



# THC ROLL-ON PRO

## OPERATIONS MANUAL

### ROUND PRODUCT LABEL APPLICATOR



# THC ROLL-ON PRO

## *Round Label Applicator*

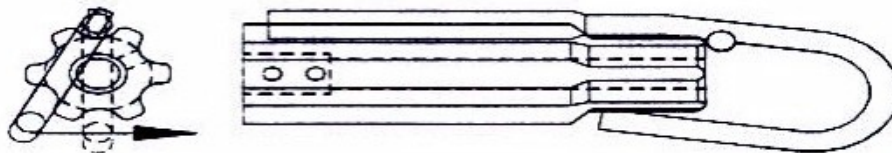
### **Machine Startup:**

1. Unpack Label applicator from shipping container.
2. Place the it on a firm level surface.
3. Plug the applicator into an 110VAC 10 AMP Grounded outlet.
4. Connect the labeler to a sufficient air supply. Minimum 80 PSI clean dry air.

Note: The applicator typically operates around 30 PSI depending on the label.

### **Label Threading:**

1. Remove outer unwind disc (48) install new roll of labels and replace disc.
2. Pull label web under the first roller, threw the photo eye (14). Continue pulling the label web over the top of the next roller. Thread webbing between the peel edge and the rubber drive roller (30). Then back towards the supply roll, over the idler roller.
3. Pull web down and wrap under the drive roller (24), and up between the drive roller (24) and pinch roller (17), then back down to the waist wind shaft (5). Note: The pinch roller (17) is spring loaded. Slight pressure will be needed to separate the pinch roller from the drive roller for threading.
4. Install waist wind clip (47) on waist wind shaft (5) placing the webbing between the shaft and the clip.



### **Teaching the photo eye:**

1. It is recommended that you teach the photo eye (14) with every new roll of labels used.
2. Remove one label from the webbing and place the webbing only in the photo eye.
3. Press and hold the “Normal” button on photo eye for 3 seconds. When the lights finish flashing the photo eye is taught.



## **Label Setup:**

The label advance potentiometer resides on top of the applicator electrical housing.

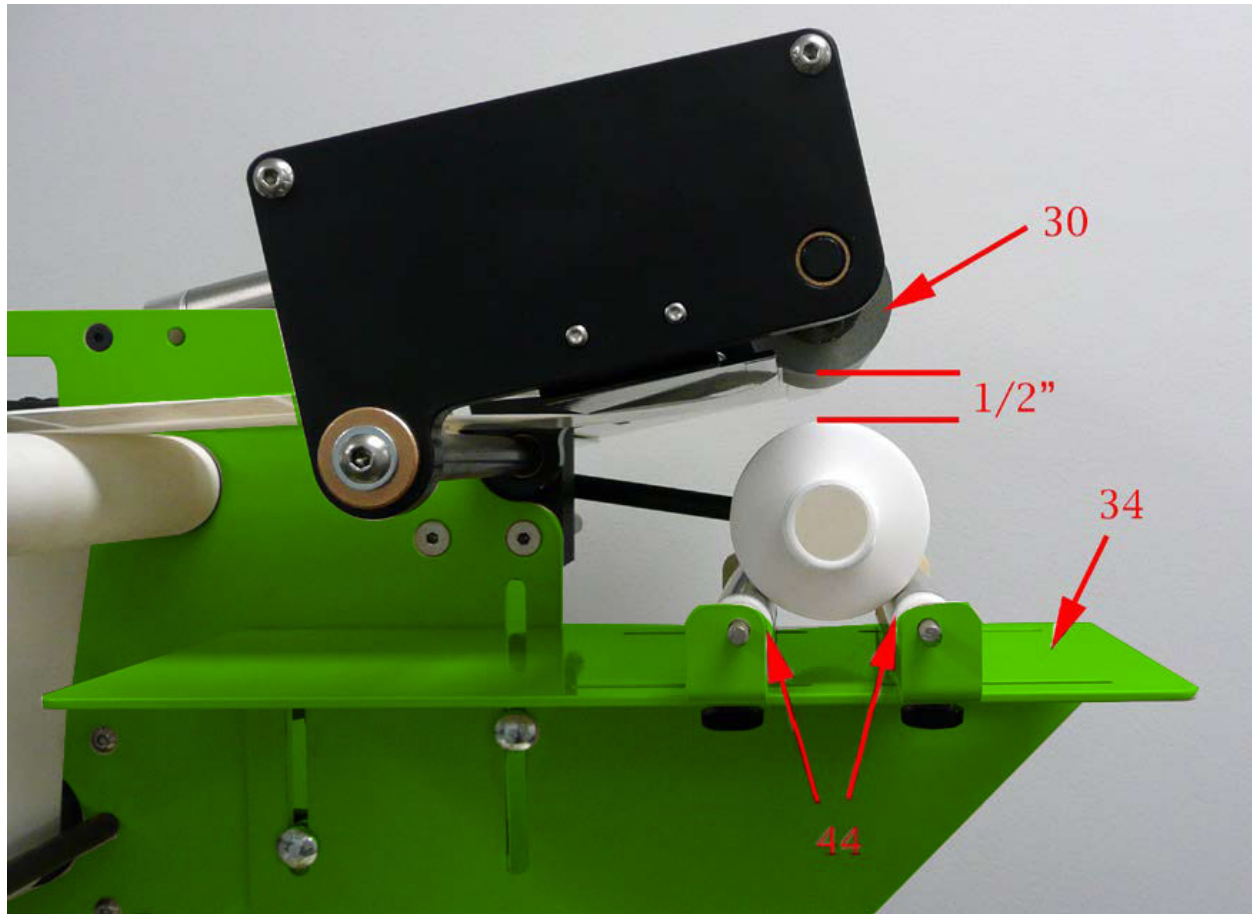
The purpose is to adjust the stopping position of the label with respect to the peel plate.

With the label advance pot turned all the way counterclockwise the photo eye will stop the applicator instantly when it senses a gap. By rotating the potentiometer toward the + the applicator will dispense more of the label, and by rotating the potentiometer toward the – the applicator will dispense less of the label.

1. To setup the label position, rotate the label advance pot to the – as far as it will rotate.
2. The goal is to have the applicator stop with a label gap right at the peel edge.
3. Activate the applicator and watch the dispensing label. If the label does not advance far enough turn the label advance pot to the +, and repeat until one label is completely dispensed and the next label is stopped at the peel edge.



## Product Carriage Setup



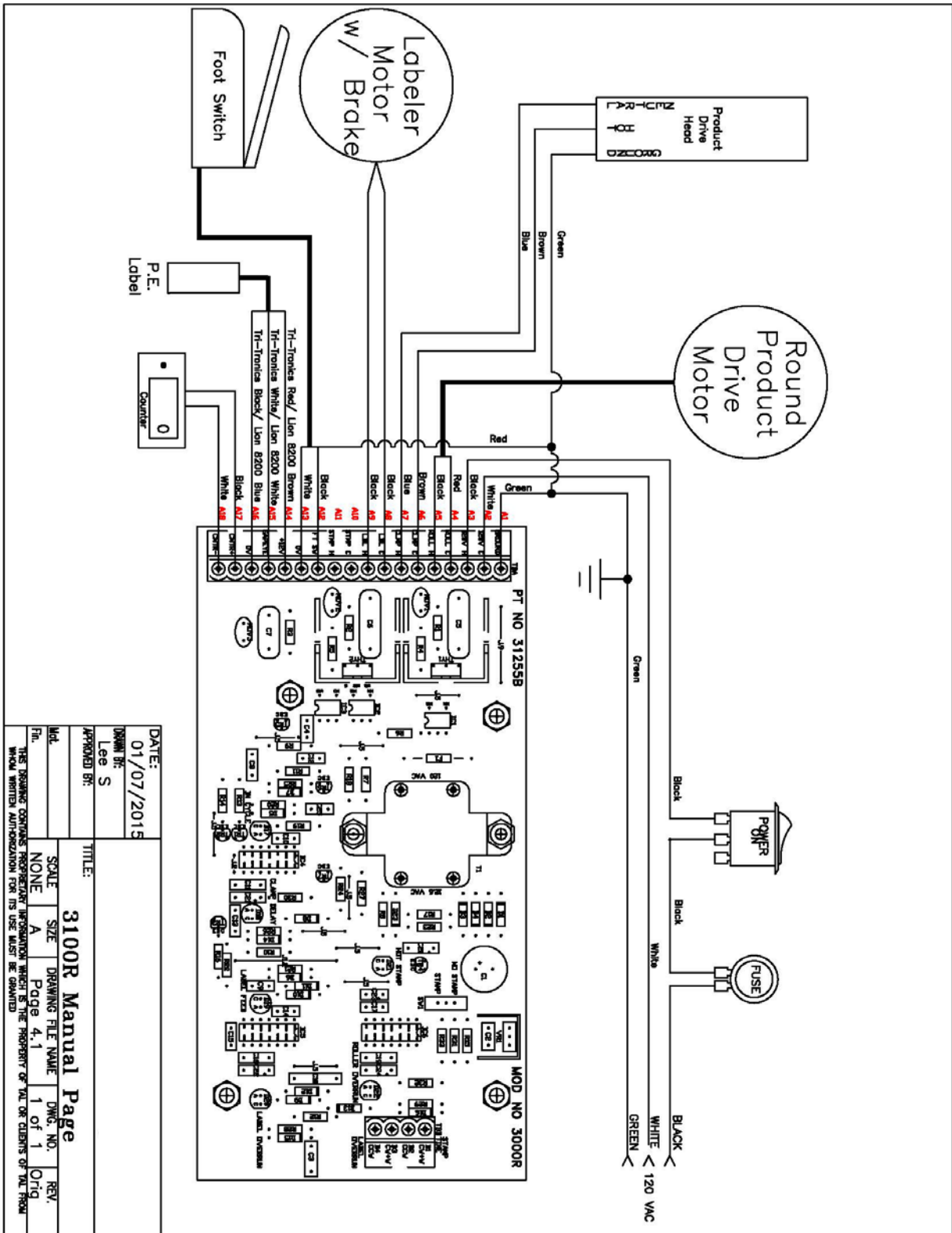
1. Keeping the product carriage table (34) level, raise or lower the product carriage by loosening the ratchet handles (2). Position the carriage with a 1/2" gap between the rubber traction roller (30) and the top of the bottle when the head is in the raised position.
2. Position the product rollers (44) with the center of the bottle under the rubber traction roller (30).
3. The product should be setting on the product rollers (44) so it will roll easily. If the label tends to “walk” to one side of the bottle during application, the product rollers (44) may need to be repositioned. Some products may even require one of the product rollers (44) to be slightly skewed.

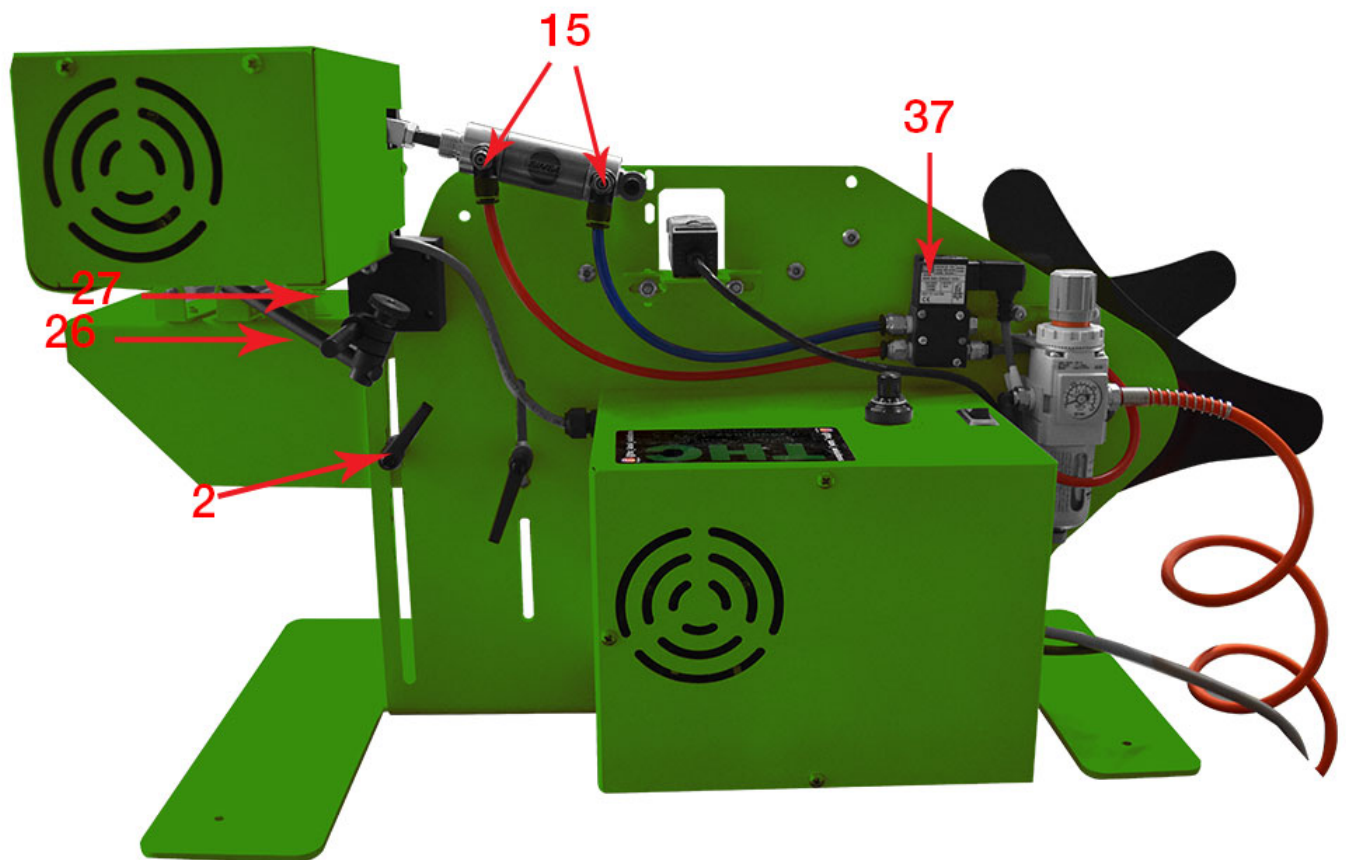
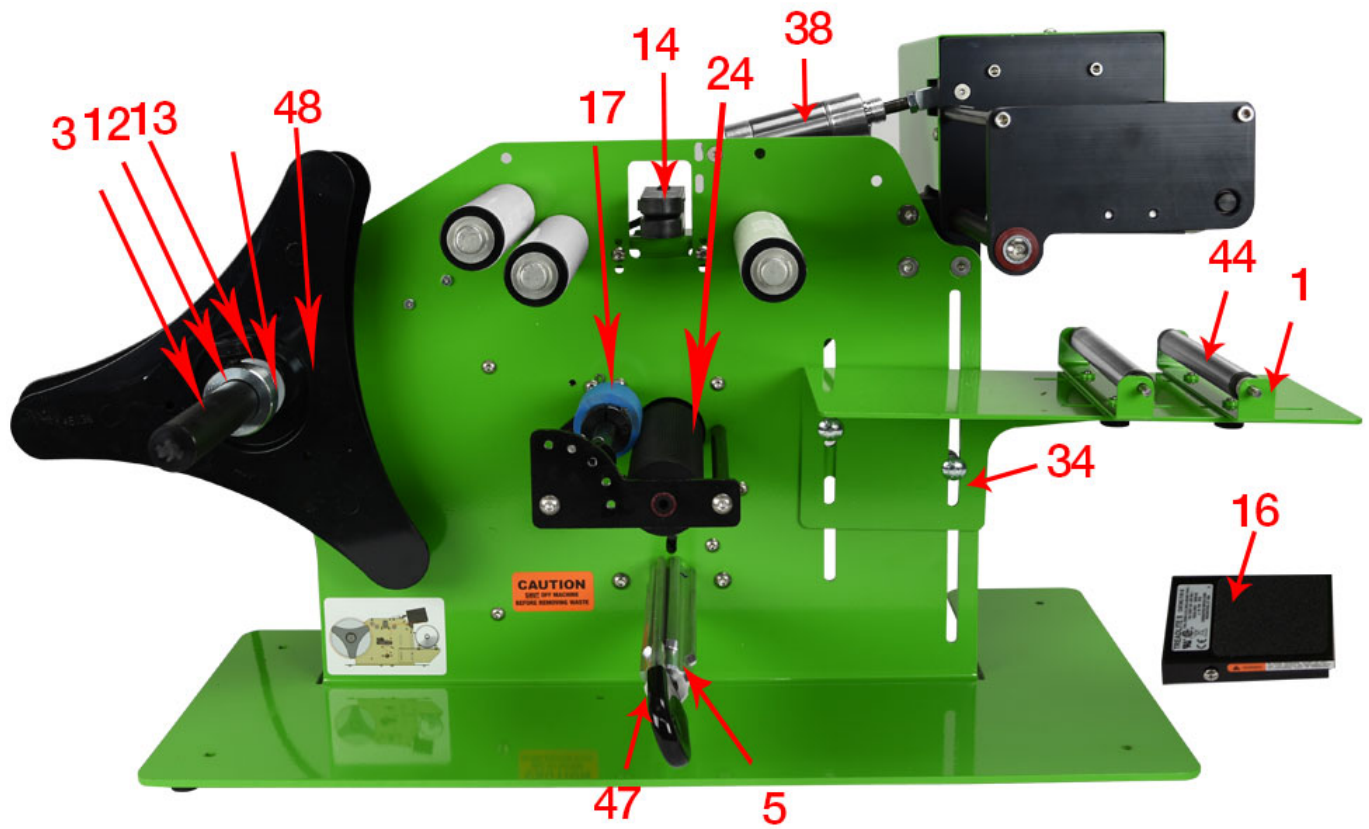
## ***Recommended Spare Parts List :***

---

| Qty. | Description          | Part # |
|------|----------------------|--------|
| 1    | Pinch Roller         | 31002  |
| 1    | Waist wind Clip      | 45131  |
| 1    | Drive V Belt         | 21031  |
| 1    | Timing Belt          | 31834  |
| 2    | Unwind Disc          | 45136  |
| 1    | Label Drive Motor    | 76800  |
| 1    | Feed Head Motor      | 31839  |
| 1    | Rubber Drive Roller  | 31408  |
| 1    | Foot Switch          | 30110  |
| 1    | Air Cylinder         | 31806  |
| 1    | Circuit Board        | 31255  |
| 3    | Unwind Felt Pad      | 72618  |
| 1    | Main Fuse            | 45157  |
| 1    | Peel Edge Cover      | 31375  |
| 1    | Valve Assembly       | 31805  |
| 1    | Photo Eye            | 30106  |
| 2    | Product Rollers      | 37007  |
| 2    | Left Torsion Spring  | 21027  |
| 2    | Right Torsion Spring | 21028  |

Depending on frequency of use and importance of the machine function, this list may need to be modified to include more of each part to prevent any down time.





## APPLICATOR

### Parts List

| Item # | Description                   | #  |
|--------|-------------------------------|----|
| 11004  | Roller Support Bracket        | 1  |
| 11007  | Carriage Ratchet Handle       | 2  |
| 11008  | Unwind Shaft                  | 3  |
| 11010  | Carriage Bolt                 | 4  |
| 11016  | Waste Wind Shaft              | 5  |
| 21031  | Gates Drive Belt              | 6  |
| 21026  | Motor Spacers                 | 7  |
| 21027  | Left Torsion Spring           | 8  |
| 21028  | Right Torsion Spring          | 9  |
| 25112  | Washer                        | 10 |
| 25113  | Spring                        | 11 |
| 26001  | Collar                        | 12 |
| 26002  | Hub Screw                     | 13 |
| 30106  | Tri-Tronics Photo Eye         | 14 |
| 30143  | Flow Control                  | 15 |
| 30110  | Footswitch                    | 16 |
| 31002  | Pinch Roller                  | 17 |
| 31015  | Plastic Bearing               | 18 |
| 31017  | Bronze Bushing                | 19 |
| 31029  | Bronze Bushing                | 20 |
| 31060  | Rewind Bracket                | 21 |
| 31255  | Control Board                 | 22 |
| 31282  | V Belt Tensioner              | 23 |
| 31355  | Main Drive Roller             | 24 |
| 31366  | Extension Rod                 | 26 |
| 31370  | 3/8" x 3/8" Knuckle           | 27 |
| 31373  | V Belt Pulley                 | 28 |
| 31380  | V Belt Tensioner Roller       | 29 |
| 31408  | Rubber Traction Roller        | 30 |
| 31416  | Label Advance Dial            | 31 |
| 31417  | Label Advance Pot with Wiring | 32 |
| 31721  | Adhesive Backed Rubber Feet   | 33 |
| 31802  | Bottle Carriage Table         | 34 |
| 31803  | Threaded Guide Rod Support    | 35 |
| 31804  | Cylinder Spacer               | 36 |
| 31805  | MAC Valve Kit                 | 37 |
| 31806  | Cylinder and Clevis           | 38 |
| 31818  | Peel Plate                    | 39 |
| 31832  | Flanged Pulley                | 40 |
| 31833  | Unflanged Pulley              | 41 |

|       |                            |    |
|-------|----------------------------|----|
| 31834 | Timing Belt                | 42 |
| 31835 | Bronze Bearing             | 43 |
| 37007 | Product Rollers            | 44 |
| 40007 | On/Off Switch              | 45 |
| 45131 | Clip                       | 46 |
| 45136 | Unwind Disc                | 47 |
| 45155 | Fuse Holder                | 48 |
| 45157 | Fuse                       | 49 |
| 45217 | Power Cord                 | 50 |
| 72618 | Felt Pad                   | 51 |
| 76800 | Heavy Duty Motor           | 52 |
| 31839 | Feed Head Motor (No Brake) | 53 |
| 81912 | Small Cord Grip            | 54 |

## *Optional Accessories*

### *All Purpose Carriage:*

The All Purpose Carriage provides greater flexibility and adjustability than the standard bottle carriage. It is especially useful for larger bottles or containers that have lips or ridges that can affect how the bottle rotates in the carriage. The All Purpose Carriage also allows some tapered products to be run on the applicator.



### *Lion 8200 Clear Label Photo Eye:*



1. Labels must pass under the “Sensing Area” indicator.
2. Remove a label and place the liner only in the sensor.
3. Press both Adjust buttons at the same time to quickly set the sensor, or...
  - a. Manually use Adjust Arrow buttons to light the “Gap Setup” light on the light bar.
4. Run labels through the sensor to verify that the three “Running” lights are active (on or flashing) while labels are passing through the sensor. If not, use Adjust buttons until they are. More lights than the three “Running” lights may be active while running labels.
5. If sensor is not performing satisfactorily, adjust up and/or down a few clicks and see if

performance improves, but always keep the three Triple-Checklights on when running.

### **Front and Back Label Option**

#### Setting First Label Advance:

1. Turn both label advance dials counter clockwise to 0.0. Then turn label spacing dial to 5.0.
2. Cycle the machine. Focus only on the first label. Using the 1<sup>st</sup> label advance pot on the left. Turn the label advance pot clockwise until the gap between the labels stops on the peel edge.

#### Setting Second Label Advance:

3. Once the first label is dispensing and stopping at the peel edge focus on the second label. Use the 2<sup>nd</sup> label advance pot on the right to advance the label so it is completely dispensed and the applicator stops at the gap.

#### Setting Label Spacing:

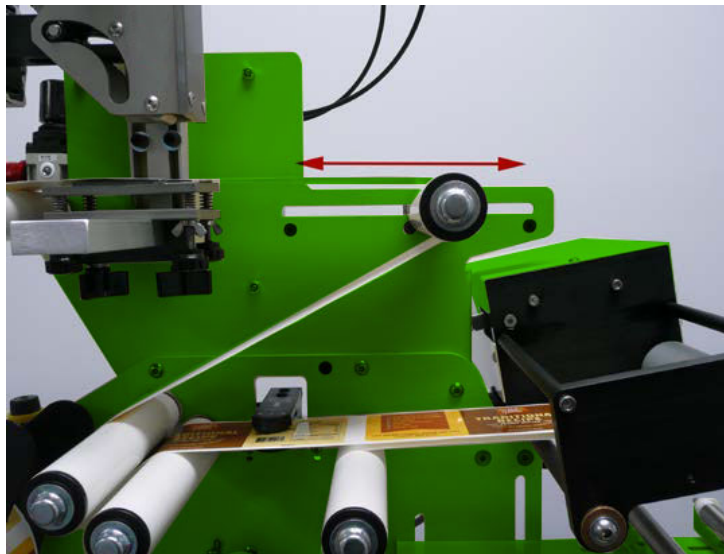
4. Use the Label Spacing pot to adjust the spacing between the front and back labels. Turning the pot to the + will increase the delay and your spacing between each label. Turning it to the – will decrease your delay and spacing.

## **Registered Ink Imprinter:**

The registered ink imprinter allows you to imprint an alphanumeric code on the label prior to application to the bottle. This is commonly used for batch codes, expiration dates, or lot codes.



- To adjust the printing location left to right on the web. Loosen two knobs and slide coder to appropriate location.



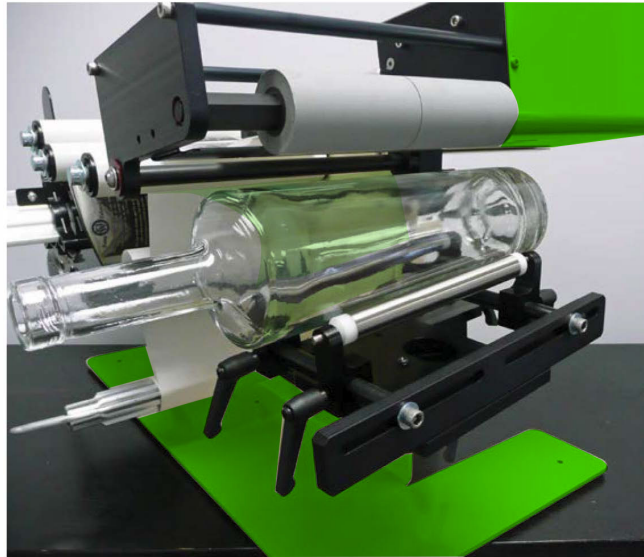
- To adjust the printing location with the flow of the web. Slide the roller forward or backwards to achieve desired print location.



### **OPTIONAL: Tapered Product Carriage:**

The Tapered Product Carriage is designed to assist in the application of labels to tapered bottles. For the tapered carriage to work properly the label must be crescent or arched in shape and match the taper/angle of the bottle.

1. Teach photo eye and set Label Advance per instructions on page 3 and 4.
2. First space two bottle support rollers to support tapered bottle.



3. Tilt the carriage so when the drive head is lowered it hits the top of the bottle flush. The full length of the rubber product drive roller should hit even and flat across the top of the bottle.





4. Using the adjustment screws (A) in the back of the carriage set the stops for the rotation of the carriage.  
With the carriage fully rotated and bottomed out against the stop the bottle should match the taper on the edge of the bottle. Once the desired locations are found, use the set screws (B) in the rear of the adjustment blocks to snug onto the threads of the bolt. DO NOT overtighten the set screw as damage can be done to the threads on the bolt.





5. The unit is now be ready to apply the first label. If the first label is not applied square to the bottle, utilize the adjustment screws (A) to make minor adjustments.  $\frac{1}{2}$  of a turn on the screw will make a large difference in how the label is applied.

