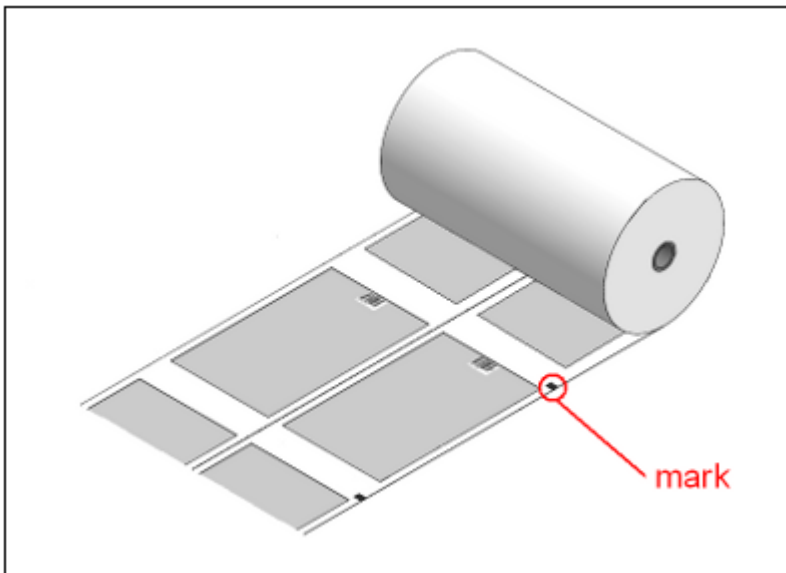


ST090002 PRINTED FILM PARAMETERS

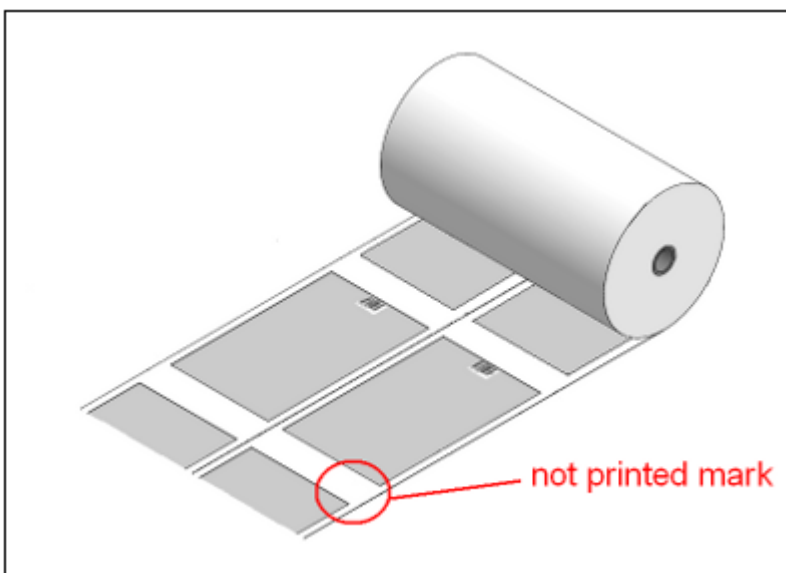
Document based on Console 704SP04.

Before to proceed with the parameters settings, it must be individualized which kind of film is used. Our system can work **three*** different kind of film:

A Type, with mark. Film centering is managed by reading the mark (mark has NOT to be transparent).

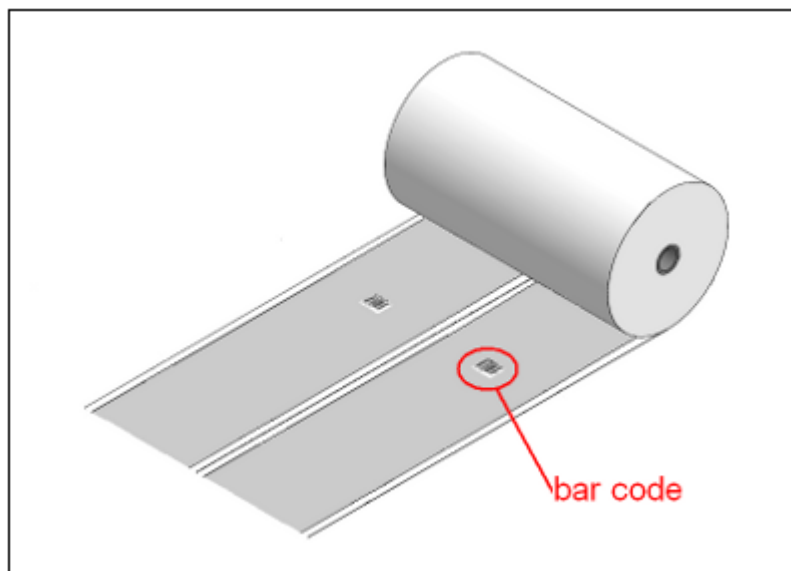


B Type, without mark. Film centering is managed by reading not printed film.



C Type*, complete printed film. Film centering is managed by reading a different color of the stamp, in the following picture could be the bar code.

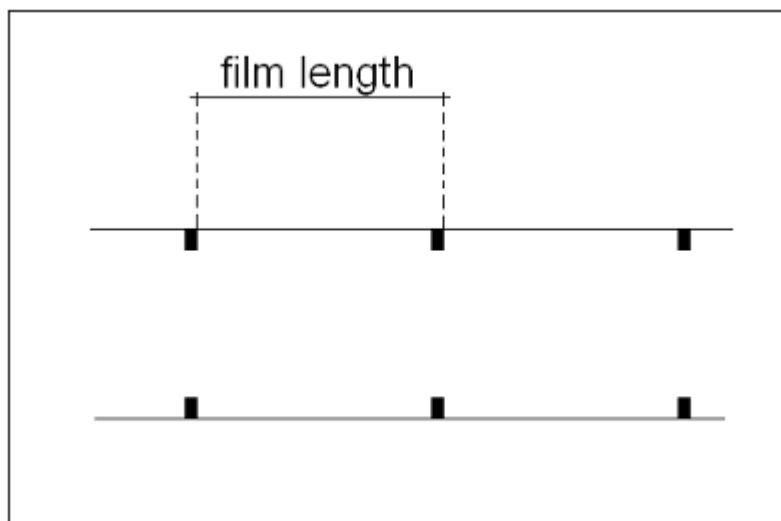
*** C Type can be managed only with the optional opto-eletronic sensor ML590011**



1. Film ramp parameters setting

Set film ramp parameters will be the first step, according with technical document **ST09005** (film ramp with mechanical clutch), or **ST090024** (film ramp with motorized blade).

Film length **must be** as the distance between the two marks, as the following picture:



2. A type and B type settings

Measure the mark width in mm, considering that:

for the **A Type** film, measurement will be on black mark,

for the **B Type** film, measurement will be on not printed film section.

ID	Parameter	Value	Range
11206	Presence sensor to use	0	(0÷1)
4097	Minimum film mark width	50	(1÷1000000 mm)
4098	Maximum film mark width	90	(1÷1000000 mm)
4099	Maximum correction	0.1	(0÷0.100000)
4100	Film mark offset	0.19	(0÷1.000000)
4101	Proportional gain	0.75	(0÷1.000000)
4102	Integral gain	0.075	(0÷1.000000)
4103	Maximum speed Offset advance	0.0	(-1.0000÷+1.0000)
4104	Stopped machine delay	0.0	(-1.0000÷+1.0000)
4105	Sensor logic 0	1	(0÷1)
11207	Sensor logic 1	1	(0÷1)
4106	Film to unroll	8	(0÷50)
4107	Film after mark for mark finding	0.8	(0÷10.0000)
4108	Cut displacement for mark searching	0.2	(0÷10.0000)

Now set the values of following parameters:

- **4097 Minimum film mark width**, mark width minus 10mm
- **4098 Maximum film mark width**, mark width plus 10mm
- **4105 Sensor logic**, with **A Type** film the value must be 1. While using **B Type** film, the value must be 0.
- **4112 Function mode**, must be 0. Mode 1 is used in case of more detection in the same cycle.

Next step will be enable the film mark search, from the main page of the program select *ZONE FILM WRAPPER (34) - FILM MARK (2)* then select ONOFF button (green led must be on).

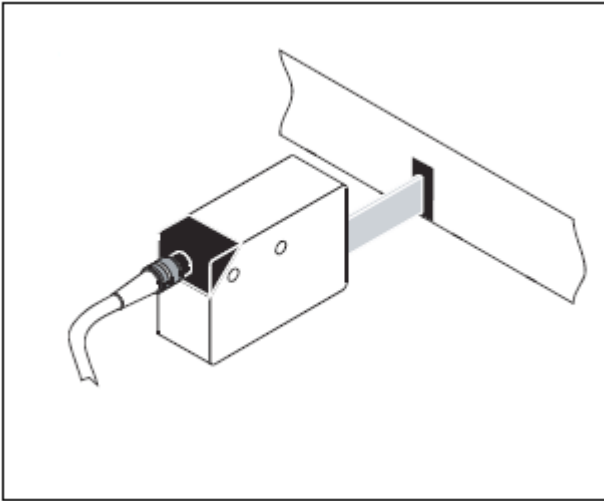
Verify the functioning of the machine with the product and check the position of the printed film, to modify the printing position around the pack, it is necessary modify the value of the parameter **4100 Film mark offset**.

It is better modify that parameter only few cent of unit per time, and produce 10 packs between one modification and next one.

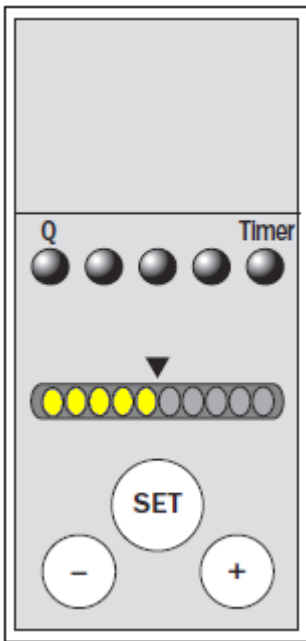
3. C Type settings

Follow next instructions, to set the opto-electronic sensor:

- move the sensor on the reference colour, pay attention, the same distance (between sensor and film) must be respect during the production.



- press **SET** button, to start with the colour capture, first five led will be on



- let the sensor few seconds in colour capture phase
- press again **SET** to confirm the setting, then verify that the led **Q** is on while the sensor is in front of the reference colour.

4. MARK DISPLAY FUNCTION

Mark display is an helpfull function to set the parameters **4097 Minimum film mark width** and **4098 Maxium film mark width**.

From the main page of the program select *ZONE FILM WRAPPER (34) - FILM MARK (2) - MARK DISPLAY:*



While the machine is running it is possible to check photecel reading value.

- In the **black** column, it is visualized the actual mark position (if the system is running correctly, that value will be similar at the parameter **4100 film mark offset**).
- In the **grey** column, it is visualized the mark width in encoder pulses.
- In the **green** column, it is visualized the mark width in mm.
- **Red** led on, means that a valide mark has been detected.

The value of the parameters **4097 Minimum mark width** and **4098 Maximum mark width**, must be respectively as the minimum detected mark width minus 10mm and the maximum detected mark width plus 10mm.