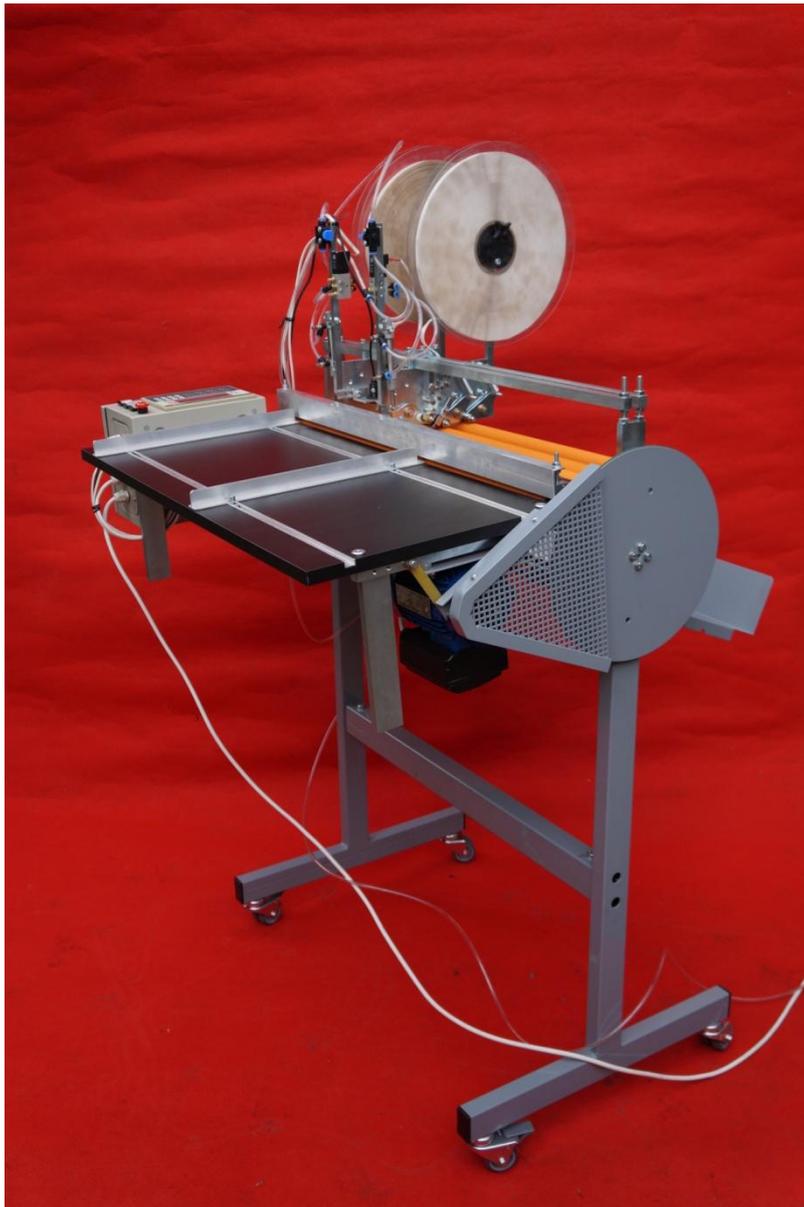


Paperfox HTD-2 Programmable Tape Applicator - Instructions manual

V1.1.

11.04.2015



Manufacturer: Paperfox Hungary

www.paperfox.eu

Application of the Paperfox HTD-2 Programmable Tape Applicator

The Paperfox HTD-2 Programmable Tape Applicator is designed for sticking max. 12mm wide double side self adhesive tapes on cardboard, stronger paper or other similar sheet materials.

The Paperfox HTD-2 Programmable Tape Applicator has two Paperfox TD-1 tape applicator heads. You can find more information about the usage of this heads in the following document: <http://paperfox.hu/pdf/manual-td-1-en.pdf>

You can lay up to 4-4 tape strips with the two tape applicator head on a sheet in the programmed position. The two head can be programmed independently.

Warning

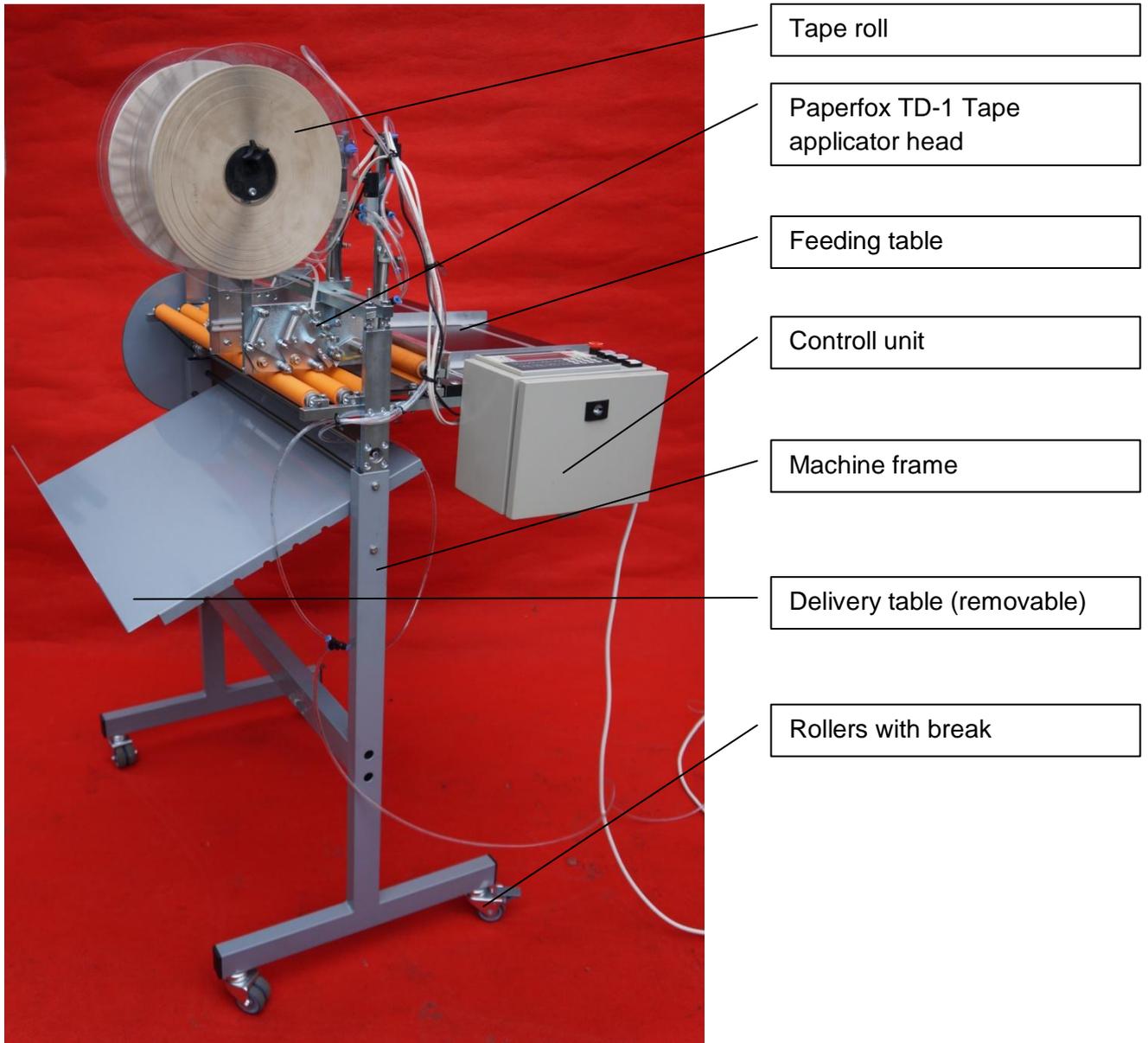
- The Paperfox HTD-2 Programmable Tape Applicator is designed for sticking 12mm wide double side self adhesive tapes on cardboard, stronger paper or other similar sheet materials. You can use other tapes and other materials, but the device isn't tested for such applications. Maybe that you have to make some modification for processing other materials.
- Prior to the Paperfox HTD-2 Programmable Tape Applicator utilization, definitely read all instructions.
- There is a very sharp knife in the Paperfox HTD-2 tape dispenser. Be careful when you change the knife or when you insert the adhesive tape in the device.

Parameters

Dimensions with stand and delivery table: (L x W x H)	100cm x 100cm x 150cm
Dimensions without stand and delivery table: (L x W x H)	100cm x 80cm x 75cm
Weight with stand and delivery table:	60 kg.
Tape width:	12mm
Tape roll outer diameter:	320mm
Tape roll core inner diameter:	75mm...3"
Tape roll length:	500m
Suggested tape roll type:	Steratape – DST/F 6/12mm x
Min. paper weight:	80 g/m ²
Control voltage:	24V DC
Operating pressure:	~ 8 bar
Knife type:	Olfa MCB-1
PLC/HMI type:	Xinje XP3-18PRT V8.0/3.2.

Standard parts of the Paperfox HTD-2 Programmable Tape Applicator

The Paperfox HTD-2 Programmable Tape Applicator consists of the following parts:

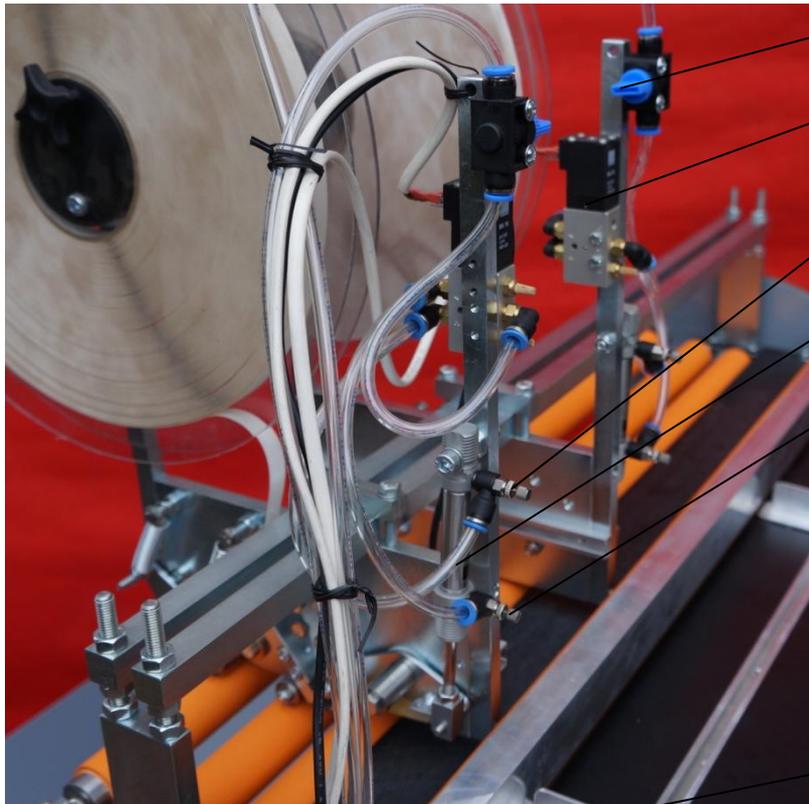




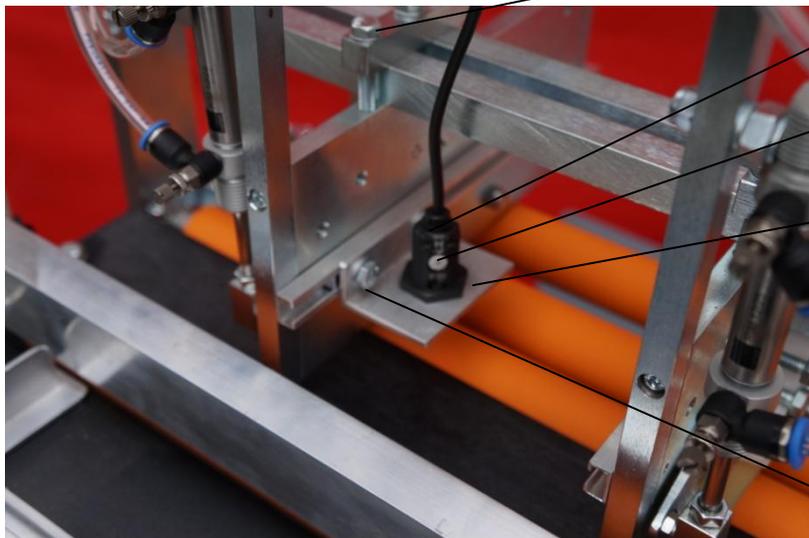
- Pneumatic manual valve
- Applicator head holding bars
- Rubber cylinders
- Paper guides
- Belt pulley
- Leg for tabletop usage.
You can use the device without machine frame on a table.



- Emergency stop button
- Motor start button
- Motor stop button
- Main switch
- Display
- Controll buttons



- Manual valve
- Electro-pneumatic valve
- Start delay valve
- Pneumatic cylinder
- Stop delay valve
- Applicator head fixing screws



- Optosensor
- Sensitivity setting
- Sliding bracelet
- Fixing screws

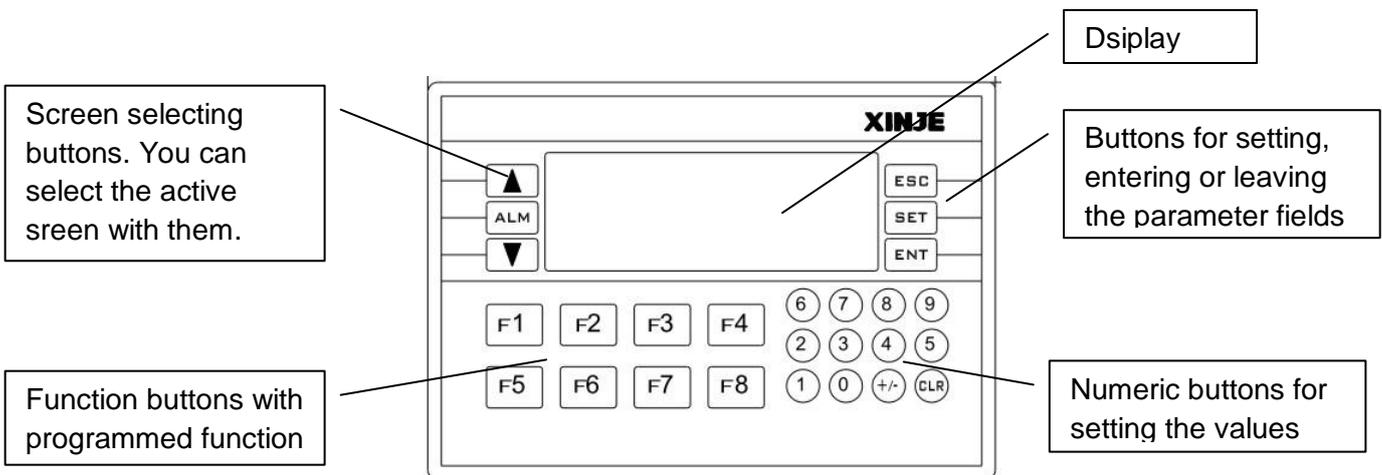
Using the Paperfox HTD-2 Programmable Tape Applicator

- Set the two tape applicator heads into the desired position. Loose the applicator head fixing screws and slide the tape applicator heads in the proper place. Fix the screws again.
- Set the paper guides to the sides of the paper which you want to process with the machine.
- Connect the device to 230V 50Hz electricity and to 8 bar compressed air.
- Open the manual valves on the head(s) you want to use.
- Switch on the machine with the main switch. (If the light not lights on, check the emergency stop button and if it is pressed down turn the head of the emergency stop button)

Programming the Paperfox HTD-2 Programmable Tape Applicator

The operator display

You can set the parameters of the tape application on the operator display (HMI). When you switch on the machine the first screen appears on the display. You can change the active display with the screen selecting buttons.



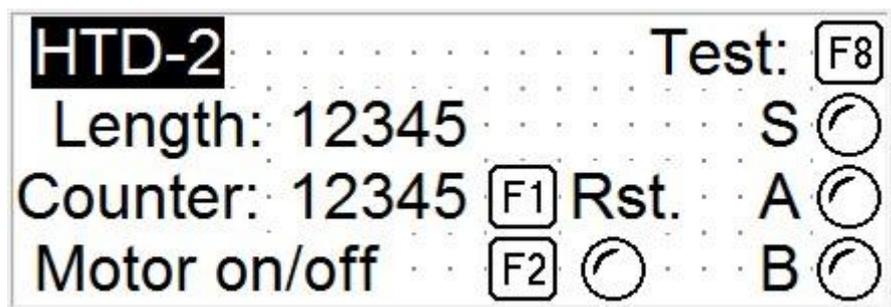
You can find the actual function of the F1...F8 function buttons on the display.

- With the “SET” button you can enter into the first data field on the display and you can write a value of the parameter with the numeric buttons.
- With the “ENT” button you can finalise the value written into the data field and jump on the following data field.

- If you don't want to write in all data fields then you can leave the data inserting mode by pressing the "ESC" button.
- When the controller is not used for a certain time then the lighting of the panel maybe swithed off automatically. If you press any key on the display the light lights on.

The first screen

After switching on the device the first screen appears:

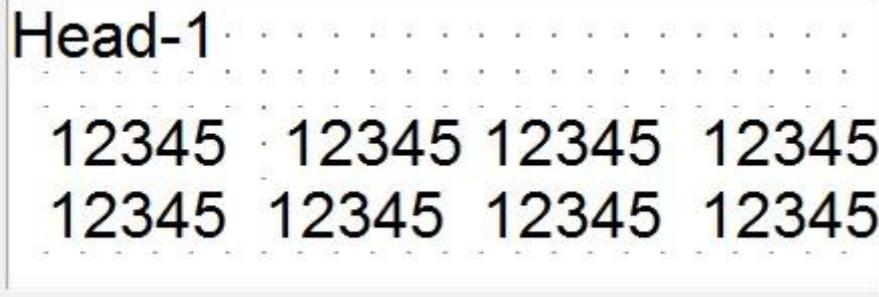


Function of the elements on the first screen:

F-1 Function button:	Resets the counter value to zero.
F-2 Function button:	Starts/Stops the motor turning.
F-8 Function button:	For test purposes only. Imitates the signal of the optosensor.
"Length" value:	An integer number proportional with the length of the last sheet. Actually it is the time during the sheet activates the optosensor.
"Counter" value:	Sheet counter.
"S" indicator lamp:	Displays the optosensor state.
"A" indicator lamp:	Displays the electropneumatic valve activity on the "A" head.
"B" indicator lamp:	Displays the electropneumatic valve activity on the "B" head.

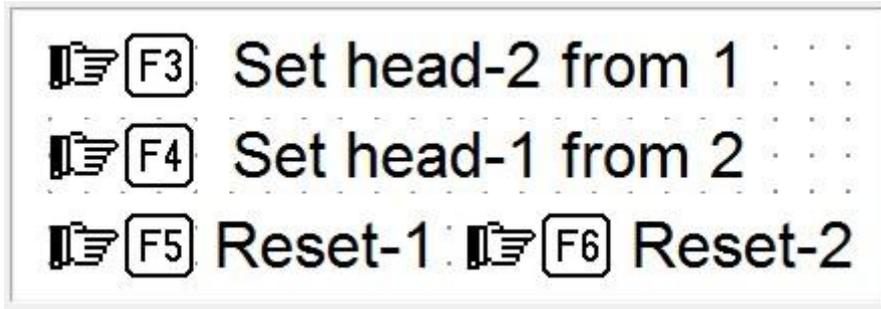
Second and third screen

The appearance of the second and third screens are similar. The second screen sets the parameters of the "A" head, the third screen sets the parameters of the "B" head. There are 8 numeric data field on this screens. If there is a zero value in this fields that means that this field is not used. If all values are zero, the head doesn't works.



1. The first value is the delay between the optosensor start signal and the first tape application starting time. If it is "1" then the tape application starts very close to the edge of the sheet. You can adjust this position with moving the optosensor into the proper position. This position depends on the speed of the sheets and on other parameters.
2. The second value is the delay between the optosensor start signal and the first tape application ending time. It should be a definitely bigger value than the first value. If there is not enough time between the start and end position then the device don't works well, because the head can't lay shorter strips than about 3cm.
3. The third field is the delay between the optosensor start signal and the second tape application starting time, and the other fields having similar functions as the first two field. All field should have definitely bigger values as the previous fields or it has to be zero. The tape application stops when the sheet goes away from the optosensor so there is no sense to write bigger values on this fields as the "LENGTH" value on the first screen.
4. If you enter "1" in the first field and all other fields are zero, then the tape application starts at the beginning of the sheet and stops at the end. You can fine adjust this positions with sliding the optosensor into proper position or with the start delay valves and stop delay valves on the pneumatic cylinders.

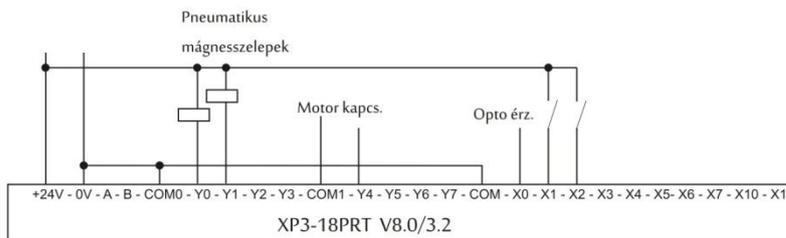
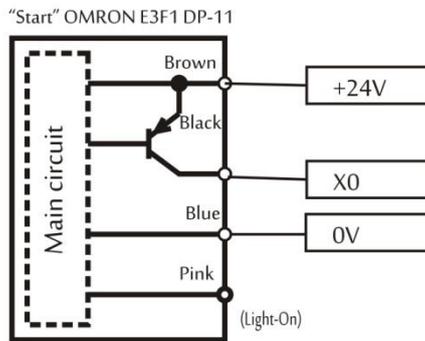
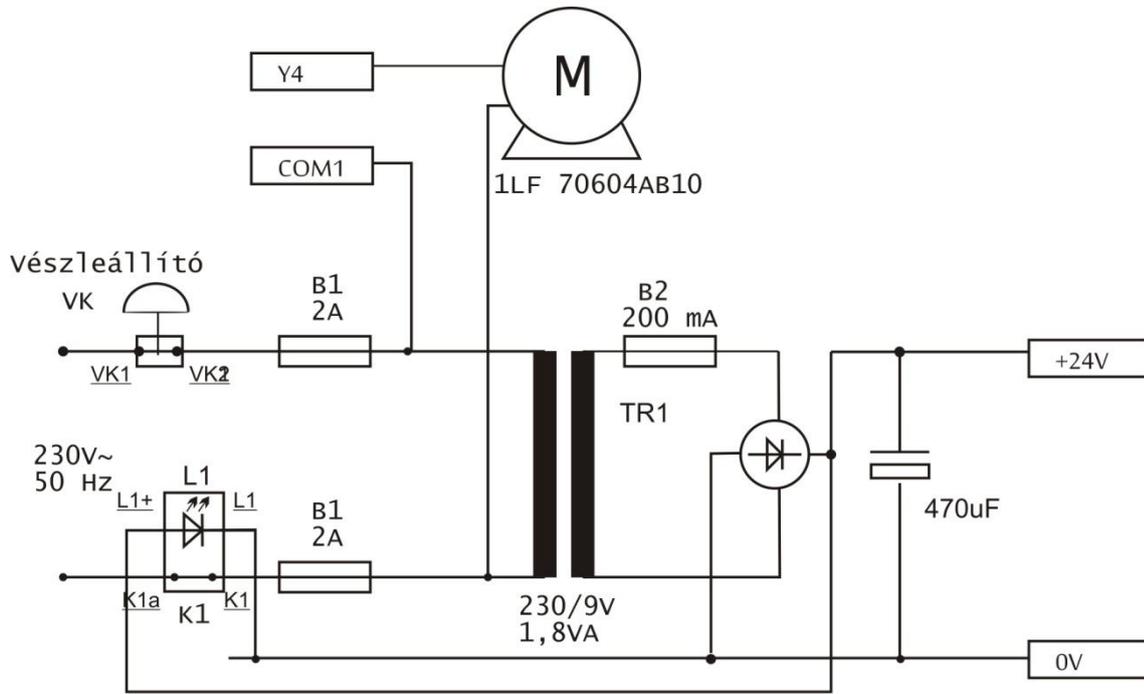
Fourth screen



F-3 Function button:	Copies the values of the parameters of the second head (screen 3) to the first head (screen 2).
F-4 Function button:	Copies the values of the parameters of the first head (screen 2) to the second head (screen 3).
F-5 Function button:	Resets all parameters in screen 2 to zero
F-6 Function button:	Resets all parameters in screen 3 to zero

Other screens

The other screens are having only diagnostic functions. You can check the value of the inputs and the registers of the controller or directly control the outputs.



PLC: XP3-18PRT V8.0/3.2.

- Az Y4-Y7 outputs are with relay.