



MEYERCORD

Linear Stamp Machine

Installation & Operation Manual (# 206-090)

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SAFETY FIRST

Before running this equipment, become familiar with the controls and know how to properly operate it. Before cleaning, inspecting or adjusting the L.S.M., depress the “E” stop button and make absolutely sure all belts and moving parts have stopped. The Opener, Stamper and Closer are each protected by clear safety covers. Each has electrical interlocks that automatically activates the “E” stop when a cover is raised. Finally, do not allow untrained or unauthorized individuals to operate this equipment.

SHIPPING DAMAGE ?

After removing all packing materials from the LSM, examine the machine thoroughly for any shipping damage, especially the top of the equipment, as this is where most shipping problems occur. If any such damages are observed, please contact Meyercord technical support with a documented list so that this information can be forwarded through the proper channels for reimbursement.

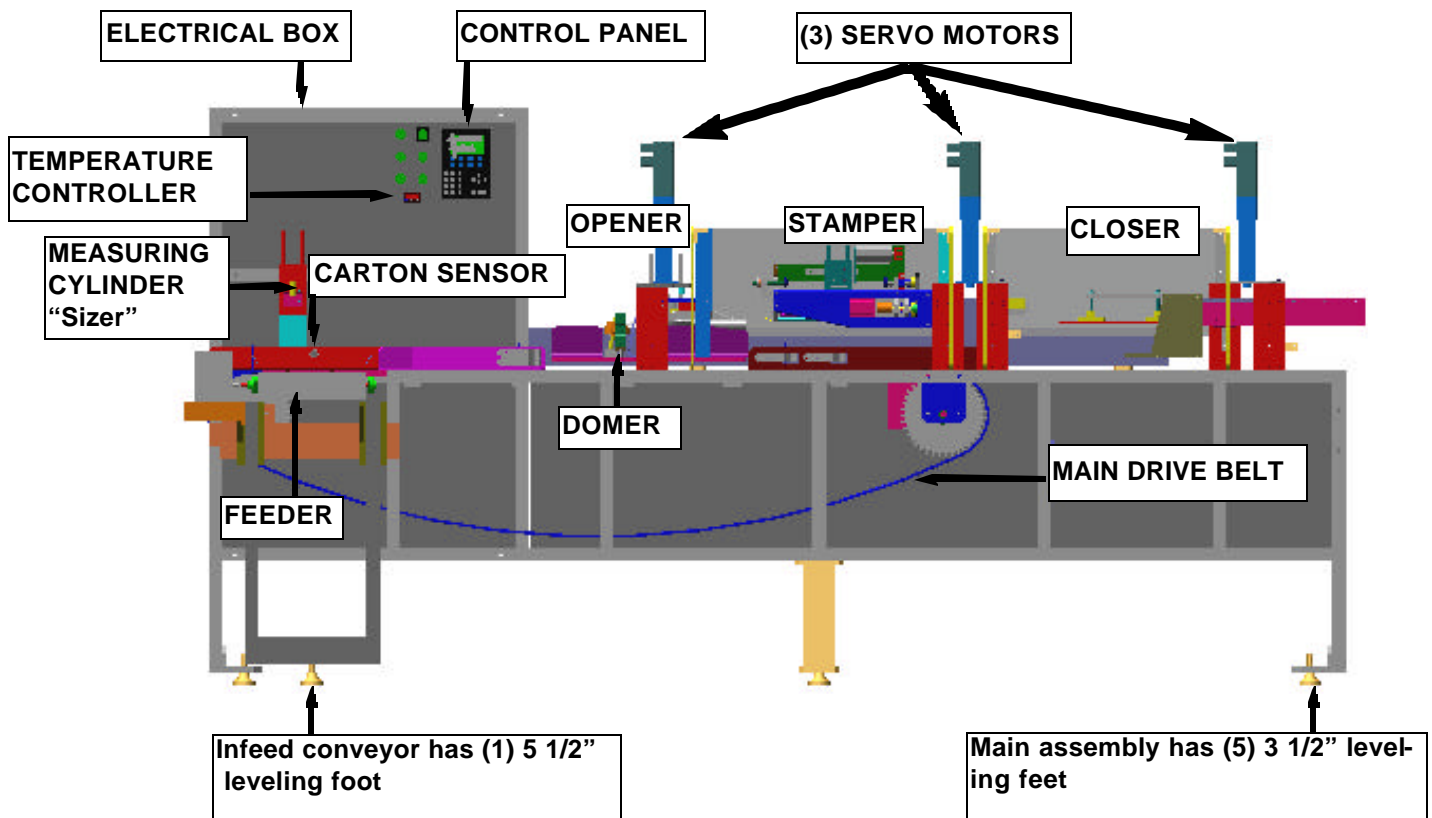
EQUIPMENT SUMMARY

The Linear Stamp Machine was designed to improve the quality of the stamp application and also do away with the necessity to make height adjustments when switching to different brands and/or sizes of cigarettes. Especially in a post-stamping operation, these adjustments can become more frequent and cumbersome for any operator.

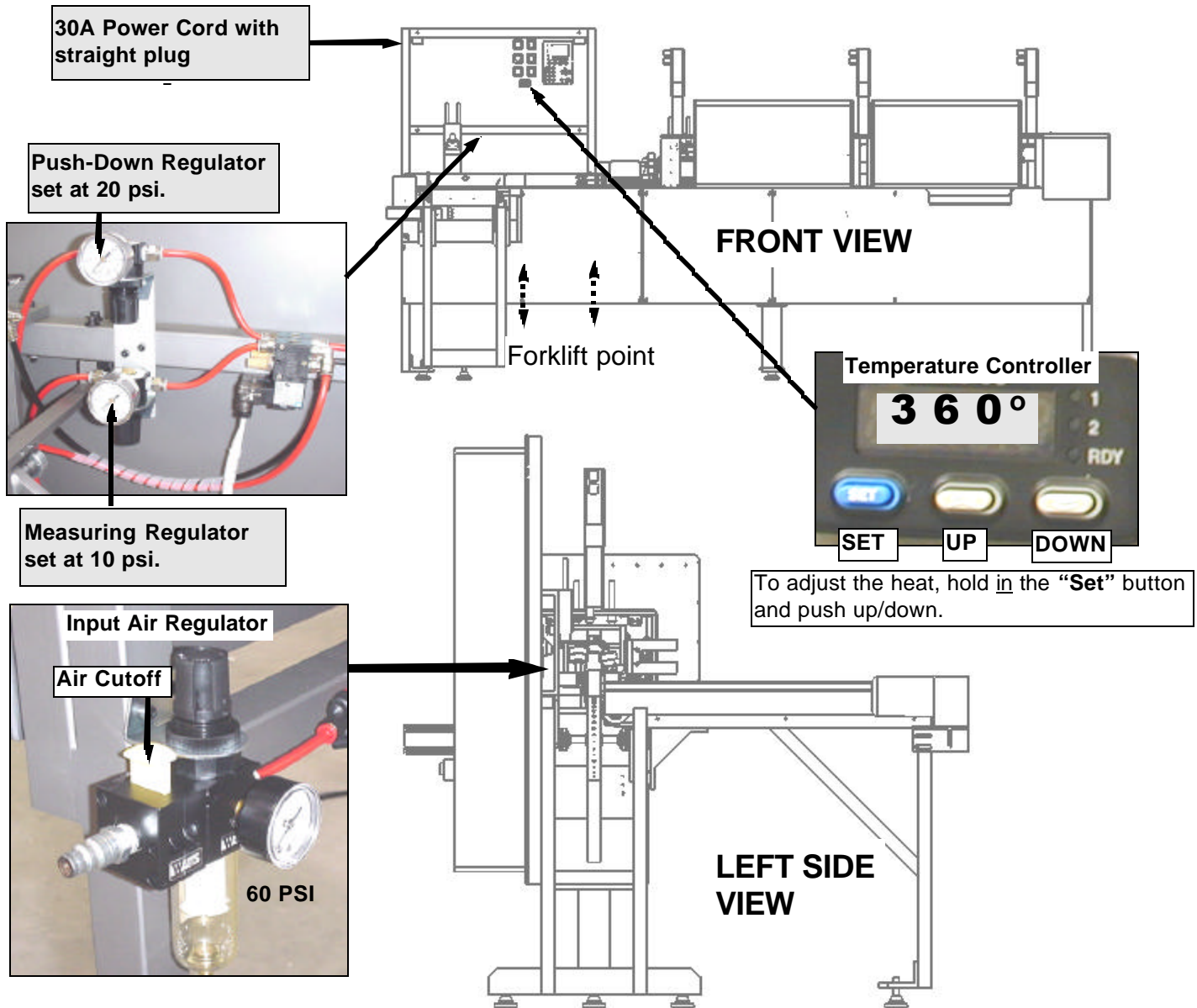
The L.S.M. derives its name (Linear) from the motion of the iron assembly which only travels up-down along a vertical axis and left-right along a horizontal axis and is pneumatically driven. This motion allows the iron head to descend directly over the stamps so that the iron pads will consistently press evenly with every carton cycle thus eliminating “toeing” and “heeling” which are usually associated with cam-driven iron assemblies.

The heater assembly is governed by a temperature controller located on the front panel. This device can be easily set at the beginning of operations and will maintain the proper temperature of the iron assembly to within ± 1 degree. The control panel and associated buttons are used to start up the machine and helps the operator locate any malfunctions.

During normal operation, the feeder brings the cartons toward an electronic sensor which signals a small cylinder “Sizer” to lower a metal plate down and quickly measures the height of each carton. This information is fed to the P.L.C. which automatically changes the height of the opener horn, stamp head, and closer components utilizing three separate servo motors. The main drive belt, which has 6 vertical paddles (evenly spaced), advances the cartons to the opener where a set of rollers compresses the width of the carton to provide the dome required by the opening horn. A “Doming” cylinder also presses down on top of the carton, approximately 2” from the leading edge, to help enhance this procedure. The main belt then continues to advance the cartons through the remaining areas and onto the closer belt.

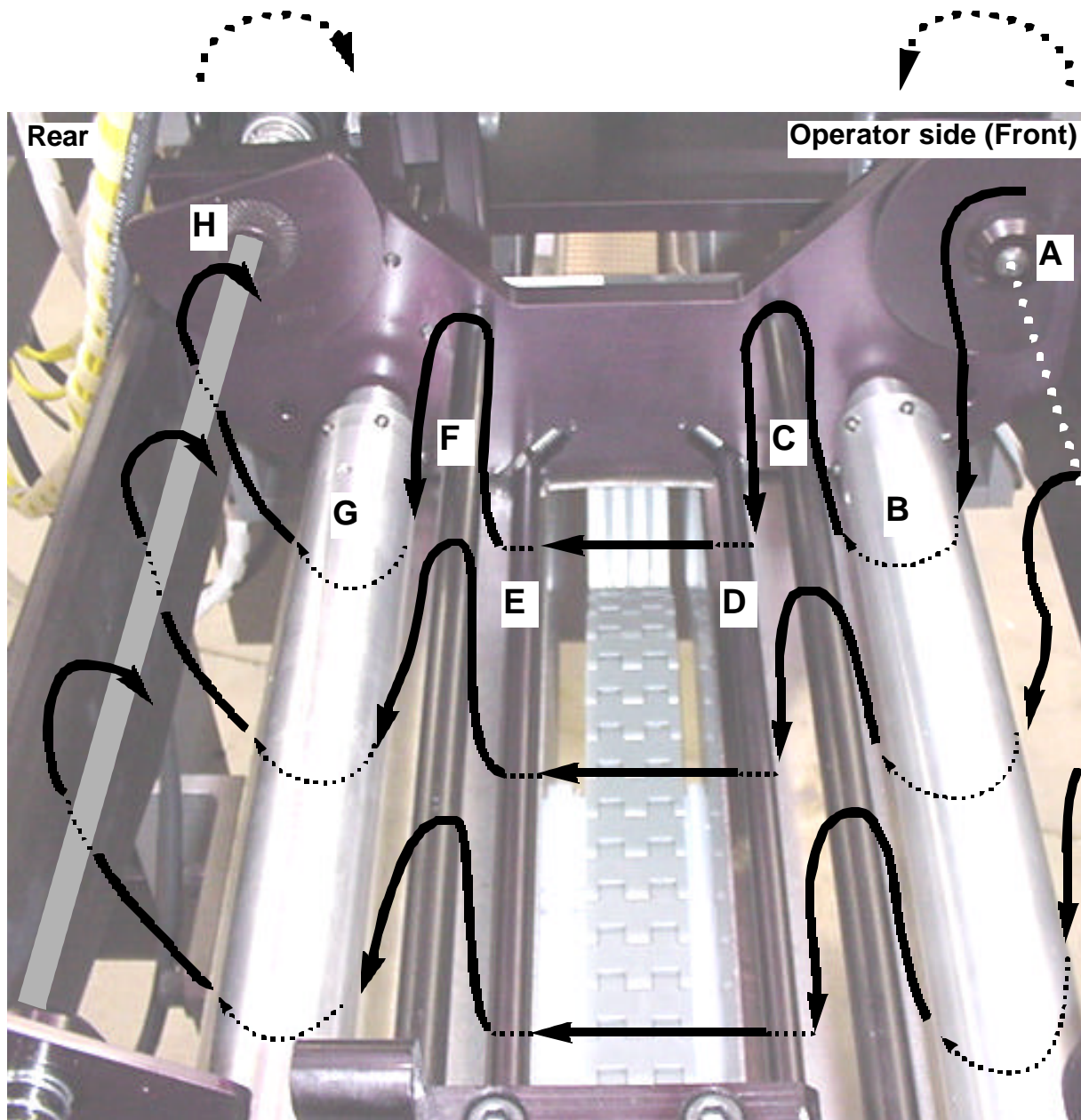


MACHINE SET UP

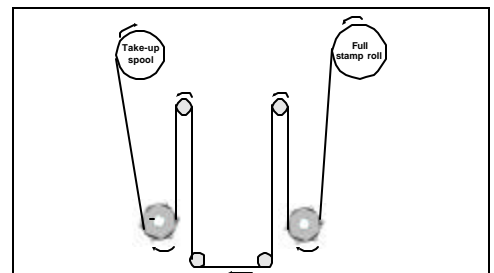


1. Using a forklift at the recommended location, remove the LSM from the shipping pallet. Set the equipment into place using the existing conveyor, packer or packing tables as guides.
2. Level the machine by adjusting the leveling feet up/down. It is important to adjust the infeed conveyor so that the cartons are feeding on a slight downward angle when going into the LSM.
3. Connect the machine to a 120 v.a.c. power source using the 30A straight plug that is provided.
4. Connect the machine to the customer's air supply (must be clean and dry). Pull the "Air Cutoff" button up to open the valve then set the input air regulator to 60 psi.
5. Set the "Measuring" and "Push-Down" regulators according to the above specifications.
6. Fill the cold glue pot 2/3 full, being careful not to overfill. Check every half hour, depending on volume.

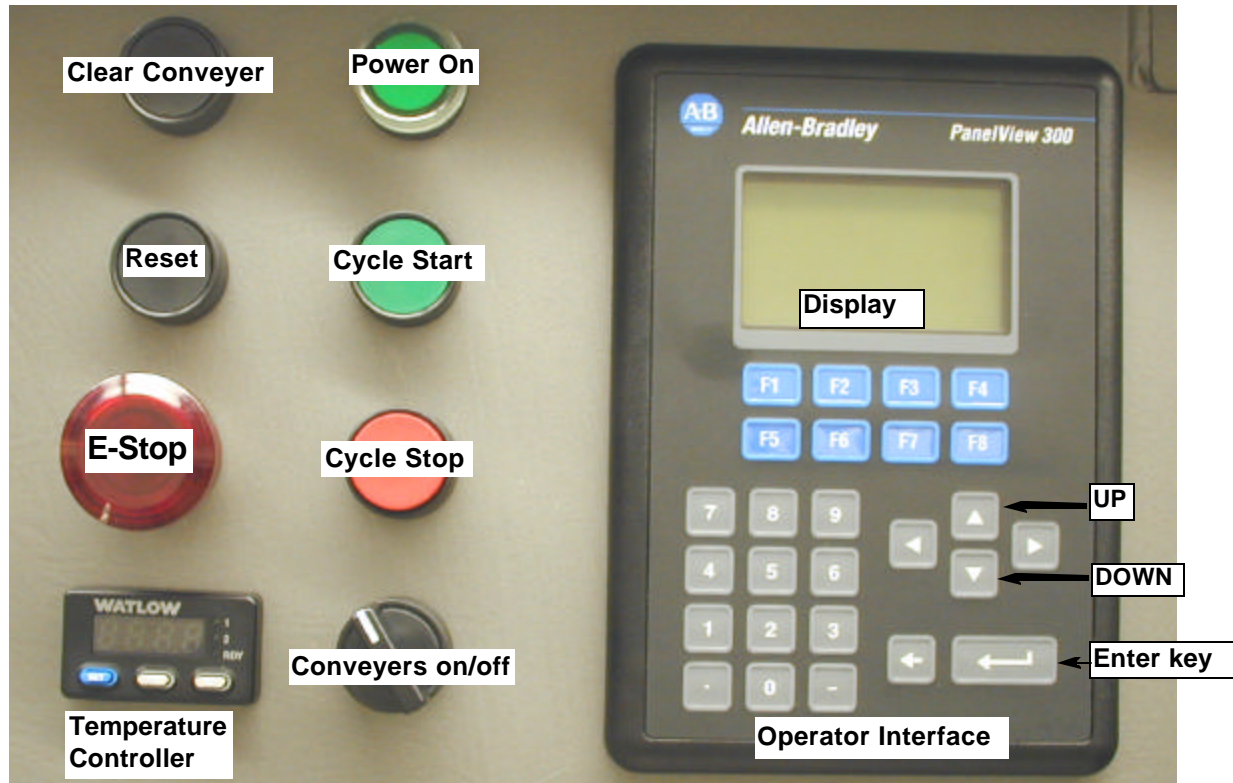
STAMP LOADING



1. Insert a full stamp roll so it is held firmly in the core holder (**A**) as indicated in the above picture.
- Place an old stamp roll core in the core holder to be used as a take up spool (**H**).
2. Feed the stamp paper down and under the peg roller (**B**).
3. Bring the paper over the guide roller (**C**) and then down.
4. Route the paper under the two trough guide rollers (**D & E**).
5. Bring the paper up and over the guide roller (**F**).
6. Feed the paper down and under the second peg roller (**G**) and then up and over the top of the take up spool (Used stamp core roll) (**H**).



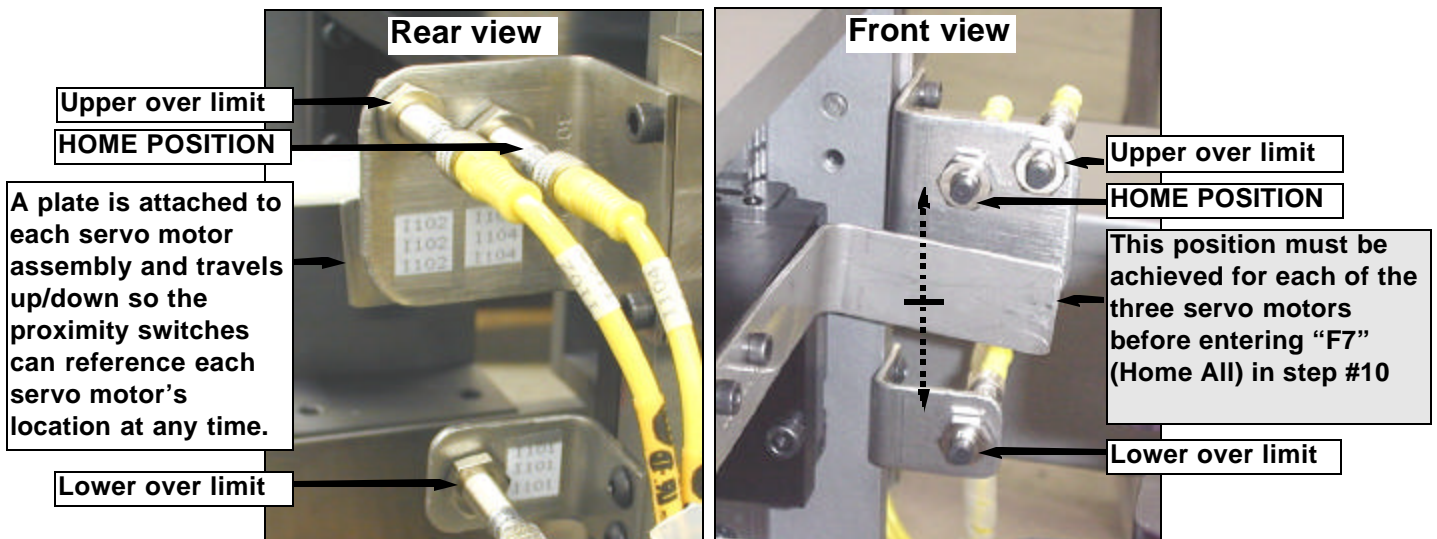
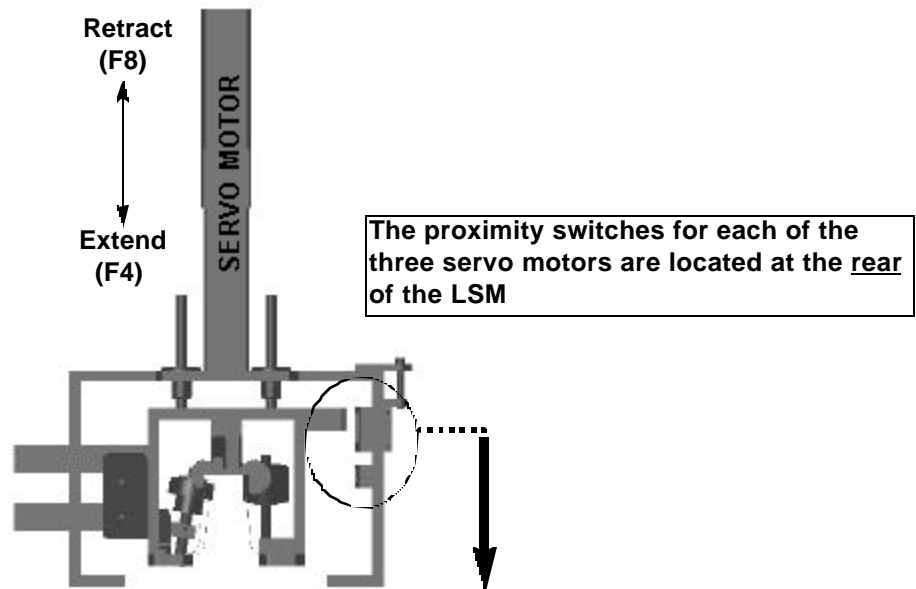
LINEAR STAMP MACHINE START UP PROCEDURE



1. Turn on the main power switch (located on the back of the electrical panel).
2. If the “E” Stop has been pressed in and is illuminated, pull out on the “E” Stop.
3. Press the the green illuminated push button “**Power On**”.
4. Press the “**F1**” button on the Operator Interface.
5. Using the up/down arrows, select the “**Servo**” screen from the list in the upper right hand corner of the display then press “**Enter**”.
6. Press the black “**Reset**” button.

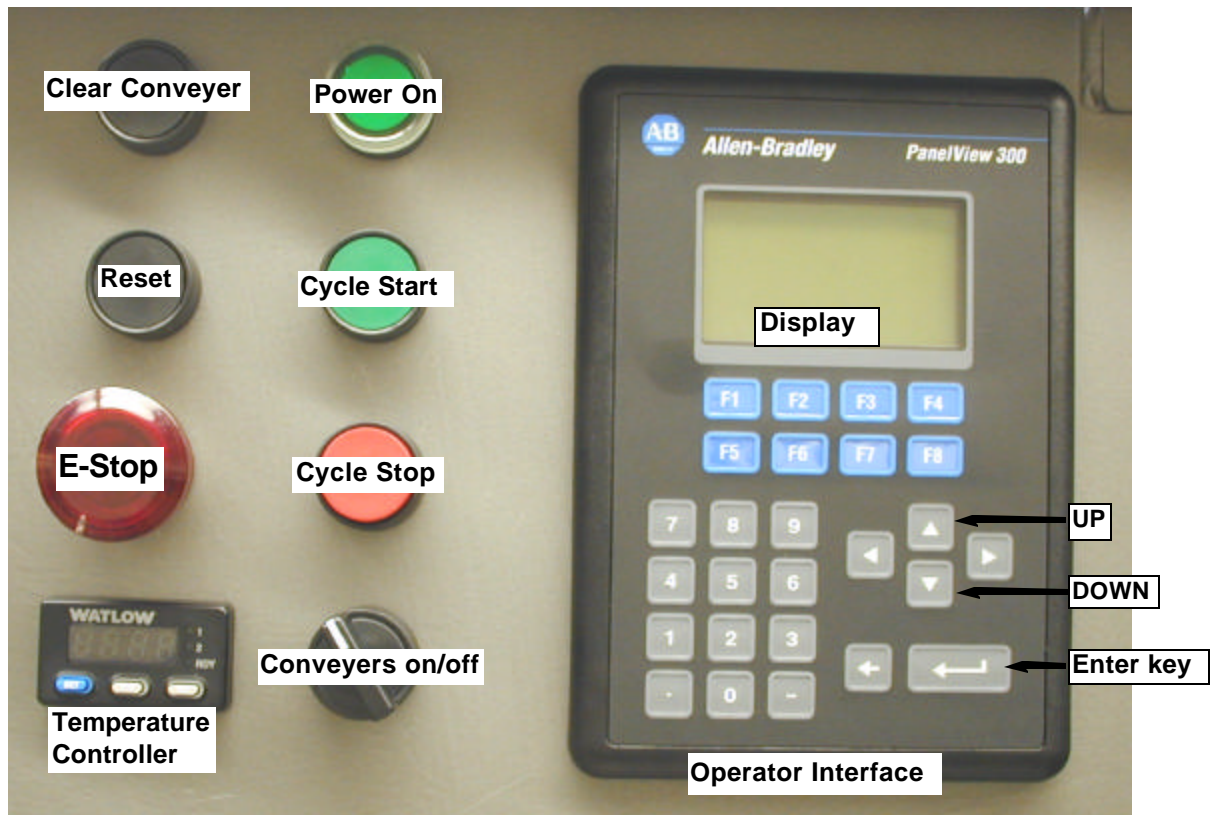
NOTE: The Opener, Stamper, and the Closer are raised/lowered by three separate servo motors. The “**F4**” (**Jog+**) button extends these servo motors downward while the “**F8**” (**Jog-**) retracts them. There are three proximity switches associated with each of these servo motors; upper limit, lower limit and home position. The purpose of the following steps is to move the servo motors away from their upper or lower limit switches so that the program can find the predetermined “Home” position. A detailed description of this can be seen on the next page and should be understood before continuing with step #7.

LSM START UP (CONTINUED)



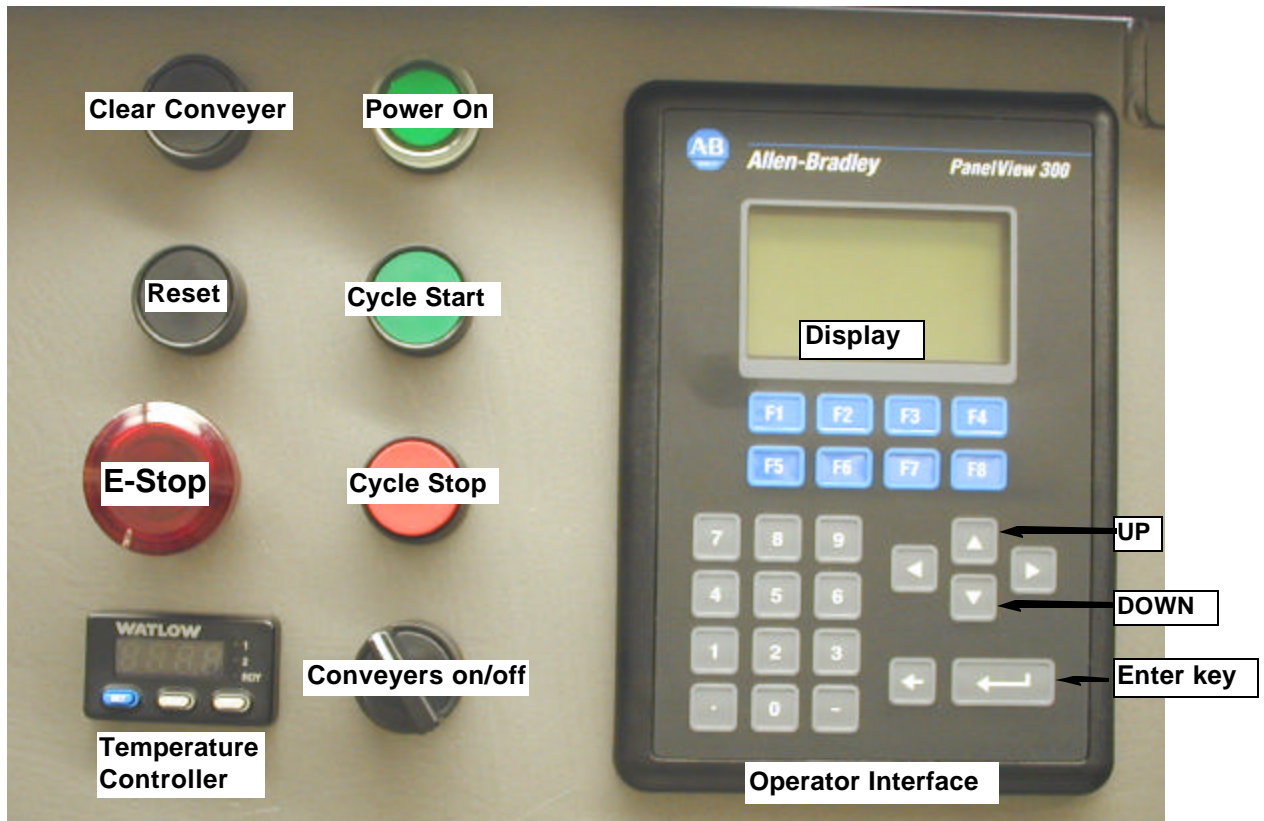
7. Press the “F2” (**Opener**) button and then press the “F4” (Jog +) or “F8” (Jog -) button.
8. Press the “F3” (**Stamper**) button and then press the “F4” (Jog +) or “F8” (Jog -) button.
9. Press the “F6” (**Closer**) button and then press the “F4” (Jog +) or “F8” (Jog -) button.
10. Press the “F7” (**Home All**) and observe that the Opener, Stamper, Closer, and conveyer will all return to their proper “Home” position in succession.
11. With the “Home” sequence completed, select the **main** screen (From the display) using the up/down arrows and press the “Enter” button.
12. Press the black “Reset” button.
13. Press the “F1” (Manual/Auto) button. The display screen will show “Auto position”.
14. Press the green “Cycle Start” button.
15. Select the proper position for the stamp head using the “F5” (Stamp Shift) button. You will need to look at the stamp roll in the machine and determine if the next stamp command will stamp at an unused stamp roll position across the row of 15 stamps..
16. The machine is now in the **Automatic** mode. When cartons are placed on the infeed conveyer the machine will cycle.

RESTARTING THE LSM AFTER A CARTON JAM



1. Using the up/down arrows, select the **“Servo”** screen from the list in the upper right hand corner of the display then press **“Enter”**.
2. Press the black **“Reset”** button.
3. Press the **“F2”** (Opener) button and then press the **“F4”** (Jog +) or the **“F8”** (Jog -) button. Jog the opener in the direction you need to move the opener axis.
4. Repeat step #3 for the stamp axis **“F3”** and the closer axis **“F6”**.
5. Press the **“F7”** (Home All) and observe that the Opener, Stamper, Closer, and conveyor will all return to their **“Home”** position in succession.
6. With the “Home” sequence completed, select the **main** screen using the up/down arrows and press the **“Enter”** button.
7. Press the black **“Reset”** button.
8. Press the **“F1”** (Manual/Auto) button.
9. Press the green **“Cycle Start”** button.
10. Select the proper position for the stamp head using the **“F5”** (Stamp Shift) button. You will need to look at the stamp roll in the machine and determine if the next stamp command will stamp at an unused stamp roll position.
11. The machine is now in the Automatic mode. When cartons are placed on the infeed conveyor the machine will cycle.

CLEARING THE LSM WHEN AN ORDER IS COMPLETED



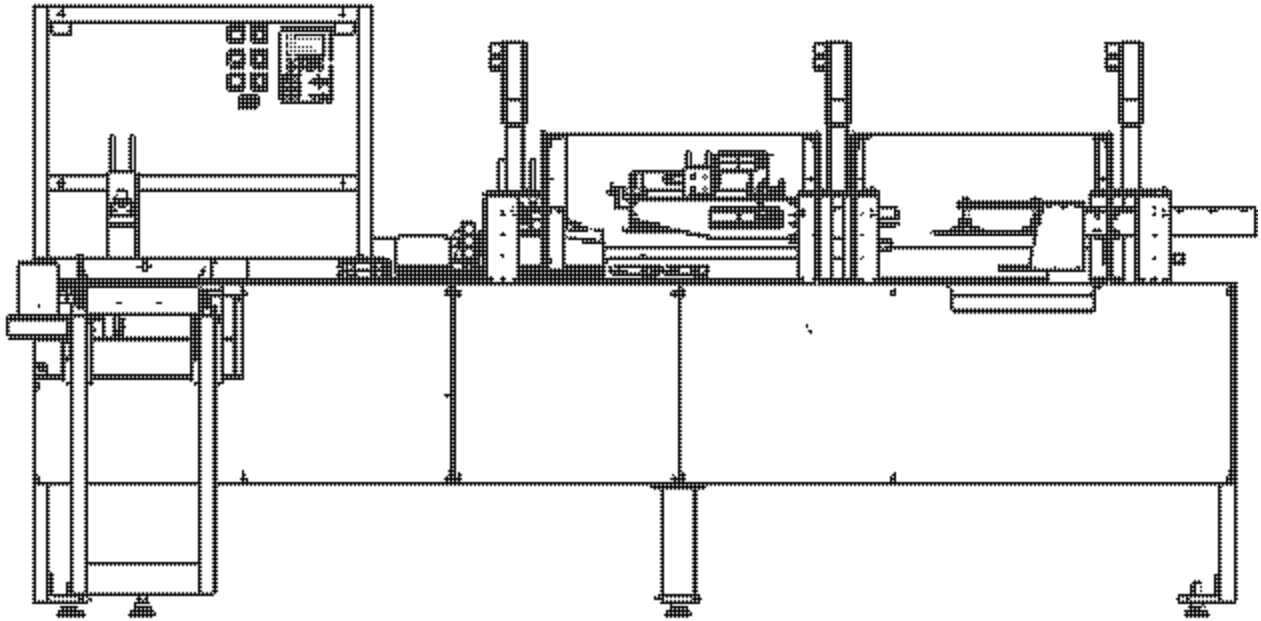
1. Press the black **“Clear Conveyor”** button 4 times.
 - The first will index the conveyor the long move.
 - The second will index the conveyor the short move and the stamp sequence will apply the stamps to the packs..
 - The third will index the conveyor the long move, sending the carton through the closer and out of the LSM.
 - The fourth will index the conveyor the short move and returns the conveyor to the Home position and ready for the next order.
2. Press the black **“Reset”** button and then the green **“Cycle Start”** button. The machine is now ready for the next order to be placed on the infeed conveyor and the machine will begin to cycle.

CLEAR CONVEYER WHEN SMALL FLAP DOESN'T OPEN

1. If the machine stops cycling, the carton in the stamp position may not have the small flap open.
 - Stop the conveyor in-feed and remove the carton that's about to contact the horn assembly. The unopened carton may be removed by pressing the black **“Clear Conveyor”** button 2 times.
 - The first will index the conveyor the long move and sends the unstamped carton through the closer and out of the LSM.
 - The second will index the conveyor the short move which returns the conveyor to the Home position making it ready for operation.
2. Press the black **“Reset”** button and the green **“Cycle Start”** button. The machine is now ready for cartons to move into the machine and begin to cycle.

NOTE: If screen still says “Ack F1”, simply press the “F1” button.

DATA SHEET



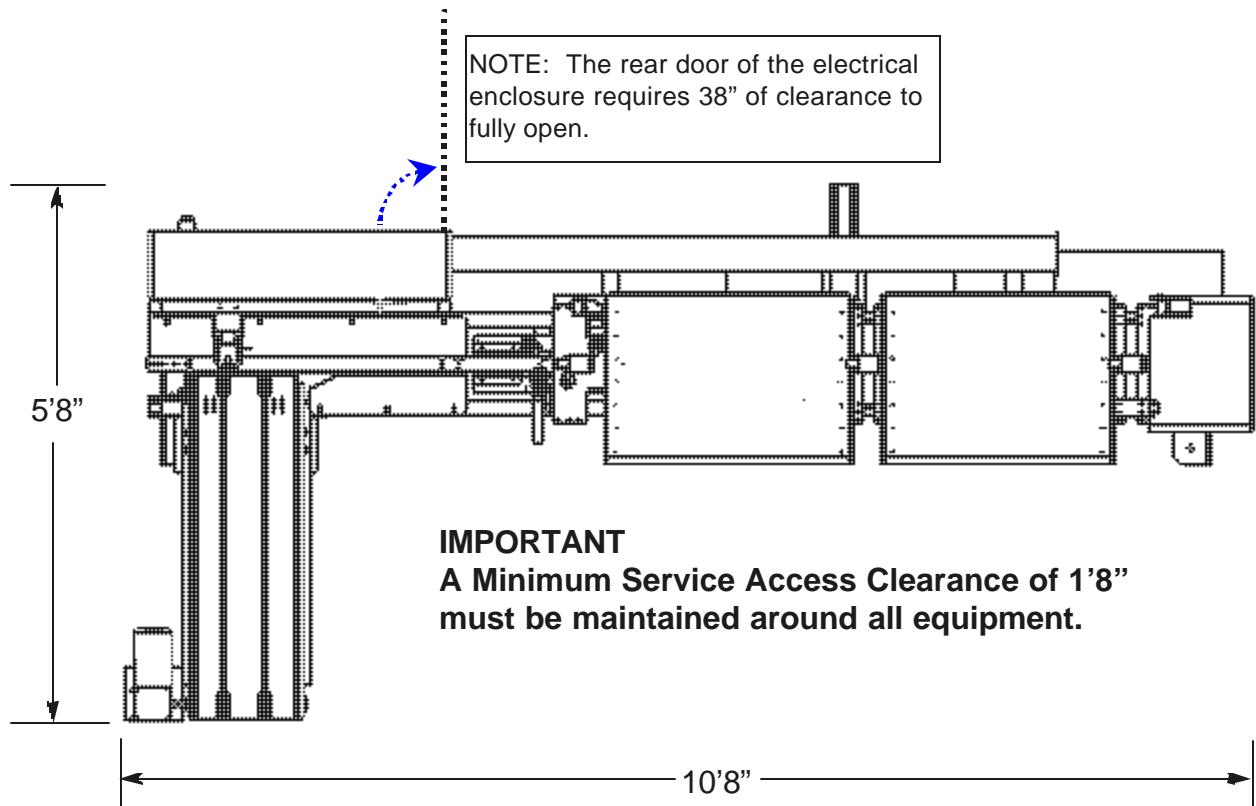
Machine Features

- Fully automatic carton sizing, flap opening, stamping, gluing and closing.
- No operator adjustments for carton size changes, regular to 120mm.
- Programmable Logic Controller (PLC) equipped with state-of-the-art heating control.
- LCD screen with readouts for monitoring of most operations.
- Heavy duty construction with industrial grade components.
- Improved stamping operation using standard stamp rolls.
- Automatic height adjustments minimizes carton and pack damage.
- Linear iron movement maximizes stamp transfer quality and virtually eliminates chopping.
- Eliminates iron heat variations and pack damage due to high heat conditions.
- Easy access to machine assemblies and controls for fast repairs and troubleshooting.

Specifications

- **Dimensions**
 - Length ____ 128"
 - Height ____ 65"
(74" with covers raised)
 - Width ____ 68"
- **Weight**
 - 1,200 lbs.
- **Electrical Requirements**
 - 120 Volts
 - 30 Amps
- **Air Requirements**
 - 90 PSI @ 1.7 CFM
- **Cycle Speed**
 - 30 - 45 CPM

DIMENSIONS



Overall height of the machine, with safety covers raised is 74".

The Linear Stamp Machine is best suited for post-stamping or partial post-stamping operations.

Your Meyercord sales representative is available for consultation on the best equipment arrangement to suit your space and production requirements.

