SPRING BLOCK MOUNTING CHANNEL	22730-00R
46	1	QUADRELNEW2	QUADREL LOGO	22730-00R

REV	DATE	DESCRIPTION	BY
A	Sep-22-25	NEW DRAWING	TAZ

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X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

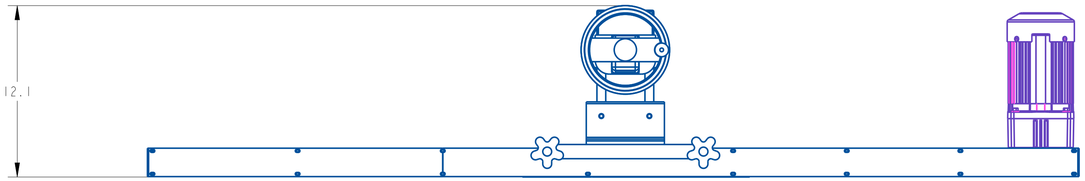
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

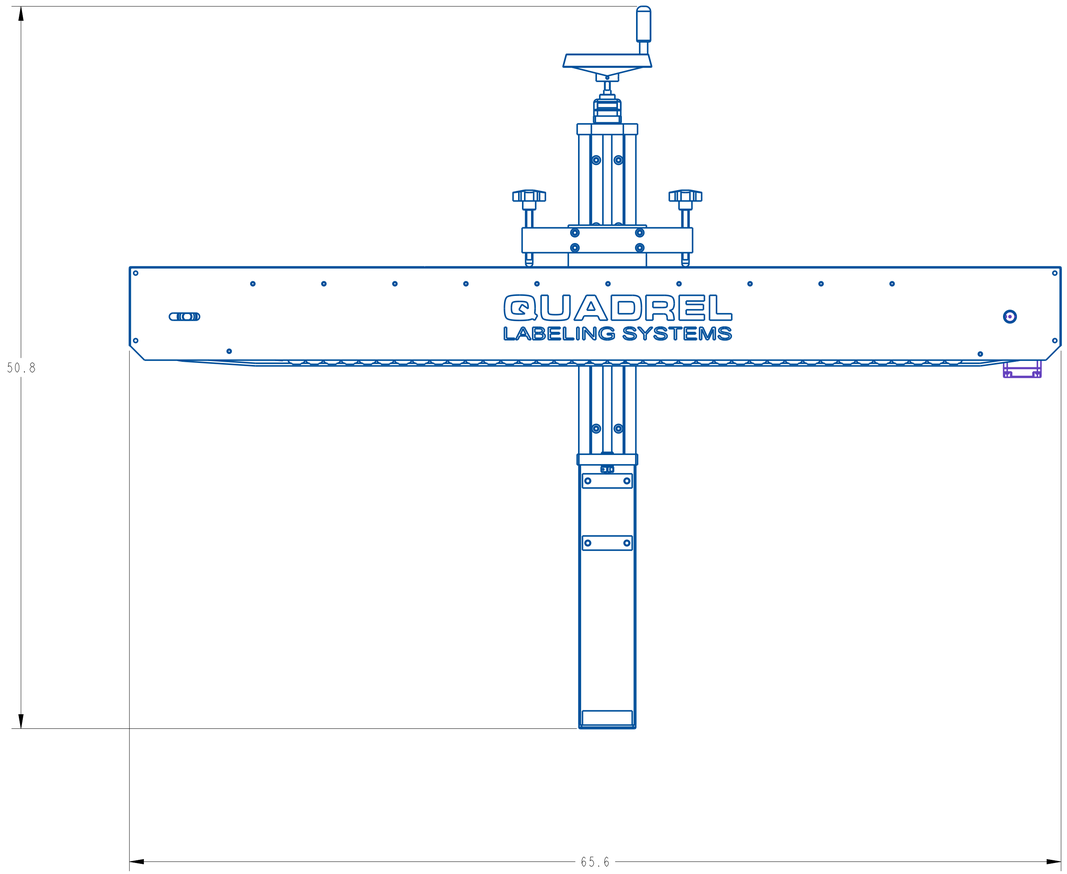
SCALE:	3/16
DATE:	Sep-22-25
DRW BY:	TAZ
CHK BY:	
APPR BY:	

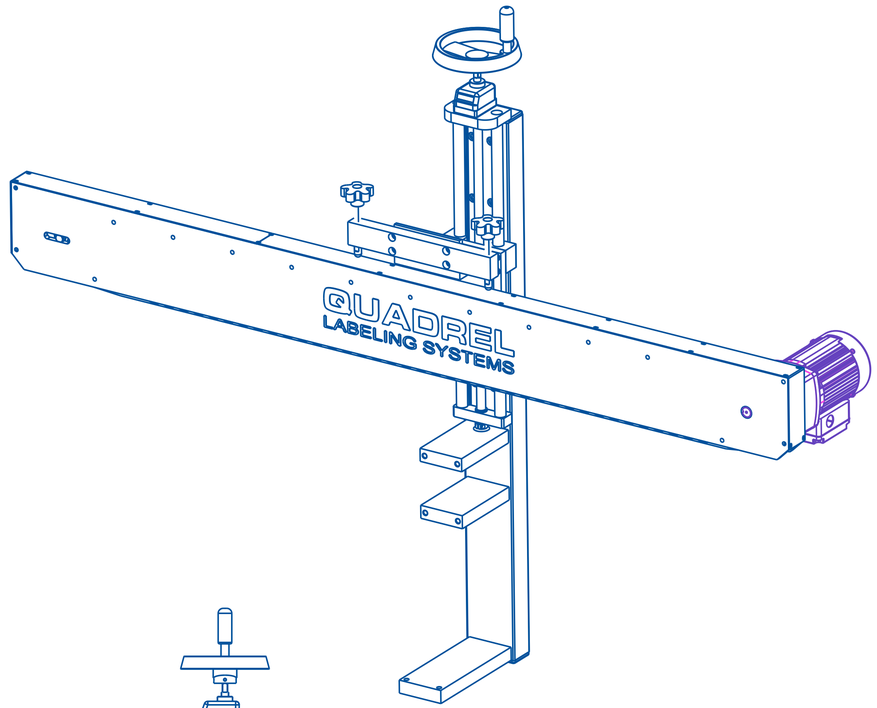
EXTENDED TOP TRAP

MAT'L 22730-00R

22730-00R







REV	DATE	DESCRIPTION	BY
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ANGLES ± 30'
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BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE:	3/16
DATE:	Sep-22-25
DRW BY:	TAZ
CHK BY:	
APPR BY:	

EXTENDED TOP TRAP

MAT'L 22730-00R

22730-00R

ASSEMBLY TITLE: **PRODUCT DETECT ASSEMBLY**

GENERAL FUNCTION:

The product detect signal is used to trigger the labeling cycle. Optimum placement and setup of the product detect sensor is critical to accurate and repeatable label placement.

SETUP AND ADJUSTMENTS:

Set the position of the product detect sensor at a point up-steam of the peel plate area. Set the vertical position of the sensor at a point on the product that provides a stable and repeatable sense area. Loosen the vertical adjustment knobs to move the assembly along the vertical axis.

Follow the manufactures data sheet for a particular set and calibration.

MAINTENANCE:

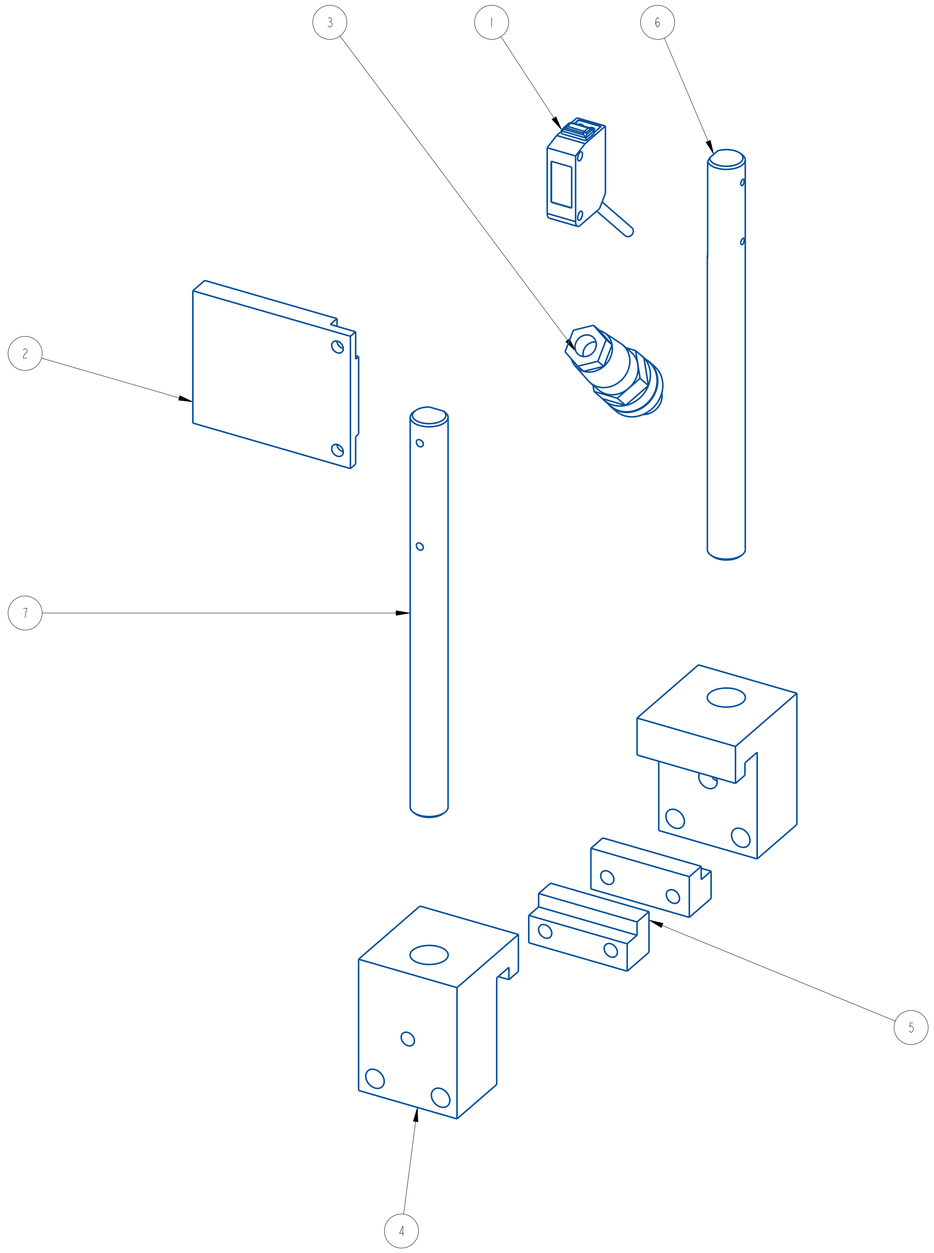
No scheduled maintenance is required for this assembly. Always keep the drive areas free of label flash and debris.

CAUTION: Before performing any maintenance or cleaning make sure the system is powered down.

TROUBLESHOOTING:

PROBLEM:	**WHAT TO DO:**
- No label trigger or intermittent trigger.	- Product does not intersect sensor scan field. Adjust sensor position until sensor detects product. - Sensor gain set is too low. Increase gain until sensor indicator displays ON status(with product in sensor field).

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	1	202192-002	CLEAR PRODUCT SENSOR	21560-012
2	1	203160-000	REFLECTOR	21560-012
3	1	252019-000	4 PIN MALE CONNECTOR	21560-012
4	2	A20875-000	RETAINER BLOCK, CONV. RAIL	21560-012
5	2	A20876-000	RETAINER BLOCK	21560-012
6	1	A24278-000	SENSOR MTG. SHAFT	21560-012
7	1	A24279-000	REFLECTOR MTG. SHAFT	21560-012



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.X ± .1
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.XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

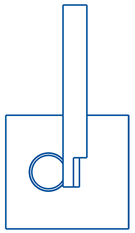
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

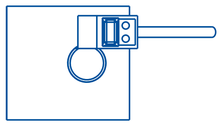
SCALE: 1/1
DATE: 07/18/2024
DRW BY: SEM
CHK BY: 07/18/2024-SEM
APPR BY:

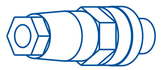
CLEAR PRODUCT DETECT, PNP

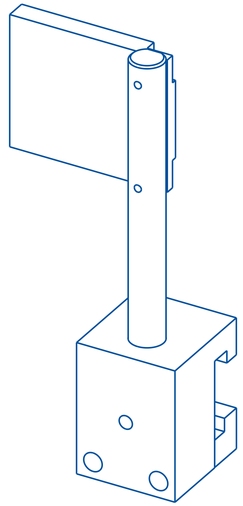
MAT'L 21560-002

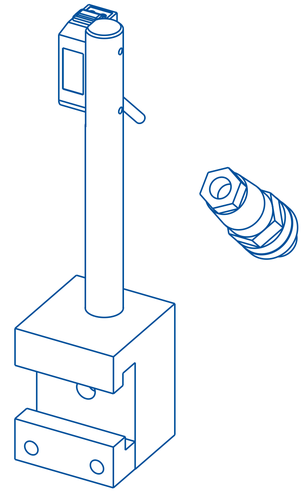
21560-012

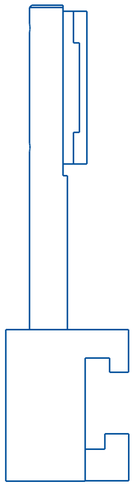


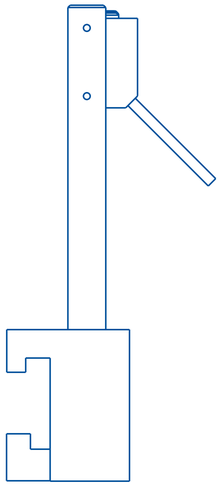


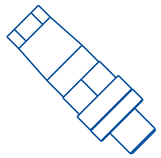


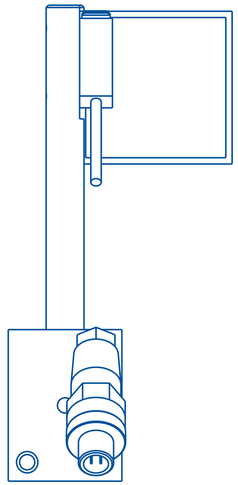












SHEET 2 OF 2

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XXX ± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/1
DATE: 07/18/2024
DRW BY: SEM
CHK BY: 07/18/2024-SEM
APPR BY:

CLEAR PRODUCT DETECT, PNP

MAT'L
21560-002

21560-012

KEYENCE

96M11227

Self-contained
Photoelectric Sensor

PZ-G Series
Instruction Manual

Read this manual thoroughly before using the product.
Keep this manual readily available for future reference.

■ Safety precautions

- Avoid running the PZ-G cable along with power and high voltage lines, as this may cause interference and/or permanent damage.
- When using a commercially available switching regulator, ground its chassis grounding and earth grounding terminals.
- Do not use in locations where direct ambient light or external light directly shines on the light receiving surface.
- With retro-reflective type sensors, when detecting highly reflective materials (such as mirrored surfaces), stabilization may be difficult. To correct this, change the angle of the sensor head, or adjust the sensitivity.
- Avoid using power which exceeds the specifications for ripple (10% max)
- Avoid using excess force when rotating the operation mode selector switch (Light-on, Dark-on) and the sensitivity adjustment trimmer.
- This product is just intended to detect the object(s). Do not use this product for the purpose to protect a human body or a part of human body.
- This product is not intended for use as explosion-proof product. Do not use this product in a hazardous location and/or potentially explosive atmosphere.

Precautions on Regulations and Standards

■ UL Certificate

This product is an UL/C-UL Listed product.

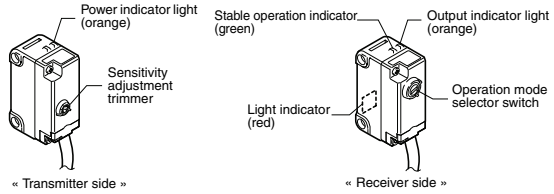
- UL File No. E301717
- Category NRKH,NRKH7
- Enclosure Type 1 (Based on UL50)

Be sure to consider the following specifications when using this product as an UL/C-UL Listed Product.

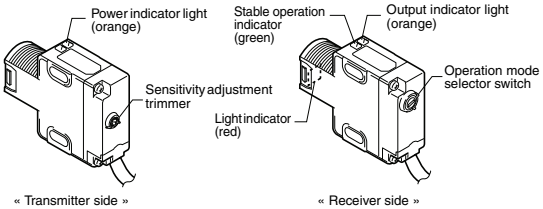
- Use the power supply with Class 2 output defined in NFPA70 (NEC: National Electrical Code).
- Power supply/ Control input/ Control output circuits shall be connected to a single Class 2 source only.
- Use with the over current protection device which is rated 30V or more and not more than 1A.

Part Names

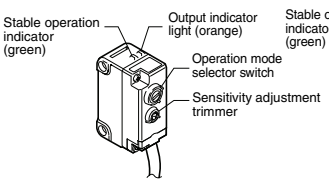
● **PZ-G5xN/G5xP**



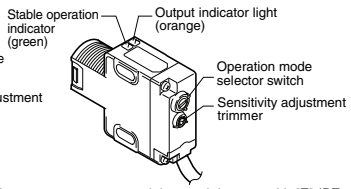
● **PZ-G5xB**



● **PZ-G4xN/G4xP/G10xN/ G10xP/G6xN/G6xP**



● **PZ-G4xB/G10xB/G6xB**

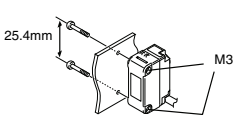


* The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

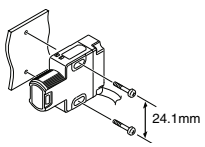
Mounting Method

■ Side Mounting (Prepare M3 screws)

Tightening torque: 0.5 N·m or less

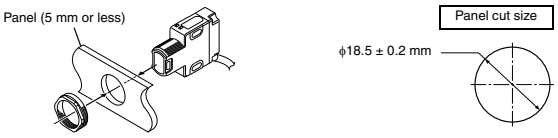


Tightening torque: 0.5 N·m or less



■ Mounting with the M18 nut (includes nut type)

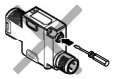
The M18 nut is also available separately as OP-84225 (2 pcs. supplied).
Tightening torque:1.0 N·m or less



Note

- Mount the M18 nut (supplied) straight in. If mounted at an angle it cannot be tightened properly.
- When tightening the M18 nut (supplied), firmly hold the main body down. The case of the main body may be damaged if held in place with a tool such as pliers.
- When tightening the M18 nut (supplied), if excess force is applied to the nut with a tool such as pliers, it may bend it out of shape. Therefore, do not apply excess force.

Sensitivity Adjustment Method

Caution ⚠	Avoid using excess force when rotating the sensitivity adjustment trimmer and operation mode selector switch as it may cause damage.	

■ Operation mode selector switch

With the operation mode selector switch, you can select either the LIGHT-ON mode (L) or the DARK-ON (D) mode.

LIGHT-ON setting

DARK-ON setting

■ Reflective type (PZ-G41/G42/G101/G102/G10R/G10G/G10B Series)

The following assumes LIGHT-ON (L) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Position target in place. Slowly rotate the sensitivity trimmer from the MIN position towards the MAX position until the (orange) output indicator turns on (Position "A"). If the output indicator does not turn off, even at MIN, then MIN is considered Position "A".	
②	Remove the target. Adjust the sensitivity trimmer from MIN towards MAX until the (orange) output indicator turns on (Position "B"). If the output indicator does not light up, the MAX position is considered Position "B".	
③	Adjust the sensitivity trimmer to the midpoint between "A" and "B". Verify that the (green) stable operation light turns on with and without a target in place.	

Reference To use the sensor in DARK-ON mode, adjust the mode selector switch to "D".

■ Thrubeam type (PZ-G51/G52 Series) / Retro-reflective type (PZ-G61/G62 Series)

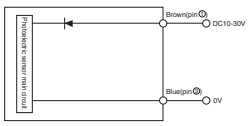
The following assumes DARK-ON (D) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Remove the target. Adjust the sensitivity trimmer to MAX. Mount the sensor heads in place so the (orange) output indicator turns off (on thrubeam models, the red light on the receiver face will turn on)	
②	Position target in place. Verify that the orange output indicator turns on (on thrubeam models, the red light on the receiver face will turn off). Adjust sensitivity lower if the output indicator does not turn on (or if the red light on the receiver face does not turn off on thrubeam models)	

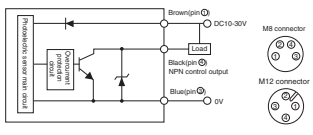
Reference To use the sensor in LIGHT-ON mode, adjust the mode selector switch to "L".

I/O Circuit Diagram

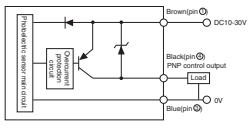
● **PZ-G5xN/G5xP/G5xB (Transmitter side)**



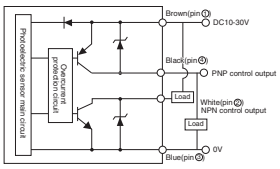
● **PZ-G5xN (Receiver side)/ G4xN/G10xN/G6xN**



● **PZ-G5xP (Receiver side)/ G4xP/G10xP/G6xP**



● **PZ-G5xB (Receiver side)/ G4xB/G10xB/G6xB**



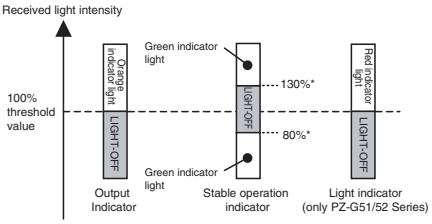
* The pin numbers represent those of the connector type / pigtail quick disconnect type. The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

PZ-GxxCN/GxxCP..... M8 connector
PZ-GxxCB/GxxEN/GxxEP..... M12 connector

■ Indicators

The following describes each ON/OFF condition of indicator when LIGHT-ON (L) is set.

Reference When the DARK-ON (D) is set, the output indicator ON/OFF will reverse.



* For PZ-G62, the upper limit is 107% and the lower limit is 93%.

If the stable operation indicator turns off during operation, readjust or fine-adjust the sensitivity.

■ Mutual interference

- For reflective type / retro-reflective type sensors, mutual interference protection can be set for up to 2 units. However, when the sensors are mounted facing each other, change the angle of the sensor head to prevent light being emitted into each unit.(The mark detection type does not include the mutual interference function.)
- Mutual interference prevention can be set when mounting a polarizing filter attachment (optional with thrubeam type sensors) (If operation is unstable even after mounting the polarizing filter, slightly lower the sensitivity.)
- For more detailed information about mutual interference or attachment, see the PZ-G Series catalog or contact your nearest KEYENCE office.

Specifications

Type			Thrubeam		Reflective				Retro-reflective		Mark detection		
Configuration	Cable shape	Output mode	Normal	High-power	Diffuse-reflective Long-detecting distance	Diffuse-reflective Short-detecting distance	Narrow-view reflective	Definite reflective	Long detecting distance (with P.R.O. function)	Transparent target detection (without P.R.O. function)	Red	Green	Blue
Rectangular	Cable	NPN	PZ-G51N	PZ-G52N	PZ-G41N	PZ-G42N	PZ-G101N	PZ-G102N	PZ-G61N	PZ-G62N	-		
		PNP	PZ-G51P	PZ-G52P	PZ-G41P	PZ-G42P	PZ-G101P	PZ-G102P	PZ-G61P	PZ-G62P			
	M8 connector	NPN	PZ-G51CN	PZ-G52CN	PZ-G41CN	PZ-G42CN	PZ-G101CN	PZ-G102CN	PZ-G61CN	PZ-G62CN	PZ-G10RCN	PZ-G10GCN	PZ-G10BCN
		PNP	PZ-G51CP	PZ-G52CP	PZ-G41CP	PZ-G42CP	PZ-G101CP	PZ-G102CP	PZ-G61CP	PZ-G62CP	PZ-G10RCP	PZ-G10GCP	PZ-G10BCP
	M12 pigtail quick disconnect	NPN	PZ-G51EN	PZ-G52EN	PZ-G41EN	PZ-G42EN	PZ-G101EN	PZ-G102EN	PZ-G61EN	PZ-G62EN	-		
		PNP	PZ-G51EP	PZ-G52EP	PZ-G41EP	PZ-G42EP	PZ-G101EP	PZ-G102EP	PZ-G61EP	PZ-G62EP			
Nut	Cable	Bipolar (NPN+PNP)	PZ-G51B	PZ-G52B	PZ-G41B	PZ-G42B	PZ-G101B	PZ-G102B	PZ-G61B	PZ-G62B			
	M12 connector		PZ-G51CB	PZ-G52CB	PZ-G41CB	PZ-G42CB	PZ-G101CB	PZ-G102CB	PZ-G61CB	PZ-G62CB			
Detecting distance*1			20 m	40 m	1 m (30 × 30 cm white mat paper)	300 mm (10 × 10 cm white mat paper)	200 mm	5 to 45 mm	0.1 to 4.2 m (when R-2L reflector is used)	0.1 to 1 m (when R-2L reflector is used)	8 to 15 mm		
Spot diameter			-	-	-	-	Approx. ϕ 5 mm (when the detecting distance is 100 mm)	Approx. ϕ 2 mm (when the detecting distance is 40 mm)	-	-	Approx. 1.5 × 4 mm (when the detecting distance is 10 mm)		
Light source (LED)			Red LED	Infrared LED × 2	Red LED					Infrared LED	Red LED	Green LED	Blue LED
Sensitivity adjustment			1-turn trimmer (230 degrees)										
Response time			500 µs								50 µs		
Operation mode			LIGHT-ON/DARK-ON, trimmer-selectable										
Indicator (LED)			Transmitter: power (orange) Receiver: output (orange), stable operation (green), light (red)		Output (orange), stable operation (green)								
Control output			Open-collector 100 mA max. (30 V max.), Residual voltage 1 V max.										
Protection circuit			Reverse-polarity protection, over-current protection, output surge absorber										
Ratings	Power voltage		10 to 30 VDC, Ripple (P-P): ±10% max, Class 2.										
	Current consumption		Transmitter: 20 mA max. Receiver: 28 mA max.	Transmitter: 25 mA max. Receiver: 28 mA max.	34 mA max.								
Environmental resistance	Enclosure rating		IEC,JEM: IP67 / NEMA: 4X,6,12 / DIN: IP69K										
	Ambient light		Incandescent lamp: 5,000 (lx) max, Sunlight: 20,000 (lx) max.										
	Ambient temperature		-20 °C to +55°C (No freezing)										
	Relative humidity		35 to 85 % RH (No condensation)										
	Vibration resistance		10 to 55 Hz, 1.5 mm double amplitude in X, Y, Z directions, 2 hours each										
	Shock resistance		1000 m/s^2 in X, Y, Z directions, 6 times each										
Interference prevention			2 units (when polarizing filter attachment is used)		2 units (with the automatic different cycle function)						-		
Material			Case, M18 nut (nut type only): reinforced glass polybutylene terephthalate (PBT), Trimmer: reinforced glass polyamide (PA) Cable (Cable type / pigtail quick disconnect type only): Polyvinyl chloride (PVC), Screw (Case connection): Steel, zinc-nickel plated, Packing (Case connection): Nitrile-butadiene rubber (NBR) Connector (pigtail quick disconnect type only): Brass-nickel plated, Polybutyleneterephtalate (PBT), Polyvinyl chloride (PVC)										
	Lens cover		Polyarylate (PAR)						Acrylic plastic (PMMA)	Polyarylate (PAR)			
Tightening torque			Rectangular type (side screw part): 0.5 N·m max. Nut type (front M18 part): 1.0 N·m max., (side slot part): 0.5 N·m max.										
Accessory*2			Instruction manual, M18 nut x 2 (nut thrubeam type), M18 nut x 1 (other nut types)										
Weight			Rectangular cable type: Approx. 60 g (Approx. 50 g for thrubeam transmitter), Rectangular M8 connector type: Approx 10 g, rectangular M12 pigtail quick disconnect type: Approx. 30 g Nut type cable type: Approx. 65 g (Approx. 55 g for thrubeam transmitter), Nut type M12 connector type: Approx 15 g										

*1 The detection distance is measured with the maximum sensitivity.
*2 The cable for the connector type / pigtail quick disconnect type is sold separately. The reflector for the retro-reflective type is sold separately.

WARRANTY

KEYENCE products are strictly factory-inspected. However, in the event of a failure, contact your nearest KEYENCE office with details of the failure.

1. WARRANTY PERIOD

The warranty period shall be for one year from the date that the product has been delivered to the location specified by the purchaser.

2. WARRANTY SCOPE

(1) If a failure attributable to KEYENCE occurs within the abovementioned warranty period, we will repair the product, free of charge. However, the following cases shall be excluded from the warranty scope.
- Any failure resulting from improper conditions, improper environments, improper handling, or improper usage other than described in the instruction manual, the user's manual, or the specifications specifically arranged between the purchaser and KEYENCE.
- Any failure resulting from factors other than a defect of our product, such as the purchaser's equipment or the design of the purchaser's software.
- Any failure resulting from modifications or repairs carried out by any person other than KEYENCE staff.
- Any failure that can certainly be prevented when the expendable part(s) is maintained or replaced correctly as described in the instruction manual, the user's manual, etc.
- Any failure caused by a factor that cannot be foreseen at a scientific/technical level at the time when the product has been shipped from KEYENCE.
- Any disaster such as fire, earthquake, and flood, or any other external factor, such as abnormal voltage, for which we are not liable.

(2) The warranty scope is limited to the extent set forth in item (1), and KEYENCE assumes no liability for any purchaser's secondary damage (damage of equipment, loss of opportunities, loss of profits, etc.) or any other damage resulting from a failure of our product.

3. PRODUCT APPLICABILITY

KEYENCE products are designed and manufactured as general-purpose products for general industries.

Therefore, our products are not intended for the applications below and are not applicable to them. If, however, the purchaser consults with us in advance regarding the employment of our product, understands the specifications, ratings, and performance of the product on their own responsibility, and takes necessary safety measures, the product may be applied. In this case, the warranty scope shall be the same as above.
- Facilities where the product may greatly affect human life or property, such as nuclear power plants, aviation, railroads, ships, motor vehicles, or medical equipment
- Public utilities such as electricity, gas, or water services
- Usage outdoors, under similar conditions or in similar environments

E 1040-1

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11227E 1070-1 96M11227
Printed in Japan

7.9 CHAIN ALIGNER ASSEMBLY

7.9.1 GENERAL INFORMATION

The chain aligner assembly is an optional module that is generally placed at the entrance of the conveyor directly before the top trap assembly. Chain aligners are primarily for oval front/back applications. This assembly centers the product on the conveyor and straightens the product to ensure label accuracy. Chain aligners are controlled with AC motors and a single AC drive located in the electrical enclosure.

7.9.2 ADJUSTMENTS

The chain aligner assembly is adjusted in and out or up and down by rotating the knobs clockwise or counter clockwise. Lock the assembly in place with the ratchet handles on the front and side of the assembly.

CAUTION

Do not make any adjustments when assembly or conveyor are running. Read and understand manual before making any adjustments.

ASSEMBLY TITLE: **CHAIN ALIGNERS**

GENERAL FUNCTION:

-Provides product alignment before label application.

SET-UP AND ADJUSTMENTS:

-VERTICAL ADJUSTMENT: Loosen clamp lever and turn adjusting rod with ratchet handle. Tighten clamp lever when desired position is obtained.

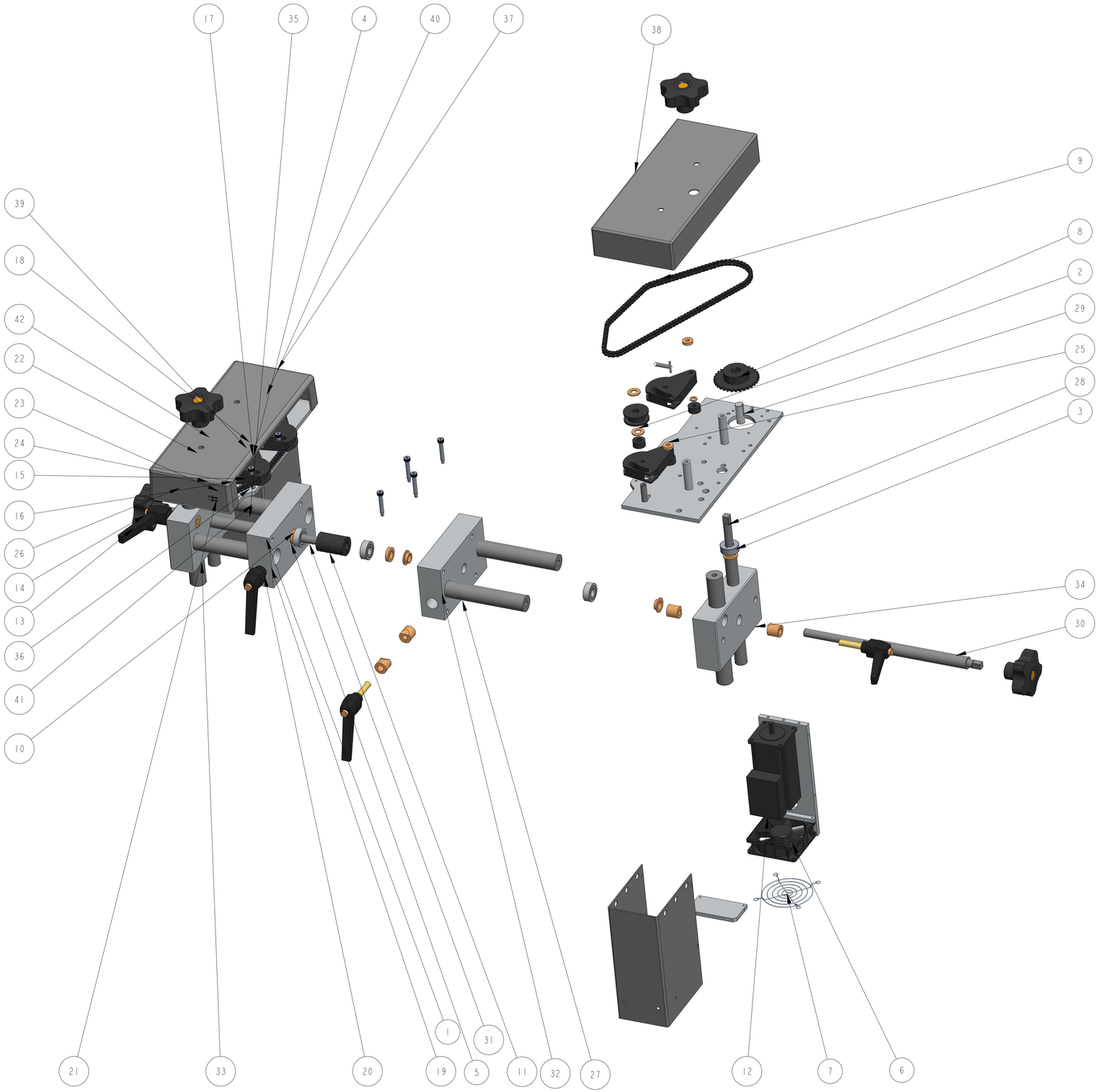
-HORIZONTAL ADJUSTMET: loosen clamp lever and turn adjusting rod with ratchet handle. Tighten clamp lever when desired position is obtained.

MAINTENANCE:

-Clean chain aligners frequently. Grease all fittings after every forty hours of operation. Use lithium grease only.

TROUBLESHOOTING:

PROBLEM	WHAT TO DO
-Products do not align	-Adjust horizontally to increase pressure on the product.
-Products will not travel through aligners.	-Adjust horizontally to apply less pressure to the product.



ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	6	131086-000	BEARING, FLANGE	20811-013
2	4	151003-000	BEARING, THRUST WASHER	20811-013
3	2	151004-000	BEARING, THRUST WASHER	20811-013
4	4	151013-000	BEARING, THRUST WASHER	20811-013
5	2	151050-000	BEARING, THRUST WASHER	20811-013
6	2	202032-000	FAN, 24V DC	20811-013
7	2	262047-000	FAN GUARD	20811-013
8	2	302052-000	SPROCKET - 25BS32HT-1/2"B-K&S	20811-013
9	2	361124-000	CHAIN, 1/4 PITCH	20811-013
10	6	361169-000	COLLAR, 1/2 IN. ID ONE-PIECE CLAMP	20811-013
11	1	361259-000	COUPLING, ONE PIECE CLAMP-ON	20811-013
12	2	413024-000	STEPPING MOTOR	20811-013
13	4	801332-000	LOBE KNOB W/ ORANGE CENTER	20811-013
14	4	801805-000	CLAMPING LEVER	20811-013
15	4	811187-000	SPRING, EXTENSION	20811-013
16	4	871116-000	ROLL PIN	20811-013
17	4	A20006-000	ROCKER ARM MOUNTING SPACER	20811-013
18	8	A20596-002	1/4 x 1-1/4 SHOULDER BOLT	20811-013
19	4	A20688-000	LOCKING CLAMP	20811-013
20	4	A20689-000	LOCKING CLAMP	20811-013
21	2	A20735-000	IDLER SHAFT	20811-013
22	4	A20736-001	GUARD SPACER	20811-013
23	2	A20737-000	IDLER SPACER	20811-013
24	2	A20738-000	IDLER PULLEY	20811-013
25	4	A20739-000	ROCKER ARM SPACER	20811-013
26	2	A21427-000	GUIDE ROD	20811-013
27	4	A21428-000	GUIDE ROD	20811-013
28	2	A21440-000	ADJUSTING SCREW	20811-013
29	2	A24555-100	ENCODER ADAPTER SHAFT	20811-013
30	1	A24656-007	ADJUSTING SCREW	20811-013
31	1	A24657-007	ADJUSTING SCREW	20811-013
32	2	A24752-011	HORIZONTAL MTG. BLOCK, CHAIN ALIGNER	20811-013
33	1	B21807-010	VERTICAL ADJUSTMENT BLOCK	20811-013
34	1	B21807-011	VERTICAL ADJUSTMENT BLOCK	20811-013
35	2	B21862-113	FAN SUPPORT	20811-013
36	2	B21862-114	FAN SUPPORT	20811-013
37	1	C20020-000	CHAIN ALIGNER GUARD	20811-013
38	1	C20020-001	CHAIN ALIGNER COVER	20811-013
39	4	C20138-000	ROCKER ARM	20811-013
40	2	C20832-100	CHAIN ALIGNER MOUNTING PLATE	20811-013
41	2	C20896-113	MOTOR COVER SIDE PLATE	20811-013
42	2	C20897-113	QI20 STEPPING MOTOR COVER	20811-013

REV	DATE	DESCRIPTION	BY
B	Feb-05-24	UPDATED DRAWING AND BOM	CRT
A	Aug-05-22	NEW DRAWING	TJS

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X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30°

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

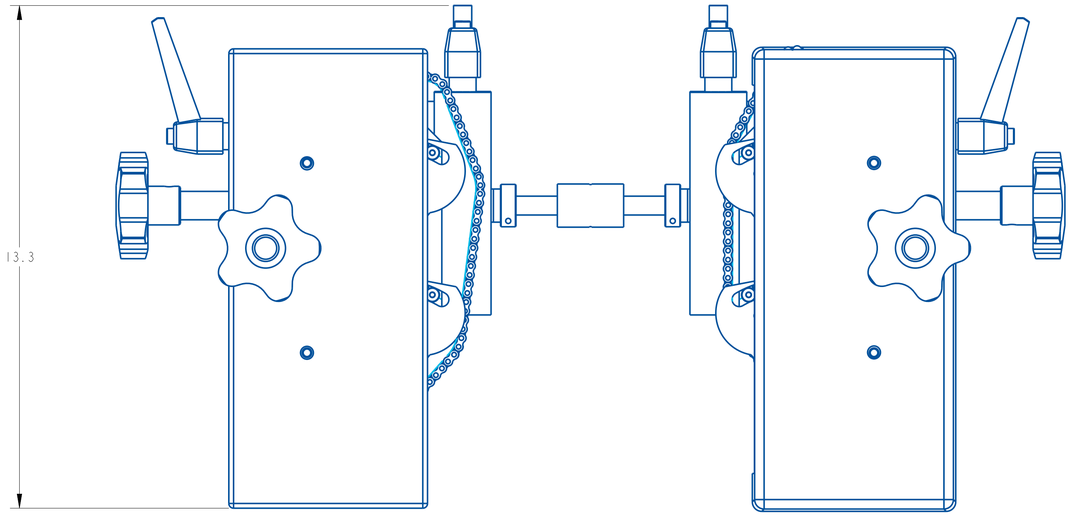
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

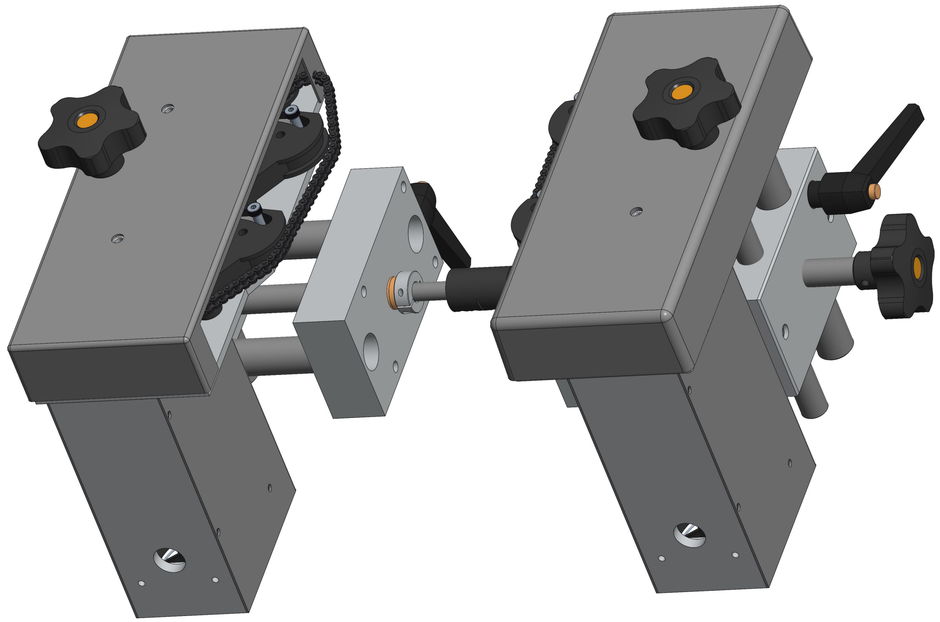
SCALE: 5/16
DATE: Aug-05-22
DRW BY: TJS
CHK BY: 03/13/2024-SEM
APPR BY:

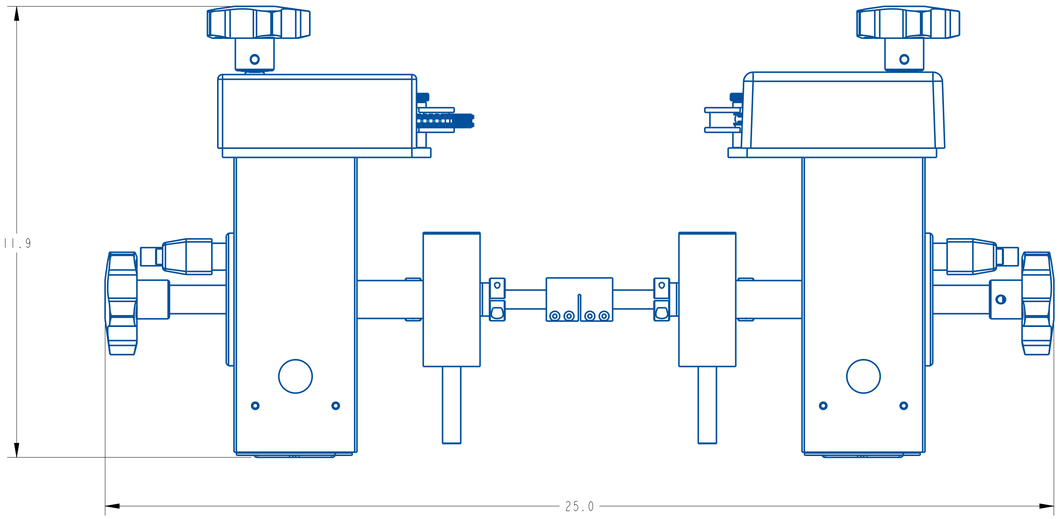
SELF POWERED CHAIN ALIGNER ASSEMBLY

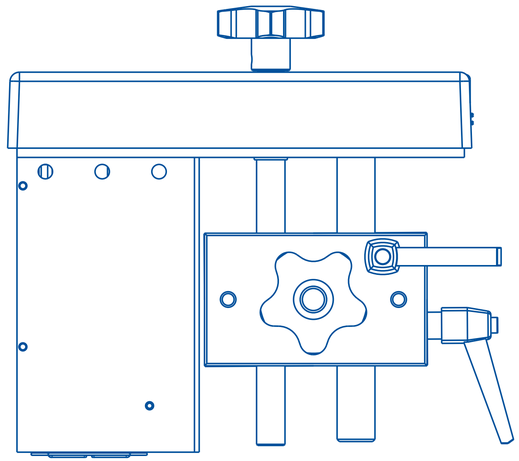
MAT'L 20811-012

20811-013









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A	Aug-05-22	NEW DRAWING	TJS

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DIMENSIONAL TOLERANCE
X ± .1
XX ± .01
XXX ± .005
ANGLES ± 30'
SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030
ALL ANGLES ARE 90°

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE: 1/2
DATE: Aug-05-22
DRW BY: TJS
CHK BY:03/13/2024-SEM
APPR BY:

SELF POWERED CHAIN ALIGNER ASSEMBLY

MAT'L

20811-013

ASSEMBLY TITLE: **INFEED / OUTFEED BANK SENSOR**

DRAWING NO.:

GENERAL FUNCTION:

- The Infeed & Outfeed bank sensors are usually used to create a bank of products into a feed or pacing screw. In some instances it is used to inhibit the flow of products if the labeler should go into a fatal fault condition, or if a sensor is used on the out feed end of the conveyor to sense a back up of products.

SET UP AND ADJUSTMENTS:

- The Infeed / Outfeed bank sensors are generally mounted to versaline rail or guide rail and can be slid back and forth by loosening the clamping blocks on the mounting plate or rail clamp. If used in conjunction with pacing or feed screws the sensors should be placed as close as possible without inhibiting the operation or change over of the screws.

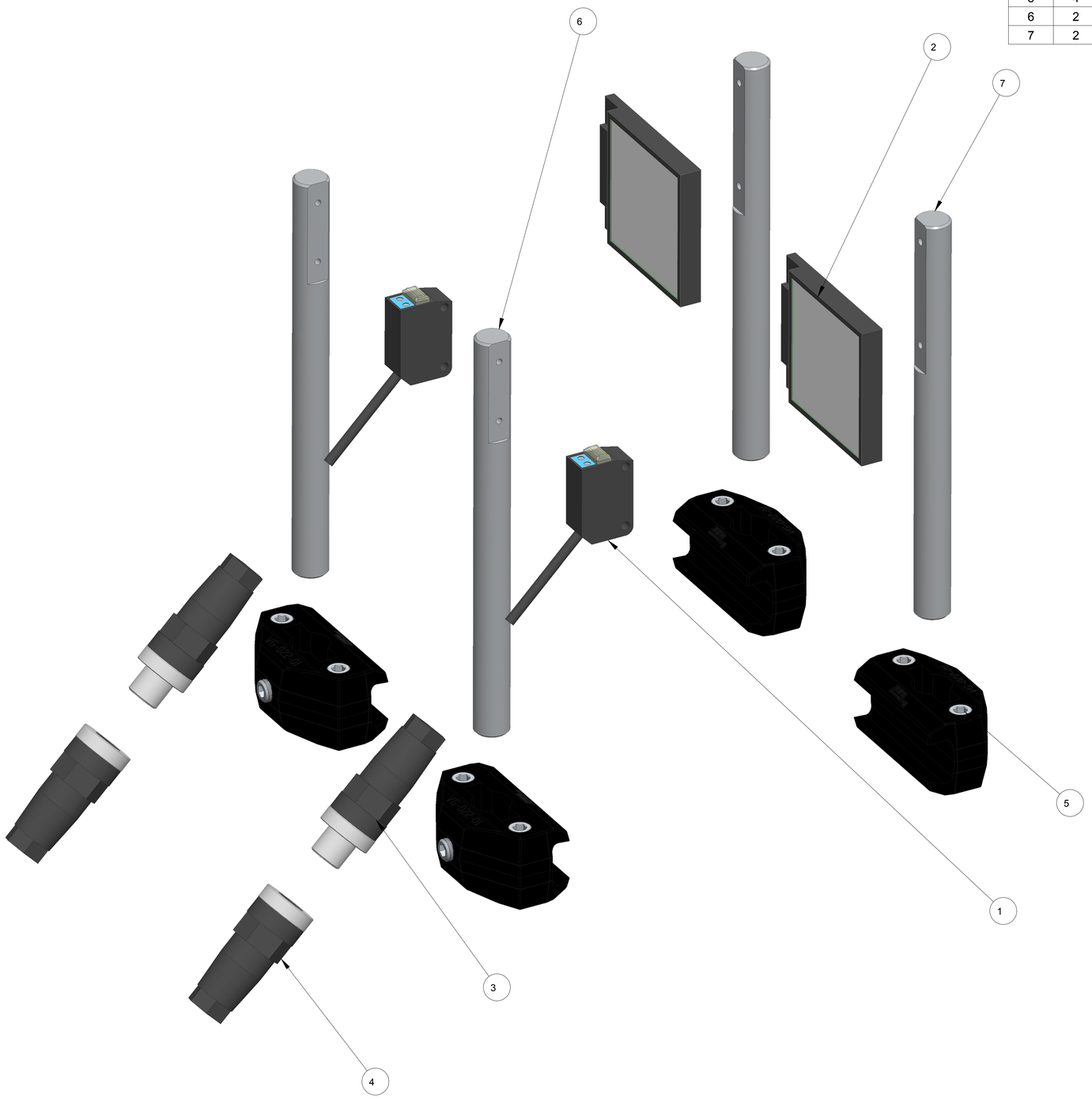
MAINTENANCE:

- Keep the sensor and reflectors clean of debris and dirt.
- Clean at regular intervals

CAUTION:

- **Before performing any maintenance or cleaning make sure the system is powered down.**

ITEM	QTY	PART NO.	DESCRIPTION	PARENT ITEM
1	2	202192-002	CLEAR PRODUCT SENSOR, PNP	22546-001
2	2	203160-000	REFLECTOR	22546-001
3	2	252019-000	4 PIN MALE CONNECTOR	22546-001
4	2	252019-001	4 PIN MALE CONNECTOR	22546-001
5	4	791460-000	GUIDE RAIL CLAMP, SENSOR MOUNT	22546-001
6	2	A24278-001	SENSOR MTG. SHAFT	22546-001
7	2	A24279-000	REFLECTOR MTG. SHAFT	22546-001



REV	DATE	DESCRIPTION	BY
A	Mar-12-20	NEW DRAWING	TJS

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UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCE

X± .1
.XX± .01
.XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

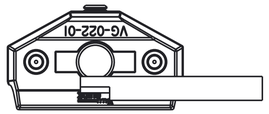
QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE	5/4
DATE	Mar-12-20
DRAWN BY	TJS

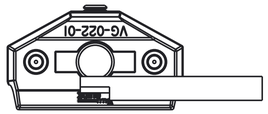
INFEED & OUTFEED BANK SENSOR ASSEMBLY

MAT'L 22546-003

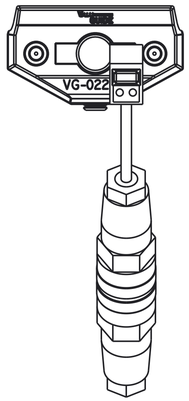
22546-003

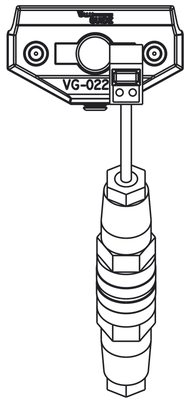


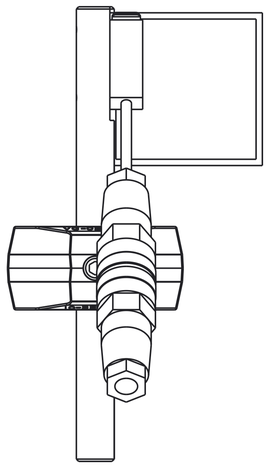
INFEED

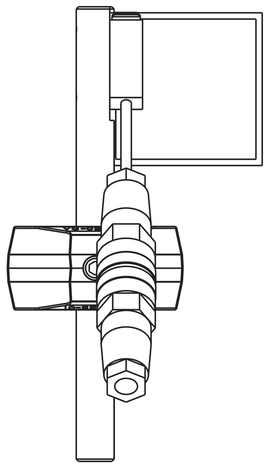


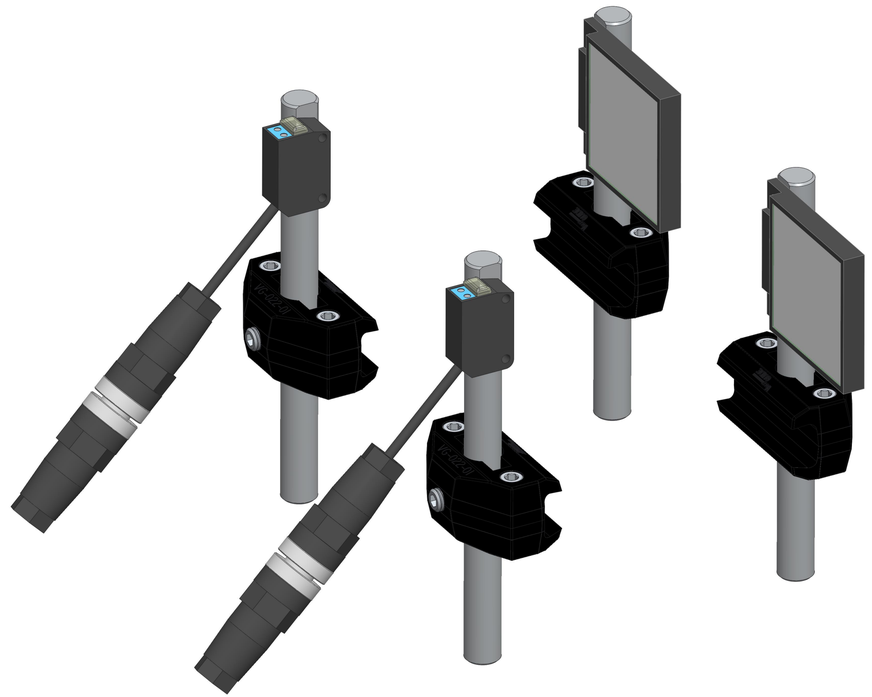
OUTFEED

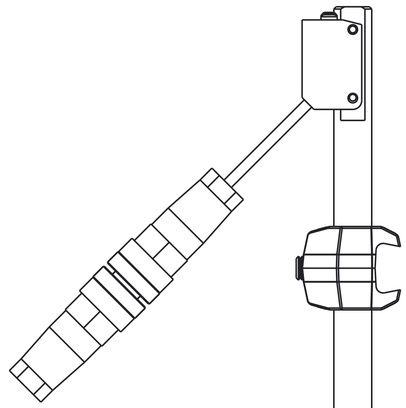


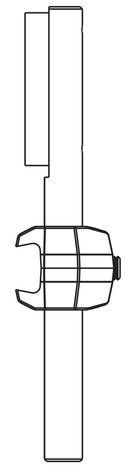












SHEET 2 OF 2

REV	DATE	DESCRIPTION	BY
A	Mar-12-20	NEW DRAWING	TJS

THIS IS A PRO-ENGINEER DOCUMENT AND MAY NOT BE MODIFIED MANUALLY

UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE

X± .1
.XX± .01
.XXX± .005
ANGLES ± 30'

SURFACE FINISH 125
BREAK ALL EDGES .005/.015
CORNER RADIUS .010/.030

QUADREL LABELING SYSTEMS
7670 JENTHER DRIVE
MENTOR, OHIO 44060
(440) 602-4700

SCALE	1/1
DATE	Mar-12-20
DRAWN BY	TJS

INFEED & OUTFEED BANK SENSOR ASSEMBLY

MAT'L		
	22546-003	22546-003

KEYENCE

96M11227

Self-contained
Photoelectric Sensor

PZ-G Series
Instruction Manual

Read this manual thoroughly before using the product.
Keep this manual readily available for future reference.

■ Safety precautions

- Avoid running the PZ-G cable along with power and high voltage lines, as this may cause interference and/or permanent damage.
- When using a commercially available switching regulator, ground its chassis grounding and earth grounding terminals.
- Do not use in locations where direct ambient light or external light directly shines on the light receiving surface.
- With retro-reflective type sensors, when detecting highly reflective materials (such as mirrored surfaces), stabilization may be difficult. To correct this, change the angle of the sensor head, or adjust the sensitivity.
- Avoid using power which exceeds the specifications for ripple (10% max)
- Avoid using excess force when rotating the operation mode selector switch (Light-on, Dark-on) and the sensitivity adjustment trimmer.
- This product is just intended to detect the object(s). Do not use this product for the purpose to protect a human body or a part of human body.
- This product is not intended for use as explosion-proof product. Do not use this product in a hazardous location and/or potentially explosive atmosphere.

Precautions on Regulations and Standards

■ UL Certificate

This product is an UL/C-UL Listed product.

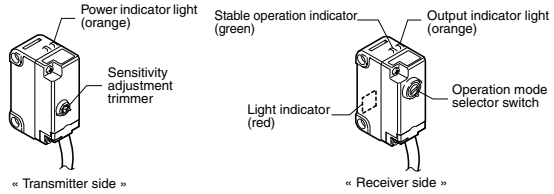
- UL File No. E301717
- Category NRKH,NRKH7
- Enclosure Type 1 (Based on UL50)

Be sure to consider the following specifications when using this product as an UL/C-UL Listed Product.

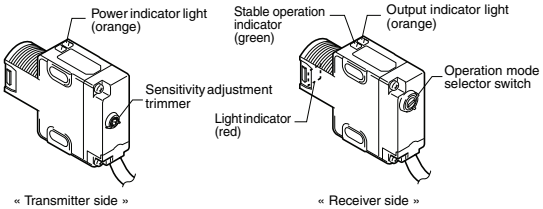
- Use the power supply with Class 2 output defined in NFPA70 (NEC: National Electrical Code).
- Power supply/ Control input/ Control output circuits shall be connected to a single Class 2 source only.
- Use with the over current protection device which is rated 30V or more and not more than 1A.

Part Names

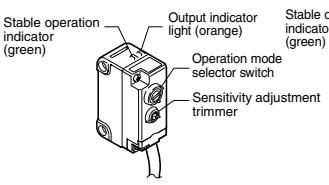
● **PZ-G5xN/G5xP**



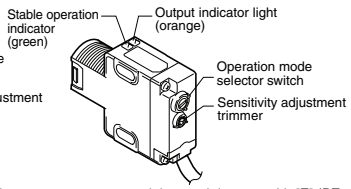
● **PZ-G5xB**



● **PZ-G4xN/G4xP/G10xN/ G10xP/G6xN/G6xP**



● **PZ-G4xB/G10xB/G6xB**

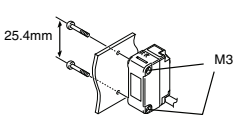


* The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

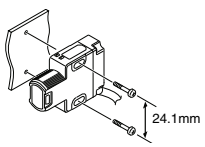
Mounting Method

■ Side Mounting (Prepare M3 screws)

Tightening torque: 0.5 N·m or less

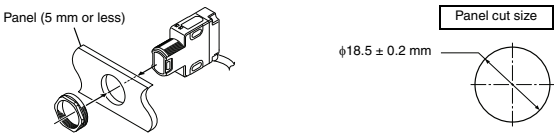


Tightening torque: 0.5 N·m or less



■ Mounting with the M18 nut (includes nut type)

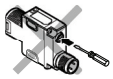
The M18 nut is also available separately as OP-84225 (2 pcs. supplied).
Tightening torque:1.0 N·m or less



Note

- Mount the M18 nut (supplied) straight in. If mounted at an angle it cannot be tightened properly.
- When tightening the M18 nut (supplied), firmly hold the main body down. The case of the main body may be damaged if held in place with a tool such as pliers.
- When tightening the M18 nut (supplied), if excess force is applied to the nut with a tool such as pliers, it may bend it out of shape. Therefore, do not apply excess force.

Sensitivity Adjustment Method

Caution ⚠	Avoid using excess force when rotating the sensitivity adjustment trimmer and operation mode selector switch as it may cause damage.	

■ Operation mode selector switch

With the operation mode selector switch, you can select either the LIGHT-ON mode (L) or the DARK-ON (D) mode.

LIGHT-ON setting

DARK-ON setting

■ Reflective type (PZ-G41/G42/G101/G102/G10R/G10G/G10B Series)

The following assumes LIGHT-ON (L) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Position target in place. Slowly rotate the sensitivity trimmer from the MIN position towards the MAX position until the (orange) output indicator turns on (Position "A"). If the output indicator does not turn off, even at MIN, then MIN is considered Position "A".	
②	Remove the target. Adjust the sensitivity trimmer from MIN towards MAX until the (orange) output indicator turns on (Position "B"). If the output indicator does not light up, the MAX position is considered Position "B".	
③	Adjust the sensitivity trimmer to the midpoint between "A" and "B". Verify that the (green) stable operation light turns on with and without a target in place.	

Reference To use the sensor in DARK-ON mode, adjust the mode selector switch to "D".

■ Thrubeam type (PZ-G51/G52 Series) / Retro-reflective type (PZ-G61/G62 Series)

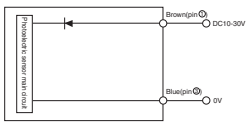
The following assumes DARK-ON (D) is set.

Sequence	Adjustment method	Sensitivity adjustment trimmer
①	Remove the target. Adjust the sensitivity trimmer to MAX. Mount the sensor heads in place so the (orange) output indicator turns off (on thrubeam models, the red light on the receiver face will turn on)	
②	Position target in place. Verify that the orange output indicator turns on (on thrubeam models, the red light on the receiver face will turn off). Adjust sensitivity lower if the output indicator does not turn on (or if the red light on the receiver face does not turn off on thrubeam models)	

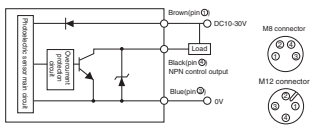
Reference To use the sensor in LIGHT-ON mode, adjust the mode selector switch to "L".

I/O Circuit Diagram

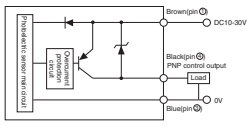
● **PZ-G5xN/G5xP/G5xB (Transmitter side)**



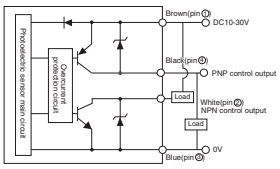
● **PZ-G5xN (Receiver side)/ G4xN/G10xN/G6xN**



● **PZ-G5xP (Receiver side)/ G4xP/G10xP/G6xP**



● **PZ-G5xB (Receiver side)/ G4xB/G10xB/G6xB**



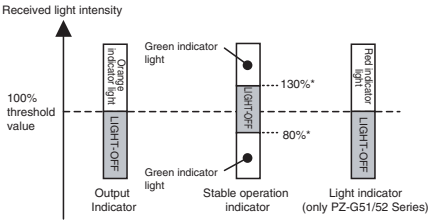
* The pin numbers represent those of the connector type / pigtail quick disconnect type. The model name with "C" (PZ-GxxCx) is the connector type, and the model name with "E" (PZ-GxxEx) is the pigtail quick disconnect type.

PZ-GxxCN/GxxCP..... M8 connector
PZ-GxxCB/GxxEN/GxxEP..... M12 connector

■ Indicators

The following describes each ON/OFF condition of indicator when LIGHT-ON (L) is set.

Reference When the DARK-ON (D) is set, the output indicator ON/OFF will reverse.



* For PZ-G62, the upper limit is 107% and the lower limit is 93%.

If the stable operation indicator turns off during operation, readjust or fine-adjust the sensitivity.

■ Mutual interference

- For reflective type / retro-reflective type sensors, mutual interference protection can be set for up to 2 units. However, when the sensors are mounted facing each other, change the angle of the sensor head to prevent light being emitted into each unit.(The mark detection type does not include the mutual interference function.)
- Mutual interference prevention can be set when mounting a polarizing filter attachment (optional with thrubeam type sensors) (If operation is unstable even after mounting the polarizing filter, slightly lower the sensitivity.)
- For more detailed information about mutual interference or attachment, see the PZ-G Series catalog or contact your nearest KEYENCE office.

Specifications

Type			Thrubeam		Reflective				Retro-reflective		Mark detection		
Configuration	Cable shape	Output mode	Normal	High-power	Diffuse-reflective Long-detecting distance	Diffuse-reflective Short-detecting distance	Narrow-view reflective	Definite reflective	Long detecting distance (with P.R.O. function)	Transparent target detection (without P.R.O. function)	Red	Green	Blue
Rectangular	Cable	NPN	PZ-G51N	PZ-G52N	PZ-G41N	PZ-G42N	PZ-G101N	PZ-G102N	PZ-G61N	PZ-G62N	-		
		PNP	PZ-G51P	PZ-G52P	PZ-G41P	PZ-G42P	PZ-G101P	PZ-G102P	PZ-G61P	PZ-G62P			
	M8 connector	NPN	PZ-G51CN	PZ-G52CN	PZ-G41CN	PZ-G42CN	PZ-G101CN	PZ-G102CN	PZ-G61CN	PZ-G62CN	PZ-G10RCN	PZ-G10GCN	PZ-G10BCN
		PNP	PZ-G51CP	PZ-G52CP	PZ-G41CP	PZ-G42CP	PZ-G101CP	PZ-G102CP	PZ-G61CP	PZ-G62CP	PZ-G10RCP	PZ-G10GCP	PZ-G10BCP
	M12 pigtail quick disconnect	NPN	PZ-G51EN	PZ-G52EN	PZ-G41EN	PZ-G42EN	PZ-G101EN	PZ-G102EN	PZ-G61EN	PZ-G62EN	-		
		PNP	PZ-G51EP	PZ-G52EP	PZ-G41EP	PZ-G42EP	PZ-G101EP	PZ-G102EP	PZ-G61EP	PZ-G62EP			
Nut	Cable	Bipolar (NPN+PNP)	PZ-G51B	PZ-G52B	PZ-G41B	PZ-G42B	PZ-G101B	PZ-G102B	PZ-G61B	PZ-G62B			
	M12 connector		PZ-G51CB	PZ-G52CB	PZ-G41CB	PZ-G42CB	PZ-G101CB	PZ-G102CB	PZ-G61CB	PZ-G62CB			
Detecting distance*1			20 m	40 m	1 m (30 × 30 cm white mat paper)	300 mm (10 × 10 cm white mat paper)	200 mm	5 to 45 mm	0.1 to 4.2 m (when R-2L reflector is used)	0.1 to 1 m (when R-2L reflector is used)	8 to 15 mm		
Spot diameter			-	-	-	-	Approx. ϕ 5 mm (when the detecting distance is 100 mm)	Approx. ϕ 2 mm (when the detecting distance is 40 mm)	-	-	Approx. 1.5 × 4 mm (when the detecting distance is 10 mm)		
Light source (LED)			Red LED	Infrared LED × 2	Red LED					Infrared LED	Red LED	Green LED	Blue LED
Sensitivity adjustment			1-turn trimmer (230 degrees)										
Response time			500 µs								50 µs		
Operation mode			LIGHT-ON/DARK-ON, trimmer-selectable										
Indicator (LED)			Transmitter: power (orange) Receiver: output (orange), stable operation (green), light (red)		Output (orange), stable operation (green)								
Control output			Open-collector 100 mA max. (30 V max.), Residual voltage 1 V max.										
Protection circuit			Reverse-polarity protection, over-current protection, output surge absorber										
Ratings	Power voltage		10 to 30 VDC, Ripple (P-P): ±10% max, Class 2.										
	Current consumption		Transmitter: 20 mA max. Receiver: 28 mA max.	Transmitter: 25 mA max. Receiver: 28 mA max.	34 mA max.								
Environmental resistance	Enclosure rating		IEC,JEM: IP67 / NEMA: 4X,6,12 / DIN: IP69K										
	Ambient light		Incandescent lamp: 5,000 (lx) max, Sunlight: 20,000 (lx) max.										
	Ambient temperature		-20 °C to +55°C (No freezing)										
	Relative humidity		35 to 85 % RH (No condensation)										
	Vibration resistance		10 to 55 Hz, 1.5 mm double amplitude in X, Y, Z directions, 2 hours each										
	Shock resistance		1000 m/s^2 in X, Y, Z directions, 6 times each										
Interference prevention			2 units (when polarizing filter attachment is used)		2 units (with the automatic different cycle function)						-		
Material			Case, M18 nut (nut type only): reinforced glass polybutylene terephthalate (PBT), Trimmer: reinforced glass polyamide (PA) Cable (Cable type / pigtail quick disconnect type only): Polyvinyl chloride (PVC), Screw (Case connection): Steel, zinc-nickel plated, Packing (Case connection): Nitrile-butadiene rubber (NBR) Connector (pigtail quick disconnect type only): Brass-nickel plated, Polybutyleneterephtalate (PBT), Polyvinyl chloride (PVC)										
	Lens cover		Polyarylate (PAR)						Acrylic plastic (PMMA)	Polyarylate (PAR)			
Tightening torque			Rectangular type (side screw part): 0.5 N·m max. Nut type (front M18 part): 1.0 N·m max., (side slot part): 0.5 N·m max.										
Accessory*2			Instruction manual, M18 nut x 2 (nut thrubeam type), M18 nut x 1 (other nut types)										
Weight			Rectangular cable type: Approx. 60 g (Approx. 50 g for thrubeam transmitter), Rectangular M8 connector type: Approx 10 g, rectangular M12 pigtail quick disconnect type: Approx. 30 g Nut type cable type: Approx. 65 g (Approx. 55 g for thrubeam transmitter), Nut type M12 connector type: Approx 15 g										

*1 The detection distance is measured with the maximum sensitivity.
*2 The cable for the connector type / pigtail quick disconnect type is sold separately. The reflector for the retro-reflective type is sold separately.

WARRANTY

KEYENCE products are strictly factory-inspected. However, in the event of a failure, contact your nearest KEYENCE office with details of the failure.

1. WARRANTY PERIOD

The warranty period shall be for one year from the date that the product has been delivered to the location specified by the purchaser.

2. WARRANTY SCOPE

(1) If a failure attributable to KEYENCE occurs within the abovementioned warranty period, we will repair the product, free of charge. However, the following cases shall be excluded from the warranty scope.
- Any failure resulting from improper conditions, improper environments, improper handling, or improper usage other than described in the instruction manual, the user's manual, or the specifications specifically arranged between the purchaser and KEYENCE.
- Any failure resulting from factors other than a defect of our product, such as the purchaser's equipment or the design of the purchaser's software.
- Any failure resulting from modifications or repairs carried out by any person other than KEYENCE staff.
- Any failure that can certainly be prevented when the expendable part(s) is maintained or replaced correctly as described in the instruction manual, the user's manual, etc.
- Any failure caused by a factor that cannot be foreseen at a scientific/technical level at the time when the product has been shipped from KEYENCE.
- Any disaster such as fire, earthquake, and flood, or any other external factor, such as abnormal voltage, for which we are not liable.

(2) The warranty scope is limited to the extent set forth in item (1), and KEYENCE assumes no liability for any purchaser's secondary damage (damage of equipment, loss of opportunities, loss of profits, etc.) or any other damage resulting from a failure of our product.

3. PRODUCT APPLICABILITY

KEYENCE products are designed and manufactured as general-purpose products for general industries.

Therefore, our products are not intended for the applications below and are not applicable to them. If, however, the purchaser consults with us in advance regarding the employment of our product, understands the specifications, ratings, and performance of the product on their own responsibility, and takes necessary safety measures, the product may be applied. In this case, the warranty scope shall be the same as above.
- Facilities where the product may greatly affect human life or property, such as nuclear power plants, aviation, railroads, ships, motor vehicles, or medical equipment
- Public utilities such as electricity, gas, or water services
- Usage outdoors, under similar conditions or in similar environments

E 1040-1

KEYENCE CORPORATION

1-3-14, Higashi-Nakajima, Higashi-Yodogawa-ku,
Osaka, 533-8555, Japan
PHONE: +81-6-6379-2211 www.keyence.com

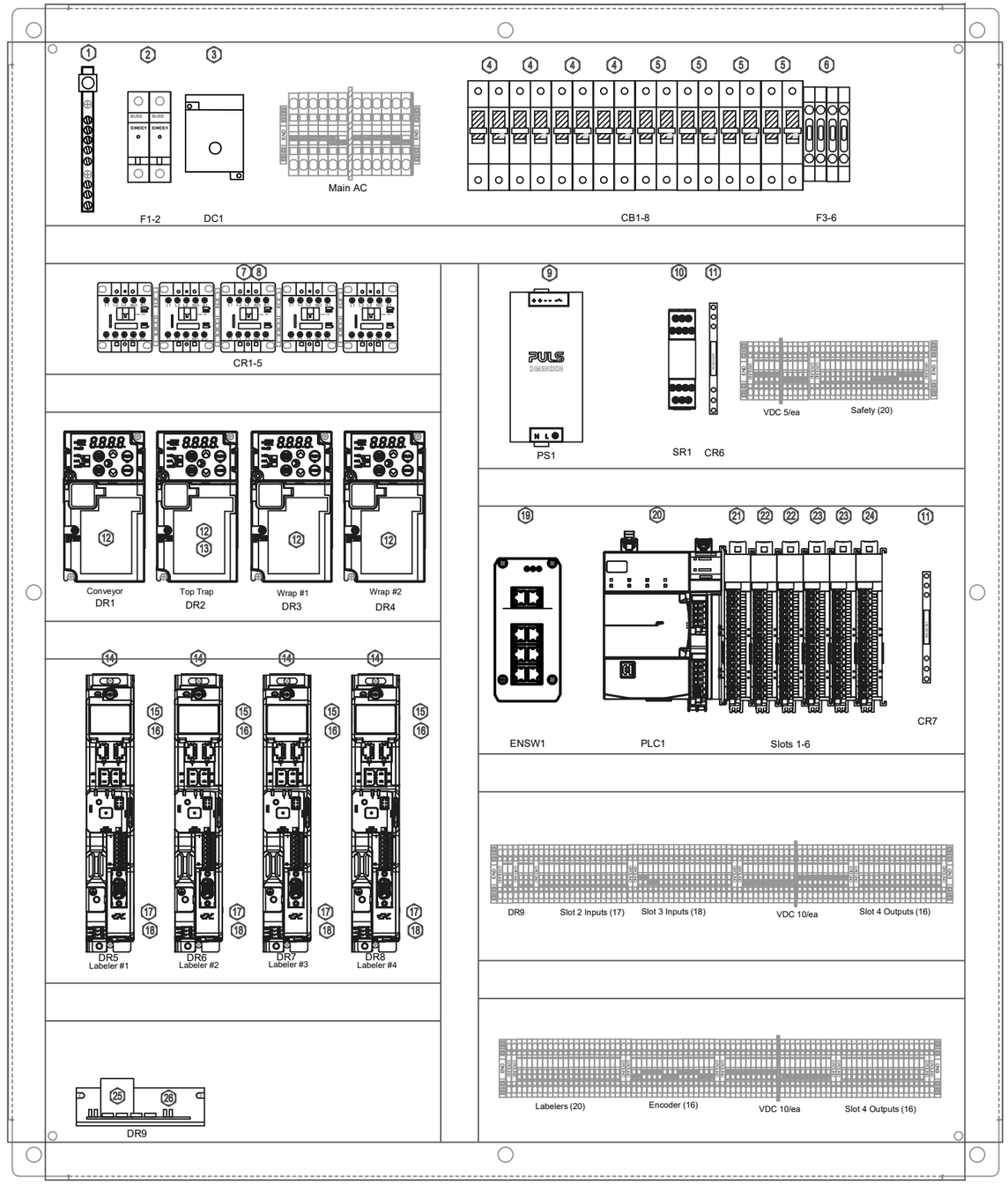
11227E 1070-1 96M11227
Printed in Japan


Electronics

42P36

--	222266-001	1	Enclosure, 42EL3612
--	222268-001	1	Panel, SCE-42P36
--	241213-000	2	Fuse, 25A, CC
--	251855-000	6	2-Pole Jumper
--	251856-000	4	3-Pole Jumper
--	251858-000	2	5-Pole Jumper
--	251859-000	4	10-Pole Jumper
--	251798-000	4	Partition Plate
--	251799-000	3	End Cover
--	251795-000	16	Phoenix Contact End Terminal
--	251854-000	25	Phoenix Contact Ground Terminal, ST1.5
--	251853-000	150	Phoenix Contact Terminal Block, ST1.5
--	251837-000	1	End Cover, ST4
--	251850-000	2	5 Pole Jumper, ST4
--	251815-000	12	Phoenix Contact Terminal Block, ST4
--	262822-001	1	Ethernet Cable, 3 ft
--	262822-006	5	Ethernet Cable, 2 ft
--	241053-000	2	Fuse, 3A, 1.25 x .25
--	241060-000	2	Fuse, 5A, 1.25 x .25
--	241213-000	2	Fuse, 25A, CC

26	263824-000	1	Connector, 2 Pin, DC Inhibit
25	411457-000	1	Minarik MM23001C Drive, DC
24	221620-001	1	Analog Output Module, 5069-OF4
23	221486-001	2	Output Expansion Module, 5069-OB16
22	221489-001	2	Input Expansion Module, 5069-IB16
21	221545-001	1	High Speed Counter Module, 5069-HSC2XOB4
20	221616-005	1	PLC, AB CompactLogix 5069-L306ER
19	221683-000	1	Ethernet Switch, 8 Port
18	412410-002	4	DB44 Cable, Female, for IO Plus
17	411902-001	4	IO 24 Plus Module
16	411902-000	4	PTi Module
15	411901-000	4	Option Card Mounting Kit
14	411900-000	4	Servo Drive, Digitax HD M750 3.5A (E171230)
13	411458-004	1	AC Drive Encoder Card
12	411458-003	4	AC Drive, Frenic ACE, 1 HP
11	202628-000	2	Relay, 24V, SPDT
10	221650-005	1	Phoenix 1301402 Safety Relay
9	211540-003	1	Power Supply, 24V, 10A
8	202607-000	4	Altech Contactor Surge Suppressor
7	202604-000	4	Altech Contactor GMD-12M-10-24V
6	251788-001	4	Fuse Holder, 1.25 x .25
5	241116-001	4	Circuit Breaker, 2 Pole, 10A
4	241319-001	4	Circuit Breaker, 2 Pole, 6A
3	272117-003	1	Non-Fused Disconnect, 25A
2	241285-001	2	Fuse Holder, CC
1	251830-002	1	Ground Bar
NO.	PART NO.	QTY	DESCRIPTION



1" Wireway Unless Noted
Component Hardware: 8-32 SHCS
Wireway/Din Rail Hardware: 8-32 BHCS

UNLESS OTHERWISE SPECIFIED
DIMENSIONAL TOLERANCE
X.± .XTOL
XX.± .XXTOL
XXX.± .XXXTOL
ANGLES ± ANGTOL
SURFACE FINISH FINISHTOL
BREAK ALL EDGES .005/.015

QUADREL LABELING SYSTEMS
7670 Jenther Drive
Mentor, Ohio 44060
(440) 602-4700

SCALE: 1:1
DATE: 11SEP2025
DRAWN BY: CMT
REVISED:

Layout, Custom Techline

MAT'L 84219F-000

B84219-000P

TECHLINE LABELING SYSTEM
220VAC, 25A
COMPACTLOGIX PLC
NIDEC SERVO DRIVES
FUJI INVERTERS

Page Listing:

WIRE SIZE/COLOR TABLE (UNLESS OTHERWISE NOTED)

120,240VAC:14AWG BLACK

24VDC/SIGNAL: 18AWG BLUE
0VDC: 18AWG WHITE/BLUE

EARTH GROUND WIRES: 14 AWG GREEN/YELLOW
AC MOTOR WIRES: 4-16AWG

: Terminal Block

: 2 Jumpered Terminal Blocks

: 3 Jumpered Terminal Blocks, etc

QUADREL
LABELING SYSTEMS
7670 JENTHER DR.
MENTOR, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: TECHLINE LABELING SYSTEM

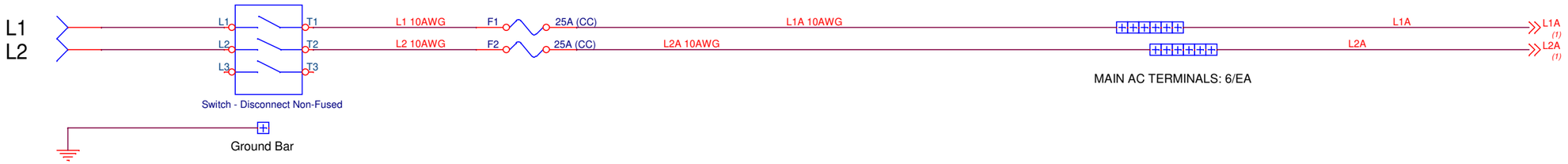
Schematic #: SB84219-000

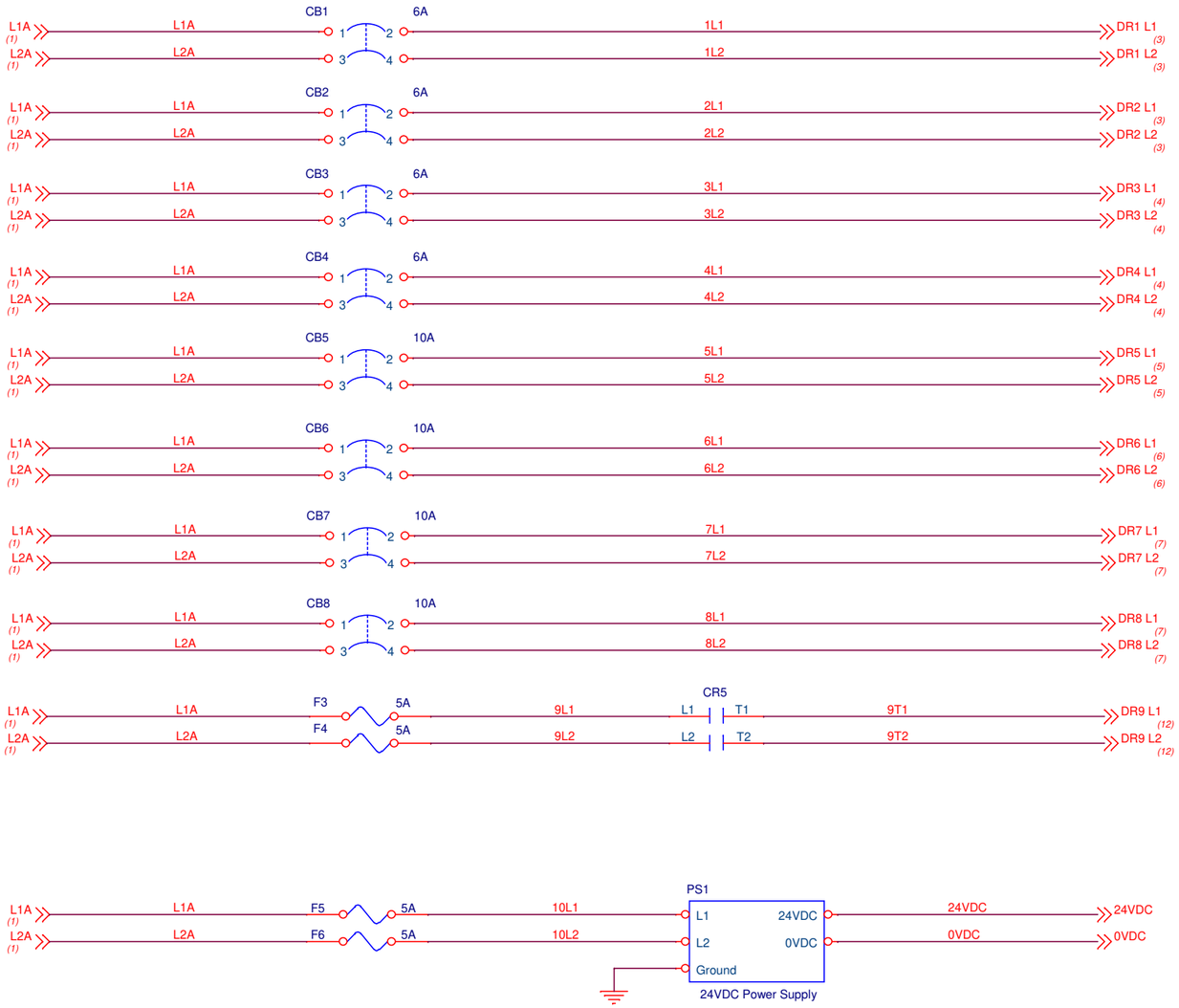
Rev: -

Date: Tuesday, November 04, 2025

220VAC , 25AMP

Main AC
Page 1





COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: MAIN AC DISTRIBUTION

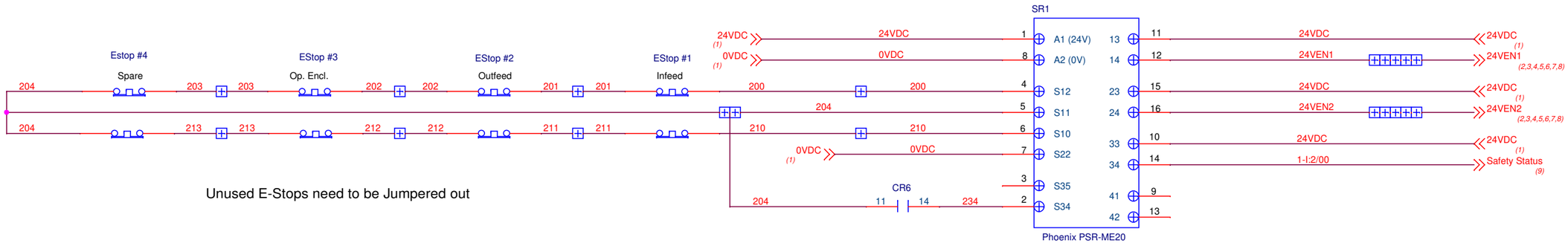
Schematic # SB84219-000

Rev -

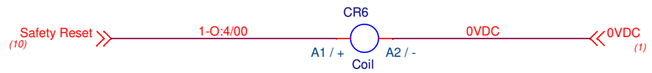
Date: Tuesday, November 04, 2025

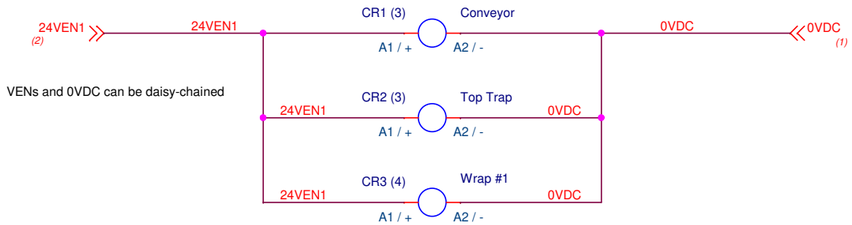
Sheet 1 of 13

Safety Relay
Page 2

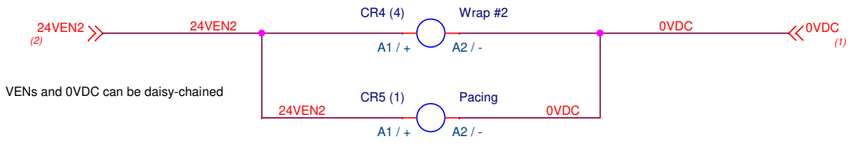


Unused E-Stops need to be Jumpered out

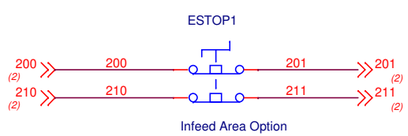




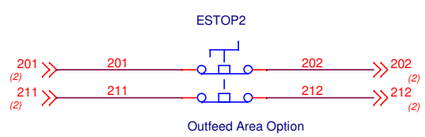
VENs and 0VDC can be daisy-chained



VENs and 0VDC can be daisy-chained



Infeed Area Option



Outfeed Area Option

COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: SAFETY RELAY

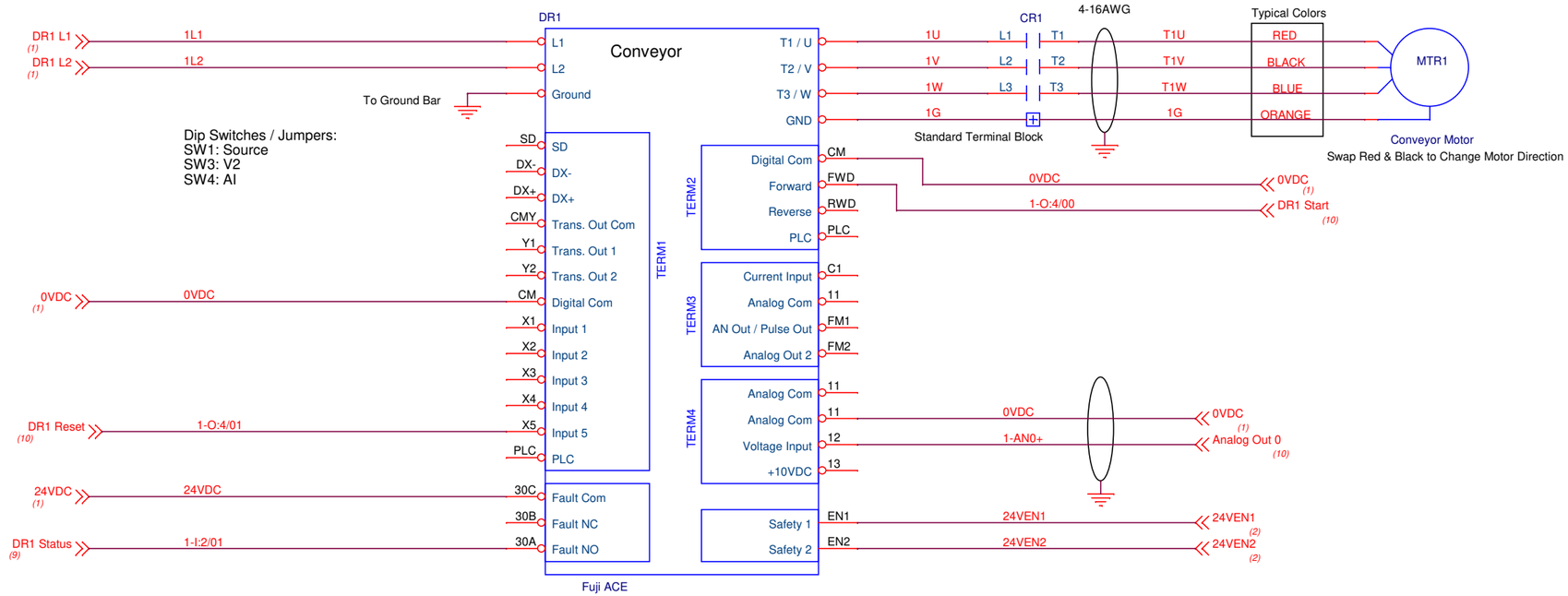
Schematic # SB84219-000

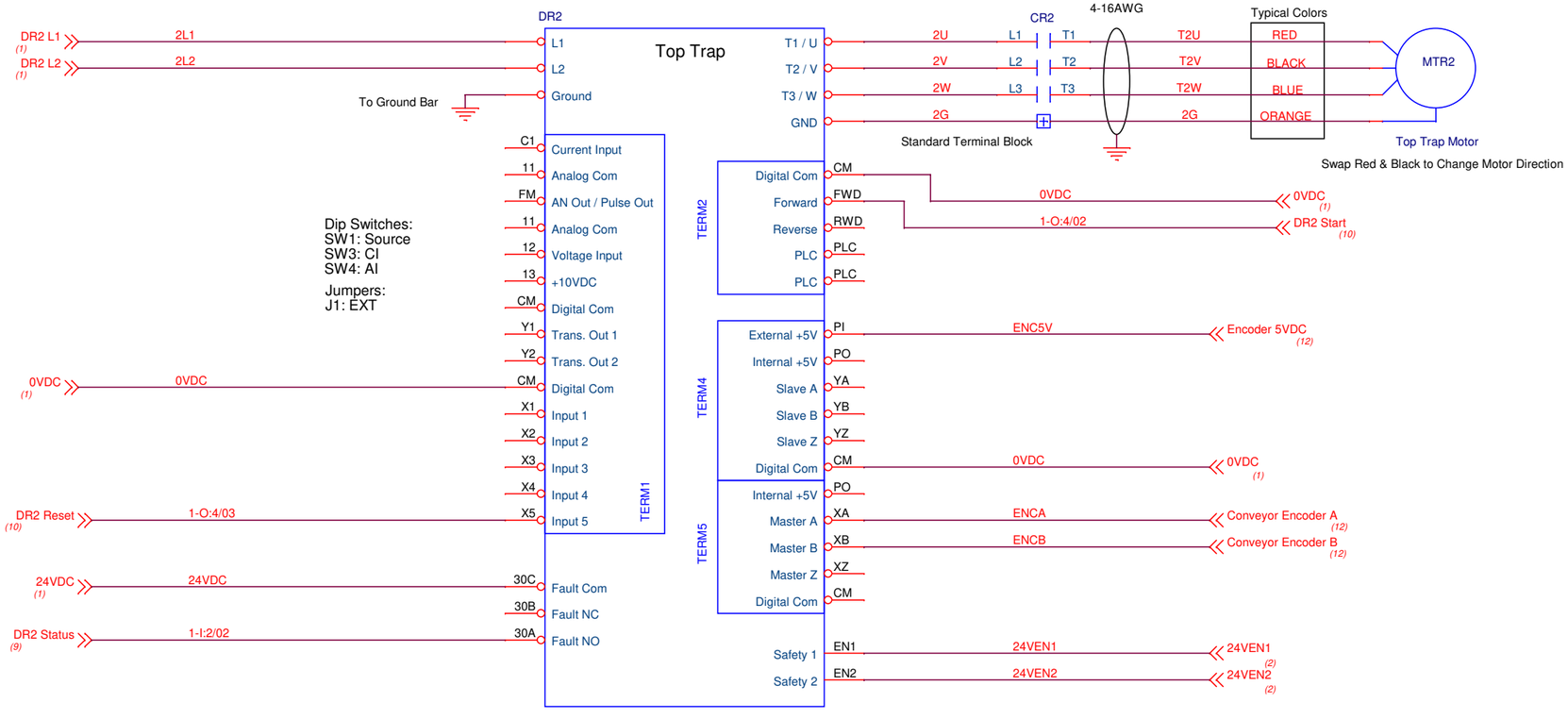
Rev -

Date: Tuesday, November 04, 2025

Sheet 2 of 13

Drives: Conveyor, Top Trap Page 3





COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

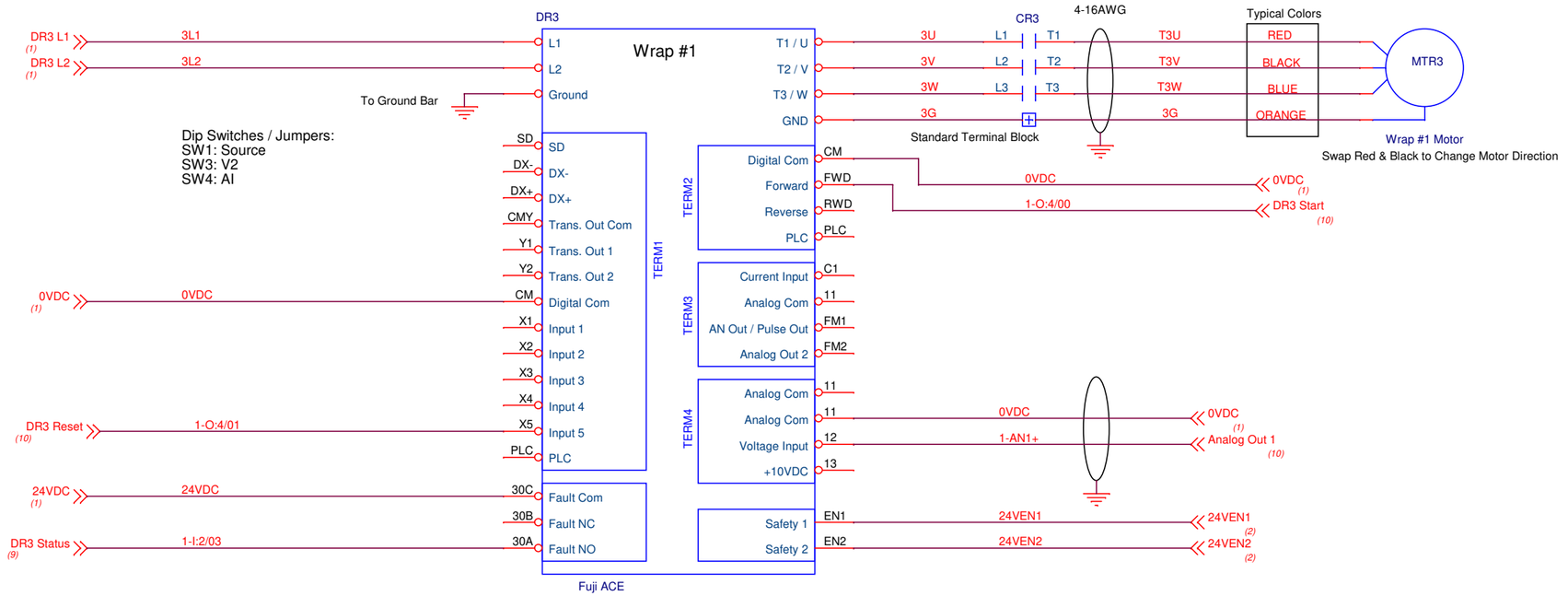
Title: CONVEYOR, TOP TRAP

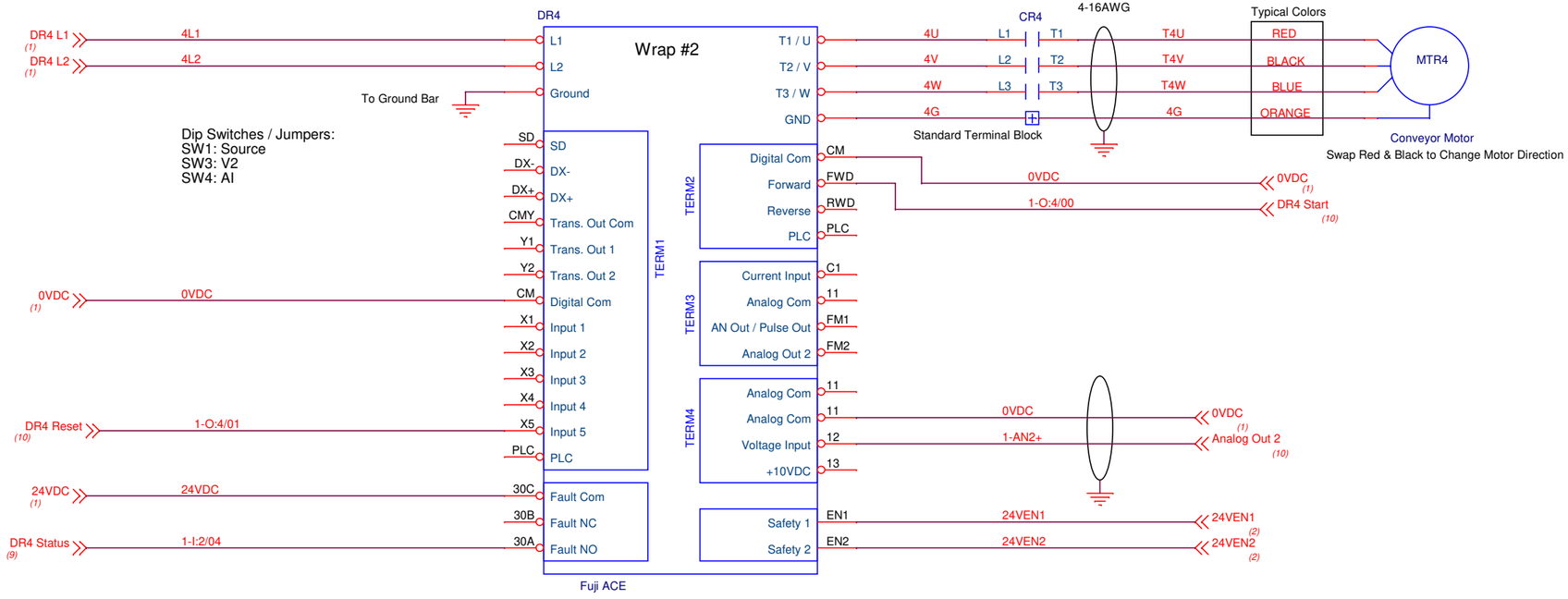
Schematic # SB84219-000

Rev -

Date: Tuesday, November 04, 2025

Drives:
Wrap #1,
Wrap #2
Page 4





COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title
WRAP #1, WRAP #2

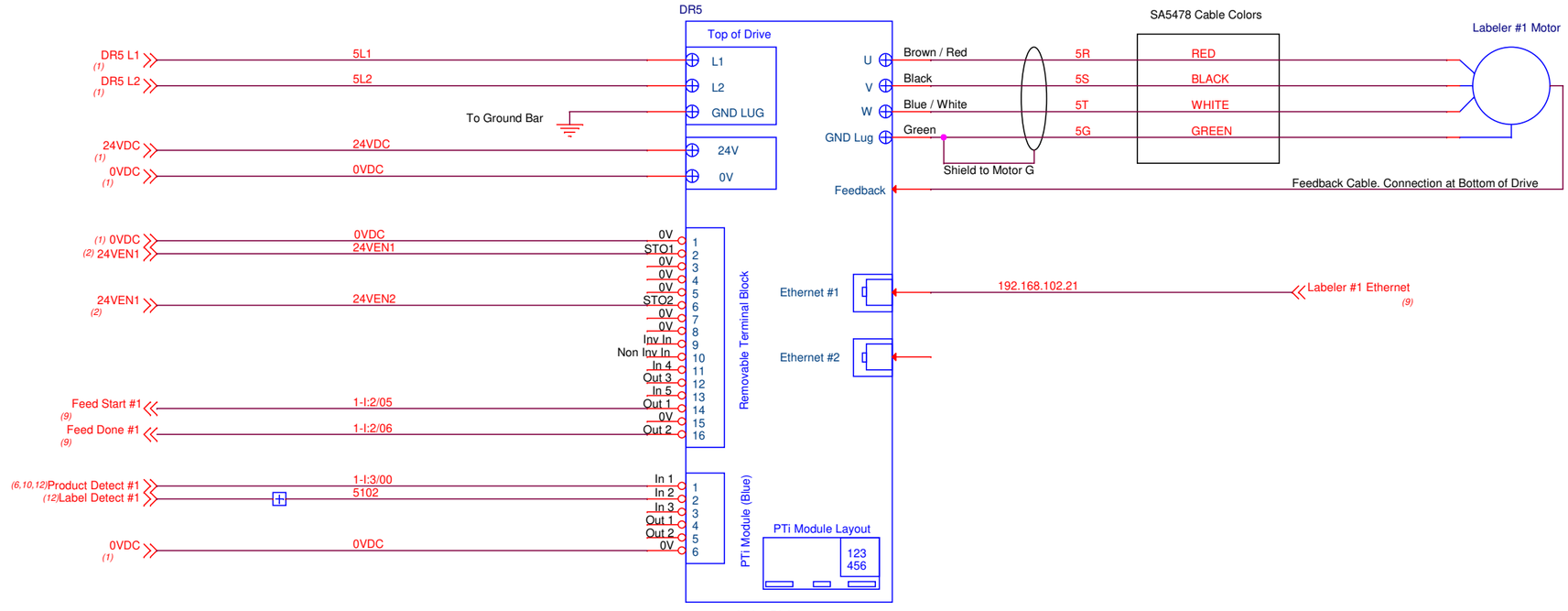
Schematic #
SB84219-000

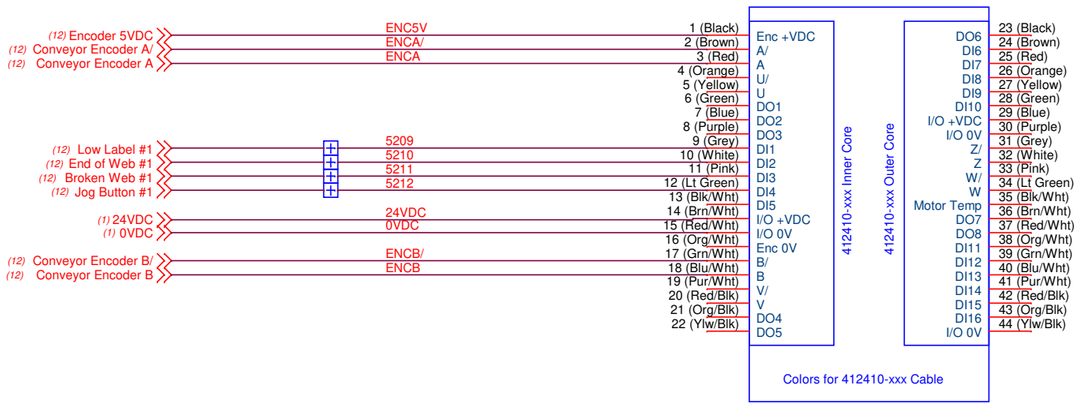
Rev
-

Date: Tuesday, November 04, 2025

Sheet 4 of 13

Drive:
Labeler #1
Page 5





COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: LABELER #1

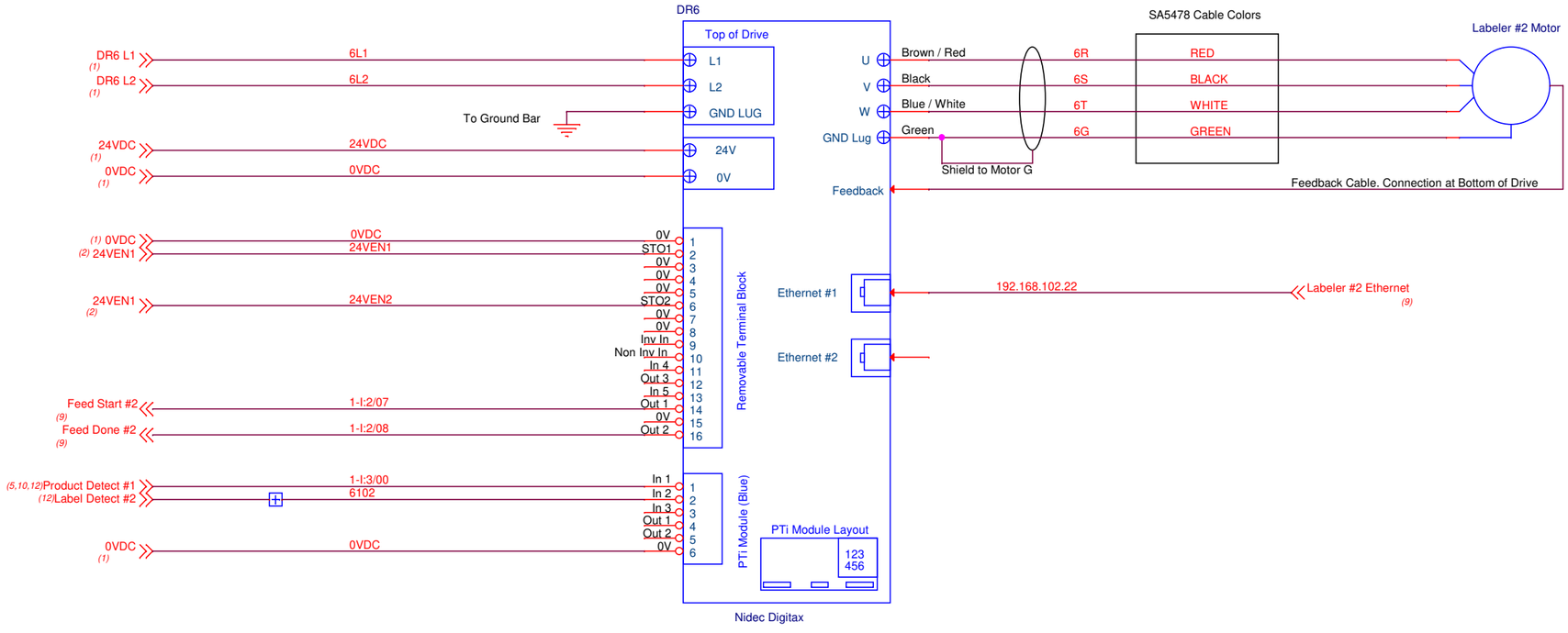
Schematic # SB84219-000

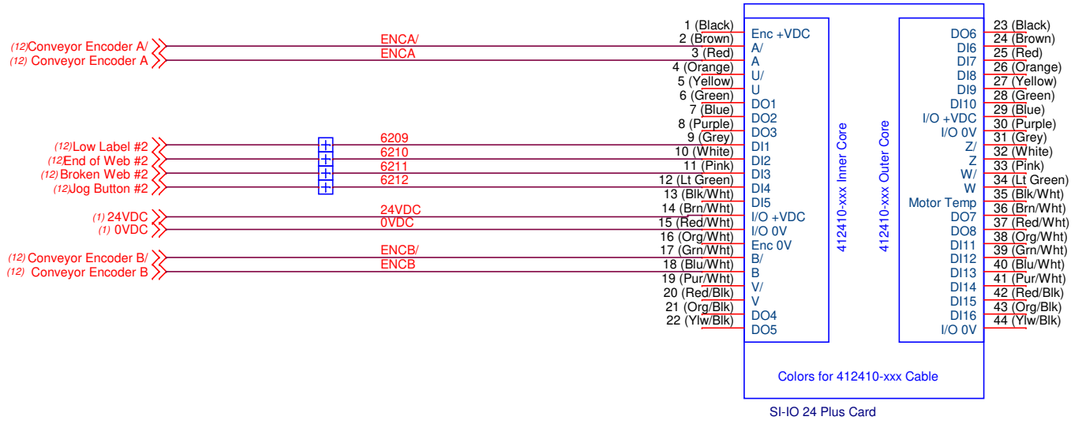
Rev -

Date: Tuesday, November 04, 2025

Sheet 5 of 13

Drive:
Labeler #2
Page 6





COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Drawn By: CMT

Title: LABELER #2

Schematic # SB84219-000

Rev -

Date: Tuesday, November 04, 2025

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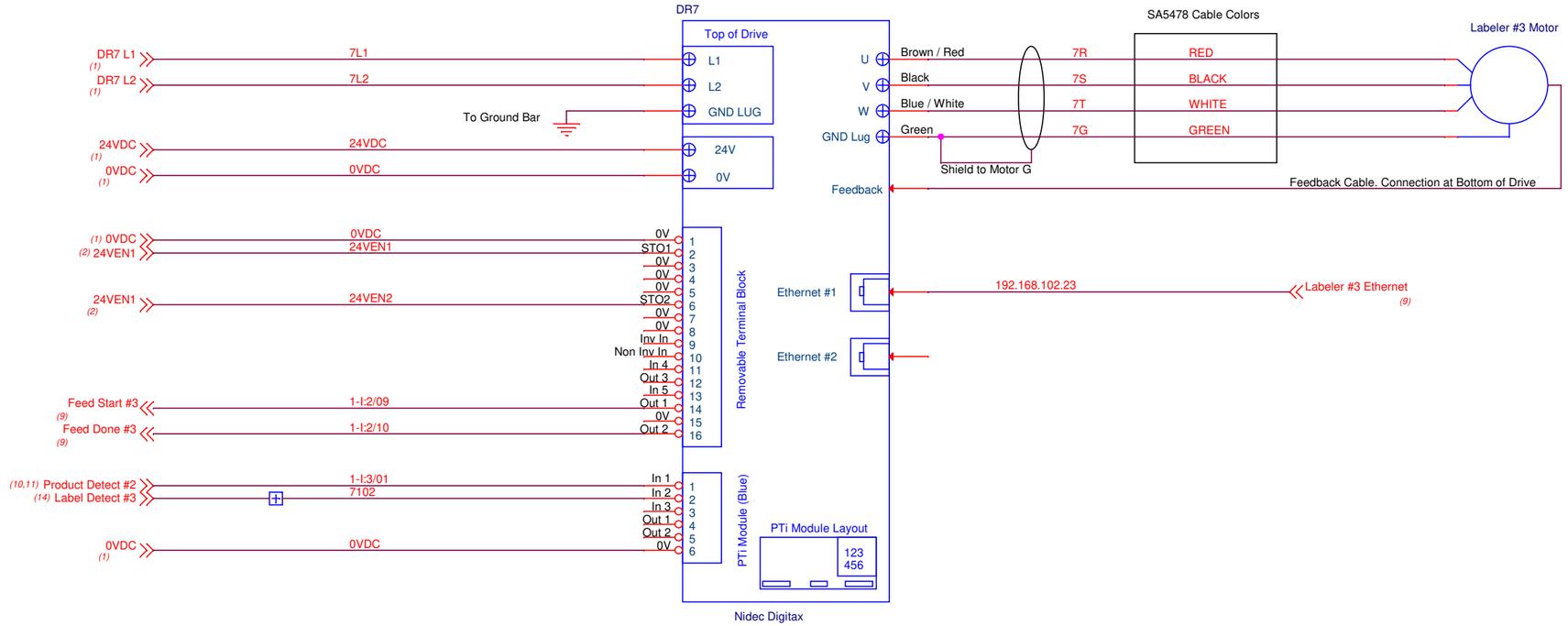
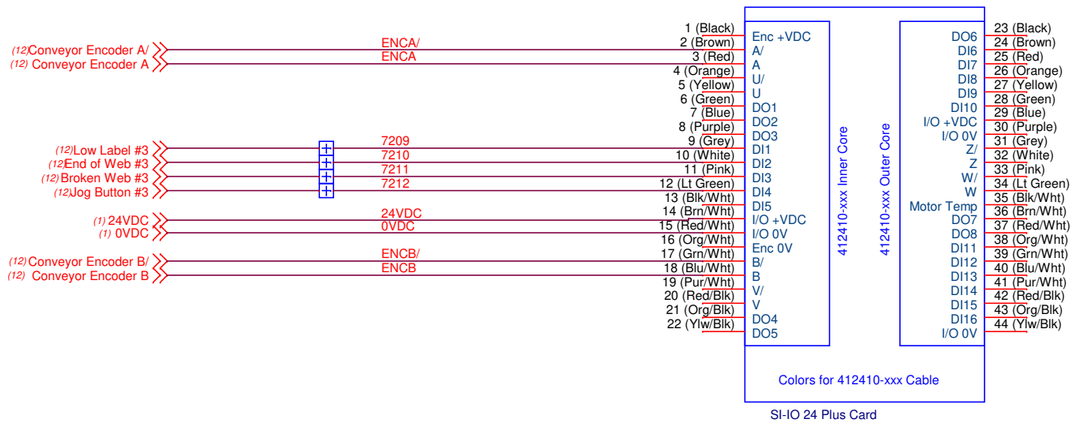
Drive:
Labeler #3
Page 7





COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: LABELER #3

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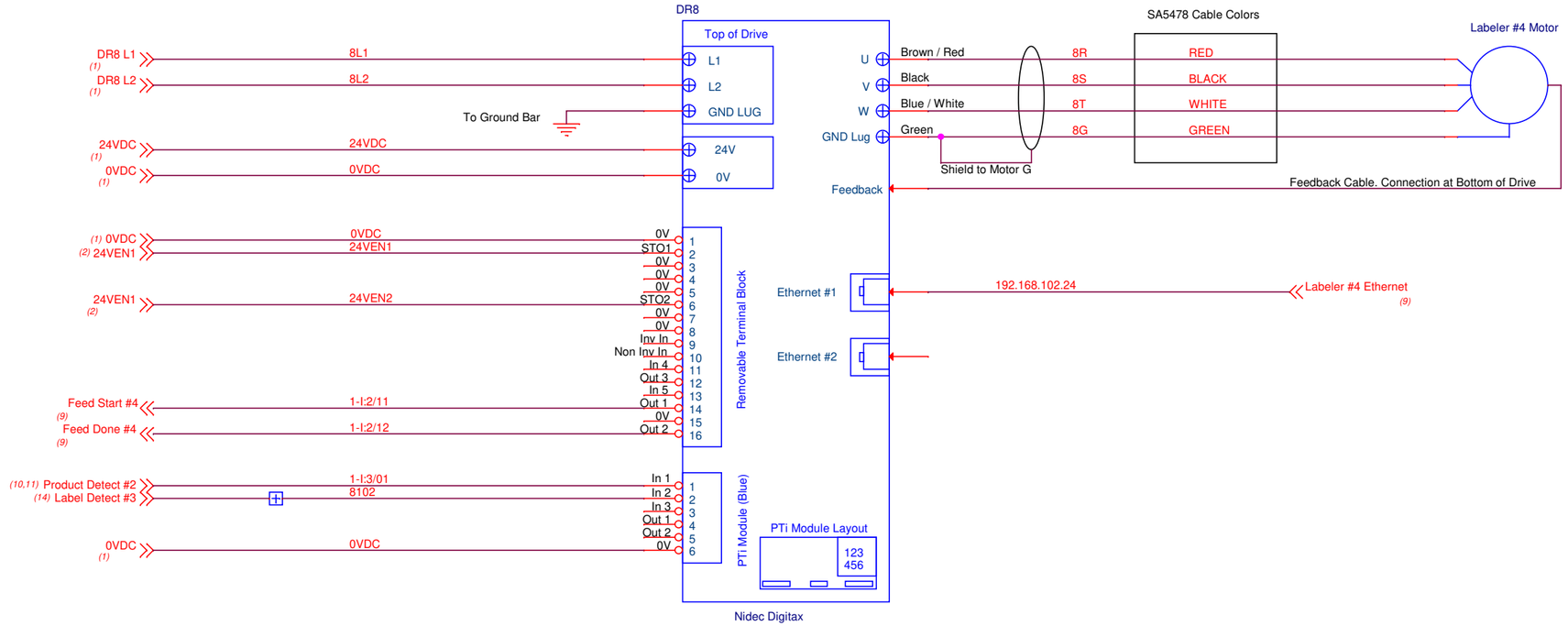
Date: Tuesday, November 04, 2025 Sheet 7 of 13

Drive:
Labeler #4
Page 8



COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Drawn By: CMT

Title: LABELER #4

Schematic #: SB84219-000

Rev: -

Date: Tuesday, November 04, 2025

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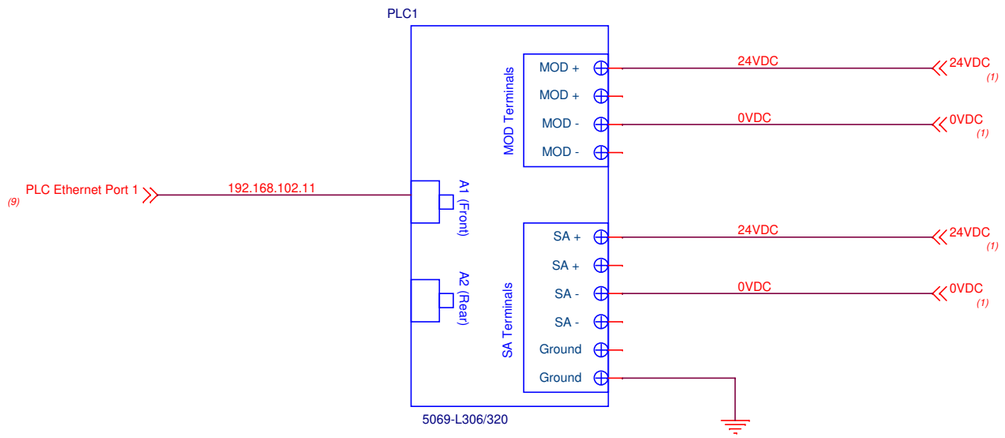
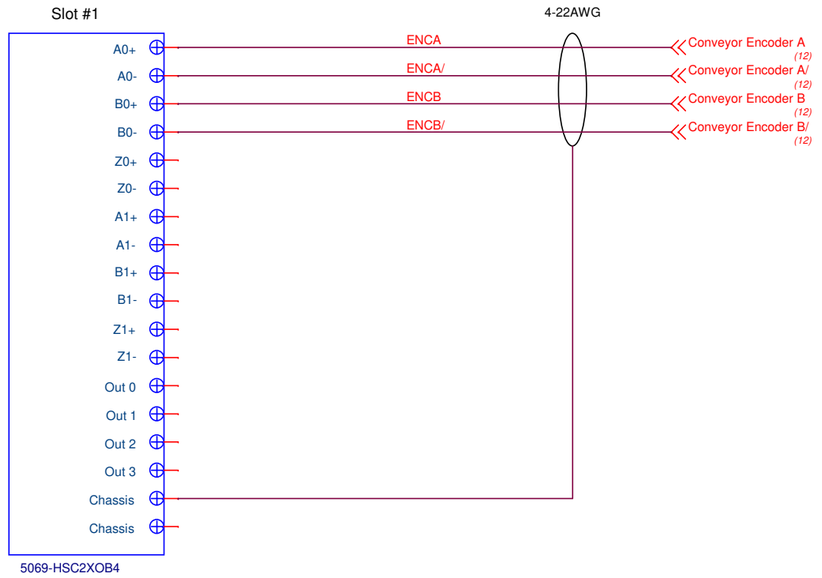
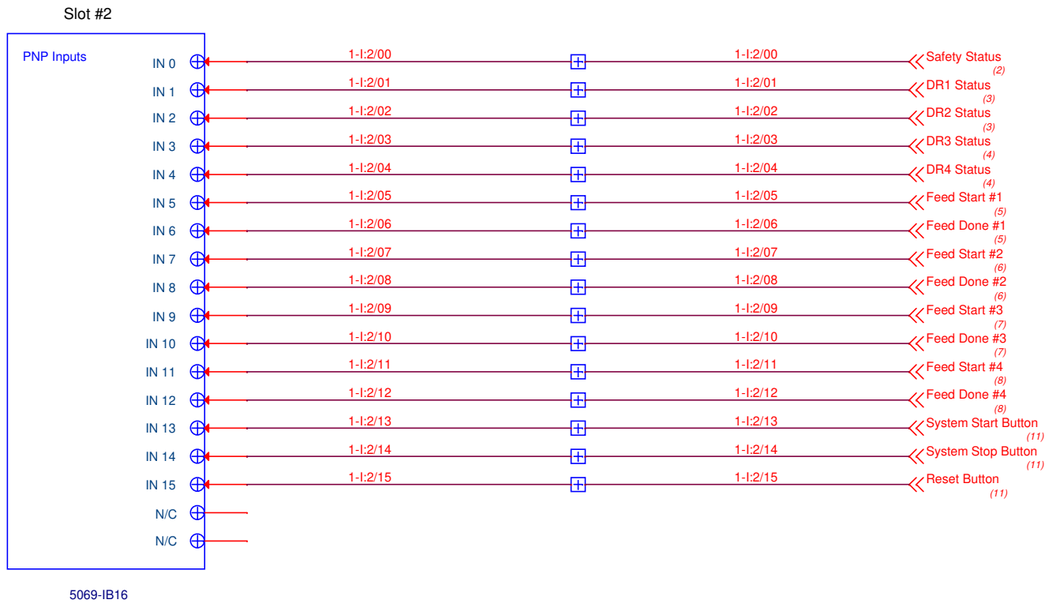
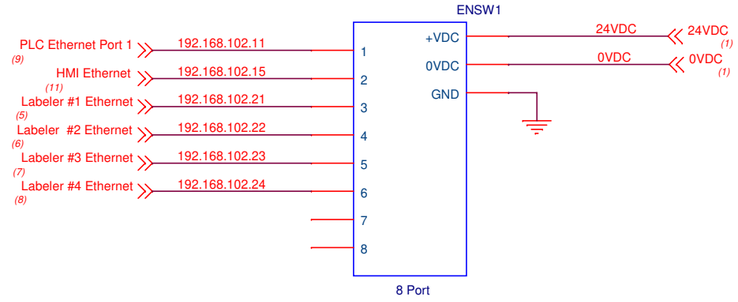
PLC Slots 1 & 2, Ethernet Page 9









COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: PLC SLOTS 1-2, ETHERNET

Schematic # SB84219-000

Rev -

Date: Tuesday, November 04, 2025

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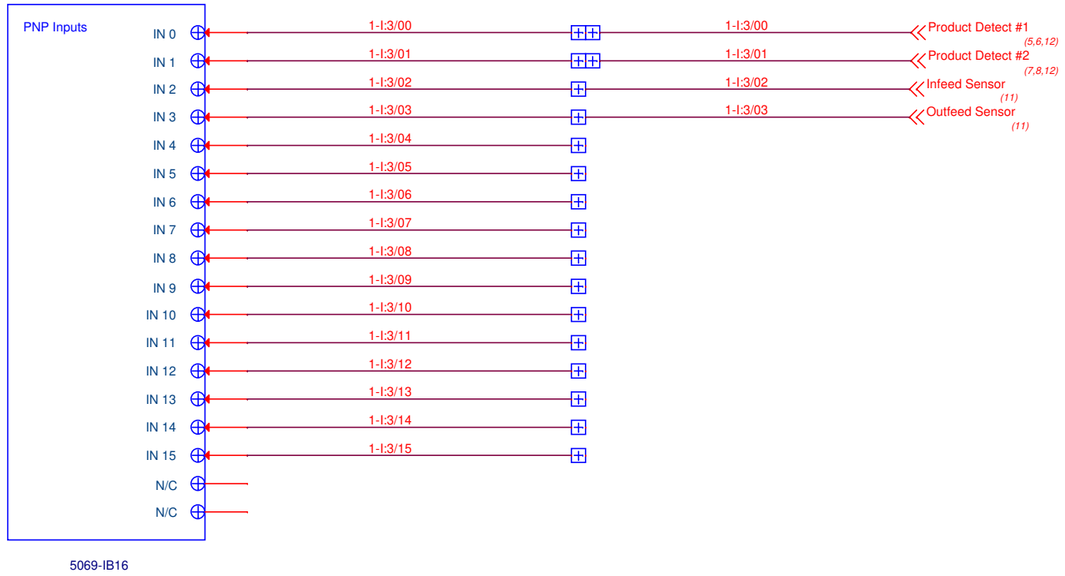
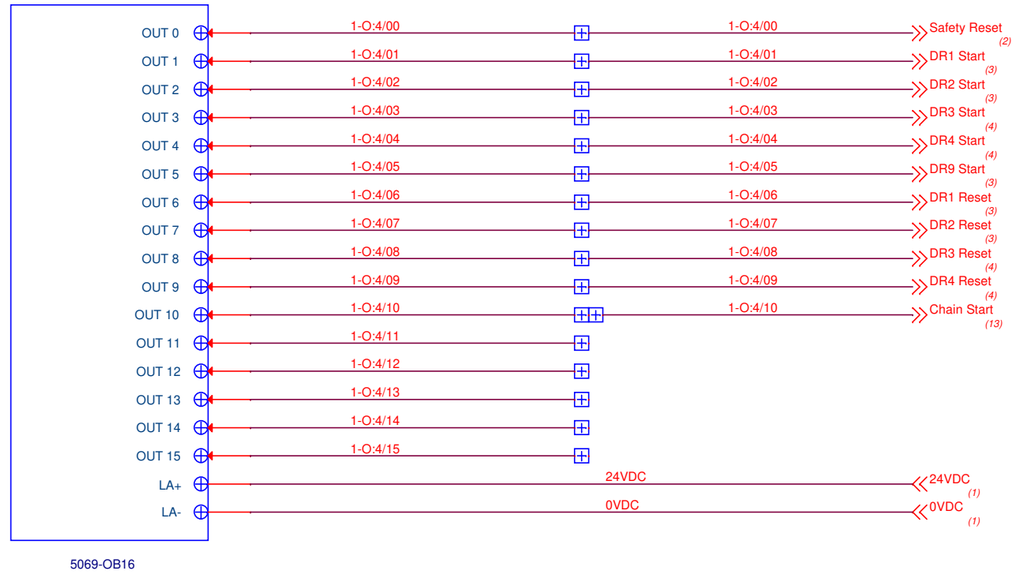
PLC #1 Slots 3-6
Page 10

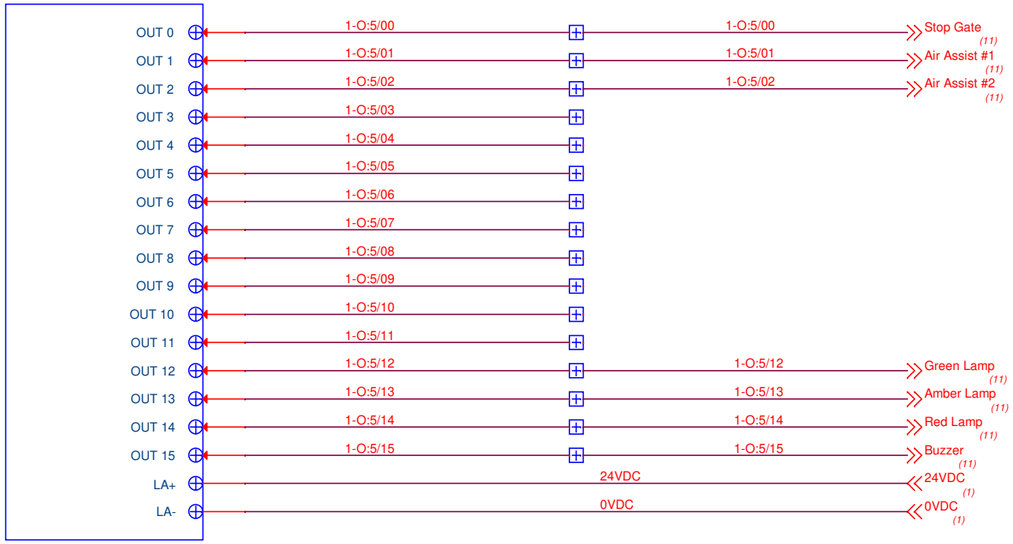
Slot #3



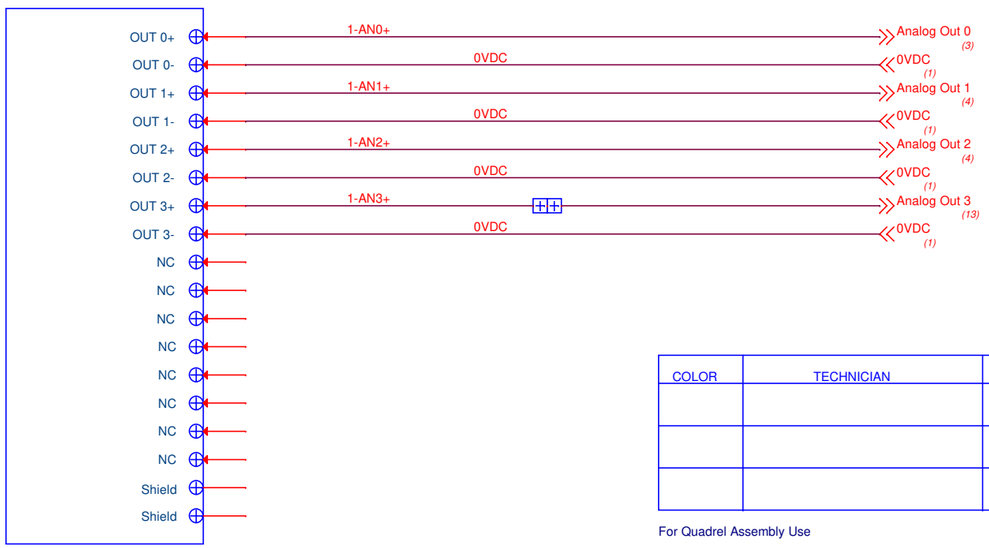
Slot #4



Slot #5



Slot #6



COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: PLC SLOTS 3-6

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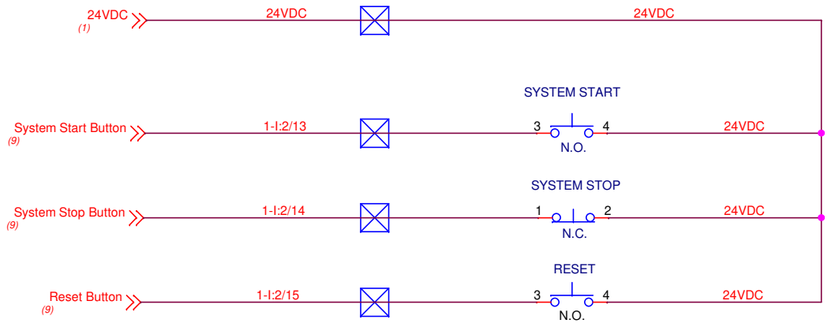
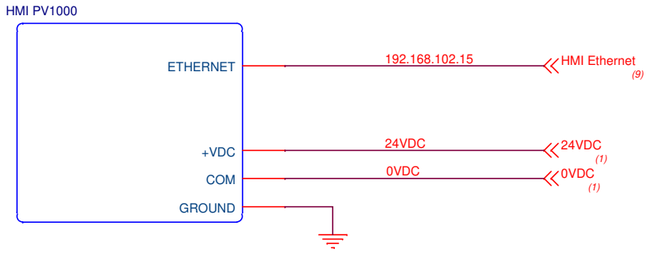
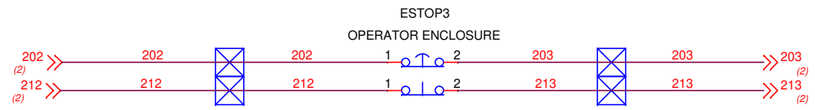
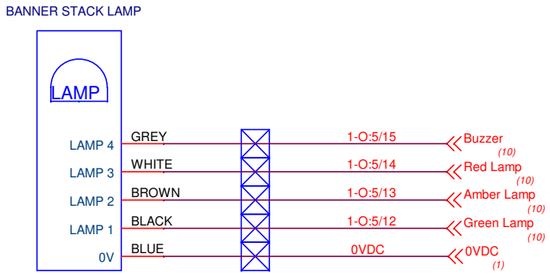
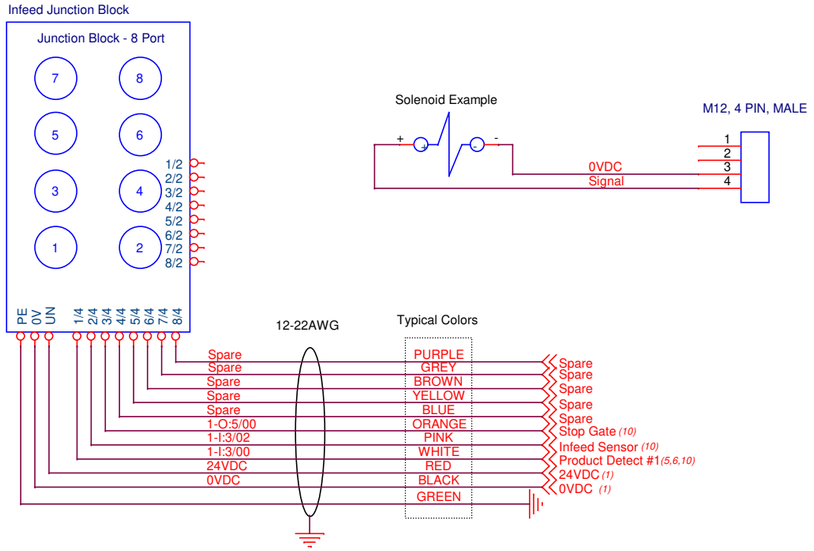
Operator Enclosure,
System Sensors
Page 11

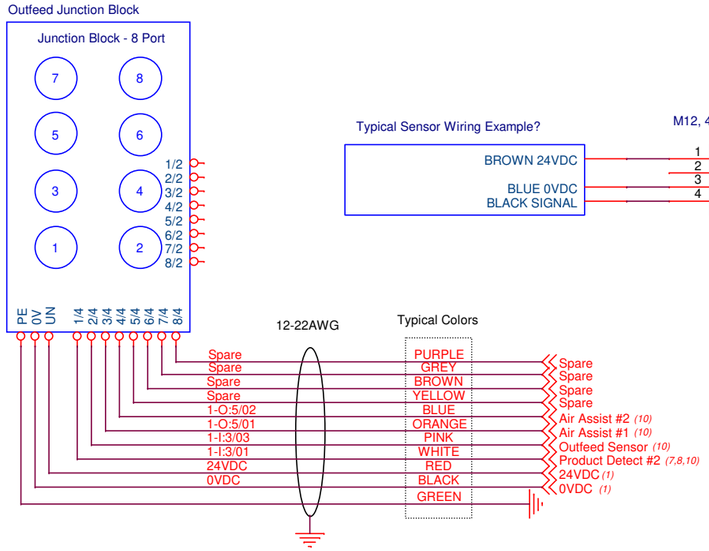


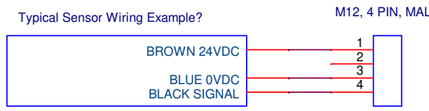












COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Drawn By: CMT

Title
OPERATOR ENCLOSURE, SYSTEM SENSORS

Schematic #
SB84219-000

Rev
-

Date: Tuesday, November 04, 2025

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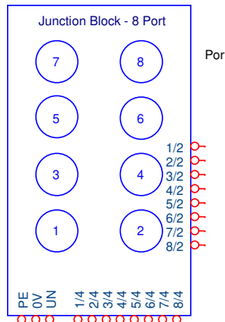
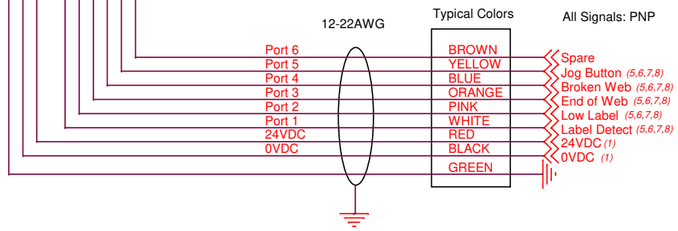
Labeler Sensors, Encoder, Pacing Drive Page 12

Labeler Junction Block

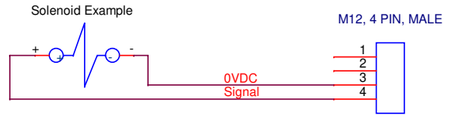


Ports 7 and 8 not Wired/Used

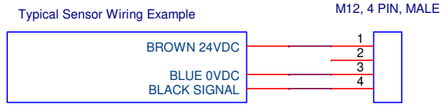
Sensor	Labeler #1	Labeler #2	Labeler #3	Labeler #4
Label Detect	5102	6102	7102	8102
Low Label	5209	6209	7209	8209
End of Web	5210	6210	7210	8210
Broken Web	5211	6211	7211	8211
Jog Button	5212	6212	7212	8212



Solenoid Example

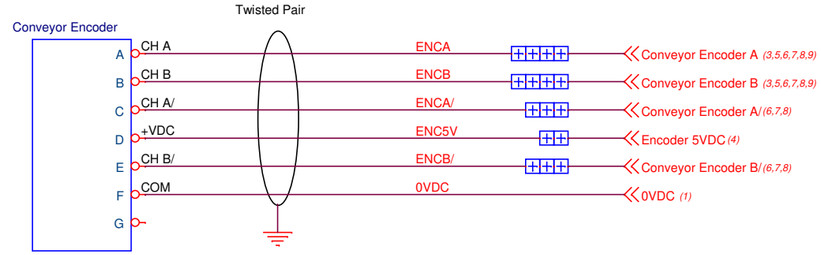


Typical Sensor Wiring Example



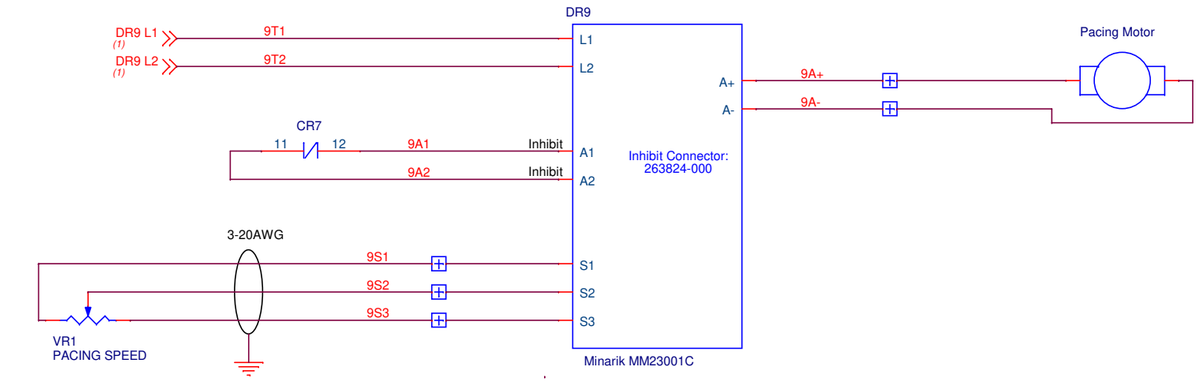
Jog Button in Remote Enclosure

Conveyor Encoder



Encoder - 770 with 7P Connector

Pacing Drive: Belt or Wheel



COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Drawn By: CMT

Title: LABELER SENSORS, ENCODER, PACING

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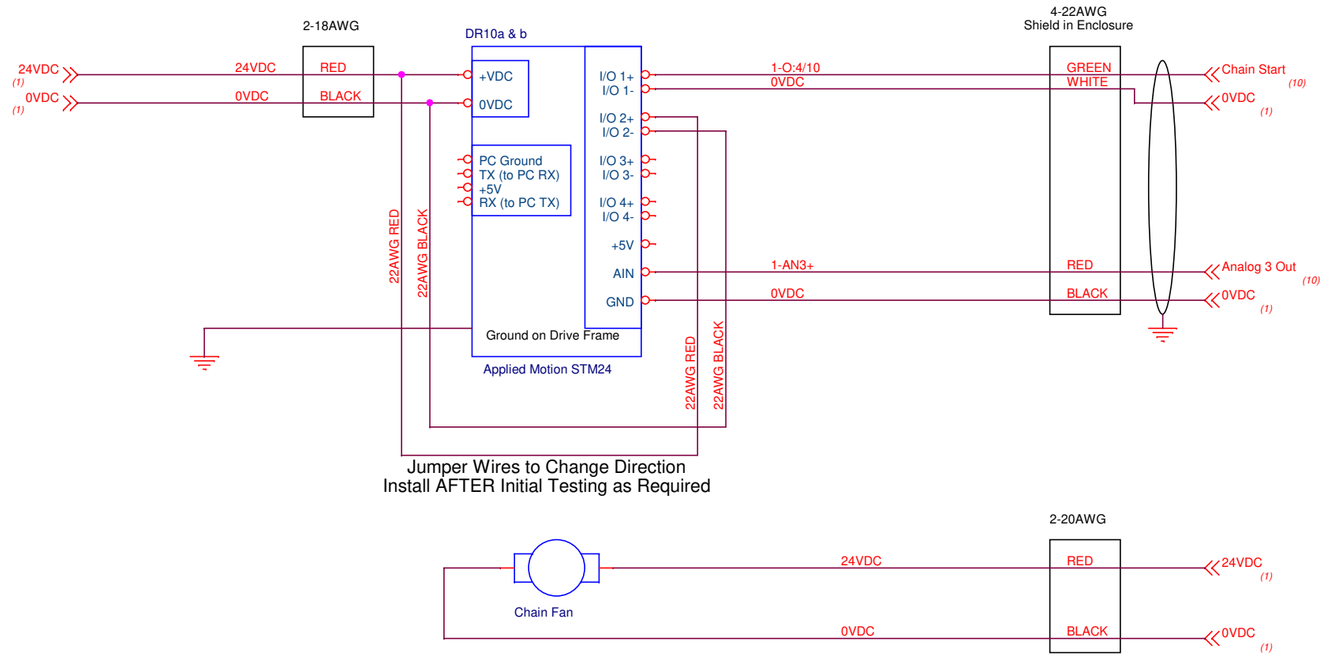
Date: Tuesday, November 04, 2025 Sheet 12 of 13



COLOR	TECHNICIAN	DATE

For Quadrel Assembly Use

QUADREL
LABELING SYSTEMS
7670 Jenther Dr.
Mentor, OH
44060

Drawn By: CMT

REV	DESCRIPTION	BY	DATE
-	Release	CMT	04NOV2025

Title: CHAIN ALIGNERS

Schematic #: SB84219-000

Rev: -

Date: Tuesday, November 04, 2025

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9 MAINTENANCE

9.1 GENERAL INFORMATION

This labeler has been designed with the minimal maintenance requirement possible. There are however some things to take into consideration.

The system is built to perform in humid conditions, but must not be pressure washed. In case of wash down conditions, it is recommended to cover each labeling head with a plastic tarp.

For the overall cleaning, it is recommended to use compressed air and clean, damp wipes.

Always turn off the system before proceeding with cleaning and maintenance.

The following section explains the preventive maintenance for each section

After every 100 hours of operation, a visual inspection of the system should be done and where it is necessary, lubricate and cleaning should be performed.

⚠ CAUTION WEAR PROTECTIVE EYEWEAR when performing any maintenance on this equipment.

⚠ CAUTION To reduce risk of fire, electrocution or other personal Injury when operating or maintaning the labeling head, follow basic safety precaution, including the following:

DO NOT perform any servicing or maintenance with the power ON.

Always disconnect the electrical plug from the wall socket

Make sure that the power is OFF or that the available E-stop buttons have been activated.

Quadrel labeling heads are reliable, versatile and durable. They will operate for years with very light maintenance. Most of the maintenance takes only a few minutes and substantially increases the operational life of the machine and maintains label placement accuracy. Not all items listed below are applicable to every machine. See sections that apply to your equipment

Daily: D
Weekly: W
Monthly M
Semi-Annually S

ASSEMBLY TITLE: **LABELING HEAD ASSEMBLY**

D- Remove glue residue and labels from all rollers and idler
M- Check and tighten all fasteners.

ASSEMBLY TITLE: **UNWIND ASSEMBLY**

W- Check and adjust dancer spring if final spring tension is too soft. Replace
W- Check and inspect band brake. Replace if torn

ASSEMBLY TITLE: **REWIND ASSEMBLY**

W- Check and inspect friction disc, Replace when worn out. (A-DRIVE only)
W- Check kinetrol for leaks, Replace if necessary. (B-DRIVE only)

ASSEMBLY TITLE: **BRAKE BRUSH ASSEMBLY**

W- Reverse brake brush direction.
M- Inspect Brake brush when brush body contour no longer viable or bristles are worn down. Replace

ASSEMBLY TITLE: **SLOT SENSOR ASSEMBLY**

D- Keep the sensor optical area clean from label and glue residue

ASSEMBLY TITLE: **SIDE PLATE ASSEMBLY**

S- Check and inspect and grease all rollers and idler**.**

ASSEMBLY TITLE: **PEEL PLATE ASSEMBLY**

D- Clean all the parts that may acquire labels or glue residue.
W- Inspect Teflon tap on peel plate tip
S- Check and inspect and grease all rollers and idler**.**

ASSEMBLY TITLE: **DRIVE AND PINCH ROLL ASSEMBLY**

D- Remove glue residue and labels from drive roller.
W- Clean with soft brass brush knurled roll.
W- Check and inspect drive roll, No play when powered up
S- Replace springs and slugs.

ASSEMBLY TITLE: **ROLLER/BRUSH IMPRESSER**

D- Check the rollers/brushes free of label flash, glue and debris. This will prevent jamming and web tears.
W- Check the foam rollers. If foam wear is noticeable, replace as necessary.

NOTE: Exercise caution when removing bad labels from foam. Careless removal can result in torn foam which may leave the labeler inoperable until the roller is replaced!

ASSEMBLY TITLE: **OPERATOR PANEL**

-No maintenance is required for the operator panel

-Occasionally, the keypad may be cleaned with any non-solvent based cleaning solution.

ASSEMBLY TITLE: **ELECTRICAL**

W- Check the foam for fan clean or replace.

ASSEMBLY TITLE: **ROLLER/BRUSH IMPRESSER**

D- Check the rollers/brushes free of label flash, glue and debris. This will prevent jamming and web tears.

W- Check the foam rollers. If foam wear is noticeable, replace as necessary.

NOTE: Exercise caution when removing bad labels from foam. Careless removal can result in torn foam which may leave the labeler inoperable until the roller is replaced!

ASSEMBLY TITLE: **TAMP PAD ASSEMBLY**

D – Check the tamp pad for label flash, glue residue and debris on tamp pad. If found clean tamp pad with adhesive remover and/or cleaner

D – (**RFID REJECT PADDLE ONLY**) – Remove rejected labels from reject paddle at least 1 time per shift and/or as needed. **No more than 5-6 labels are to be on reject paddle at any time. Once 5-6 labels are on reject paddle they should be removed to ensure proper operation**

W – Lightly run scotch bright across pad to ensure it is lightly scuffed. A shiny pad could cause label to stick to the pad as it is dispensing

W – Check for air leaks around tamp pad block and pad. Reseal as necessary with RTV silicon sealant.

W – Inspect all pneumatic components for wear.

W – Lubricate Pneumatic cylinder slide rods

ASSEMBLY TITLE: **OPERATOR PANEL**

-No maintenance is required for the operator panel

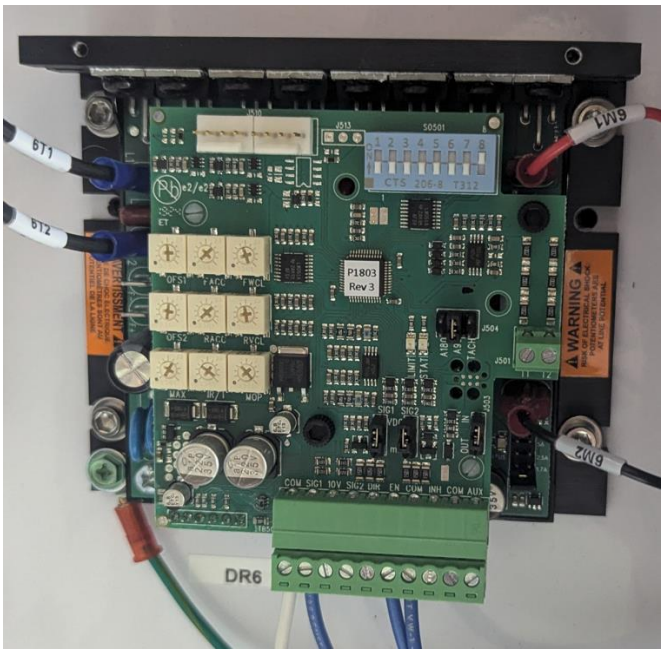
-Occasionally, the keypad may be cleaned with any non-solvent based cleaning solution.

ASSEMBLY TITLE: **ELECTRICAL**

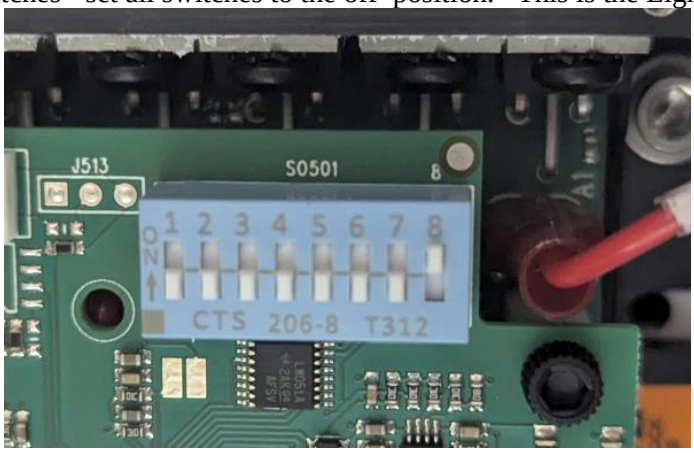
W- Check the foam for fan clean or replace.

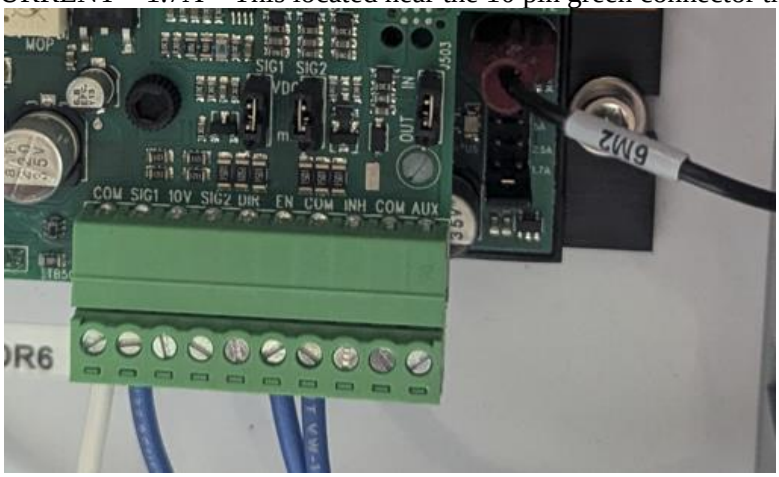
NOTES:

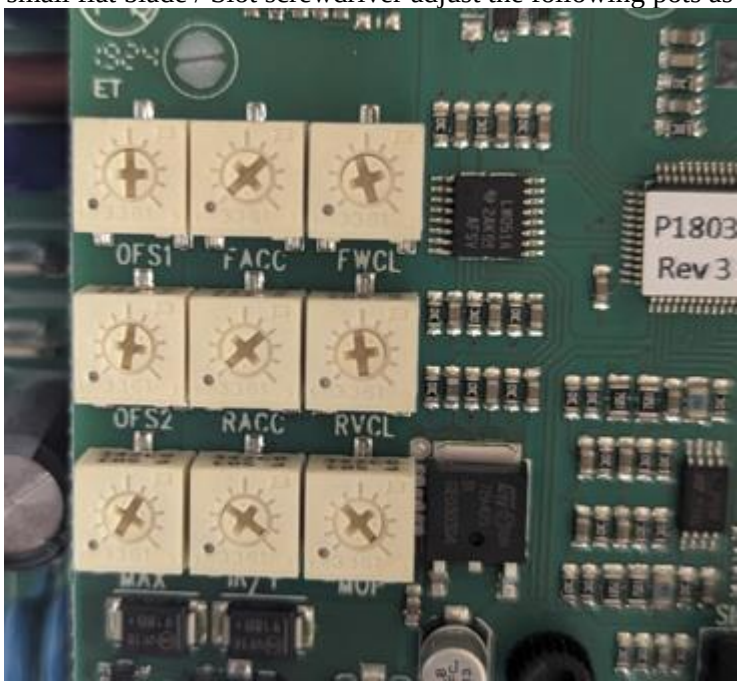
Setup procedure for Powered rewind using MGC403-11-00MD drive



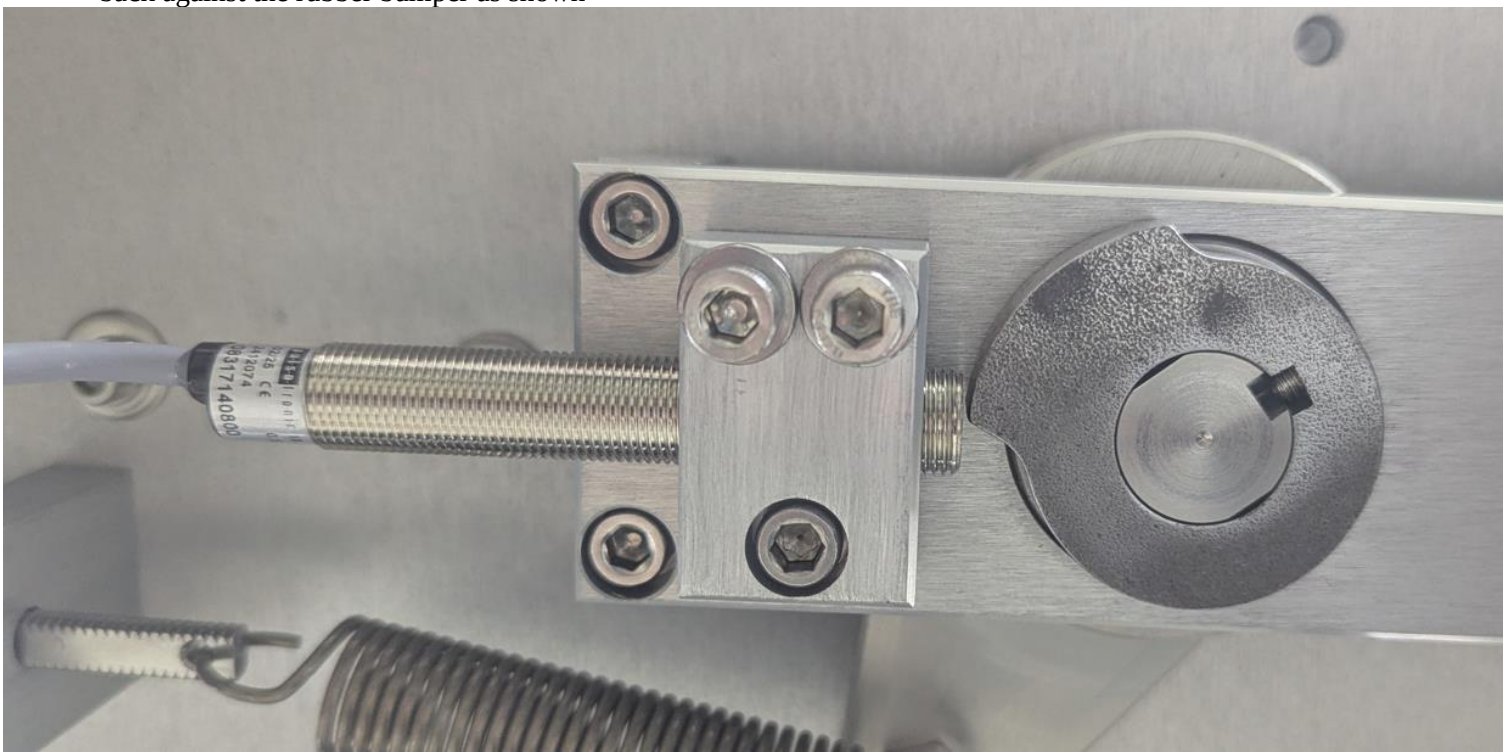
Upon receiving drive set the following BEFORE installing in the machine.

1. Dip switches - set all switches to the off position. This is the Light blue row of switches shown in the image below
   a. 

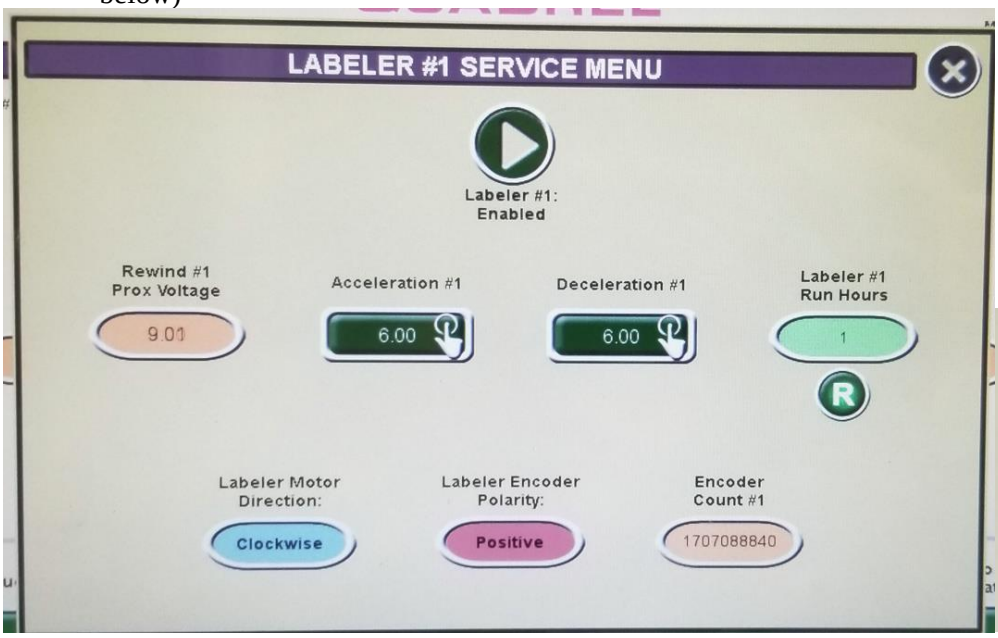
2. Set Jumpers on drive based on electrical schematic for your machine
   a. SIG1 – VDC
   b. SIG2 – VDC
   c. J504 – A90
   d. AMP CURRENT – 1.7A – This located near the 10 pin green connector that
      i. 

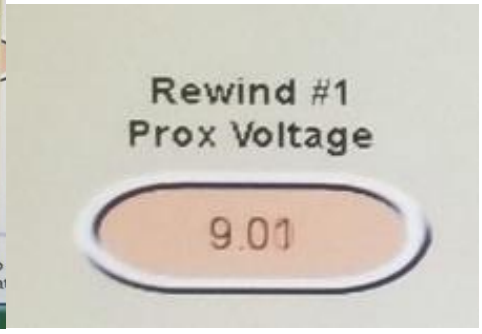
3. Using a small flat blade / Slot screwdriver adjust the following pots as indicated in the image below:
   a. 

      i. Top row **OFS1** – WILL BE ADJUSTED AT LATER STEP
      ii. Top row – **FACC -** turn counter clockwise until it stops.
      iii. Top row **FWCL** – set to half way point – midpoint
      iv. Middle row **- OFS2** – turn counter clockwise until it stops. This turns the pot OFF
      v. Middle row – **RACC -** turn counter clockwise until it stops
      vi. Middle row – **RVCL** – set to half way point – midpoint
      vii. Bottom row – **MAX** – Set to 3/4 point
      viii. Bottom row **– Leave other 2 pots at factory setting – DO NOT ADJUST**
4. **Install drive in machine then proceed to next steps**
5. Set the Cam on the rewind dancer per image below when the dancer arm is at rest. Rest is when the arm is all the way back against the rubber bumper as shown

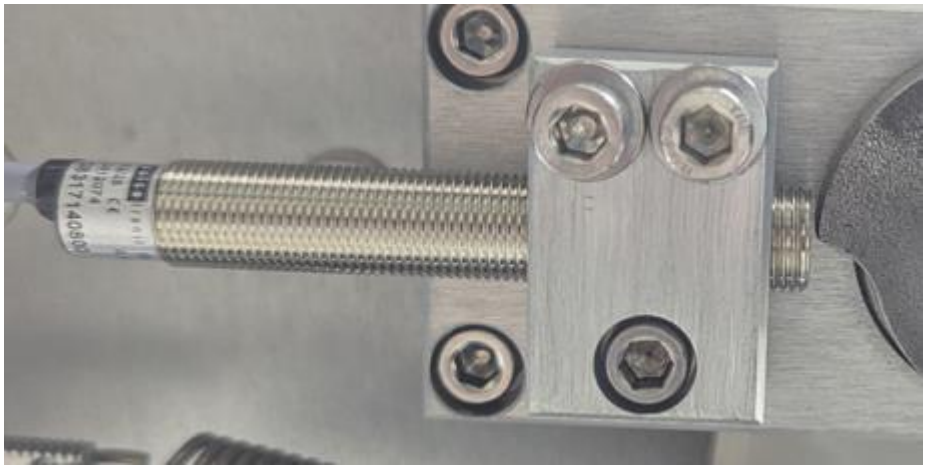


6. On the HMI go to into labeling head service menu. You will be looking at the REWIND PROX VOLTAGE (example below)

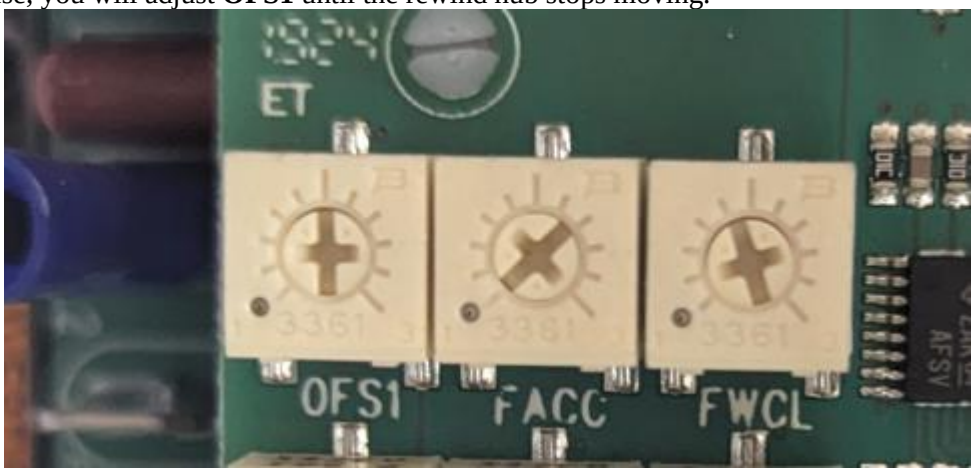




7. Adjust the sensor gap at the cam by loosening the bolt using an allen key so that the sensor can be moved forward or backward. The bolt does NOT touch the sensor. Loosening it opens the clamp so you can adjust.
8. Set the gap so the REWIND PROX VOLTAGE on the HMI reads .**90 it must be under 1 volt.**
    a. **Retighten screw so the clamp sensor no longer moves**

b. 

9. Test by moving the rewind dancer arm forward. When doing this you should see the rewind prox voltage on the HMI increase up to 9 volts

    a. **If you do not see the voltage increase steadily, recheck cam sensor gap in step 7**
10. Turn on rewind switch on the back of the labeler. This will engage / turn on the motor.
11. Move the rewind dancer arm forward the rewind hub should start to turn clockwise. It will slow then stop as you move forward. Rewind hub should ALWAYS be turning clockwise. If it moves counter clockwise move to **step 11a**
    a. While holding the arm in the position where it started to run counter clockwise, it MUST be running counter clockwise, you will adjust **OFS1** until the rewind hub stops moving.
    i. 

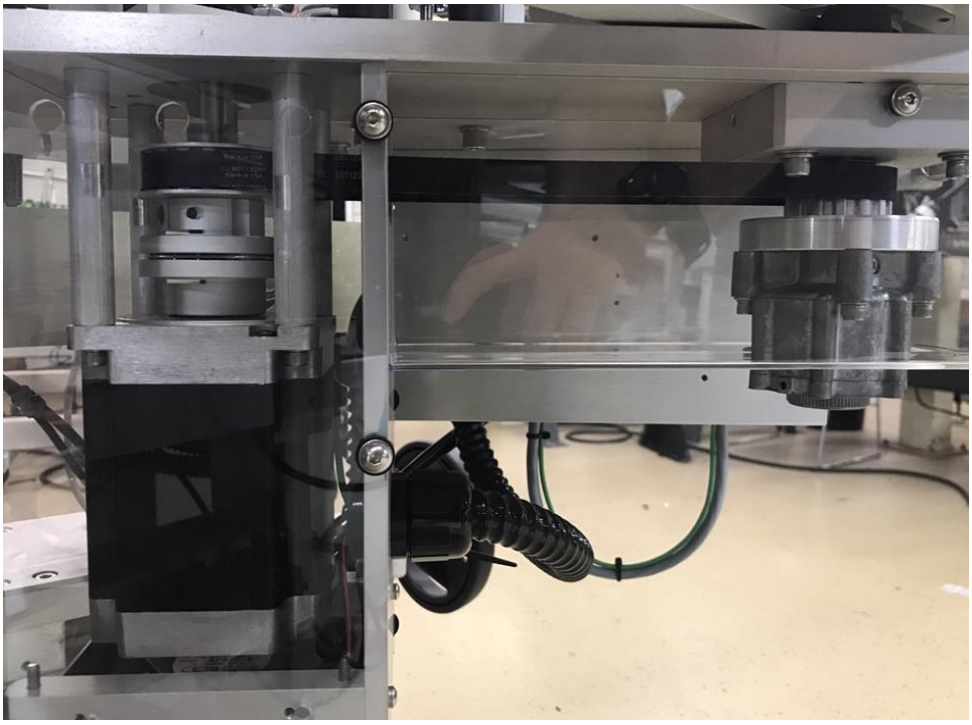
    b. This adjustment may need to be done multiple times until it no longer moves counter clockwise when rewind arm is all the forward and at rest.

9.2 BELTS

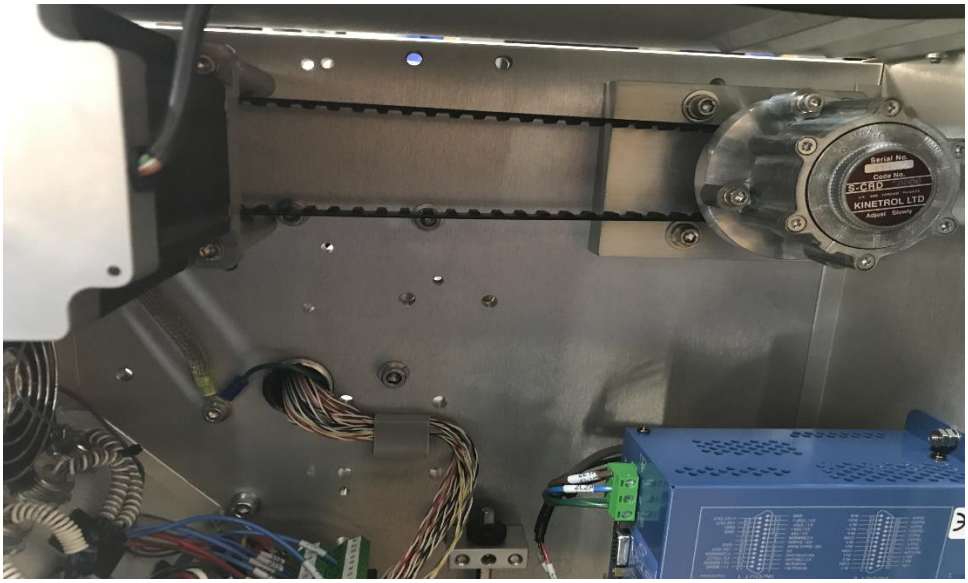
Monthly, a visual inspection of the rewind belt and timing belt, to do this depending on the labeling head you may need to remove the bottom cover on the head.

Refer to photos below.

Servo labeling head.

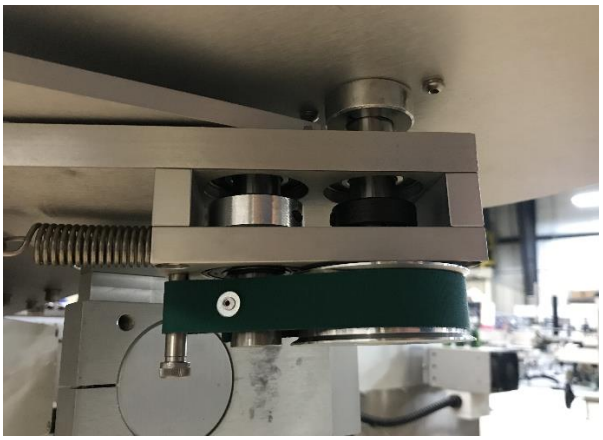


Stepping labeling head.



⚠ CAUTION DO NOT ATTEMPT doing this with the equipment under tension (with power on).

The visual inspection should consist of looking for cracks or defects in the belts. If this is the case, change the belts that are defective. Refer to the parts listing in the labeling head section of this manual.
The brake band mechanism requires a monthly visual inspection as well. Also once every 12 months you should consider replacing the belt (it is possible that you may need to change it later or earlier than 12 months depending the usage of the labeling head).
The brake band belt assembly is located at the base of the unwind assembly. See images below for reference.

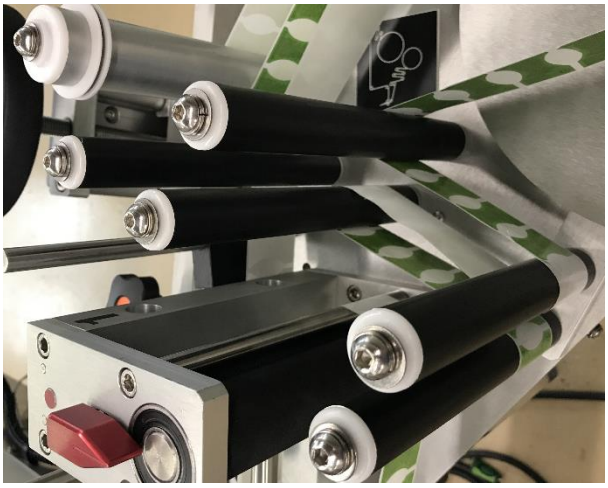


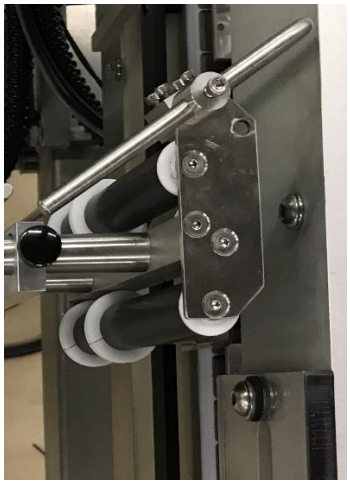
For replacement parts see the unwind assembly drawing for your labeling head in this manual.

9.3 ROLLERS

It is important that your labeler is as clean as possible in its environment in order for it to perform property. Daily, it is suggested to clean all the rollers including the drive roller (the rubber roller), the pressure shoe and peel plate using a damp cloth with alcohol. Make sure those parts have no glue or labels on it.

Weekly, spray a silicone base lubricant on each end of the plastic bearing.





9.4 SENSORS

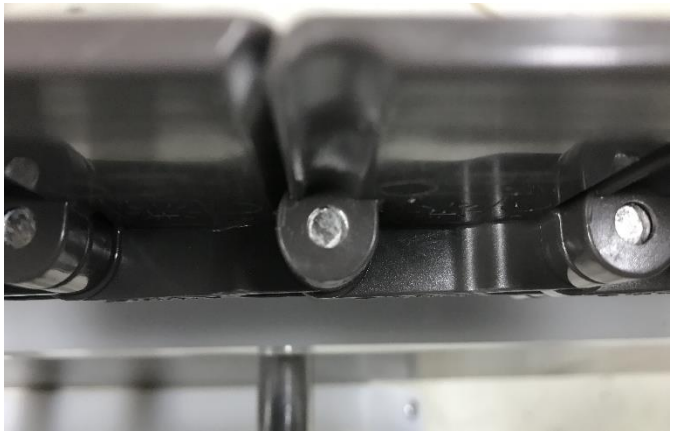
The sensors all have an electronic eye called a photocell; these must be free of lint or dirt. Since the photocells are generally made with glass or plastic lenses. They naturally attract substances which could easily trigger the sensor, use a cotton swap to gently clean the eye of the sensor as you would any lens, in a circular motion.

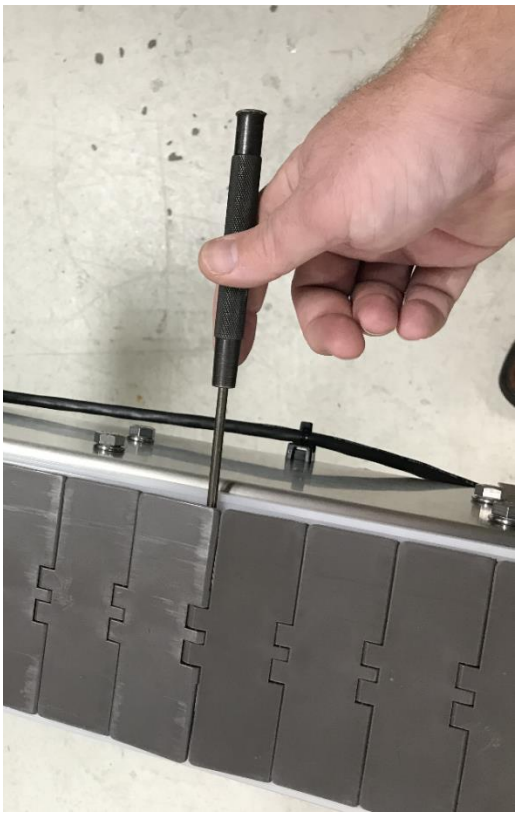
9.5 CONVEYOR

Always keep the belt or (chain) clean. To clean it simply use compressed air with an osha approved nozzle and/or damp wipes. If necessary, a soft cleaning agent can be used.

9.5.1 CLEANING

To clean the under carriage portion of the conveyor, simply remove the belt using an punch or similar tool and hammer to tap out the retaining belt link pin. (see images below, the chain has an orientation to the pins, you must tap it out from the narrow diameter) Clean the desired portion with a damp cloth and replace the pin to the belt. The pin will be tapped in the opposite side you tapped it out. *You can also lift the chain and wipe under it.





10 CLEARING A JAM

In the event a jam occurs on your Quadrel Labeler reference the following steps to clear.

1. Press the conveyor stop button or the emergency stop if you are unable to reach the stop button.
2. Clear the jam manually in the affected are of the equipment where jam is located
3. Once jam is cleared reenergize the estop, if pressed, and press the reset button (where applicable) to clear faults.
4. Put equipment back into “run” and press start to turn the system back online to continue labeling

11 WARRANTY

The standard warranty period for Quadrel equipment is 12 months following invoicing. The warranty covers all parts with consideration taken towards reasonable use and normal wear and tear. Not covered by warranty are parts that have a limited wear factor, any required labor by Quadrel. Prior to return to Quadrel, parts must be verified defective.

Return of defective parts

To return a defective part, you will need to get an RMA number from Quadrel. All RMA’s are issued though our parts department. Please specify the serial number of the equiptment, the client’s name, address, phone number, contact name and the nature of the problem. To get a replacment part, a purchase order is required. You will be billed for the new part and credited for the defective part after return and evaluation. If the part is determined to be defective due to improper use, no credit will be issued.

Appropriate Use of Equipment

The equipment supplied to the end user by Quadrel are to be used for the sole purpose for which they were intended and must follow Quadrel’s specifications on usage as well as appropriate functions. Quadrel will not assume any responsibility for any inappropriate use or modifications to the said equipment other than for the use it was initially built for. The warranty will cease to apply forthwith, in Quadrel’s opinion, the equipment has been used abnormally or in an abusive manner, if it has not been properly maintained, if it has not been carried on a truck equipped with an air-ride suspension when required by Quadrel or if it has been used, or maintained contrary to the owners manual provided by Quadrel.

Responsibility Limits

The solution put forth has been prepared with the information that has been provided to Quadrel by the end user. Subsequently, Quadrel cannot assume any responsibility for the exactitude, precision, and the validity of the information which was supplied. Moreover, Quadrel cannot be responsible for (a) any damages, direct or indirect, secondary, or

accessory, including without limitations, the loss of profit, workflow interruption, loss of production, loss of profits and other; (b) any and all damages claimed against the end user by a third party; (c) any or all damages caused to the property of end user or any other third party; (d) any or all resulting in an act from the end user or third party, major force, or act of god, unforeseen cause, or event.

With all reservation, in the eventuality where the responsibility is that of Quadrel relative to any defect of quality of said equipment or proposed solution Quadrel would be able to accept the responsibility, to its entire discretion, with the replacement of part of the said equipment or solution. By a compatible or identical equipment or solution or by a reimbursement of value agreed upon. In no case can Quadrel's responsibility exceed the total monetary sums received for the said defective equipment or solution.