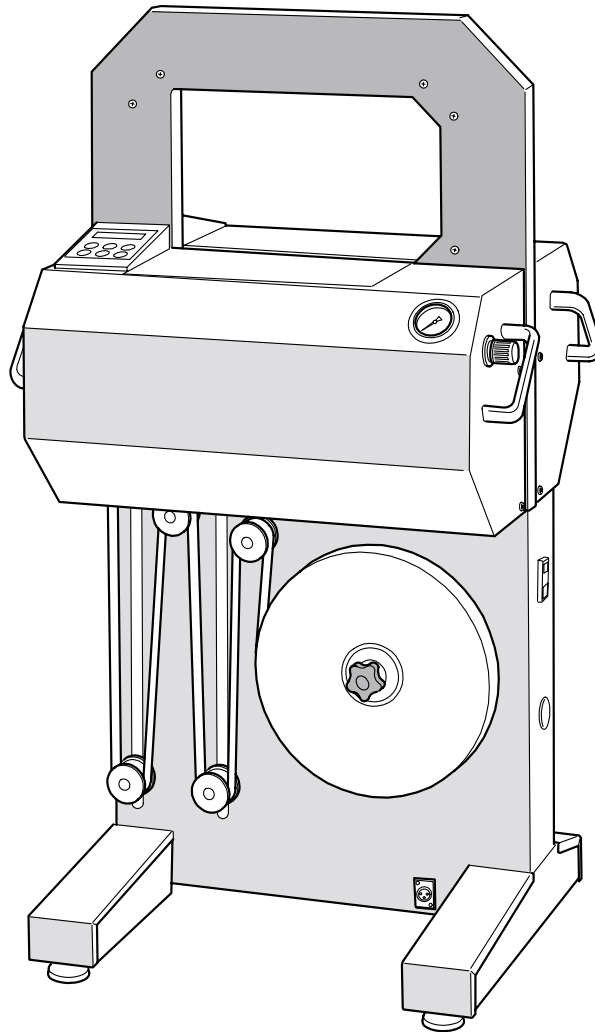


BAND-ALL

OPERATING INSTRUCTIONS



SUPPLIER : **BAND-all *international***
Marconiweg 9a
3442 AD Woerden
Tel.: +31 348-431520
Fax: +31 348-431480
E-mail: Info@bandall.nl

MODEL : **BAND'ALL 24/32/40/48**
E-prom version 5.09 and higher

Machine no. :

Date of construction :

The model plate with the CE coding is located on the left hand side of the undercarriage.

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1. OPERATING CONDITIONS

The operating location of the machine must meet a number of requirements.

The ambient circumstances may influence the quality of the banderole, the capacity, and the life span of the machine.

OPTIMUM

Temperature: 10°C - 30°C

Atmospheric humidity 10 - 90%

Ventilated location

Solid, even basis

UNFAVOURABLE

Extremely dusty location

Humidity

Presence of gases and vapours

CONNECTIONS

- Avoid multiple wall sockets and extension cords
- The plug must be fixed in the wall socket
- The plug must be grounded
- Voltage fluctuations have to be less than 10%.

SAFETY

- The machine is only to be turned on by the main ON/OFF switch
- The machine has to be switched off before attempts are made to remove the hoods
- The head of the sealing mechanism can be heated up to 220° C.
- Great caution is required during cleaning work.
- Do not touch moving parts while the machine is switched on.
- Ensure that dirt, dust, foil and paper remnants do not fall into the machine.
- Switch the machine off during long breaks.

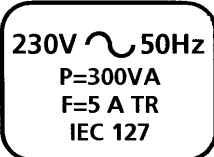
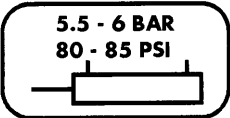
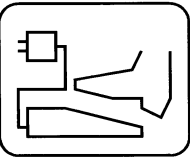
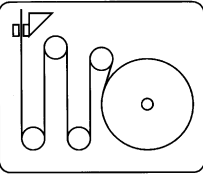
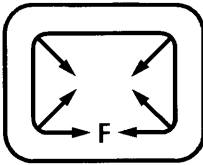

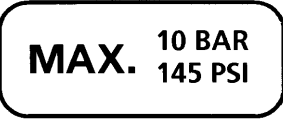

OPERATION, MAINTENANCE, REPAIR

- The use of the machine is restricted to the banding of dry products that fit in the arch.
- The machine is only to be operated by staff members who have been instructed by the supplier.
- Maintenance and repair may only be executed by qualified personnel.
- Do not use any water and/or corrosive detergents when cleaning the machine.

Any alterations of the machine, which are executed during the warranty period without notification of the supplier, may influence the warranty.

MARKS

If the marks are worn of, or if they have become illegible, they have to be replaced by the user.

	where	meaning
	right hand side undercarriage top	net-entrance
	right hand side undercarriage bottom	manometer working pressure
	front undercarriage left bottom	connection foot pedal
	front undercarriage left middle	diagram guide rollers
	front table right	manometer tape tension
	top table plate left	clamping danger
	back undercarriage left bottom	air connection
	back undercarriage middle top	electricity danger

1. CONNECTING THE BAND-ALL

Connect the machine to the compressed air supply (fig. 1). Minimum pressure 6 bar, maximum pressure 12 bar. The compressed air must be clean and dry. To make the connection, a female 1/4" ORION coupling is required. The air consumption is appr. 2 litres/min. at a rate of 30 bandings per minute.

Use the electrical cord supplied, and plug it into a grounded wall socket.

Voltage is 220-240 Volt 50 Hz / 110-120 Volt 60 Hz.

Power consumption 500 W.

Position the cord so, that it does not inconvenience the operator and is well clear of any moving parts such as, for instance, the tape guiding rolls.

Switch the main switch on the right side of the machine.

The display shows:

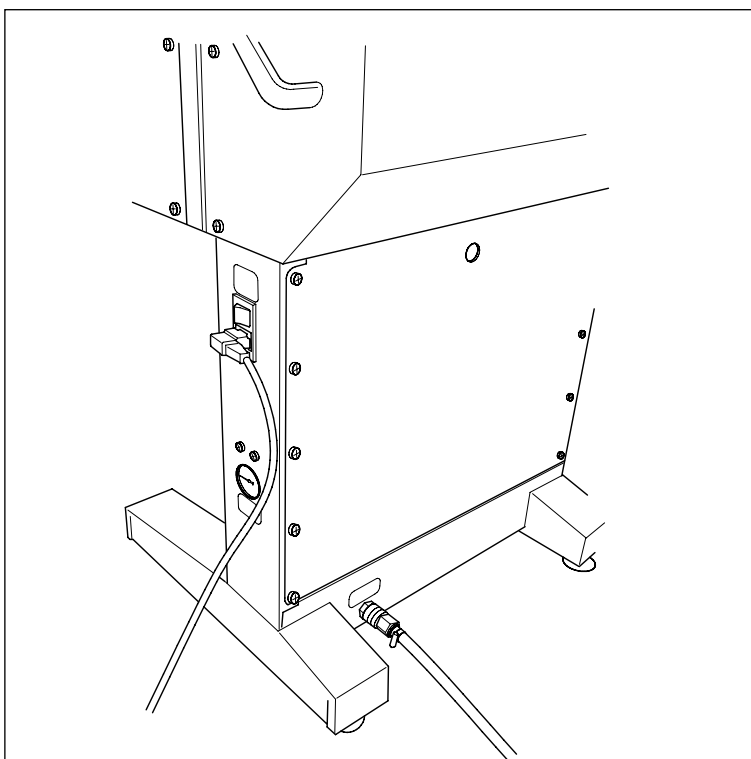
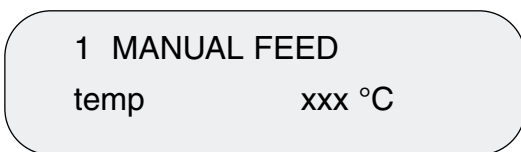


Fig. 1

MANUAL + FOOT OPERATION

When using the foot pedal (for connection see fig. 2) consult Summary of the program

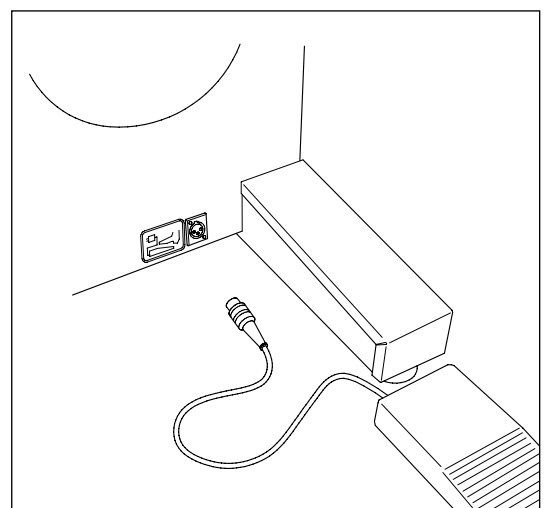


Fig. 2

2. INSTALLING A REEL OF TAPE

Turn the black knob counterclockwise to loosen it. Then remove the core of the old reel. Place a new reel on the holder in such a way that it unwinds as illustrated on fig. 3. Press the cardboard of the reel backwards as far as it will go.

DO NOT PRESS on the tape to prevent it from being pushed off the core. Now turn the black knob clockwise until the reel is well fixed.

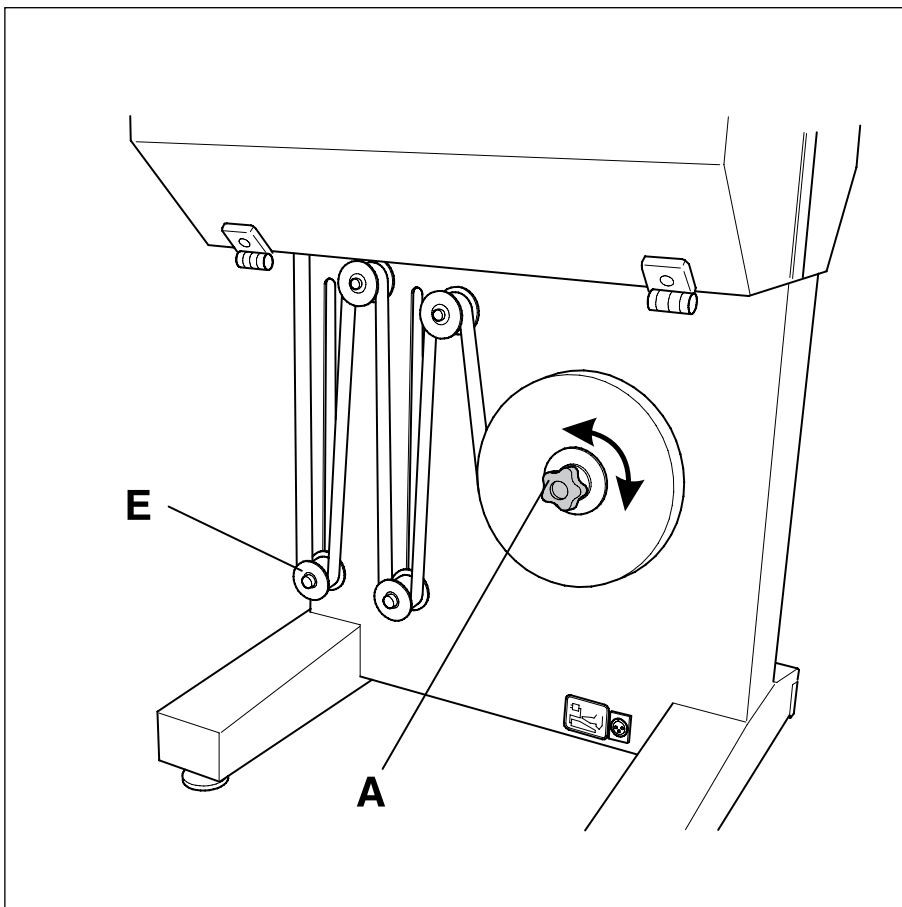



Fig. 3

3. FEEDING THE TAPE INTO THE MACHINE.


Feed the tape around the plastic rolls as illustrated on fig. 3 and then feed it through the brake-clamp (B). Feed the end of the tape under the green button at the left side of the machine (C) and hold the tape (D) by pressing the green button with one hand.

Now with the other hand press "enter"  The display shows: "pulses".

Now press "arrow up"  until the tape appears under the sealing-plate.

Release the green button. Hold the tape which appears under the sealing-plate.

Now press:  to cut tape.

Now press "manual":  until the machine automatically feeds the tape round in the loop.

Now press and hold "run"  until the display shows "counter".

If the tape is already fed in, it is possible to switch on the machine with the mainswitch on the right hand side.

The tape will now be pulled against the belts.

You can now push the tape under the sealplate.

You can go directly to "counter" and the machine is ready to be used.

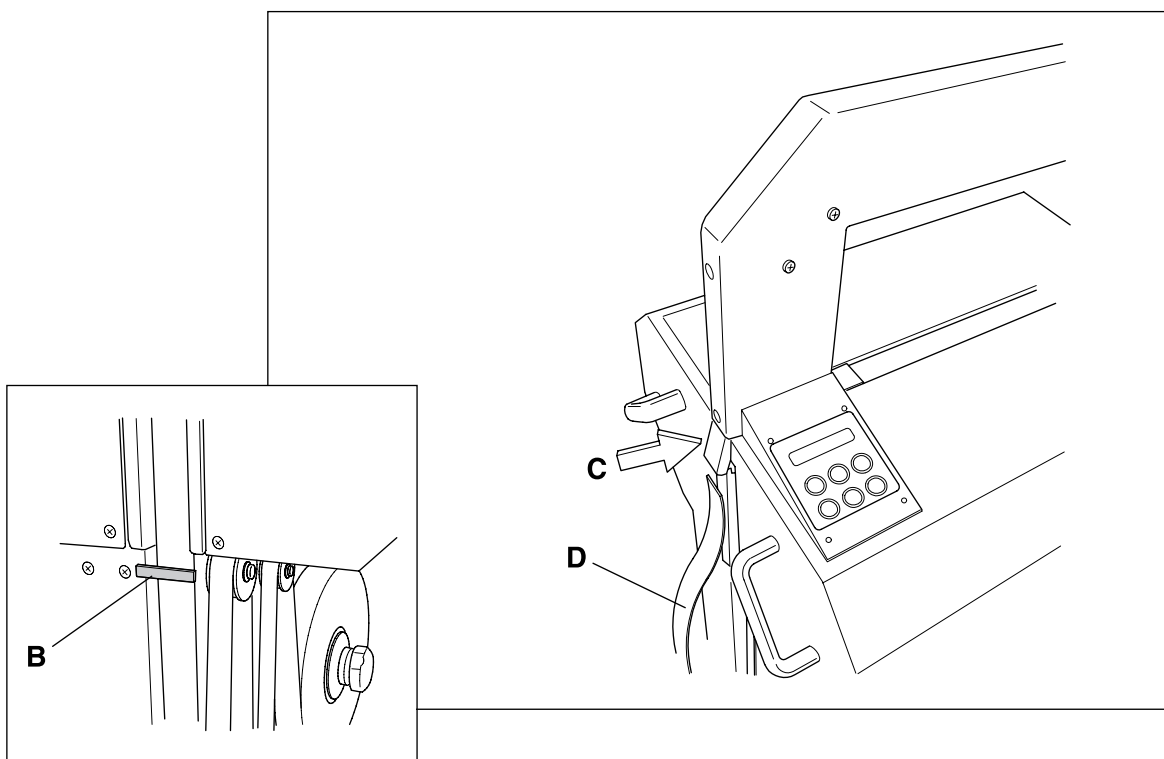


Fig. 4

4. TENSIONING THE TAPE

Before starting the banding procedure, the tape must be tensioned. Lift the guiderolls by hand (E) about 10 cm. The brake of the reel will now be released.

Now turn the reel counterclockwise; thus winding the tape onto the reel.

When the tape is tensioned, release rolls and reel; the reel unwinds a bit and is then stopped by the brake.

The machine is ready for operation now.

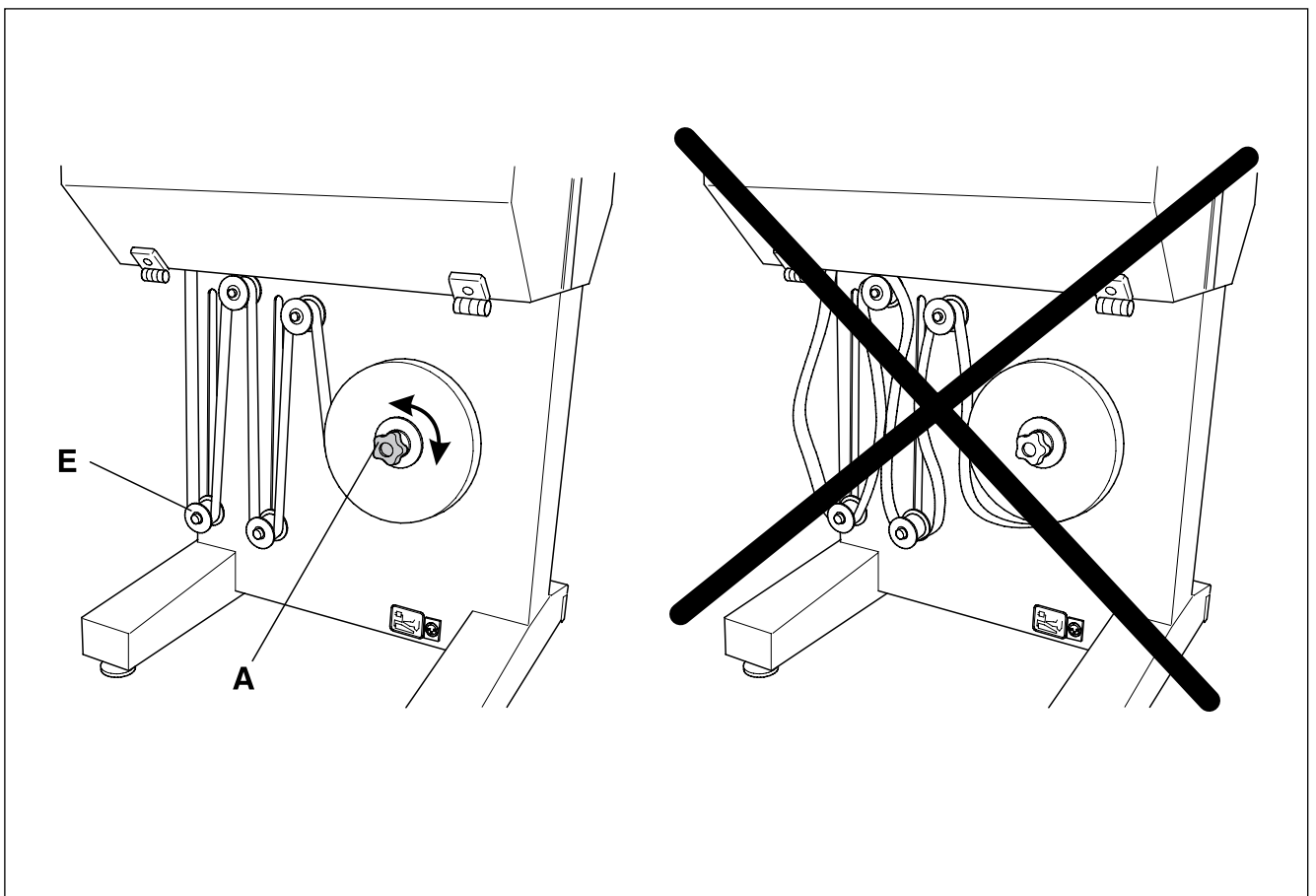


Fig. 5

5. ADJUSTING THE TAPE TENSION.

The tape tension of the BAND-all is continuously adjustable by means of the adjustment knob. The adjustment knob can be locked by pressing it inward and unlocked by pulling it outward. Turn the knob clockwise to increase the tape tension. You will see that the reading on the tension gauge increases. When the pointer has reached 6, the maximum tension has been set **and there is no point in turning the adjustment knob any further.**

To decrease the tape tension, turn the knob counterclockwise. You will see that the reading on the tension gauge decreases. The tape tension should always be adjusted in the increasing direction. So, when changing from a higher to a lower tape tension, first decrease too much and then increase back up to the desired value.

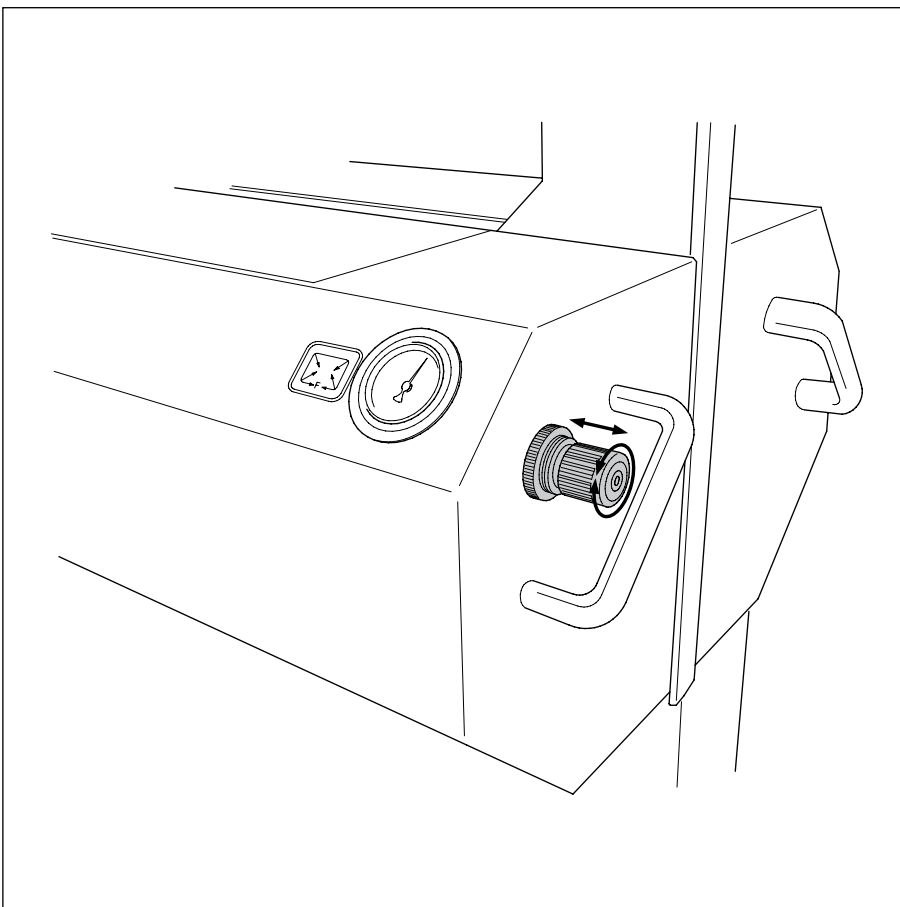


Fig. 6

6. REPLACING THE FUSE IN THE MAIN SOCKET

After the machine has been plugged into the mains and switched on by means of the main switch, the light in the main switch must light up. If this is not the case, check the power socket for voltage. If a voltage is present and the light in the switch is not lit, the fuse in the power socket must be replaced. Remove the power cord plug from the wall socket and remove the power cord from the BAND-all.

The fuse holder is located below the power cord jack in the power socket (see fig. 7). The fuse holder has two positions for holding fuses. Both positions are for operating fuses.

Replace the fuse in the holder with a similar fuse, dimensions 5 x 20 mm, 5 Amp, slow, 220 V. **NEVER** replace the fuse with one having an amperage higher than 5.

If the fuse blows again immediately after the machine has been switched on, there is probably a short-circuit somewhere in the machine. In this case contact your supplier.

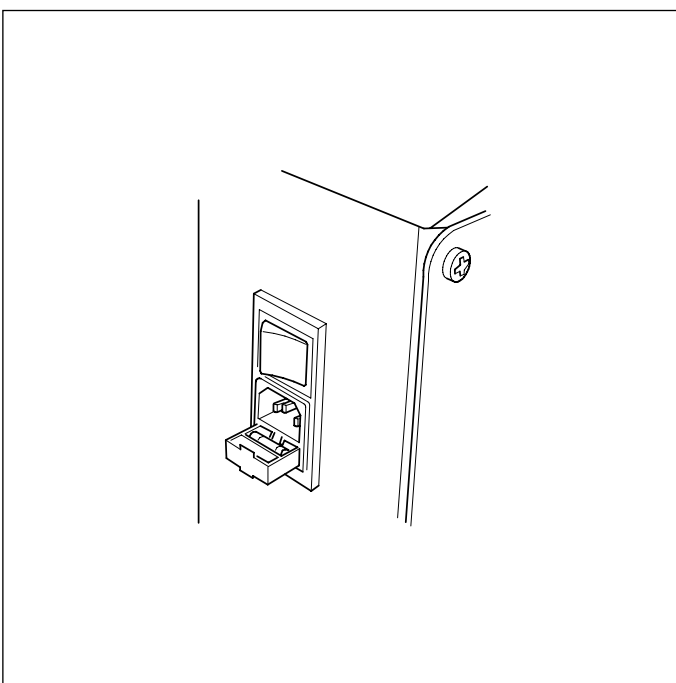
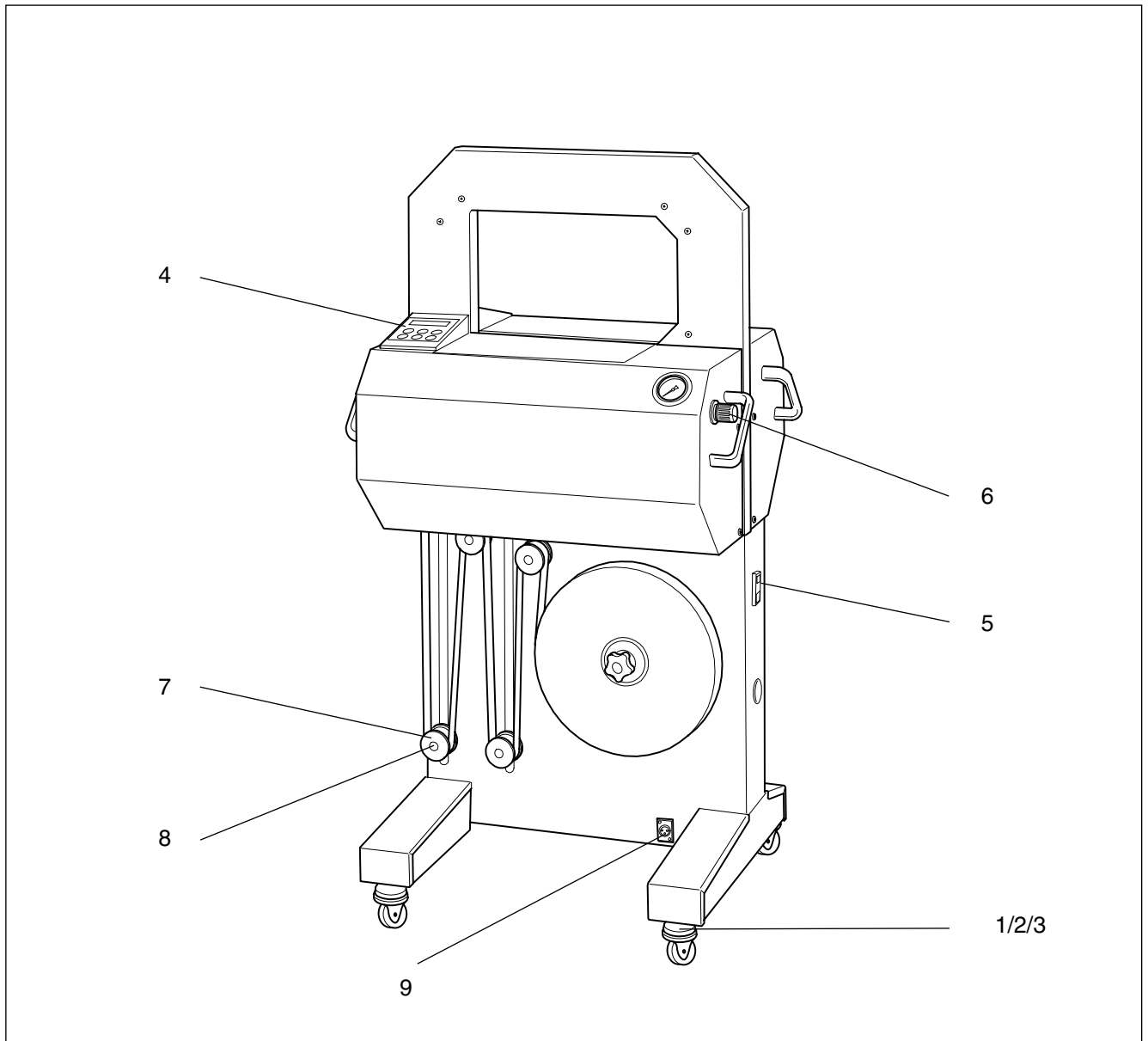


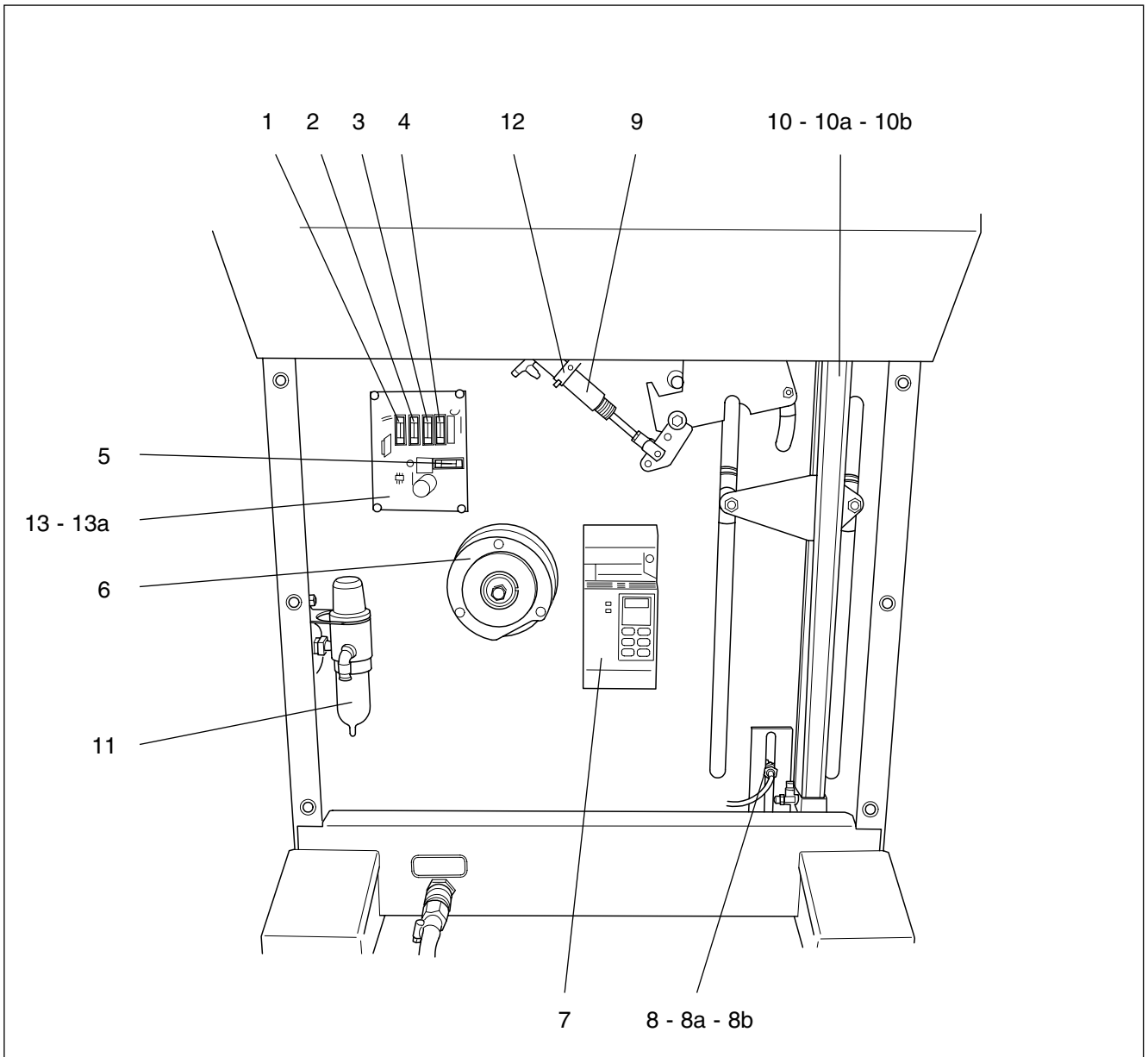
Fig. 7

P-01



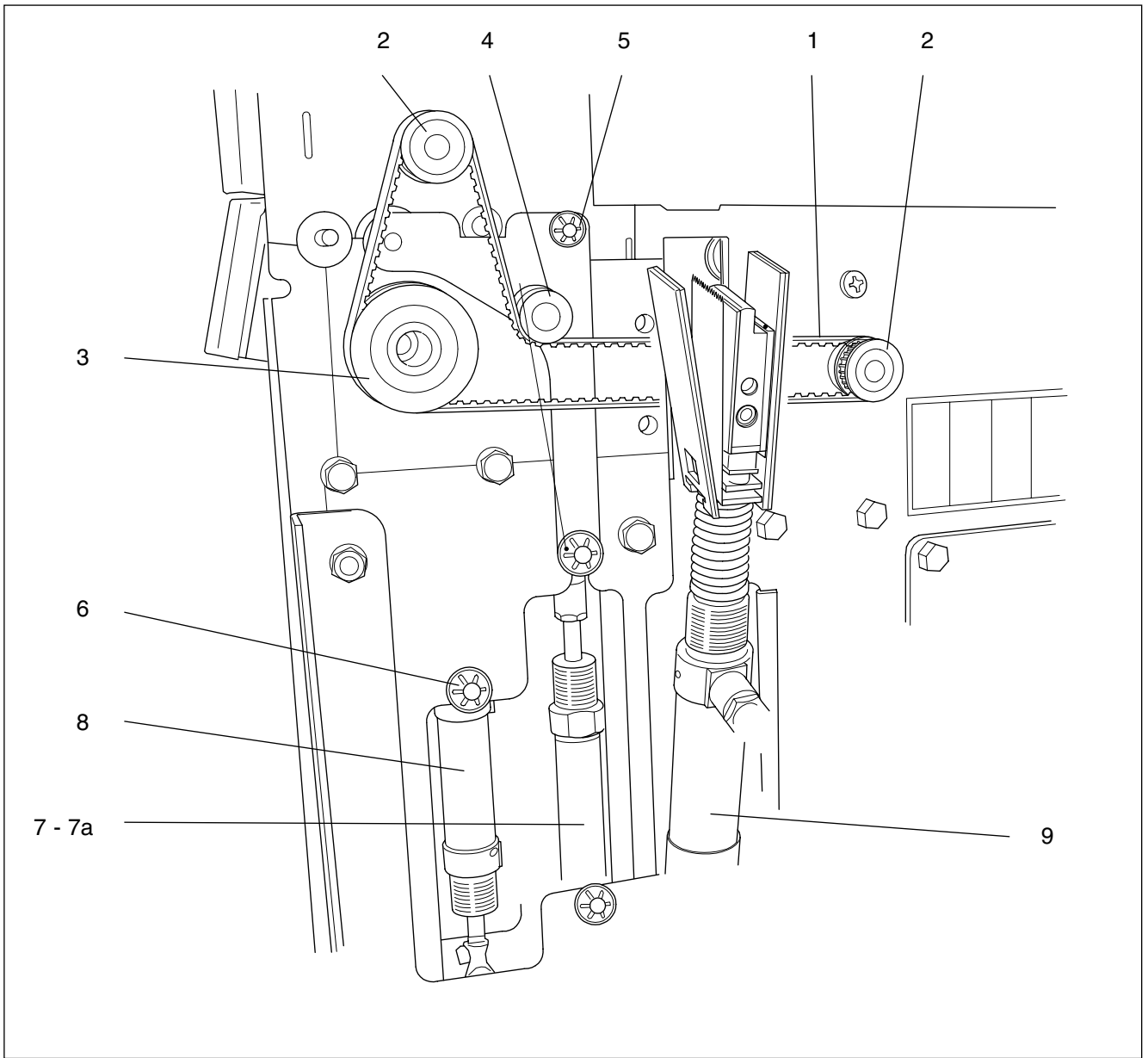
Pos.	Description	Part number
1	Wheel	2OZ300040
2	Wheel with brake	2OZ300050
3	Wheel set	2OZ300060
4	Display complete	2ET307080
5	Main socket	2EN307010
6	Press.reducer tape tension	2PR304210
7	Guide roller	2OO305410
8	Bolt guide roller	2OP305510
9	Footswitch socket	2EC307260

P-02



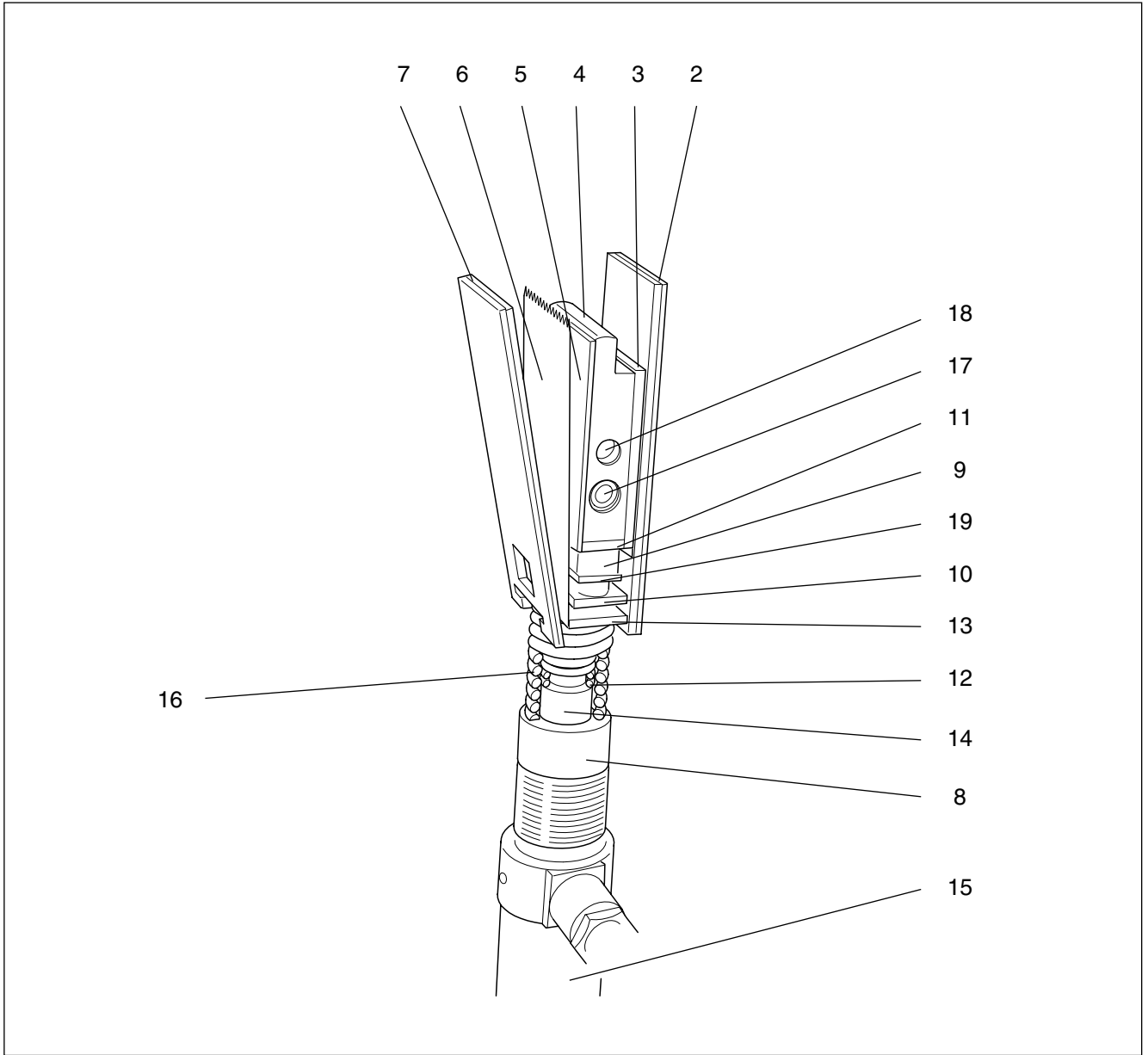
Pos.	Description	Part number
1	Fuse solid state relay	2F 800 ma
2	Fuse display/transformer	2F 250 ma
3	Fuse fan	2T 1 A
4	Fuse freq. controller	2T 3,15 A
5	Fuse brake/LED (green)	2T 2 A
6	Electric magnetic brake	2EE300630
7	Freq. controller	2EF307050
8	Sensor wagon	2ES300730
8a	Wagonsensor OMRON	2ER305760
8b	Wagonsensor SUNIX	2ES305750
9	Cylinder tapetension	2PC305670
10	Lintra Norgren	2PB306010
10a	Lintra Band-all	2PB306011
10b	Lintra (25 mm)	2PB306012
11	Press. reducer	2PR300810
12	Sensor tapetension	2ES305730
13	Switchboard 220 V	2EP307110
13a	Switchboard 220 V exchange	2EP307111

P-03



Pos.	Description	Part number
1	Timing belt	2AT301970
2	Pulley belt drive	2AP301910
3	Motor pulley	2AP301850
4	Tensioner	2AL302080
5	Lock	2AB301580
6	Lock	2AB301650
7	Cyl. upper left clamp	2PC301700
7a	Cyl. upper left clamp (20 mm)	2PC301600
8	Cylinder tape brake	2PC302530
9	Cut + seal unit complete	2LC302600

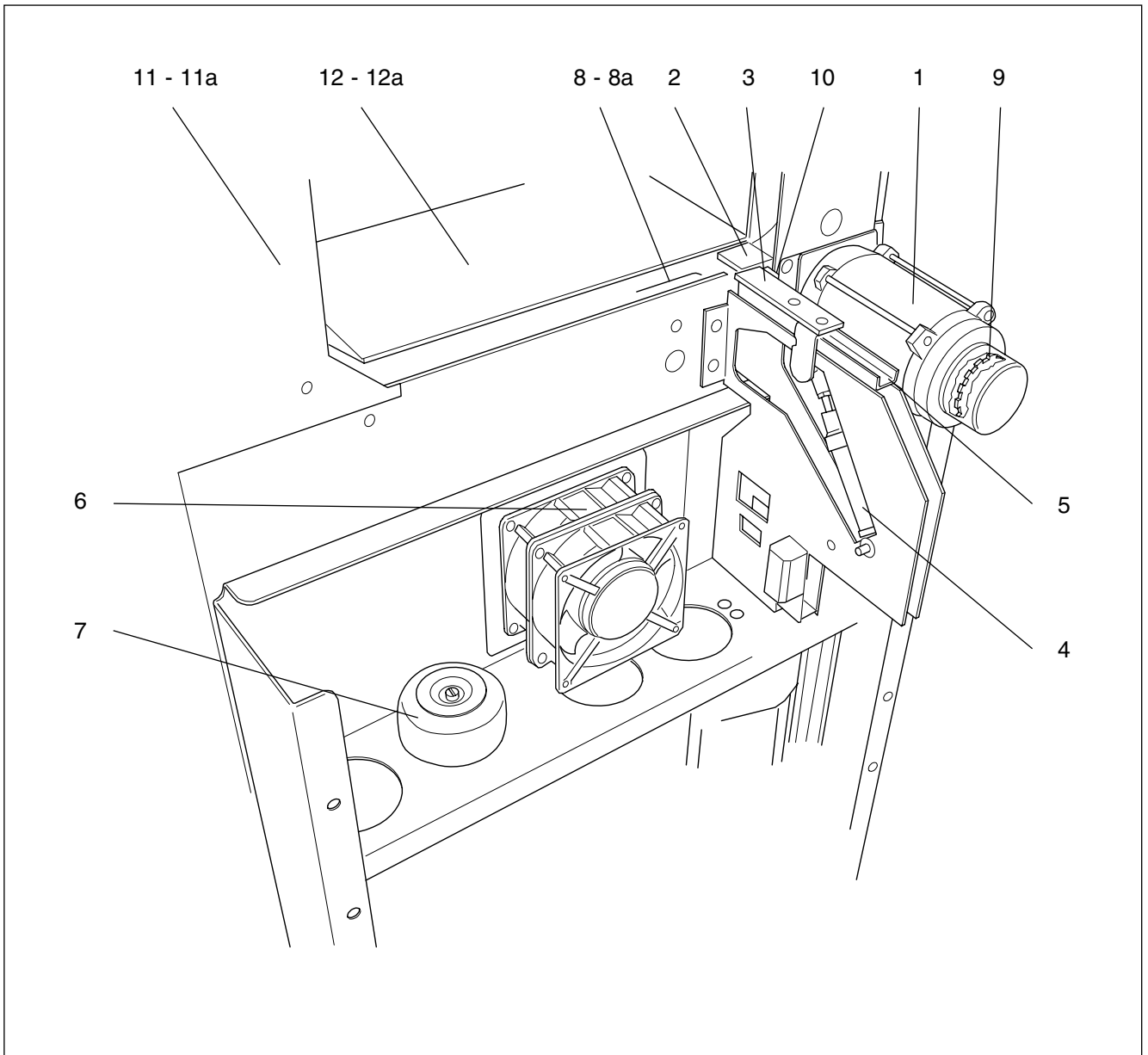
P-04



Pos.	Description	Part number
1	Cut + seal unit complete	2LC302600
2	Clamp right	2LK302780
3	Isolation R.	2LI 302810
4	Sealhead	2LK302610
5	Isolation L.	2LI 302800
6	Cutter	2LM302740
7	Clamp left	2LK302770
8	Spring guide	2LB302830
9	Block sealhead	2LB302670
10	Pushplate cutter	2LD302730
11	Earthplate sealhead	2LL302660
12	Spring cutter	2LV 302750
13	Pushplate clamps	2LD302760
14	Connecting rod	2LK302820
15	Cyl. Cutting + sealing	2PC302840
16	Spring clamps	2LV302790

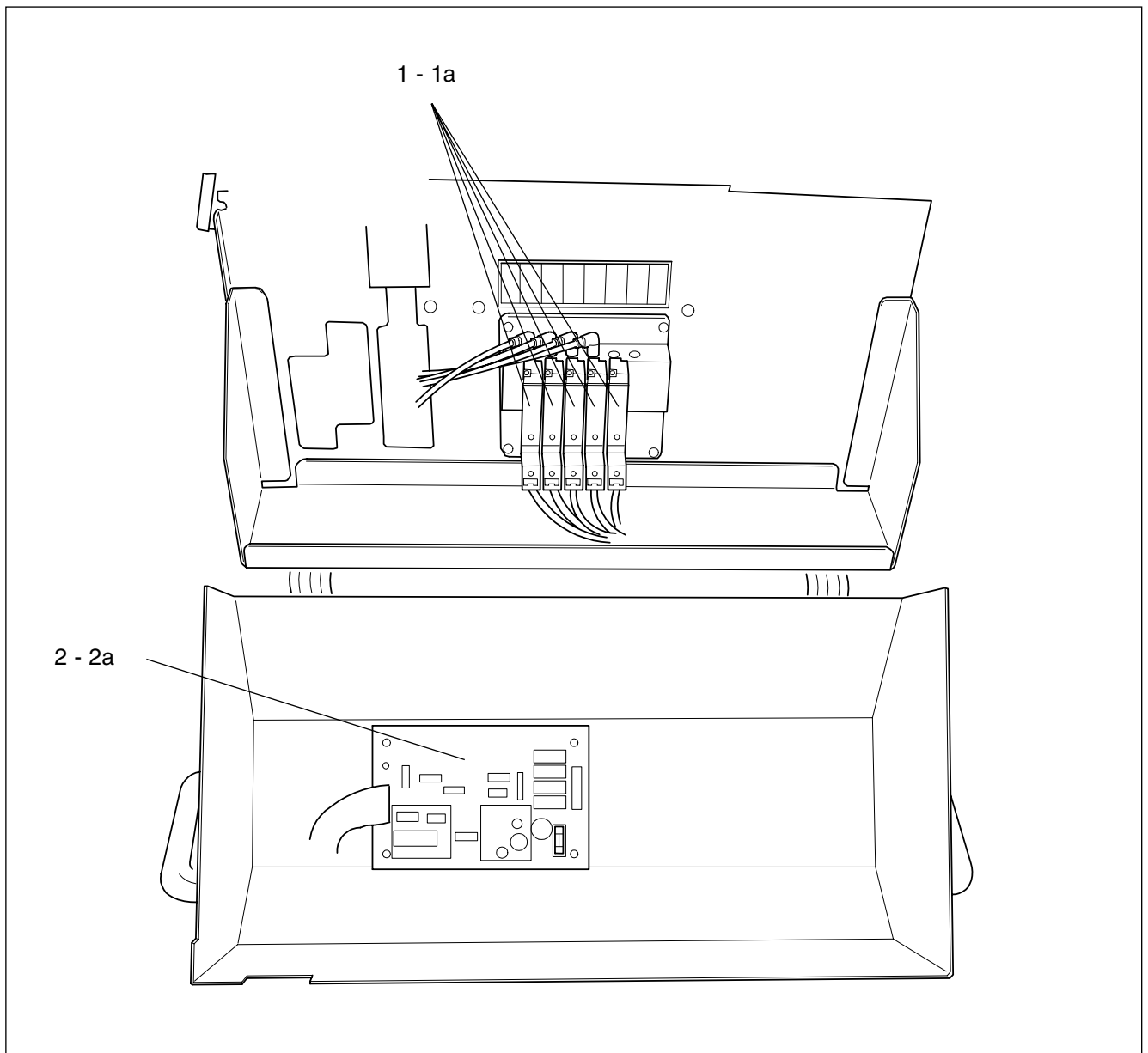
Pos.	Description	Part number
17	Heatingcartridge	2EV302620
18	PT 100	2ET302630
19	Mounting plate sealhead	2LM302700

P-05



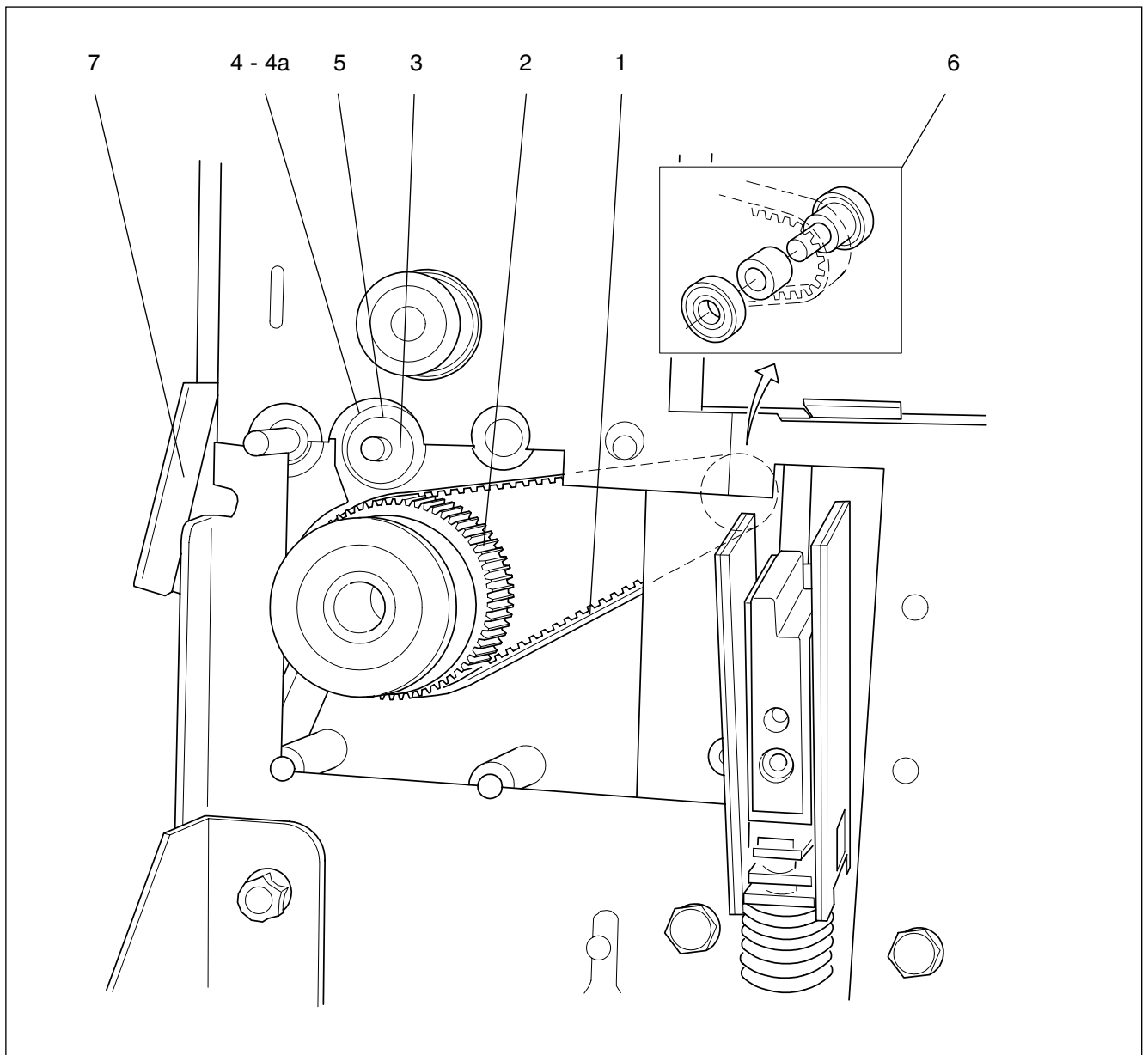
Pos.	Description	Part number
1	Motor	2EA301810
2	Upper left clamp	2LK301540
3	Sealingplate	2LL303020
4	Cyl. sealingplate	2PC303830
5	Slide sealingplate	2LS302970
6	Fan	2EV300610
7	Transformer	2ET304120
8	Beltset BA 32	2AS300590
8a	Beltset BA 24	2AS300240
9	Counter plate	2EP301880
10	Fotocel	2EF303960
11	Archplateset BA 24	2OB301430
11a	Archplateset BA 32	2OB301200
12	Tablecoverplate stainless BA 24	2OW304420
12a	Tablecoverplate stainless BA 32	2OW304230

P-06



Pos.	Description	Part number
1	Valve NORGREN	2PL308020
1a	Valve BAND all	2PV308130
2	Switchboard 24V	2EP307120
2a	Switchboard 24V exchange	2EP307121

P-07



Pos.	Description	Part number
1	Belt tape feed	2AT301960
2	Motorpulley	2AM301850
3	Spacer	2AK301730
4	Tension roller 15 mm	2AA301790
5	Bearing	2AL301750
6	Bearing set tape feed	2AL305820
7	Feed-in button complete	2AK303400

APPENDIX

Summary of the program (display-functions)

PROGRAM MODES

The program of the machine is divided into three modes:

1 The user mode.

This mode only allows feeding tape into the machine and operating it.

2 The “Set up” mode.

This mode allows the same functions as in user mode as well as making adjustments to the setting.

3 The “Service mode”.

This mode allows the same functions as in “set up” mode as well as making changes in 16 other menu's which affect operation characteristics.

The “Service” mode is only available to representatives of manufacturer, supplier and dealer!.

THE USER MODE

The user mode is always automatically available when machine is switched on. It gives access to only menu 1, manual feed, to feed tape into machine and to operate it.

1. USERS MENU

Switch the machine on by means of the main switch. Menu 1 appears in the display. Install a reel of tape and feed the tape around the plastic rolls as shown in the diagram. Feed the end of the tape under the green button and press the button thereby clamping the tape. When the machine is switched on, menu 1 is selected automatically.

Press  and then 

Then press  to cut tape.

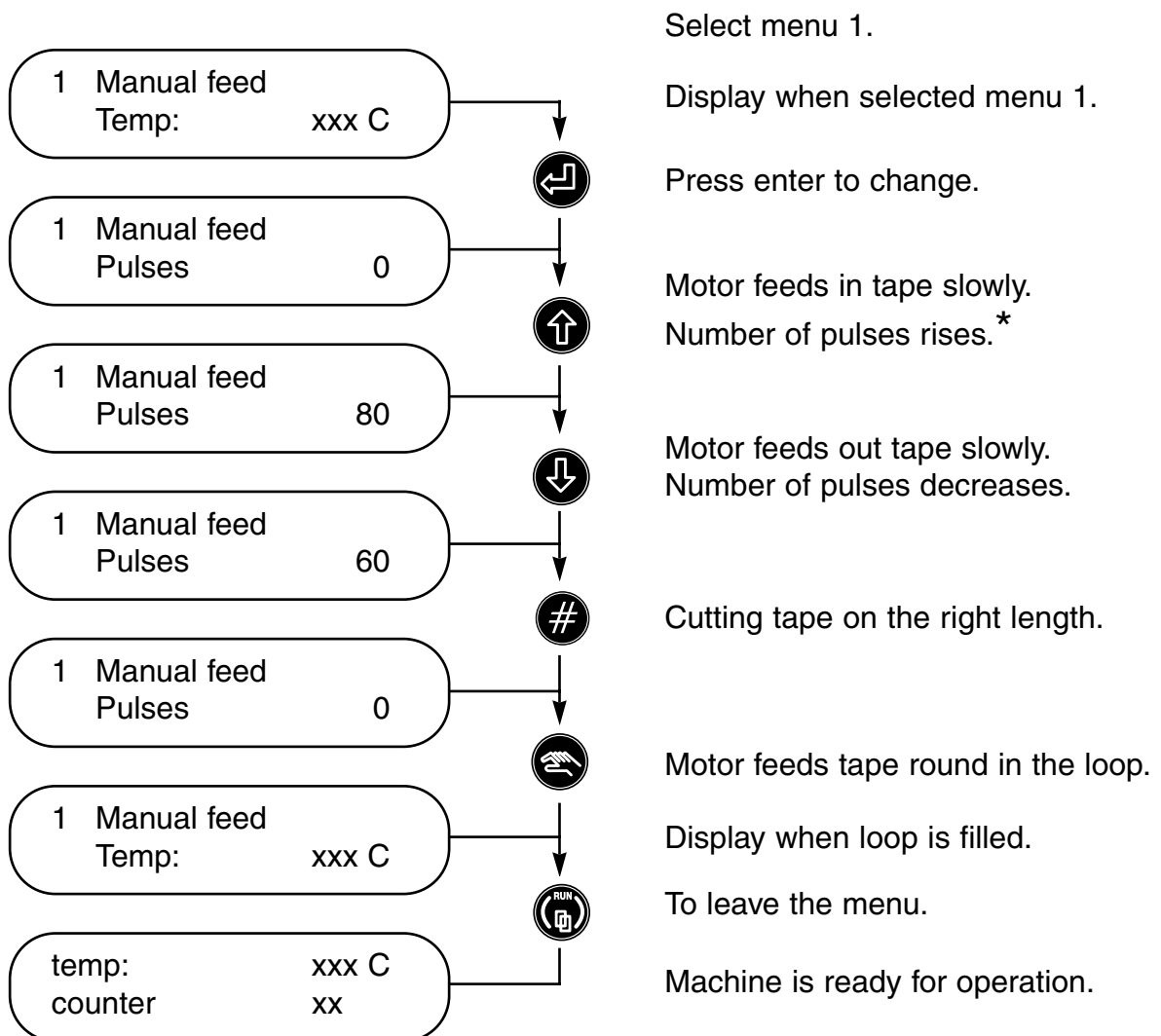
Then press  until tape is fed. Then press  until counter is activated.

If the tape is already fed in, it is possible to switch on the machine with the mainswitch on the right hand side.

The tape will now be pulled against the belts.

You can now push the tape under the sealplate.


You can go directly to "counter" and the machine is ready to be used.



* If tape does not appear under the sealplate, the feed-in is not right. **Stop feeding material** to avoid damage.

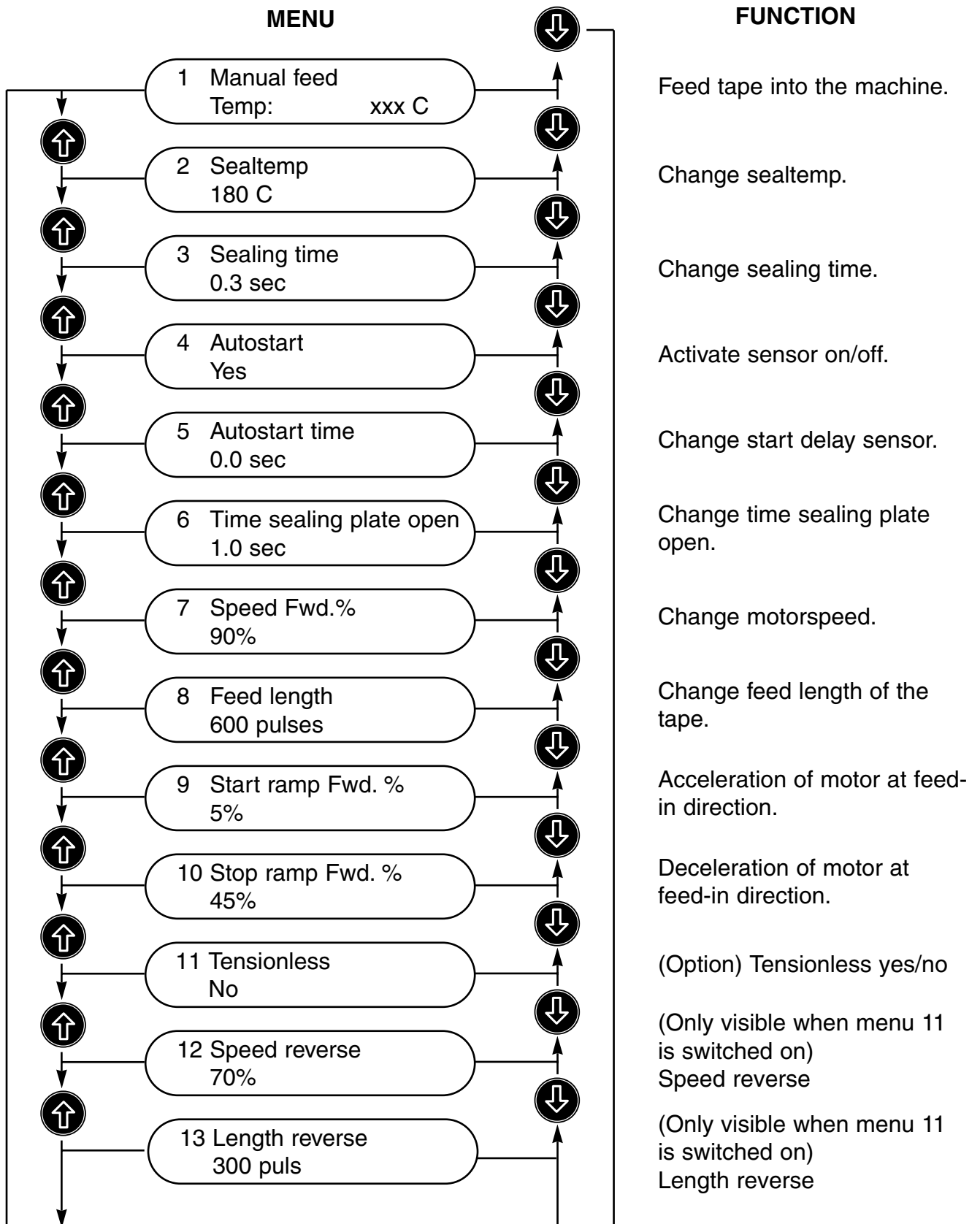
THE “SET UP” MODE

To make the “Set up” mode available the machine has to be switched off first.

Then switch the machine on again while keeping the  button pressed.

We recommend not to make this start-up procedure public if it is desired that users do not make changes!.

SUMMARY OF THE FUNCTIONS IN THE "SET-UP" MENU 1/2



continued on page 23

SUMMARY OF THE FUNCTIONS IN THE "SET-UP" MENU 2/2

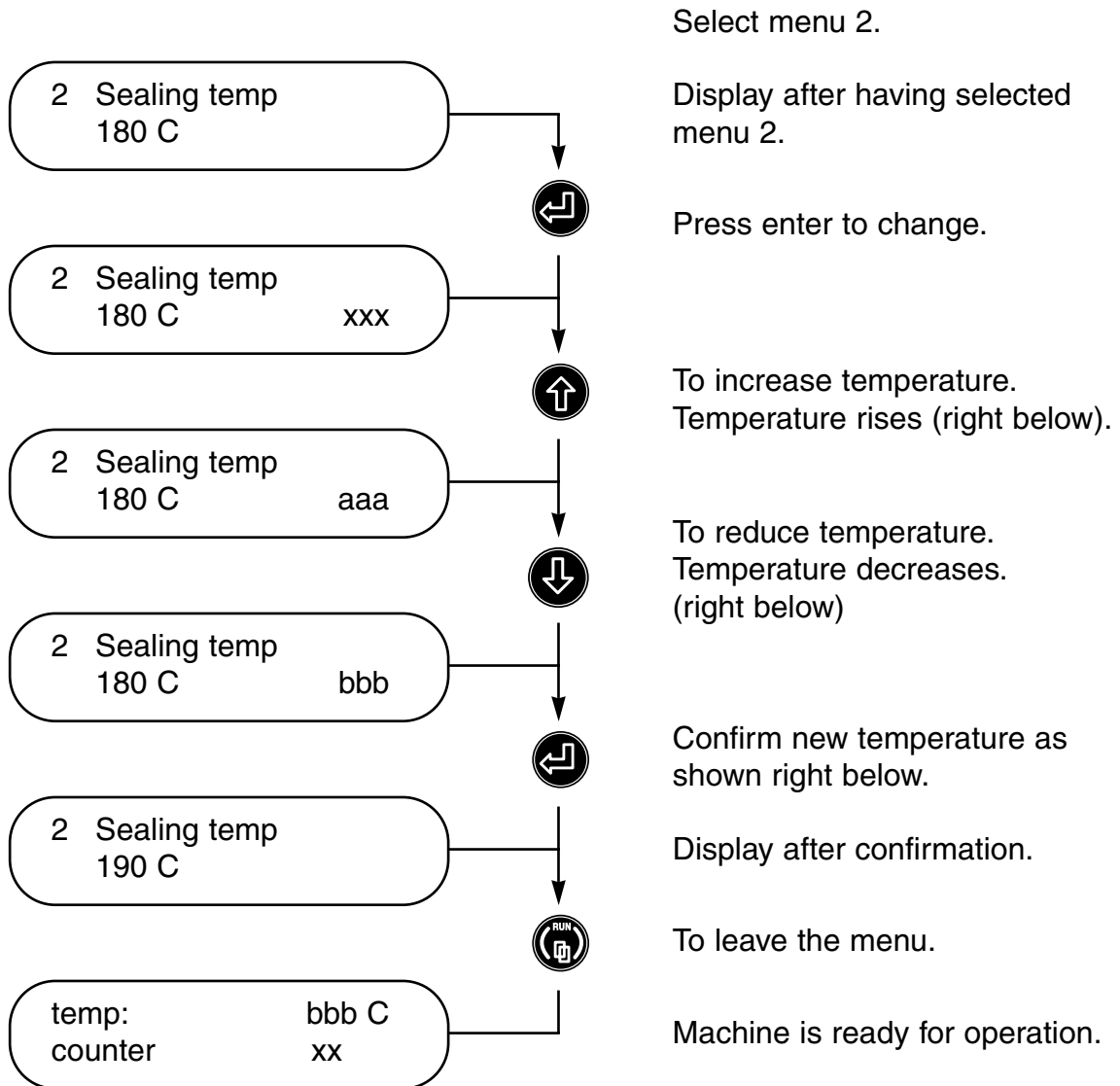
MENU	FUNCTION
14 Start ramp reverse 5%	(Only visible when menu 11 is switched on) Acceleration of motor while feeding out tape
15 Stop ramp reverse 30%	(Only visible when menu 11 is switched on) Deceleration of motor while feeding out tape
16 Mark reader Off	Mark reader off/on
17 Type of Mark Spot	(Only visible when menu 16 is switched on) Adjusting Type Mark
18 Press Off	(Option) Press off/on
19 Press start 3.0 sec.	(Only visible when menu 18 is switched on) Adjusting Press starting time
20 Press release 3.0 sec.	(Only visible when menu 18 is switched on) Adjusting Press stopping time
21 Extra tension off	Extra tape tension off/on.
22 Pressure monitor Off	(Option) Pressure monitor off/on
23 Select language English	Change language on display.
24 Save program	Save machine settings.
25 Load program	Load machine settings.

2. CHANGE SEALING TEMPERATURE

The quality of the sealing depends on the right quantity of supplied heat. If more or less heat is required, the temperature of the sealing-head can be increased or reduced. **DO NOT** increase the temperature of the sealing head over 225°C. The teflon on the sealinghead can not take more than 225°C. If you want to supply more heat, increase the sealing time in menu 3.

To change the temperature, select menu 2.

Use the buttons:   



Standard temperature settings are:

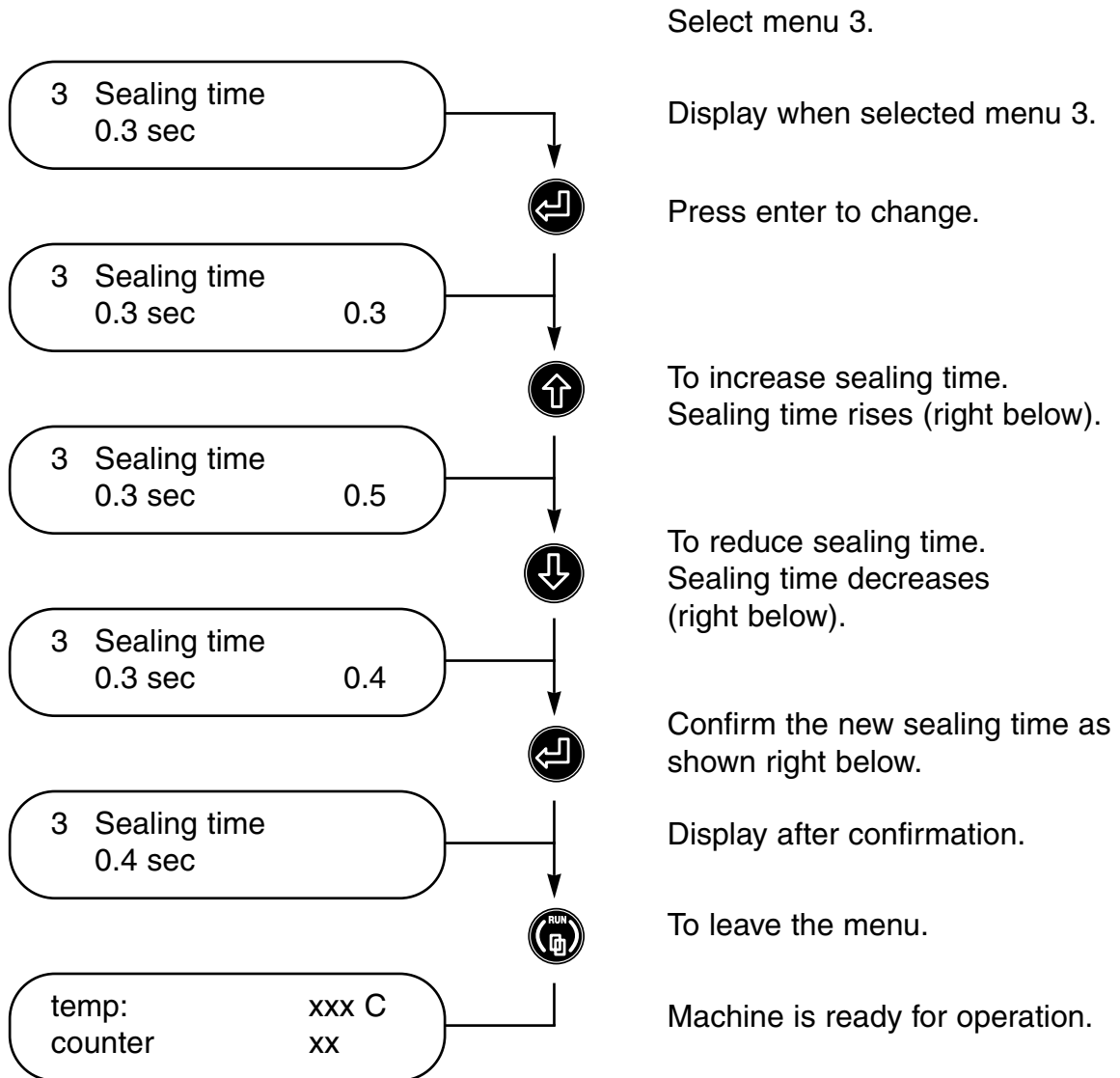
Film 50 my	180°C
Film 80 my	200°C
Paper	200°C

3. CHANGE SEALING TIME

The quality of the sealing depends on the right quantity of supplied heat. If more or less heat is required, the sealing time can be increased or reduced. **DO NOT** reduce the sealing time below 0,3 sec. This prevents the changing air pressure of the compressor from having too much influence on the seal. If you still want less heat, reduce the sealing temperature in menu 2.

To change the sealing time, select menu 3.

Use the buttons:   



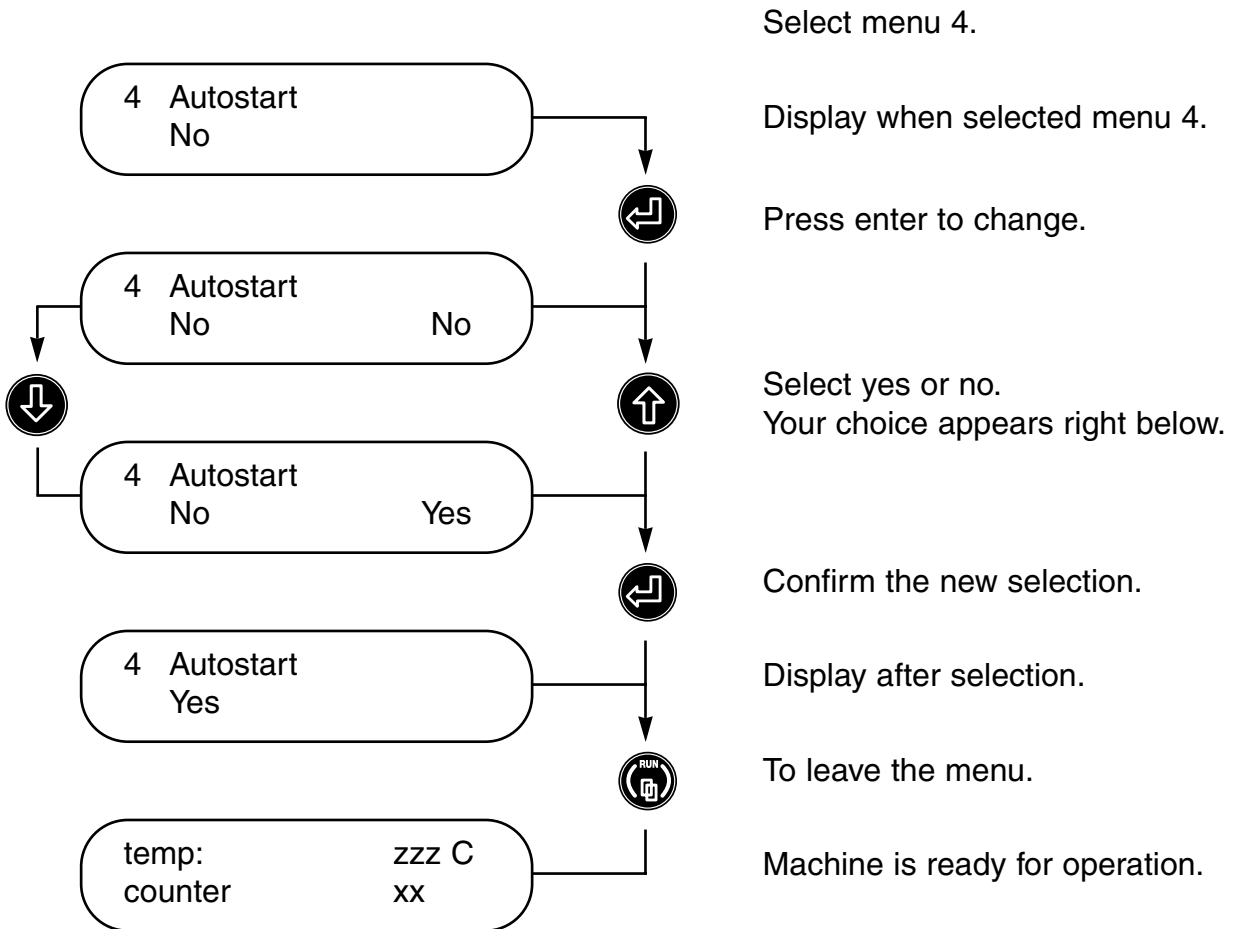
Standard sealing time: 0,3 - 0,4 sec.

4. ACTIVATE SENSOR ON/OFF.

The machine can be operated manually (button) or by foot (switch), and **automatically** as well. If the menu "4 autostart" has been selected, the machine starts automatically as soon as the product covers the sensor (the sensor detects the product).

To select automatic start, select menu 4.

Use the buttons:   



If selected "auto start no" the machine can be operated by hand or foot, **but the product must always cover the sensor.**

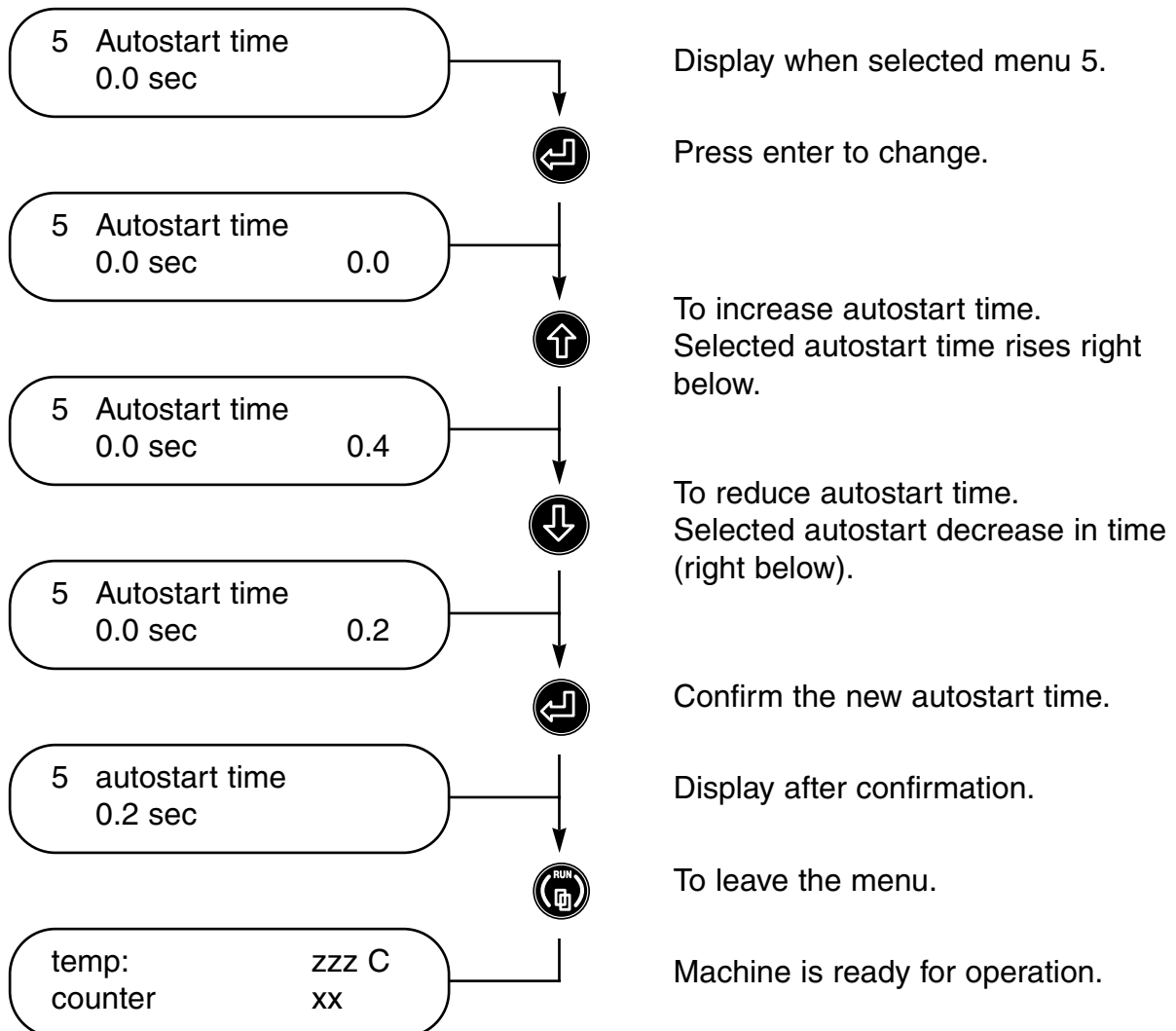
5. CHANGE START DELAY SENSOR.

The machine starts automatically, when in the menu 4 "autostart" has been selected and the product covers the sensor in the table (the sensor must detect the product).

If more time is required between placing the product on the table and the automatic starting of the machine, the start delay of the sensor can be reduced and vice versa.

To change the delay of the sensor, select menu 5.

Use the buttons:   



6. CHANGE "TIME-OPEN" SEALING PLATE.

While the machine bands a product, the sealing plate is between the product and the tape. To avoid the tape from being clamped by the sealing plate when it is moved in a backward direction and then closed, the time-open can be increased.

ATTENTION: If this time is set on 0.1 sec. or higher and the photocell is not covered while banding, then the sealplate will NOT open!.

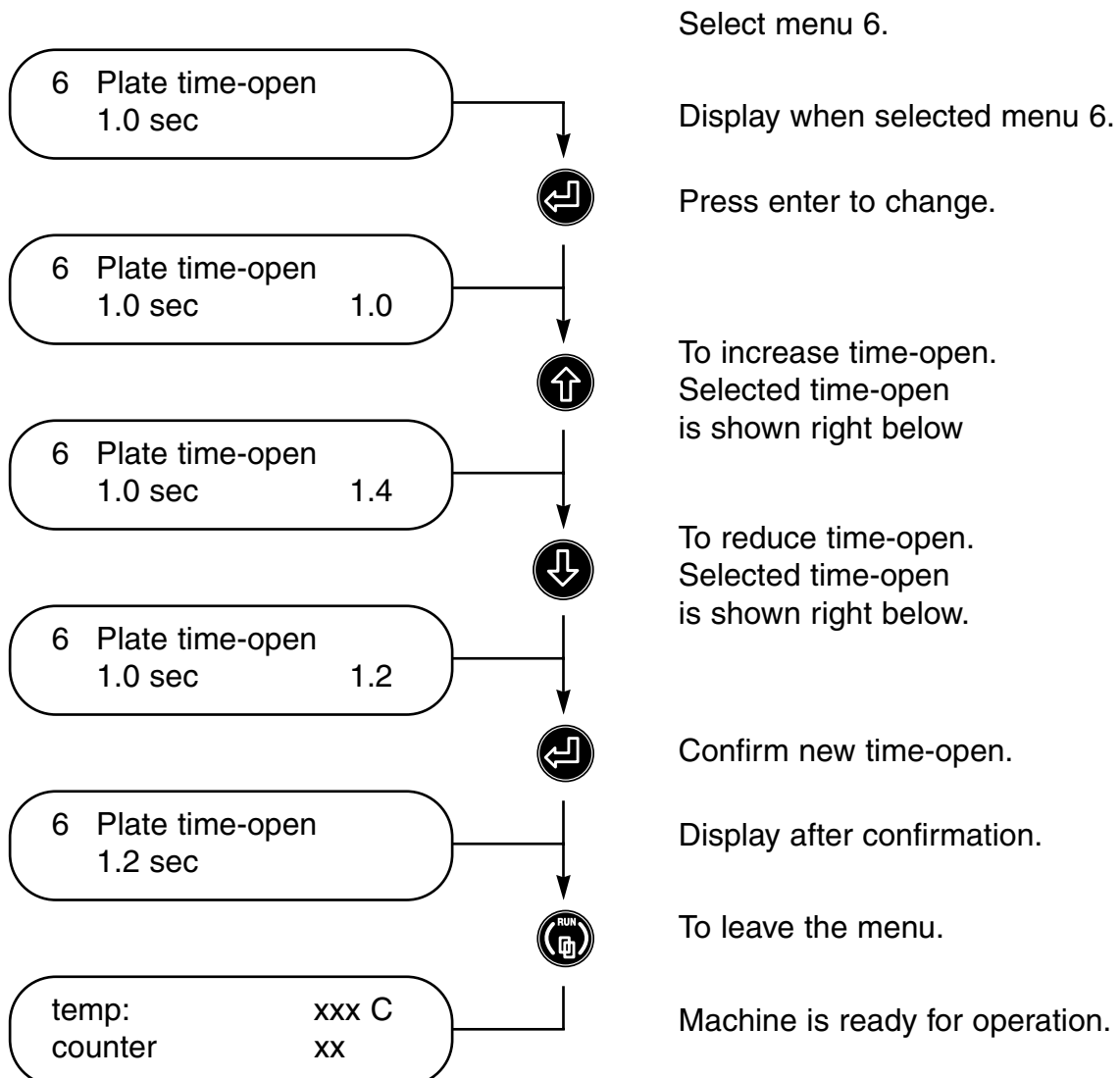
This is done for safety reasons.

When this time is set on 0.0 sec., then the sealplate will stay open as long as the photocell is covered!.

But when this time is set on 0.0 sec. and the photocell is not covered while banding the sealplate will open for 0.1 sec.!. This is done to make the machine more suitable for automatic lines.

To change the "open time" of the sealing plate, select menu 6.

Use the buttons:   

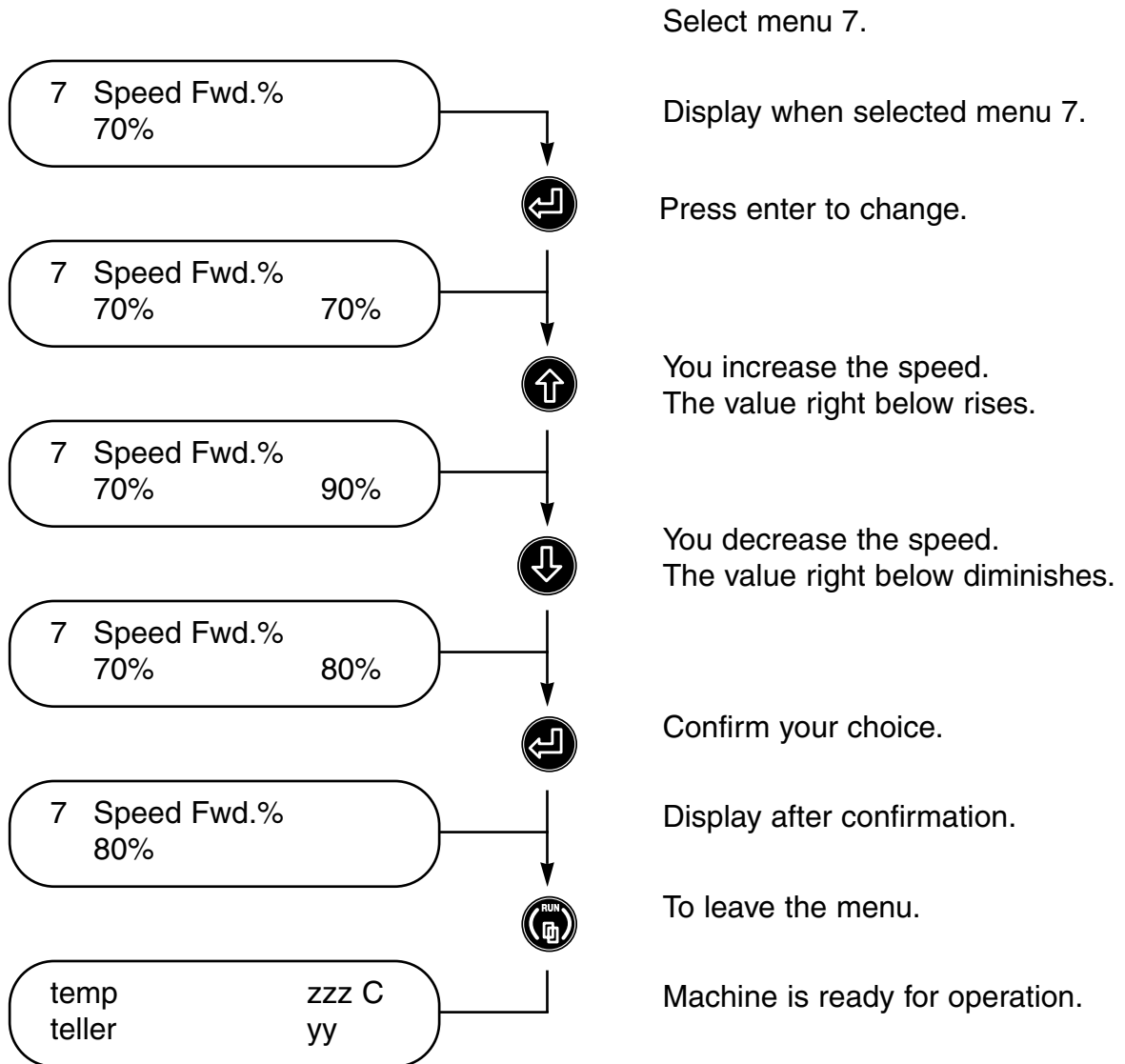


7. CHANGE FEED-IN SPEED.

In some cases it is desirable to change the feed-in speed of the tape. It is possible to change the speed in steps of 1 %.

To change the speed, select menu 7.

Use the buttons:   



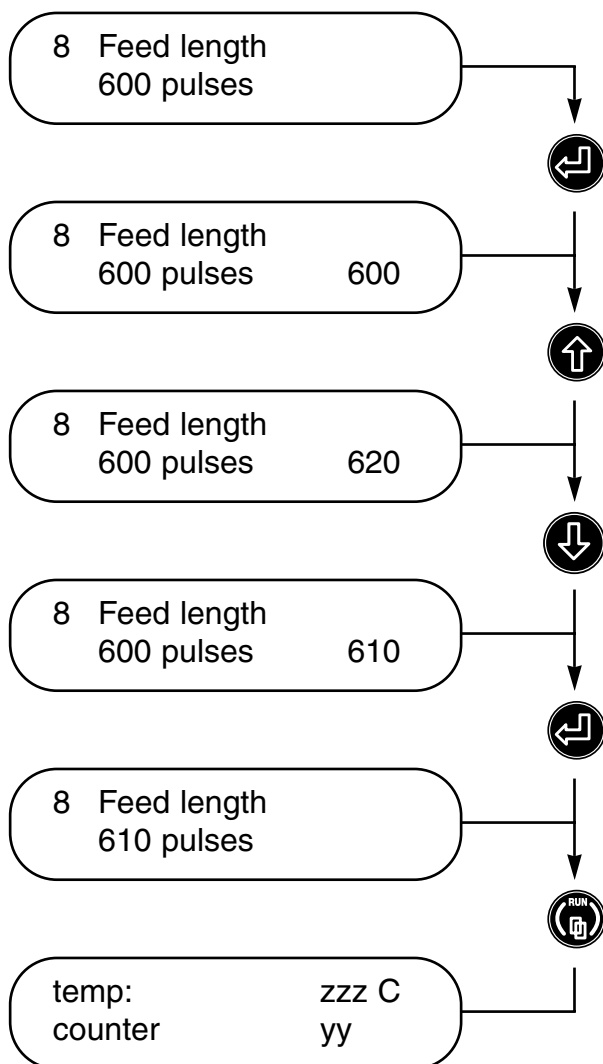
8. CHANGE THE FEED LENGTH OF THE TAPE.

After having made a banding, new tape is inserted into the loop. Precisely enough tape is inserted, to appear under the sealing plate.

The right length of the tape can be adjusted by increasing or reducing the number of pulses.

To change the length of the tape, select menu 8.

Use the buttons:   



Select menu 8.

Display when selected menu 8.

Press enter to change.

To increase the number of pulses.
The number of pulses right
below rises.

To reduce the number of pulses.
The number of pulses right
below decreases.

Select the number of pulses right
below as new value

Display after confirmation.

To leave the menu.

Machine is ready for operation.

9 STARTRAMP FWD.%

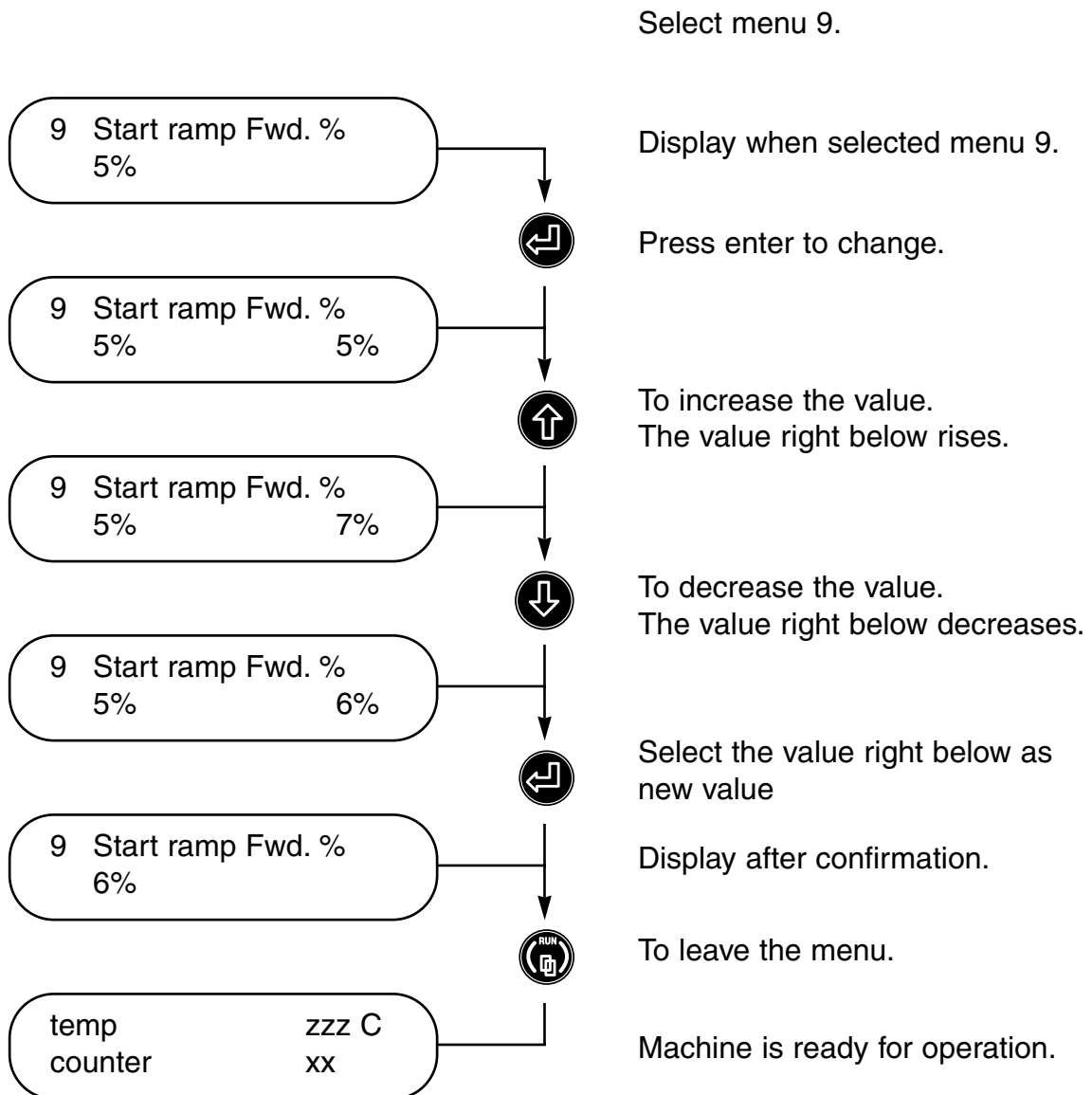
With this adjustment you can change the acceleration of the motor in feed-in direction. The acceleration is indicated in %.

This percentage is related to the amount of pulses that is set in menu 8 "feed-in length".

So if menu 8 is set on, for example, 600 pulses and menu 9 "Startramp Fwd." on 5%, then the motor will use 30 pulses (5% of 600) to go from 0 to maximum speed.

ATTENTION: Do **NOT** adjust "Startramp Fwd." lower than 5%!

Use the buttons:



10 STOPRAMP FWD.%

With this adjustment you can change the deceleration of the motor in feed-in direction.

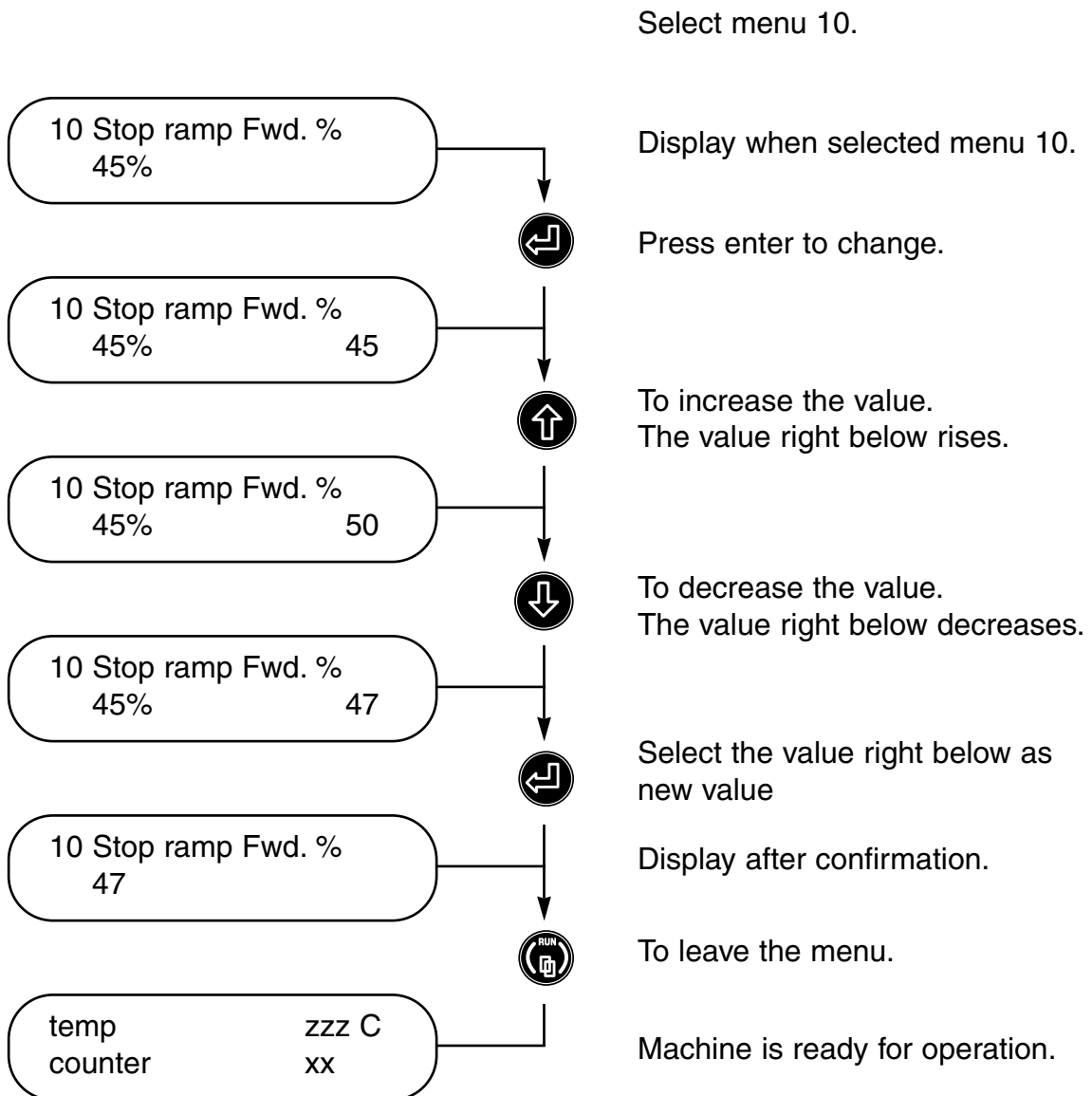
The deceleration is indicated in %.

This percentage is related to the amount of pulses that is set in menu 8 "feed-in length".

So if menu 8 is set on, for example, 600 pulses and menu 10 "Stopramp Fwd." on 40%, then the motor will use 240 pulses (40% of 600) to go from maximum to 0 speed.

This adjustment is machine dependent.

Use the buttons:



11 TENSIONLESS (Optional)

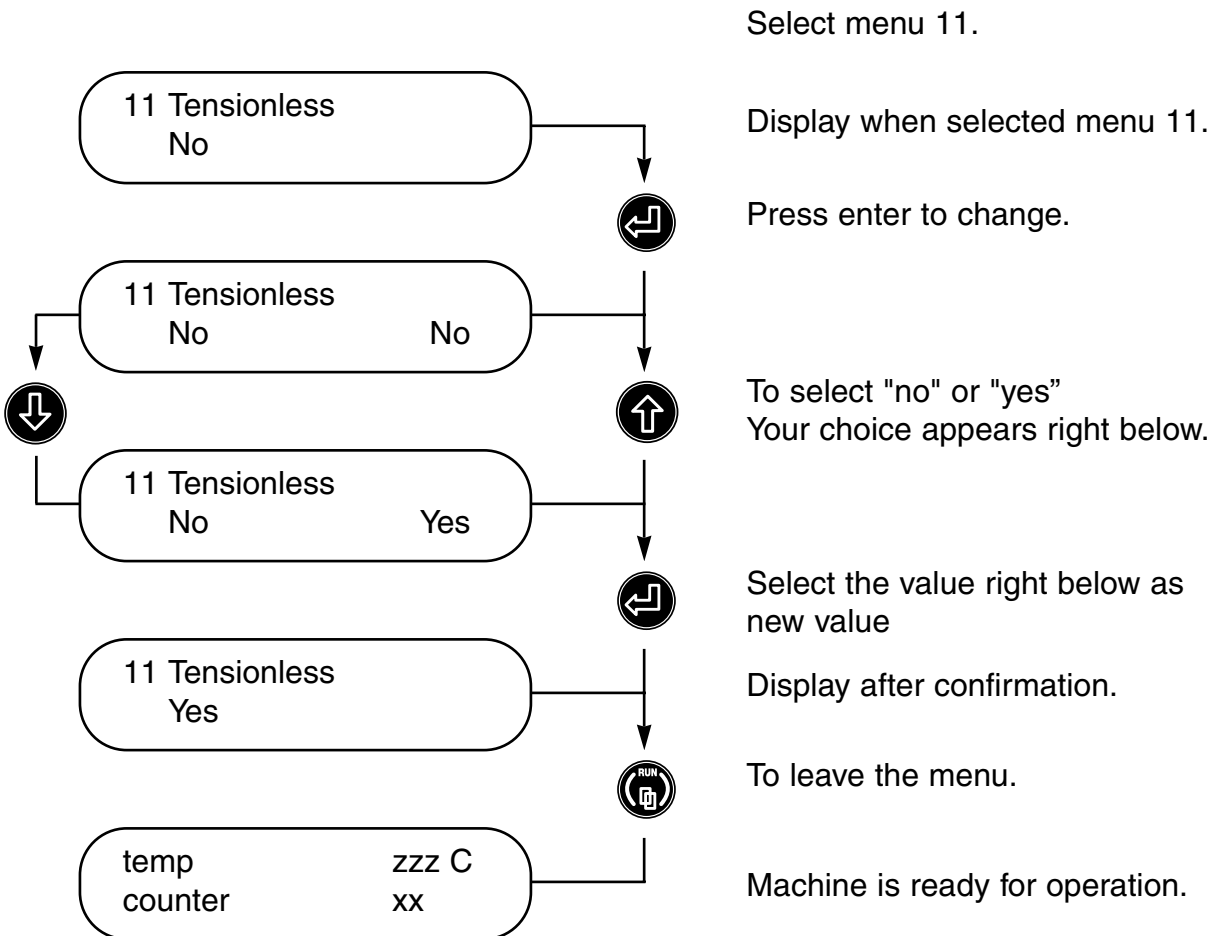
When the machine is equipped with the option "Tensionless", it is possible to switch this option on and off in menu 11.

With this option it is possible to band products without deforming them.

When this option is switched on, the motor will pull back a certain length of tape.

This length is adjustable in menu 13 "Length Rev".

Use the buttons:   

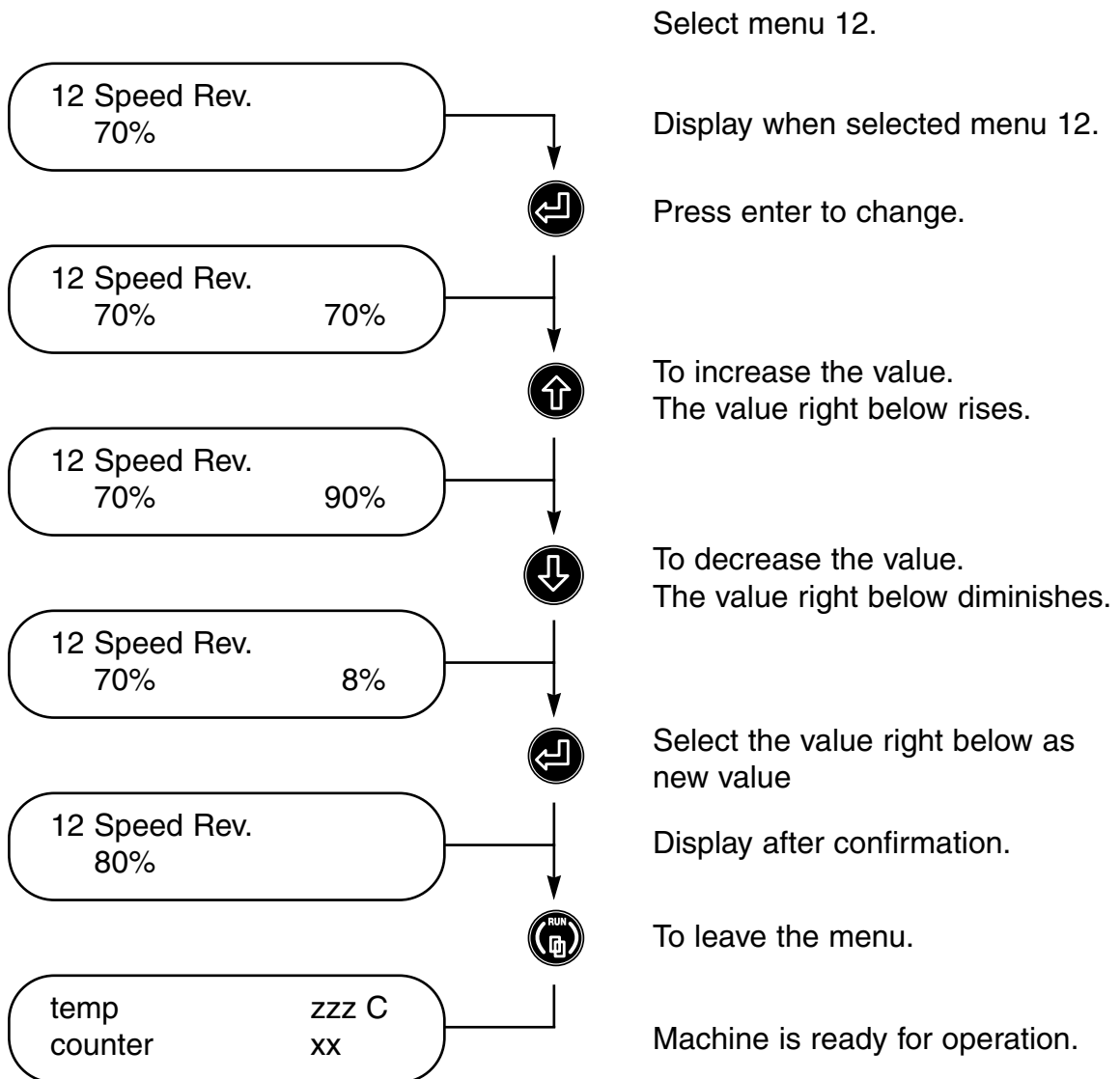


12 SPEED REVERSE (Only visible when menu 11 is switched on)

In this menu it is possible to adjust the speed of the motor in reverse.
This is the speed with which the tape is pulled back when the option "Tensionless" (menu 11) is switched on.

For speed reverse, select menu 12

Use the buttons:   



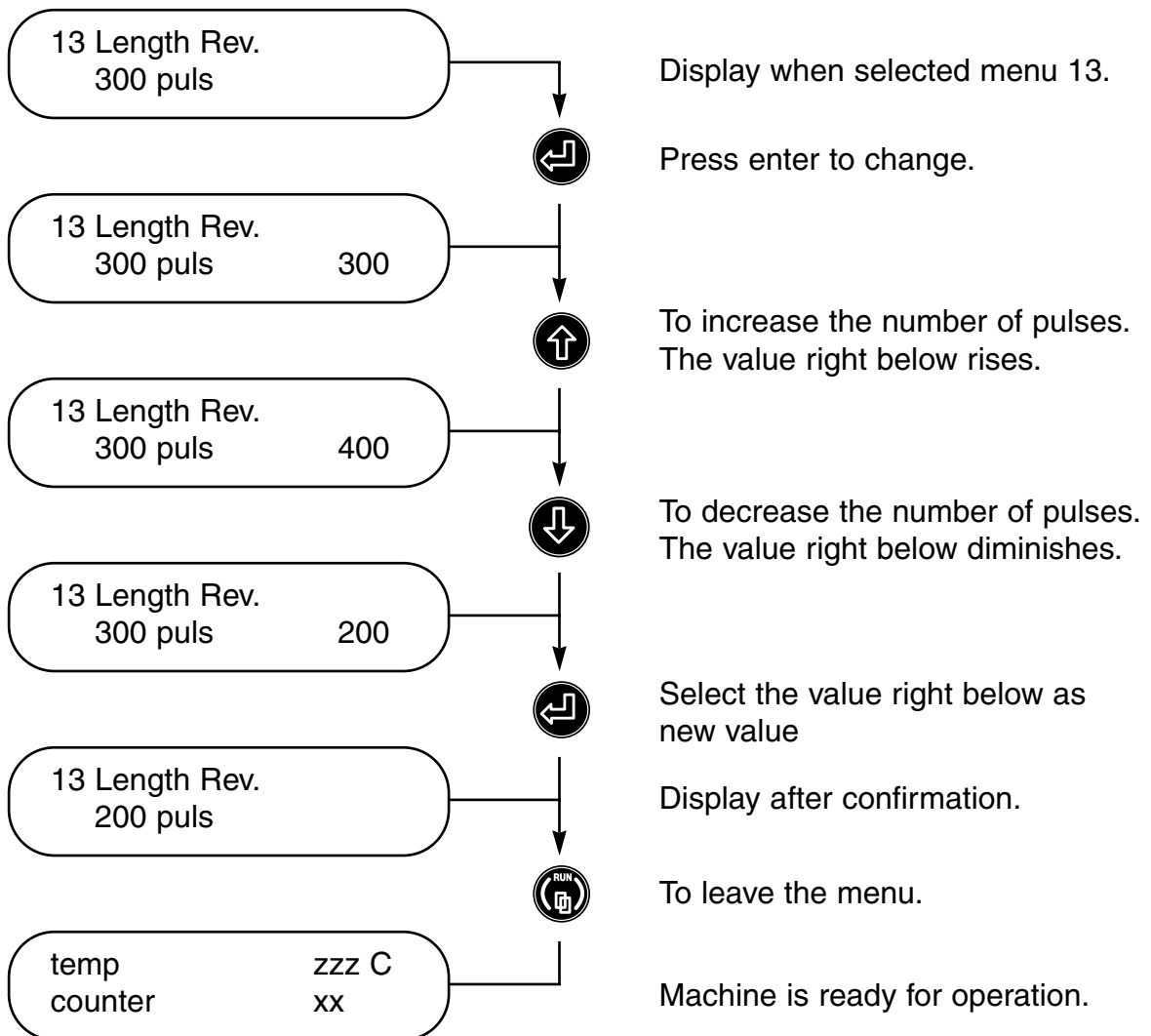
13 LENGTH REVERSE

(Only visible when with menu 11 is switched on)

In this menu it is possible to adjust the length of tape that is pulled back when the option "Tensionless" (menu 11) is switched on.
 The bigger the product gets, the smaller the value must be set.

For length reverse, select menu 13.

Use the buttons:   



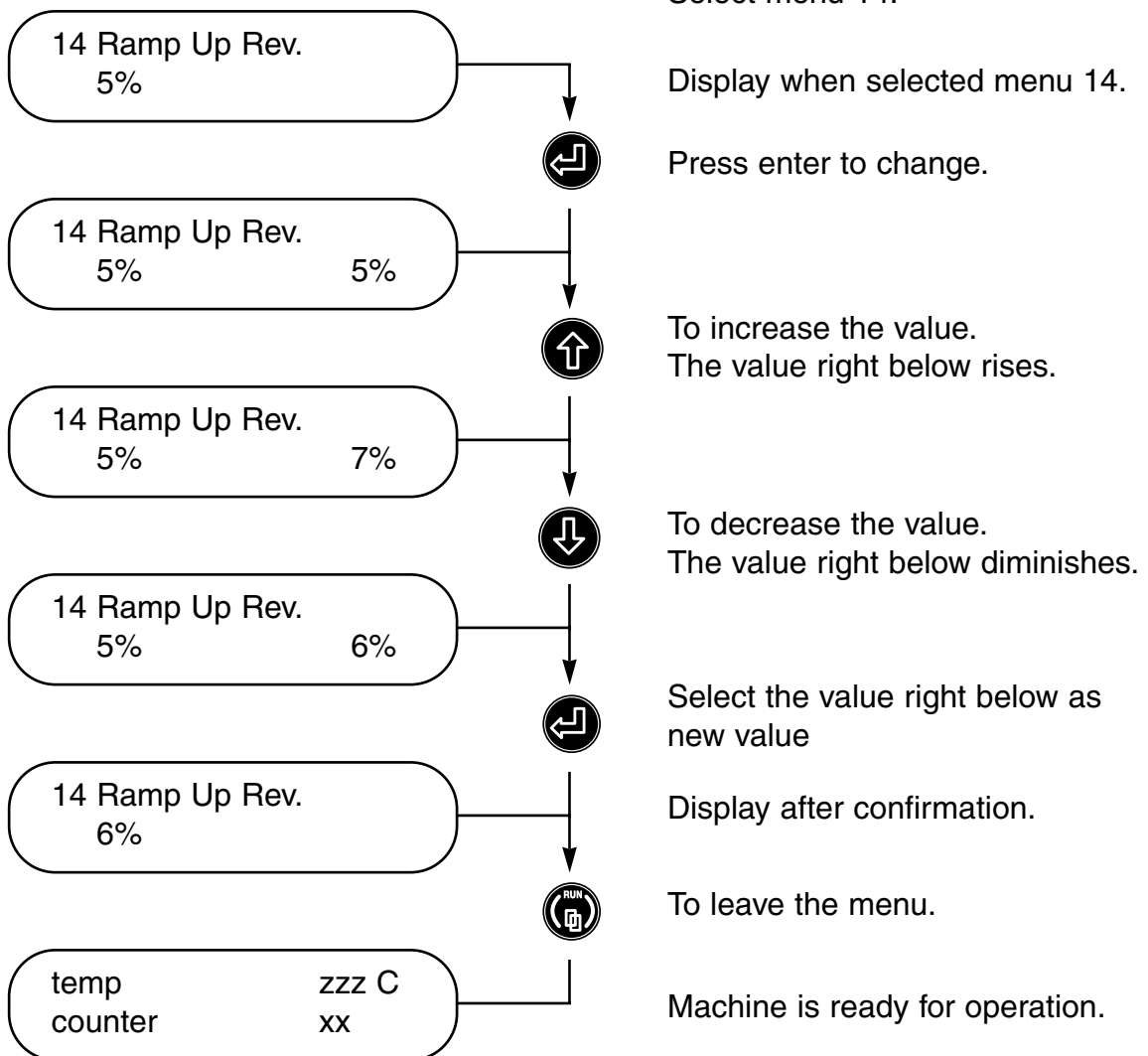
14 START RAMP REVERSE (Only visible when menu 11 is switched on)

With this adjustment you can change the acceleration of the motor in feed-out direction. The acceleration is indicated in %.

This percentage is related to the amount of pulses that is set in menu 8 "feed-out length". So if menu 13 "Length reverse" is set on, for example, 600 pulses and menu 14 "Ramp up reverse." on 5%, then the motor will use 30 pulses (5% of 600) to go from 0 to maximum speed.

ATTENTION: Do **NOT** adjust "Startramp Fwd." lower than 5%!

Use the buttons:



Select menu 14.

Display when selected menu 14.

Press enter to change.

To increase the value.
The value right below rises.

To decrease the value.
The value right below diminishes.

Select the value right below as new value

Display after confirmation.

To leave the menu.

Machine is ready for operation.

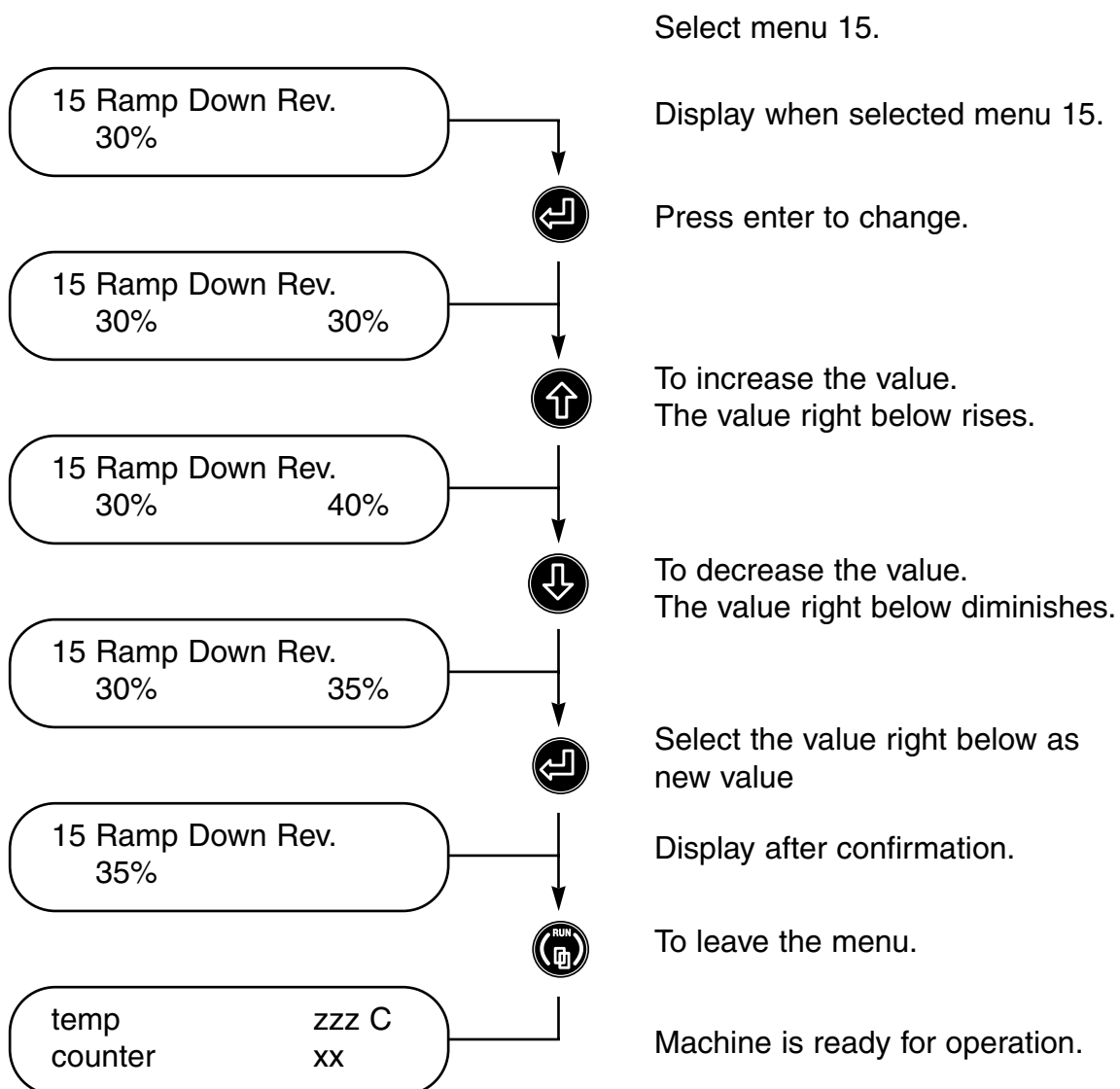
15 STOP RAMP REVERSE (Only visible when menu 11 is switched on)

With this adjustment you can change the deceleration of the motor in feed-out direction. The deceleration is indicated in %.

This percentage is related to the amount of pulses that is set in menu 8 "feed-out length". So if menu 13 is set on, for example, 600 pulses and menu 10 "Stopramp Fwd." on 40%, then the motor will use 240 pulses (40% of 600) to go from maximum to 0 speed.

This adjustment is machine dependent.

Use the buttons:   

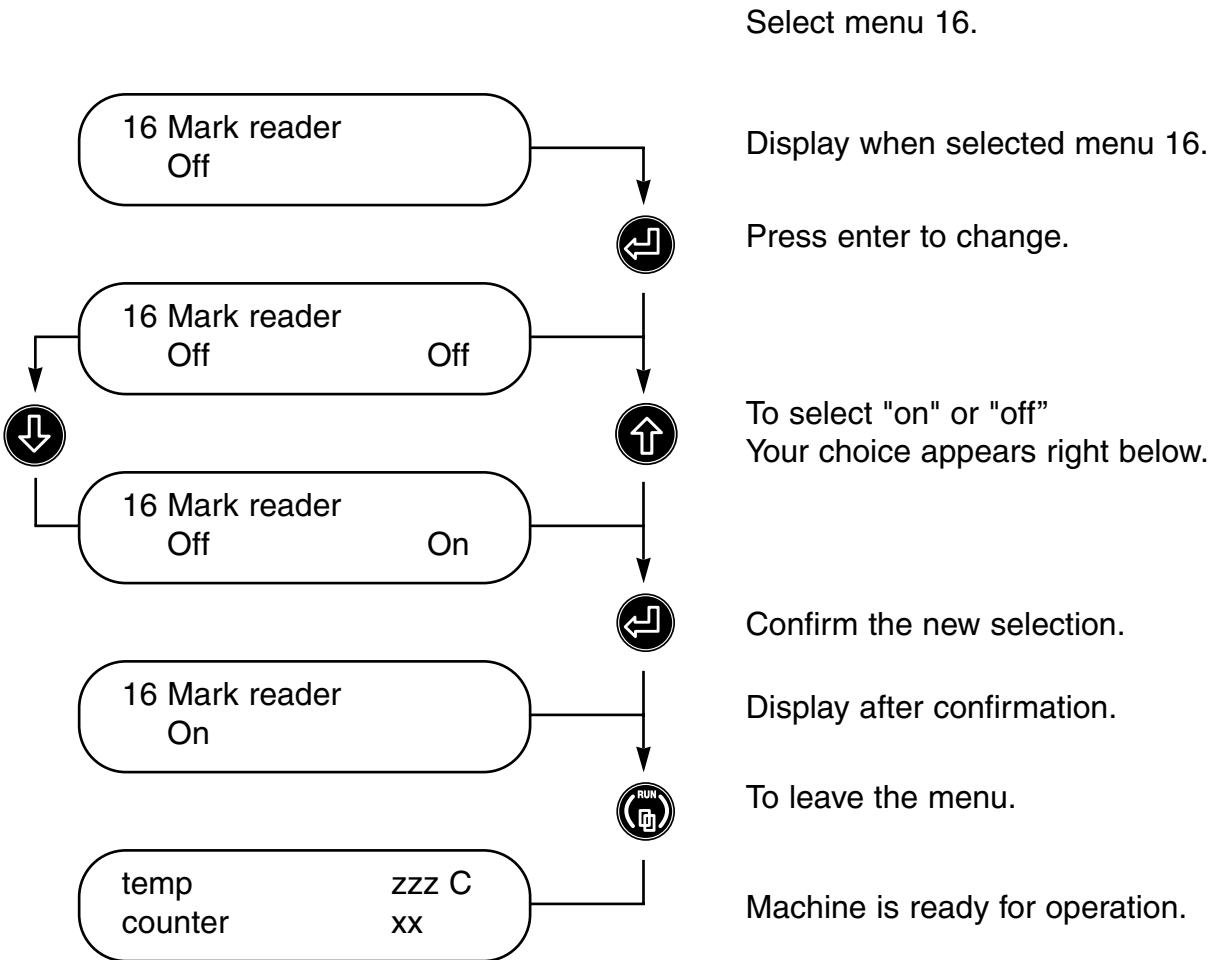


16 MARK READER (option)

This menu is optional. If present, the uncoiler is fitted with a photocell
 This option is used to position a preprinted text or sign.

ATTENTION: When the outline of a product changes, the position of the text will change to!
 This means that for products with different outlines you have to use different pre-printed tapes.

Use the buttons:   



Select menu 16.

Display when selected menu 16.

Press enter to change.

To select "on" or "off"
 Your choice appears right below.

Confirm the new selection.

Display after confirmation.

To leave the menu.

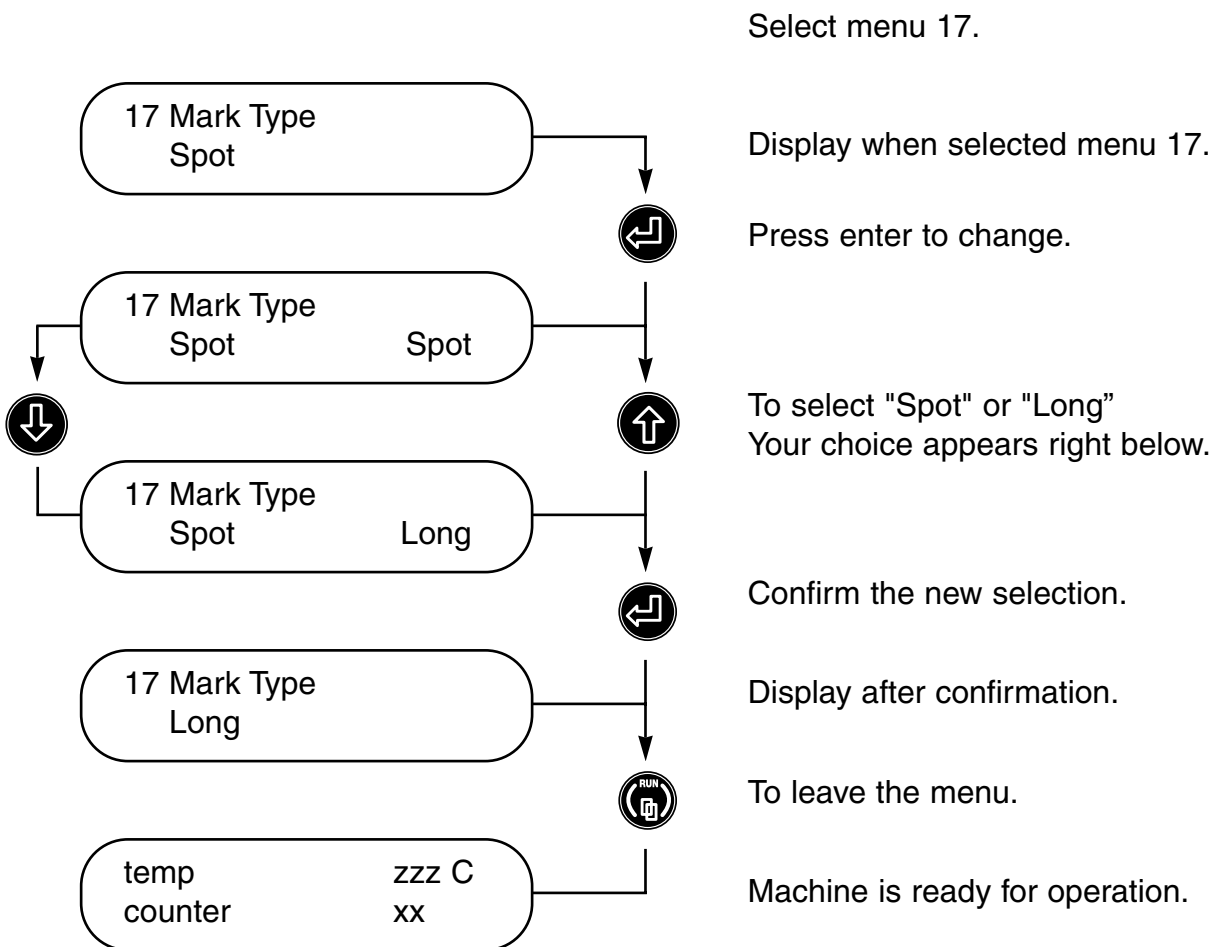
Machine is ready for operation.

17 TYPE OF MARK (Only visible when menu 16 is switched on)

In this menu it is possible to set the photocell for working with a short or long spot.
This setting is dependable of the spot that has been printed on the tape.

Change the language in the display in menu 17.

Use the buttons:   



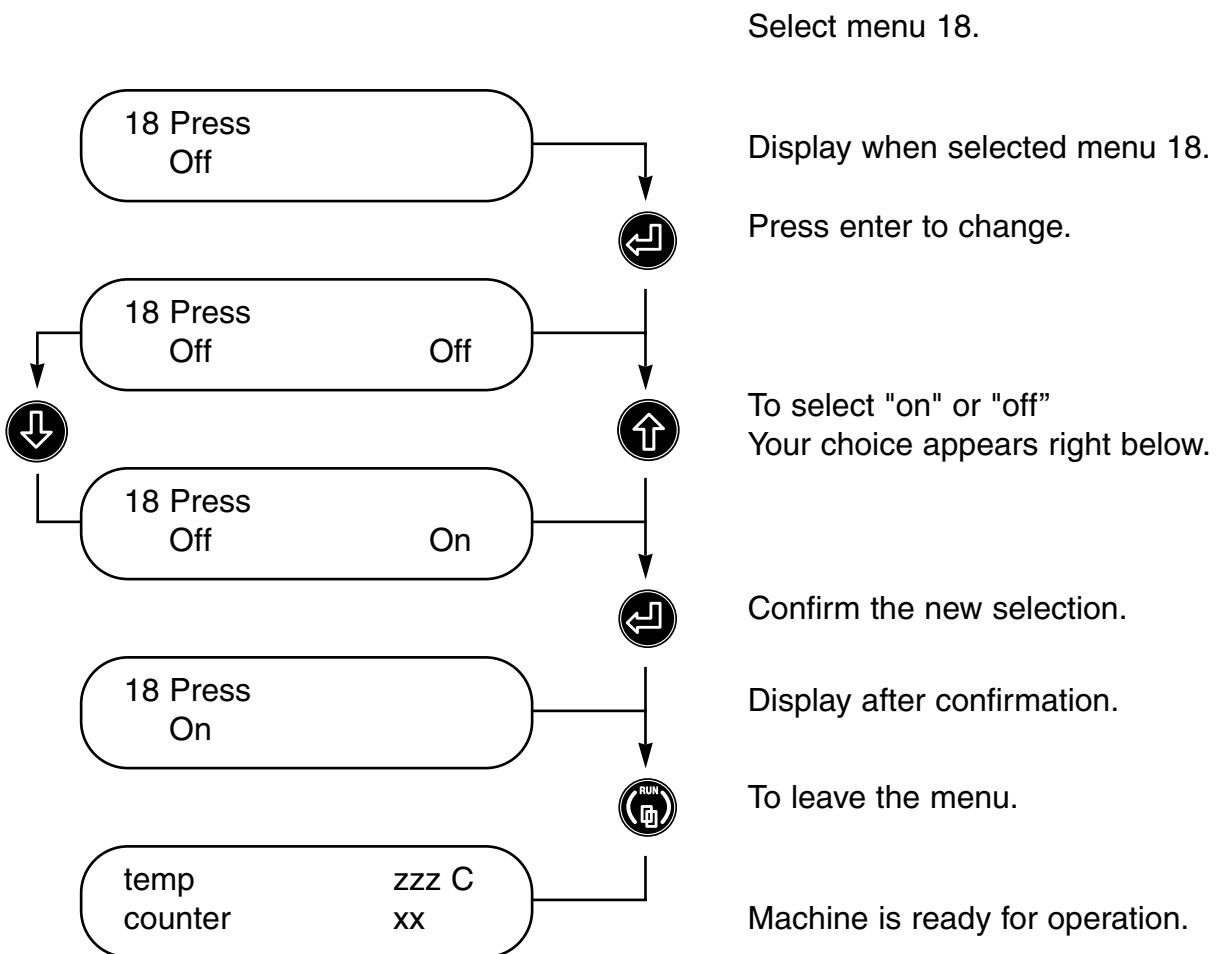
18 PRESS ON/OFF (Option)

In this menu it is possible to switch the press, or another application that is connected to this exit, on or off.

You could use this press to compress products just before they are banded.

To switch the press on or off, go to menu 18.

Use the buttons:   

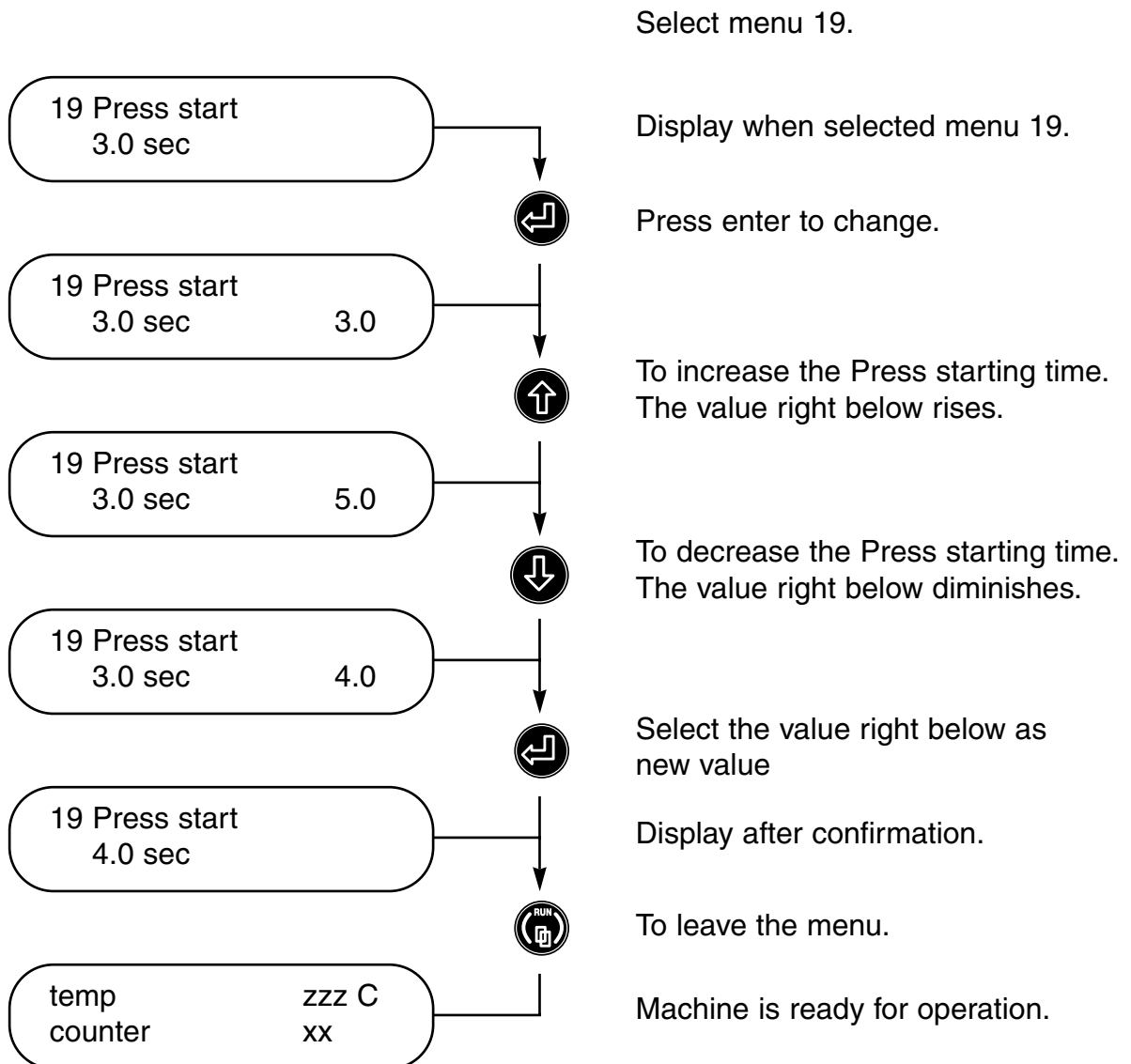


19 PRESS STARTING TIME (Only visible when menu 18 is switched on)

In this menu it is possible to adjust the time between the activation of the press, or another application that is connected to this exit, and the starting of the banding cycle.
For example: you could use this time to press the air out of the product.

To adjust the press starting time, go to menu 19.

Use the buttons:   



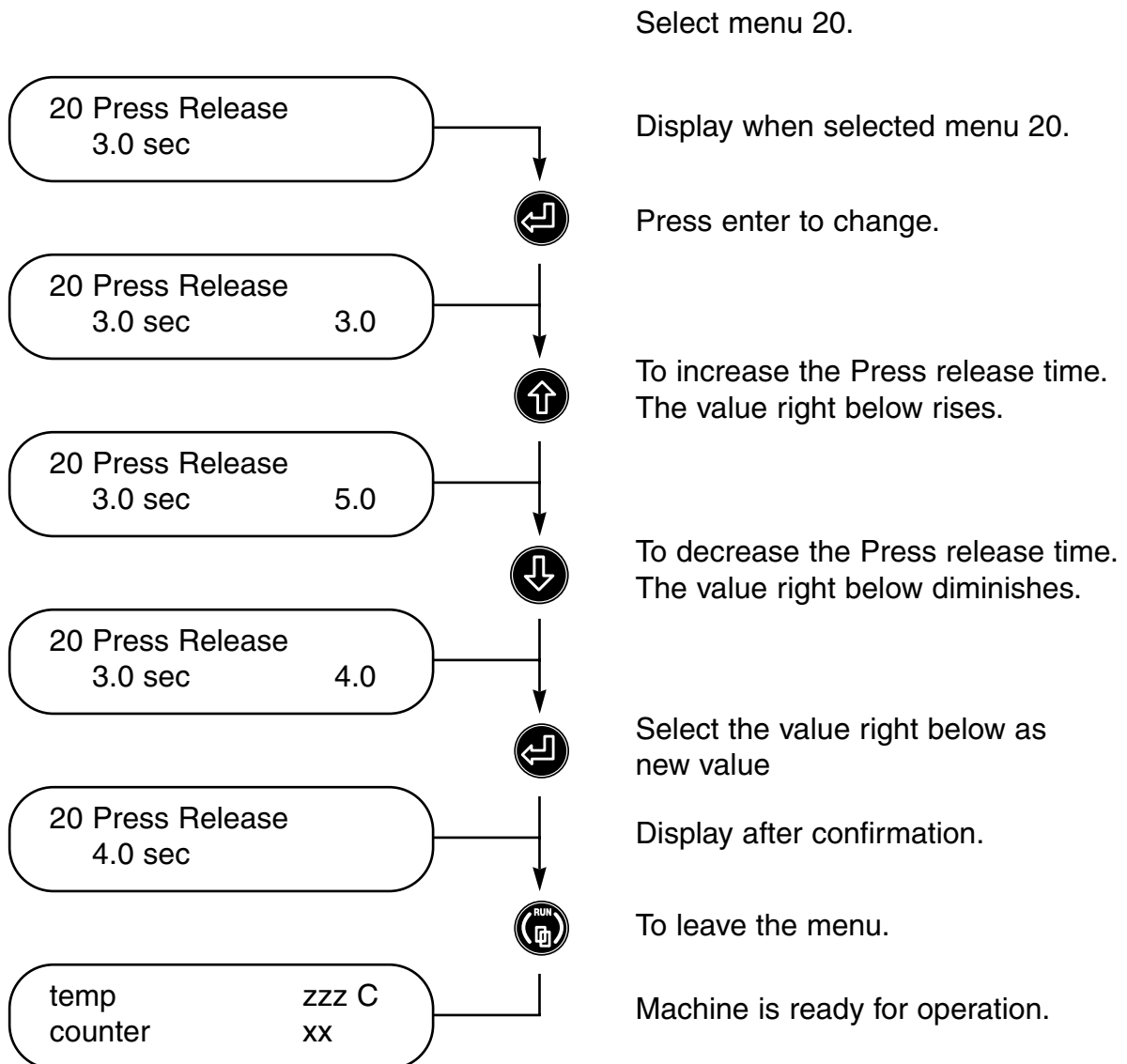
20 PRESS RELEASE TIME (Only visible when menu 18 is switched on)

In this menu it is possible to adjust the time between the end of the banding cycle and deactivation of the press.

This time is used to hold the product by the press for a certain time to let the seal cool before the tension of the product is released on the seal.

To adjust the press release time, go to menu 20.

Use the buttons:   

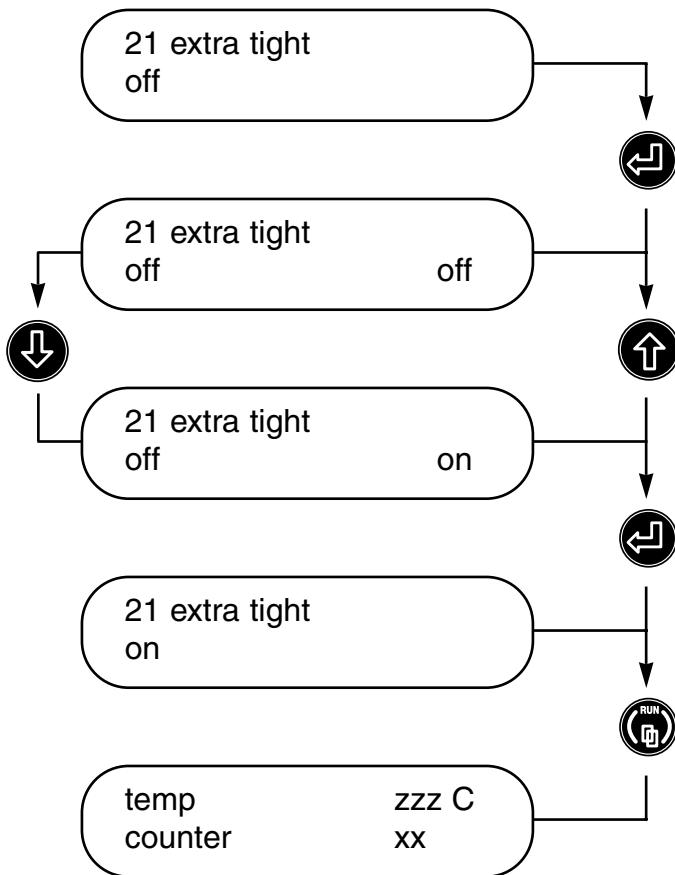


21. SET EXTRA TAPE TENSION.

The tension of the tape can be increased by selecting "extra tight" in the menu. While pulling back the tape around the product, the motor will turn back slowly.

For extra tension, select menu 21.

Use the buttons:   



Select menu 21.

Display when selected menu 21.

Press enter to change.

To select "on" or "off"
Your choice appears right below.

Confirm the new selection.

Display after confirmation.

To leave the menu.

Machine is ready for operation.

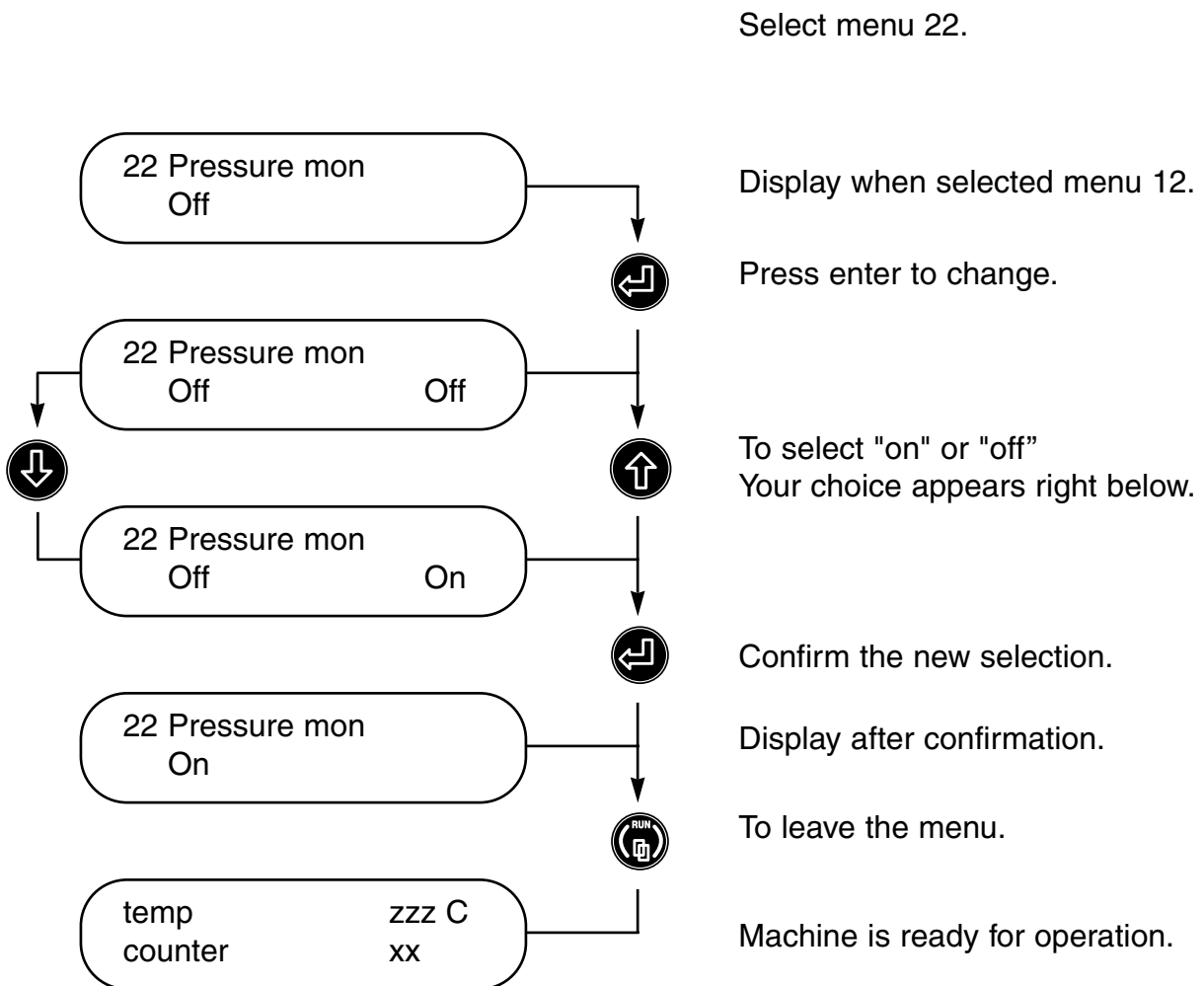
22 PRESSURE MONITOR ON/OFF (Option)

With this option it is possible to check the pressure of the incoming air.

If this rises above or drops under a certain value you will get a error message and it is possible to connect an extern warning system.

To activate the pressure monitor, go to menu 22.

Use the buttons:   



Select menu 22.

Display when selected menu 12.

Press enter to change.

To select "on" or "off"
Your choice appears right below.

Confirm the new selection.

Display after confirmation.

To leave the menu.

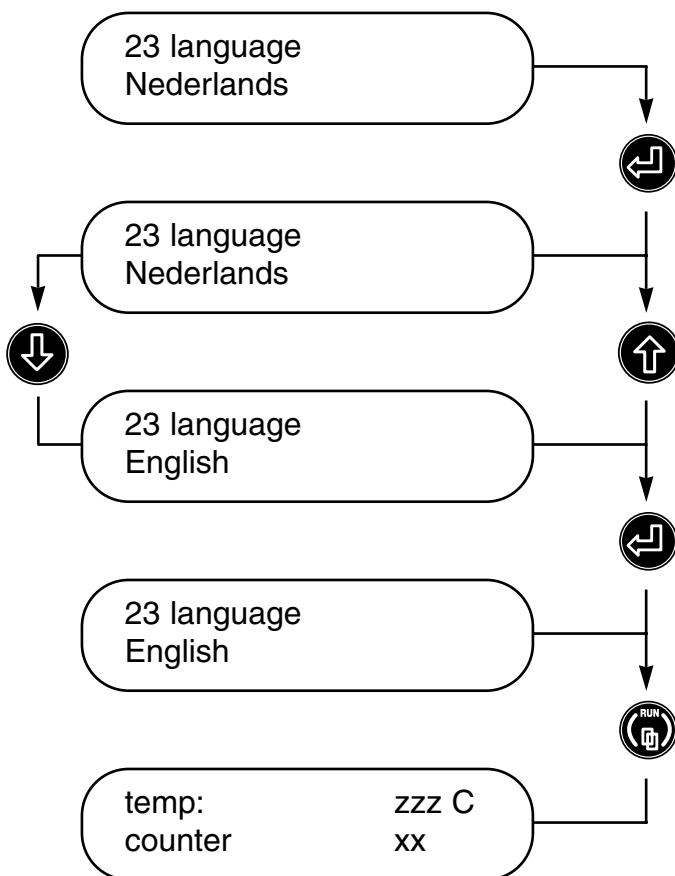
Machine is ready for operation.

23. CHANGE THE LANGUAGE.

This feature allows you to select the language on the display. Available are: Dutch, English, French, German, Spanish and Italian.

To change the language, select menu 23.

Use the buttons:   



Select menu 23.

Display when selected menu 23.

Press enter to change.

To change the language.
Display shows right below
selected language.

Confirm selected language.

Display after confirmation.

To leave the menu.

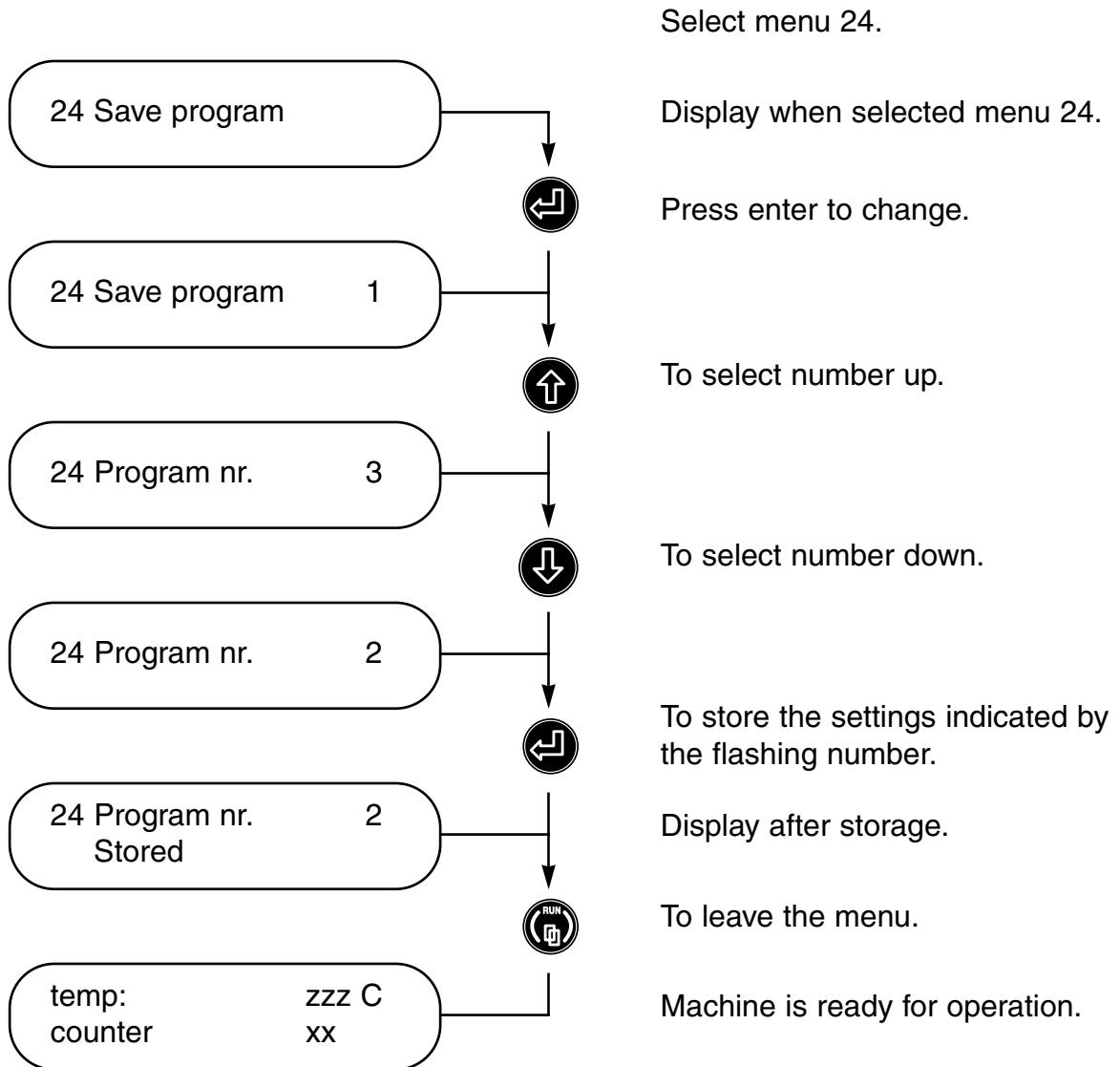
Machine is ready for operation.

24. SAVE MACHINE SETTINGS.

The settings of the machine for your product and/or kind of tape, can be stored under a program number and loaded when required. Available are program numbers 1 upto 10,21 and 23. You can save 15 different programs.

To save machine settings, select menu 24.

Use the buttons:   

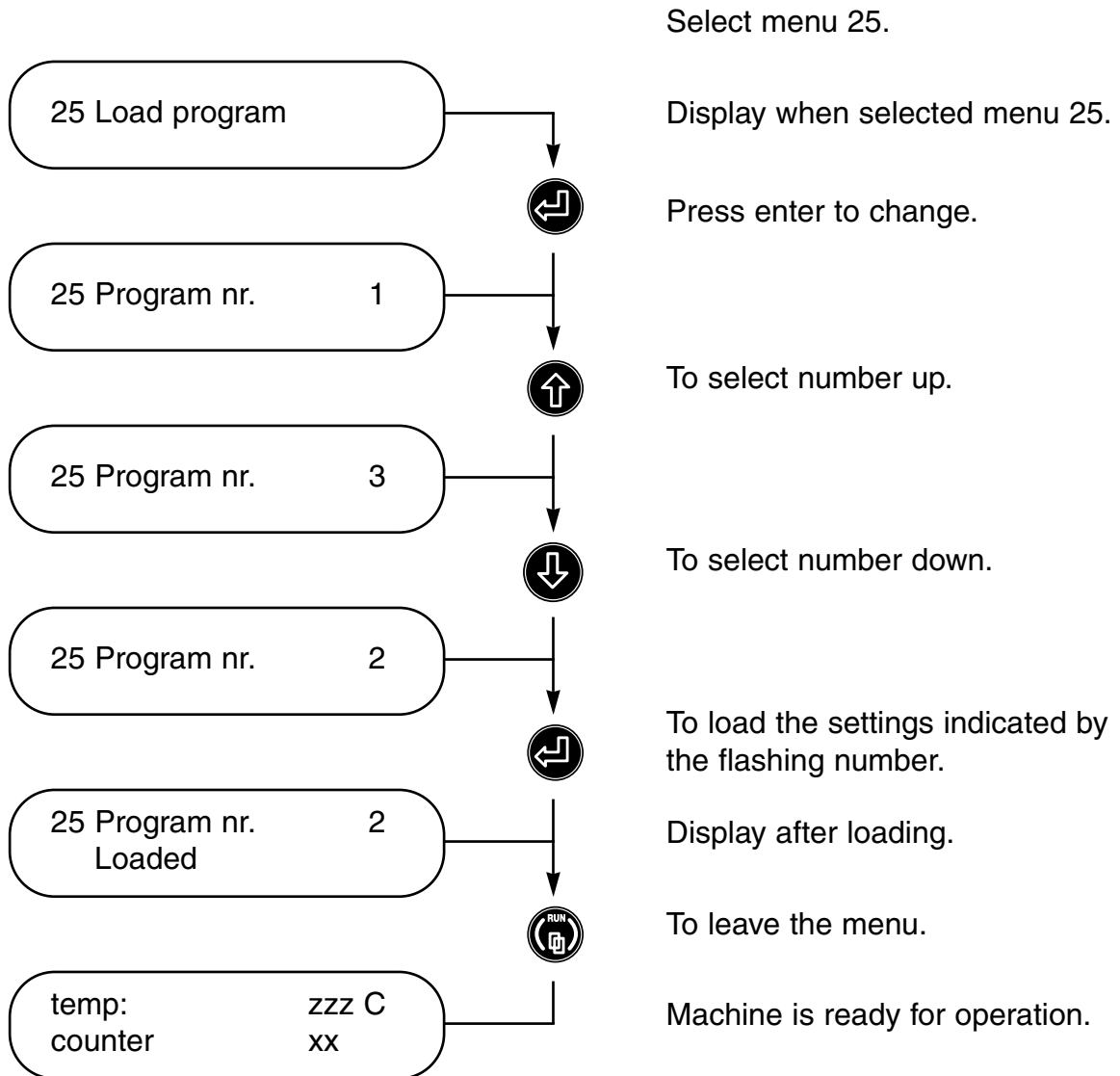


25. LOAD MACHINE SETTINGS.

A previously saved program for your product and/or kind of tape can be loaded again simply. Available are program numbers 1 upto 10,21 and 23. You can load 15 different programs

To load the machine settings, select menu 15.

Use the buttons:   



ERROR MESSAGES ON DISPLAY

Temp: xxx
Temp zone

The set temperature has not yet been reached,
wait for it to warm up

Reset error (#)
Time out

The tape transport is disturbed.

Press the  button to reset.

Check the tape transport.If necessary remove all tape
and feed it into the machine again.

Reset error (#)
Tape stuck

The tape is stuck.

Press the  button to reset.

Check the tape transport,if necessary remove all tape
and feed it into the machine again.

Reset error (#)
reel empty

The machine has run out of tape or tape is broken.

Press the  button to reset.

Replace the reel of tape.

If necessary remove all the tape and feed it into the
machine again.

TROUBLE SHOOTING BAND-ALL

No power on machine.

- Plug is not in socket → Put plug in socket.
- Fuse in mains is defective → Replace fuse.
- Mechanical or electrical problem → Contact your dealer.

Tape does not seal or seals poorly.

- Temperature is too high or too low set in menu 2 → Change setting.
- Sealing time is too long or too short set in menu 3 → Change setting.
- Overlap is too short set in menu 8 → Change setting.
- Sealing plate or seal head are dirty
(WARNING: The seal head is coated, avoid damaging it).
- Mechanical or electrical problem → Contact your dealer.

Machine is not warming up.

- Check temperature setting in menu 2 → Change setting.
- Heater cartridge or thermocouple is defective → Contact your dealer.
- Power supply to heater cartridge is defective → Contact your dealer.

Display shows Temperature “999”.

- Thermocouple is defective → Contact your dealer.

Tape doesn't feed in properly and shows a “bump” on the tape.

- Check if all the green belts in the arch are well fitted in their track → Place belts in their track.
- Mechanical or electrical problem → Contact your dealer.



Tape feeds in halfway.

- Tape reel is empty → Replace reel.
- Check if the tape is following all the guide rollers → Place the tape over the rollers as shown in the diagram on the front of the machine.
- Mechanical or electrical problem → Contact your dealer.

Tape feeds in but doesn't show under sealingplate.

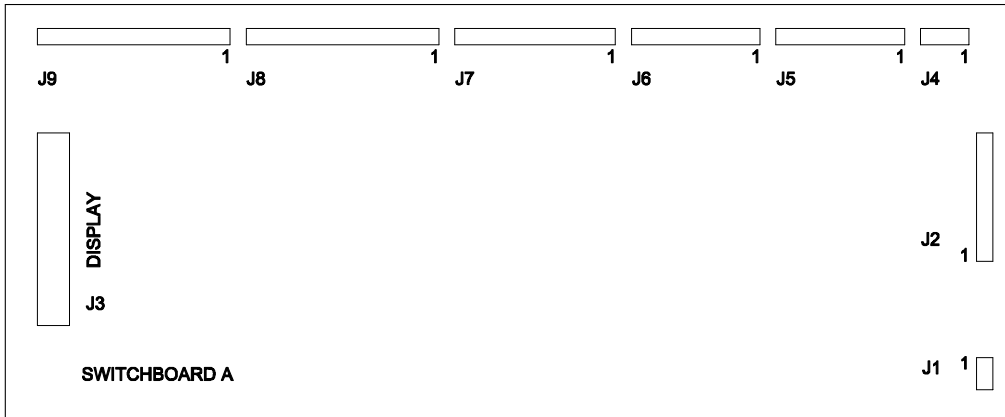
- Check air pressure at the left side of the machine, this has to be between the values given on the sticker on the side of the machine.
- Check if compressor is switched on.
- Check if air pressure of the compressor is high enough (Pressure must be at least 6 bar/600 Kpa/92Psi)
- Mechanical or electrical problem → Contact your dealer.

Brake of tape reel stays on.

- Machine runs in "RUN" mode → Switch display to menu 1 and push  or  Machine is now in feed-in mode again.
- Fuse number 5 is defective → Replace fuse.
- Mechanical or electrical problem → Contact your dealer.

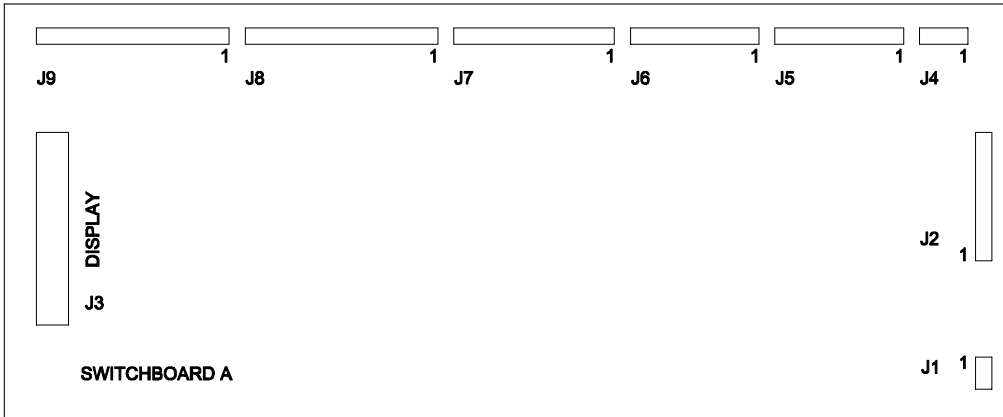
Tape falls out of the machine.

- Overlap to short → Change overlap.
- Overlap to long → Change overlap.
- Mechanical or electrical problem → Contact your dealer.



CONNECTIONS MAIN SWITCHBOARD "A" BAND ALL

J1 =	pin 1	power 24 Vac		220V switchboard / J6-1	
	pin 2	power 24 Vac		220V switchboard / J6- 2	
J2 =	pin 1	BAND all buzy signal			K 1
	pin 2	common			
	pin 3	BAND all exit run with error			K 2
	pin 4	common			
	pin 5	BAND all sealplate signal			K 3
	pin 6	common			
	pin 7	BAND all ready			K 4
	pin 8	common			
J4 =	pin1	temp.control		220V switchboard / J5- 1	
	pin2	> 220V switchboard		220V switchboard / J5- 2	
	pin3			220V switchboard / J5- 3	
J5 =	pin1	valve sealplate		blue	Nr.2
	pin2	24Vdc		brown	
	pin3	sign.			
	pin4	24Vdc			
	pin5	sign.			
	pin6	24Vdc			
	pin7	sign.			
	pin8	24Vdc			
J6 =	pin1	valve Lintra		blue	
	pin2	24Vdc		brown	
	pin3	valve side brake		blue	
	pin4	24Vdc		brown	
	pin5	valve sealhead		blue	
	pin6	24Vdc		brown	
	pin7	valve clamp/contraroller		blue	
	pin8	24Vdc		brown	
J7 =	pin1	signal	analog to Freq.contr.	Freq.contr. Fr	brown
	pin2	min.	analog to Freq.contr	Freq.contr. Fc	white
	pin3	Forw	signal Freq.contr.	Freq.contr. SF	yellow
	pin4	comm.	signal Freq.contr.	Freq.contr. SC	green
	pin5	Rev.	signal Freq.contr.	Freq.contr. SR	gray
	pin6	min.	encoder signal		white
	pin7	sign.	encoder signal		green
	pin8	5Vdc	encoder signal		brown
	pin9	Pt100			brown
	pin10	Pt100			white



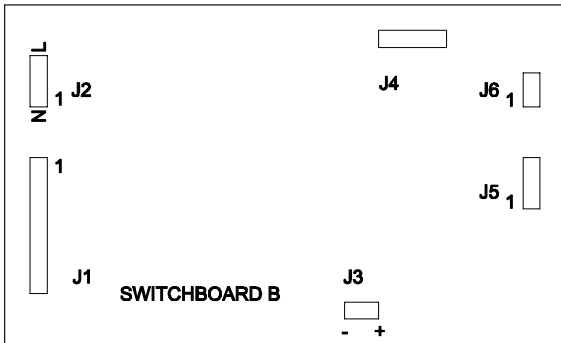
CONNECTIONS MAIN SWITCHBOARD "A" BAND ALL (CONT.)

J8 =	pin1	signal	markreader*	
	pin2	min.	markreader*	
	pin3	24Vdc	markreader*	
	pin4	signal	sensor tapetension	black
	pin5	min.	sensor tapetension	blue
	pin6	24Vdc	sensor tapetension	brown
	pin7	signal	external start (footswitch)	white
	pin8	min.		
	pin9	24Vdc	external start	brown
	pin10	signal	spare*	
	pin11	min.	spare*	
	pin12	24Vdc	spare*	
J9 =	pin1	signal	product sensor	white
	pin2	min	product sensor	green
	pin3	24Vdc	product sensor	brown
	pin4	signal	wagon sensor	black
	pin5	min	wagon sensor	blue
	pin6	24Vdc	wagon sensor	brown
	pin7	signal	sensor tape in loop	black*
	pin8	min.	sensor tape in loop	blue*
	pin9	24Vdc	sensor tape in loop	brown*
	pin10	signal	sensor reel empty	black*
	pin11	min.	sensor reel empty	blue*
	pin12	24Vdc	sensor reel empty	brown*

Valves:

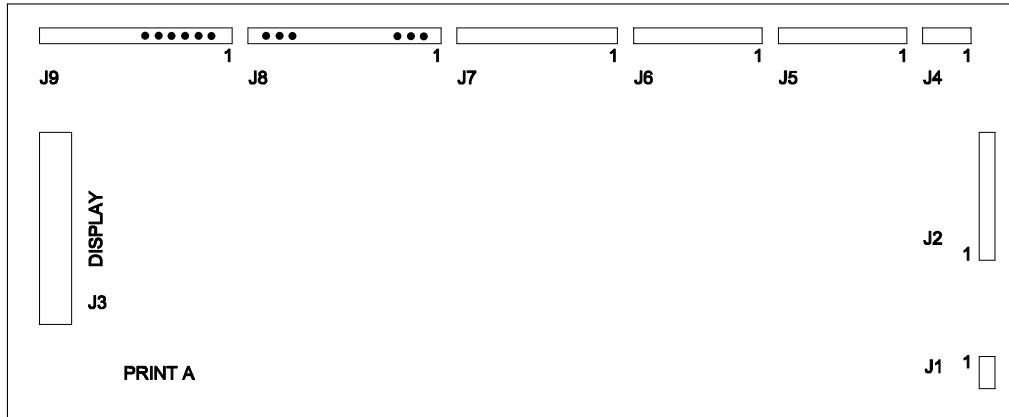
Sealhead	= 1
Sealplate	= 2
Clamp/roller	= 3
Lintra	= 4
Side clamp	= 5

* optional, see page 40.



CONNECTIONS SWITCHBOARD 220 V "B" BAND-all

J1 =	pin1	freq.controller 220 V supply		
	pin2	freq.controller 220 V supply		
	pin3	fans 220 V		
	pin4	fans 220 V		
	pin5	transformer 220 V		
	pin6	transformer 220 V		
	pin7	heater cartridge 220 V		
	pin8	heater cartridge 220 V		
J2 =	pin1	220 V	N	
	pin2			
	pin3	220 V	L	
J3 =	pin1	min.	brake	blue
	pin2	24Vdc	brake	brown
J4 =	pin1	transformer	red	
	pin2	transformer	yellow	
	pin3	transformer	blue	
	pin4	transformer	gray	
J5 =	pin1	temp.contr.		mainswitchboard/ J4-1
	pin2	temp.contr.		mainswitchboard/ J4-2
	pin3	temp.contr.		mainswitchboard/ J4-3
J6 =	pin1	24Vac supply mainswitchboard		mainswitchboard/ J1-1
	pin2	24Vac supply mainswitchboard		mainswitchboard/ J1-2



OPTIONS:

J8 =	pin 1	signal	markreader	
	pin 2	min.	markreader	
	pin 3	24Vdc	markreader	
	pin 10	signal	spare	
	pin 11	min.	spare	
	pin 12	24Vdc	spare	
J9 =	pin 7	signal	sensor tape in loop	black
	pin 8	min.	sensor tape in loop	blue
	pin 9	24Vdc	sensor tape in loop	brown
	pin 10	signal	reel empty	black
	pin 11	min.	reel empty	blue
	pin 12	24Vdc	reel empty	brown

EARTHING:

Mains	→	central earthing
Front cover	→	central earthing
Fan holder	→	central earthing
Sealhead	→	connector
Connector	→	central earthing
Freq.contr.	→	central earthing

WIRING DIAGRAM

