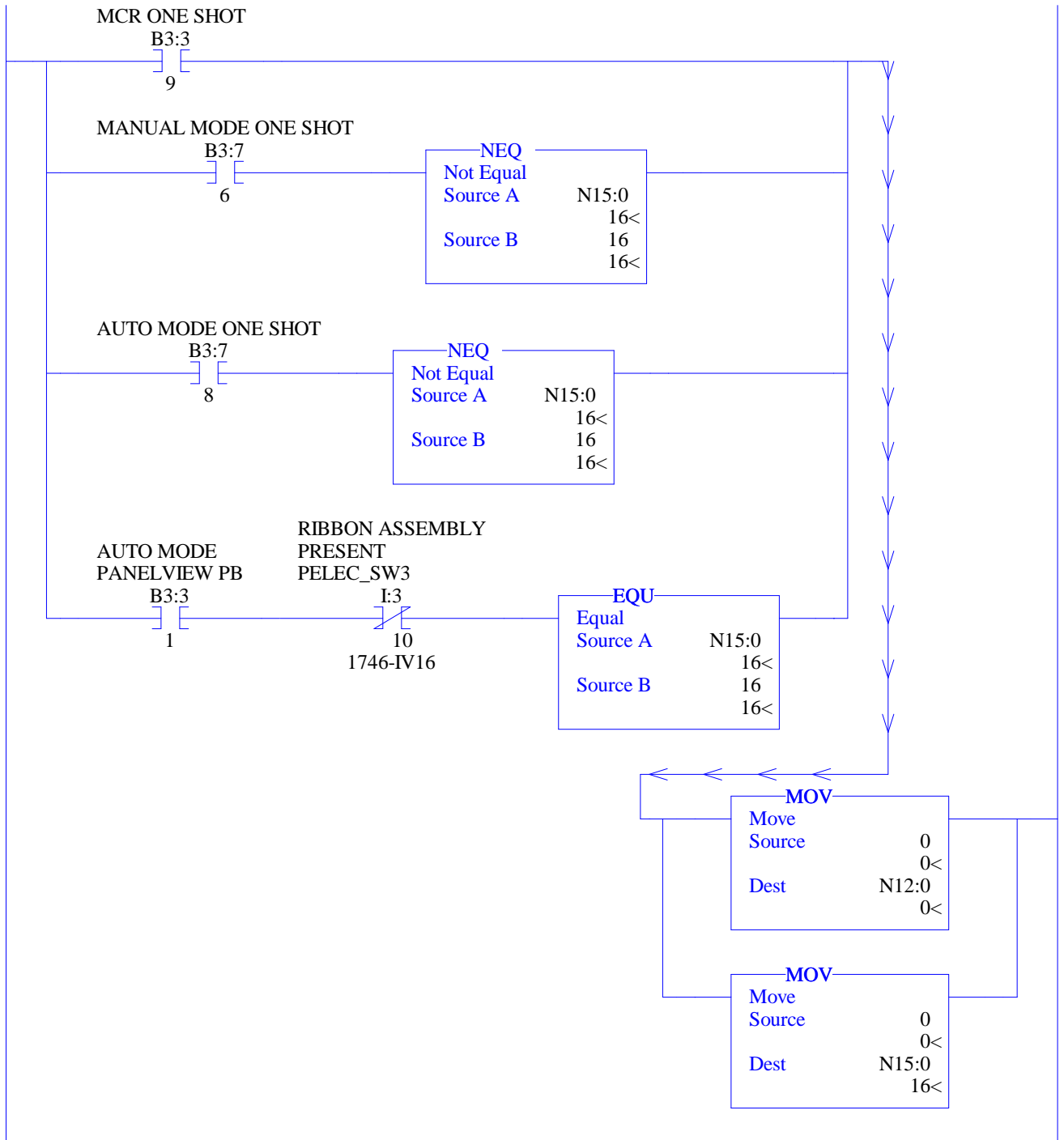
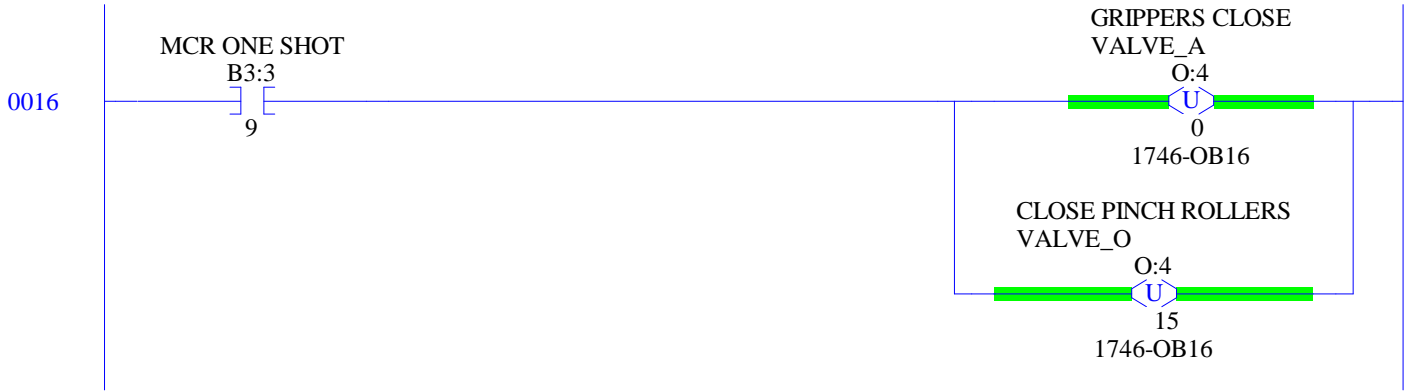
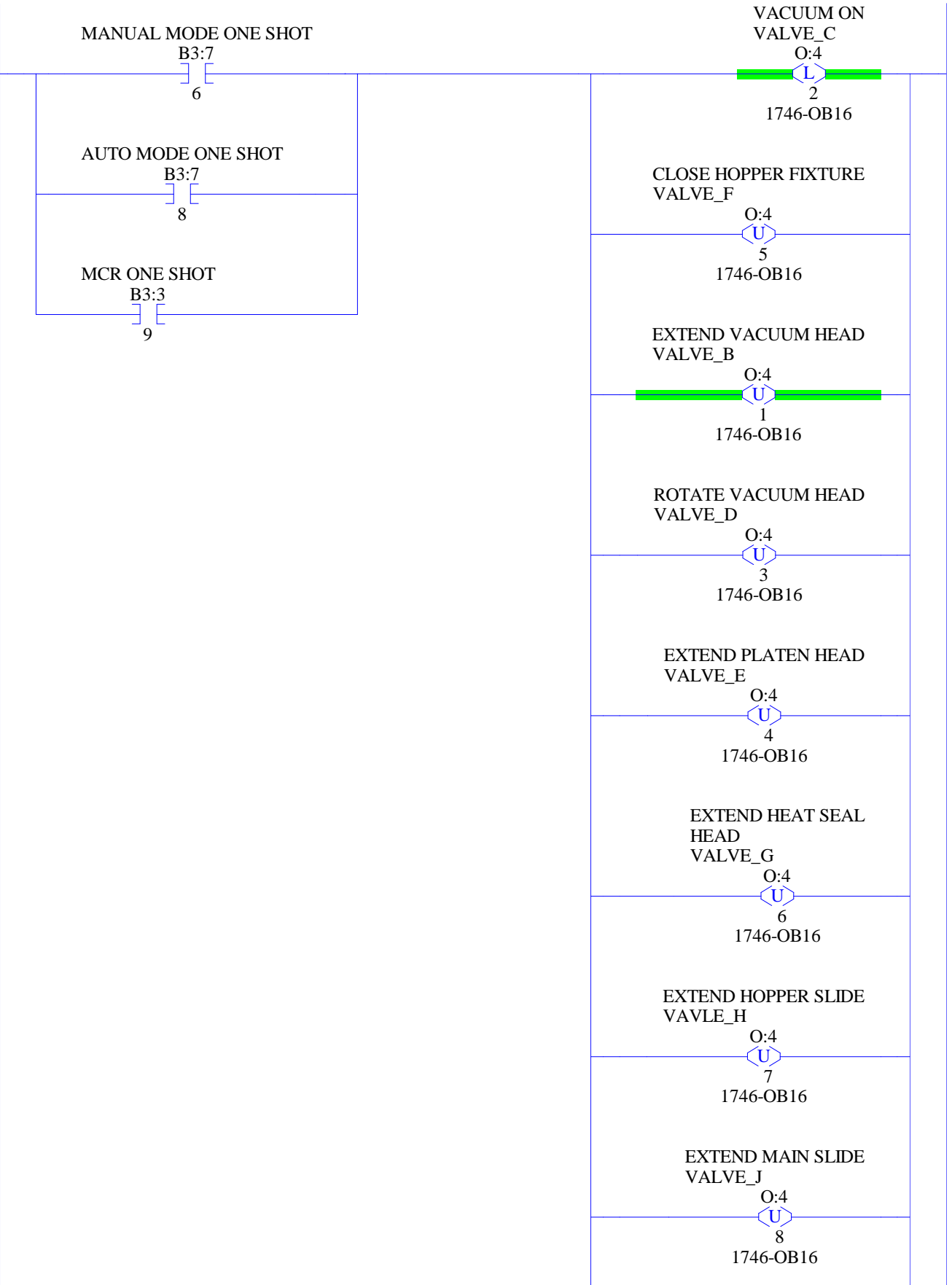


0015





0017



RAISE HOPPER PLATEN
VALVE_K

O:4



9

1746-OB16

EXTEND HOPPER SEAL
HEAD
VALVE_L

O:4



10

1746-OB16

EXTEND CUTOFF
VALVE_M

O:4



11

1746-OB16

STAGE CUTOFF
CYLINDER
VALVE_N

O:4

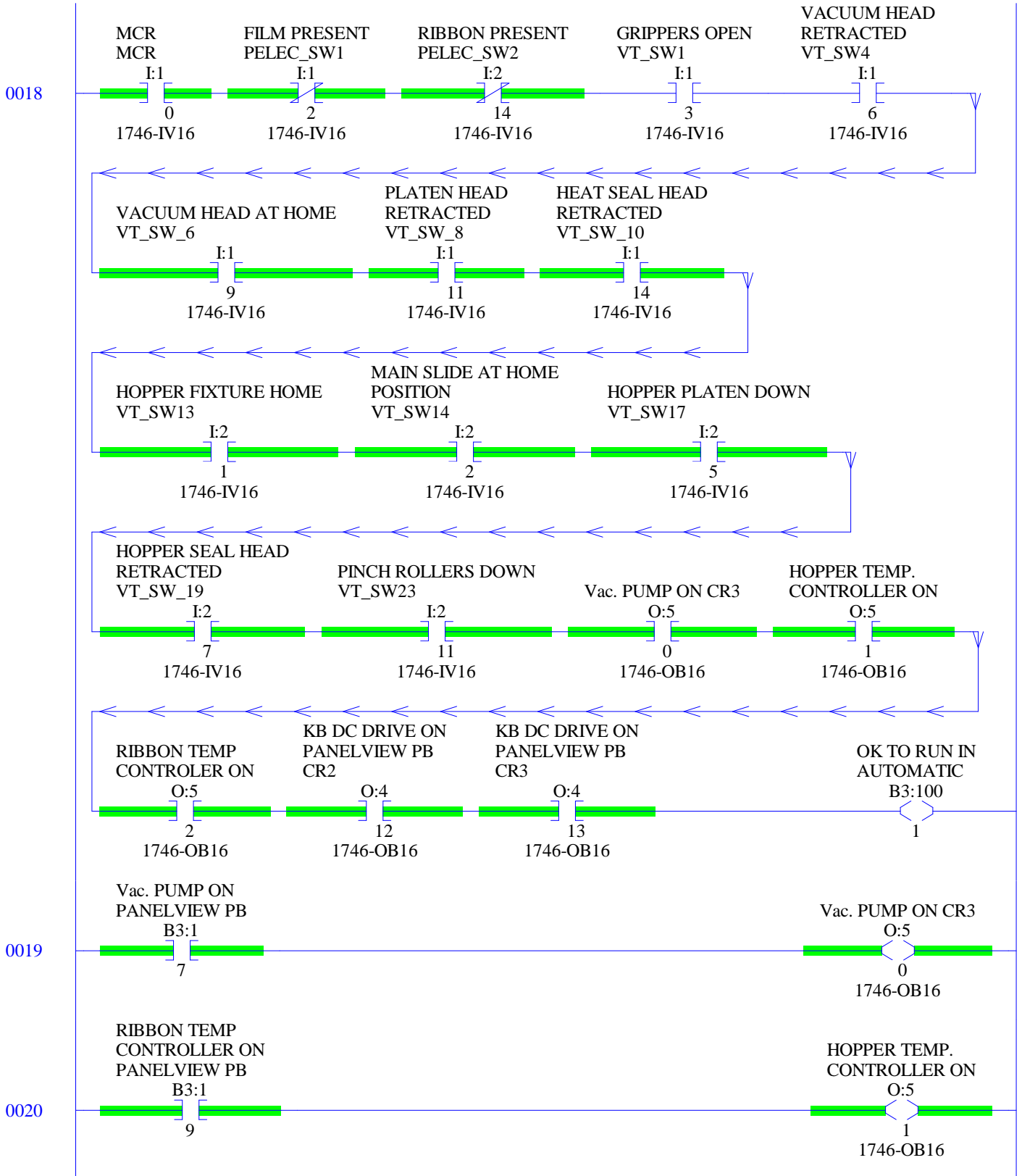


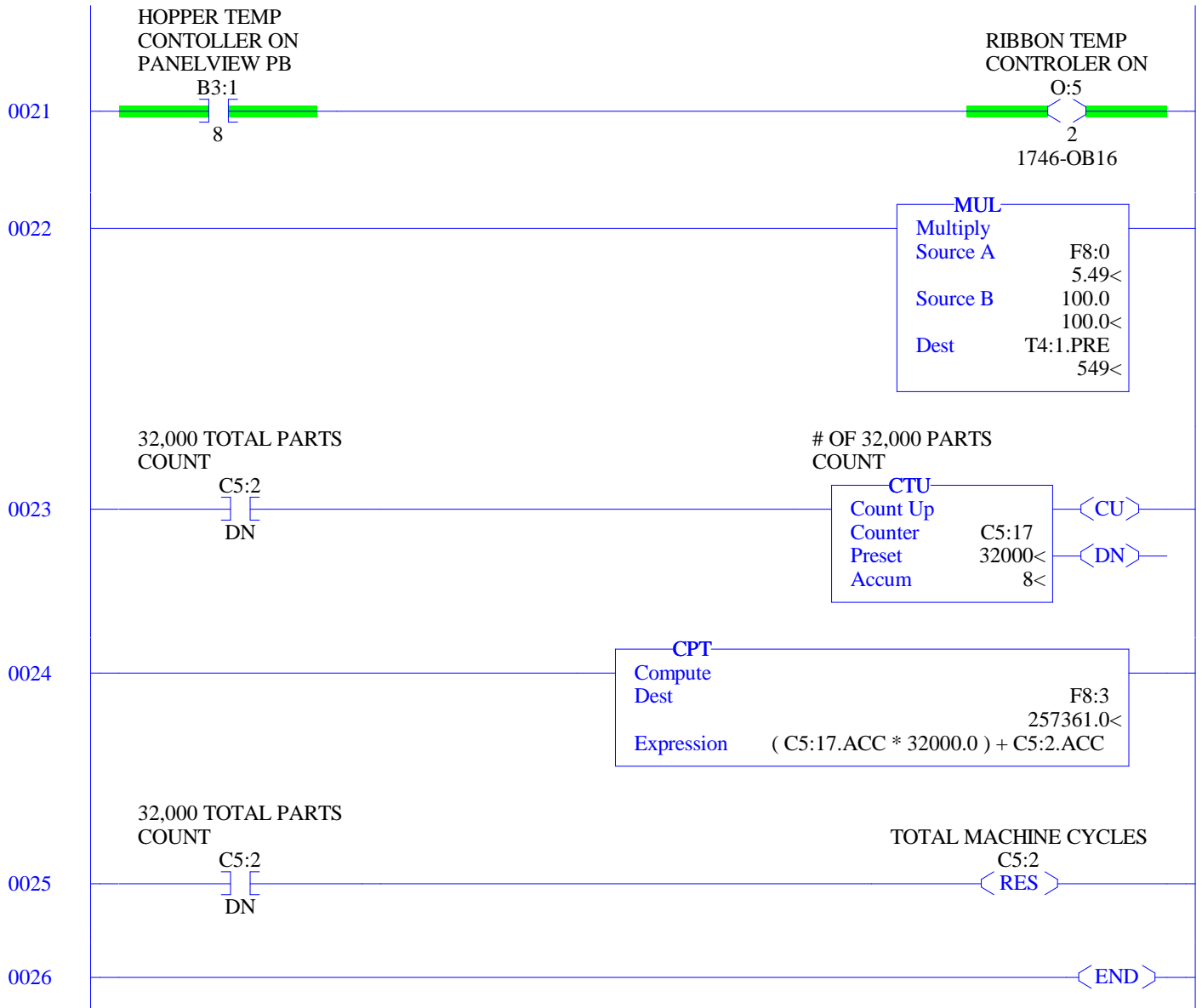
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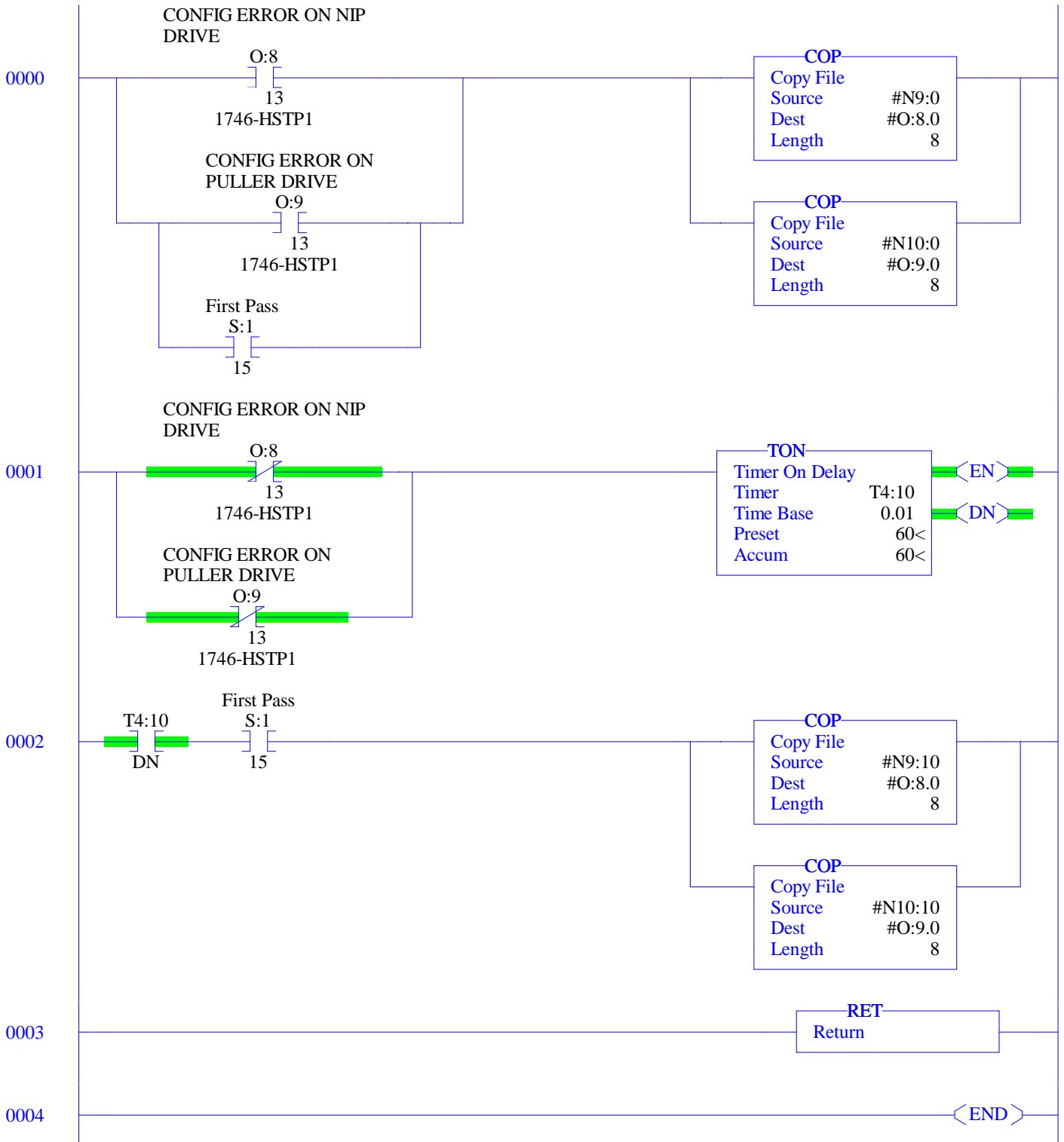
1746-OB16

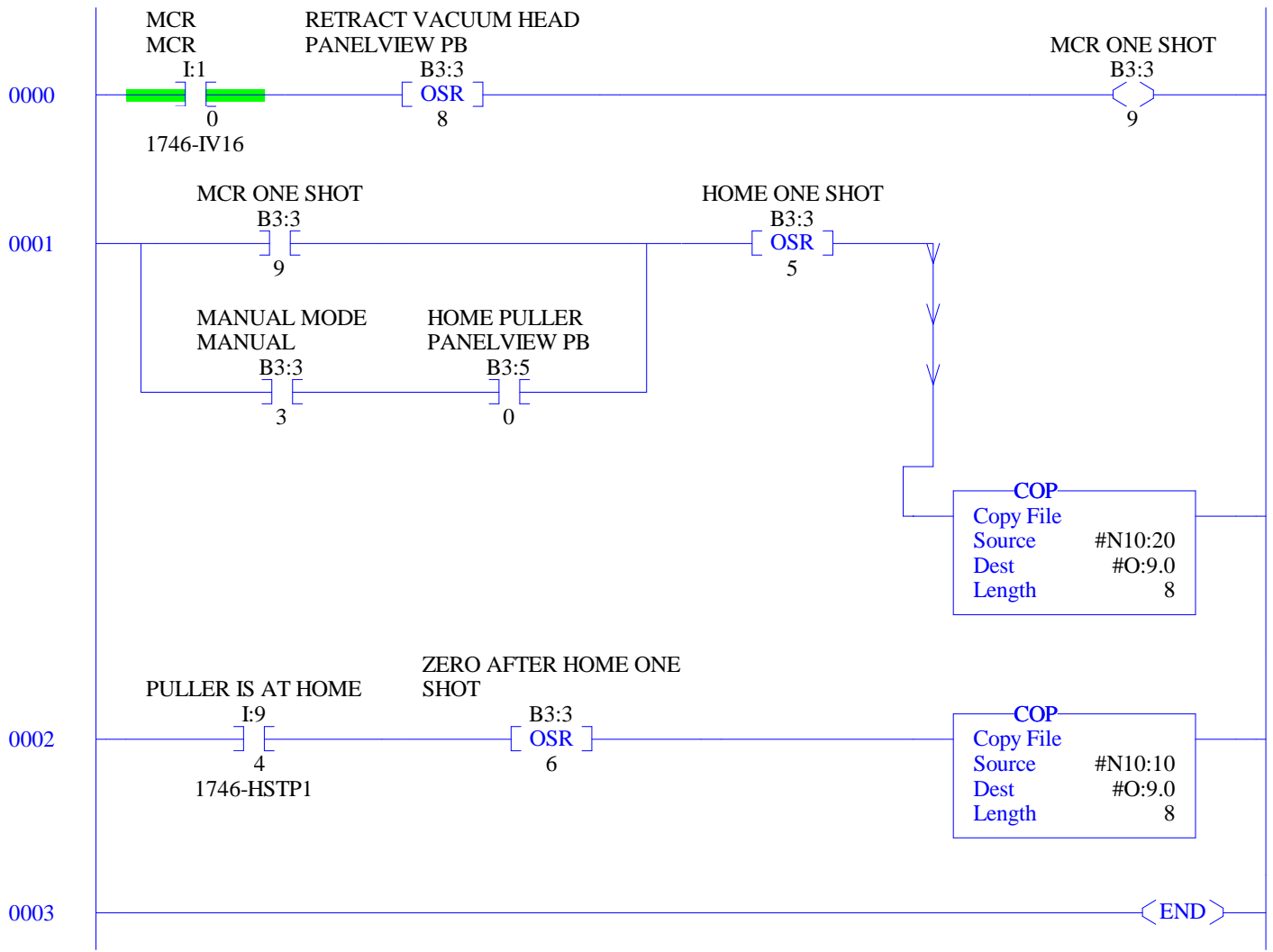
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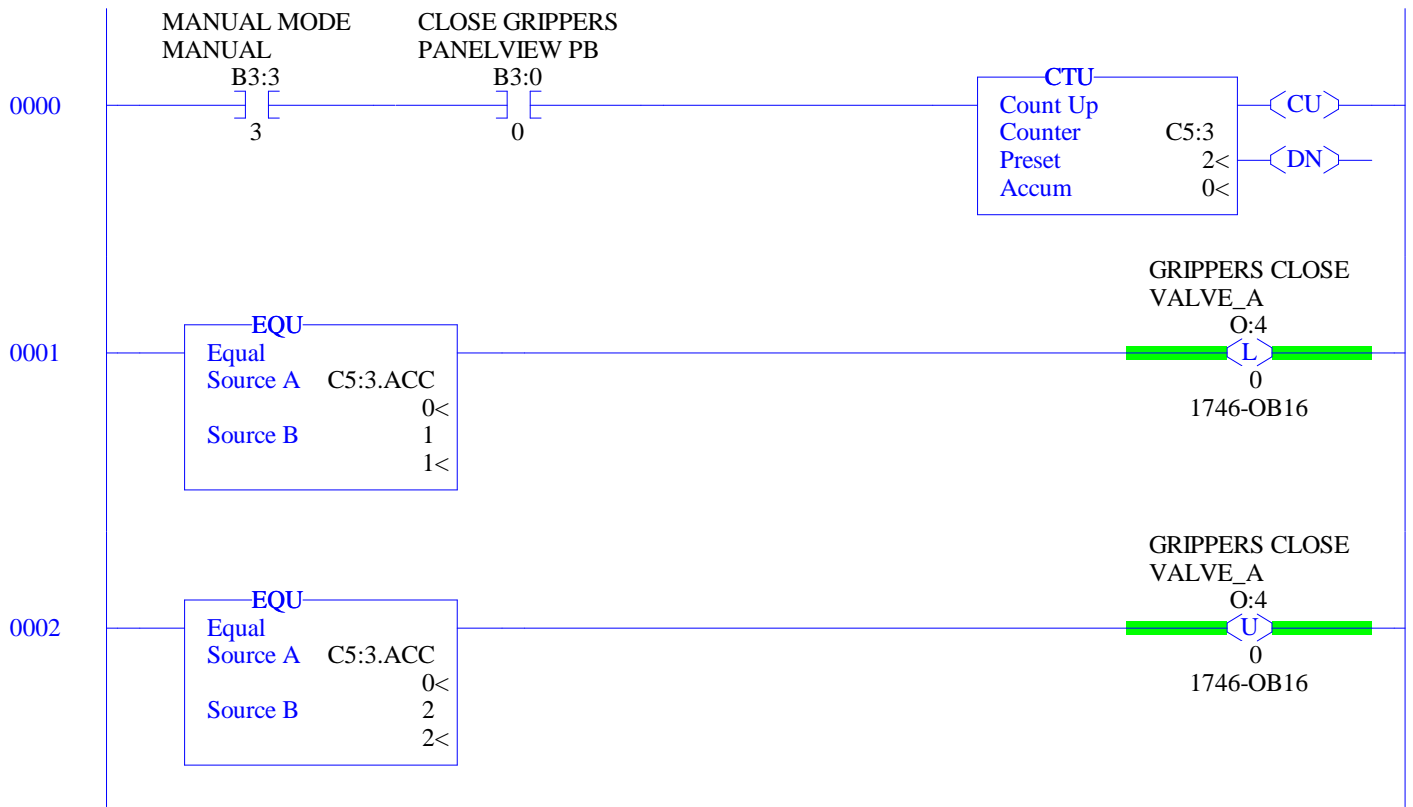
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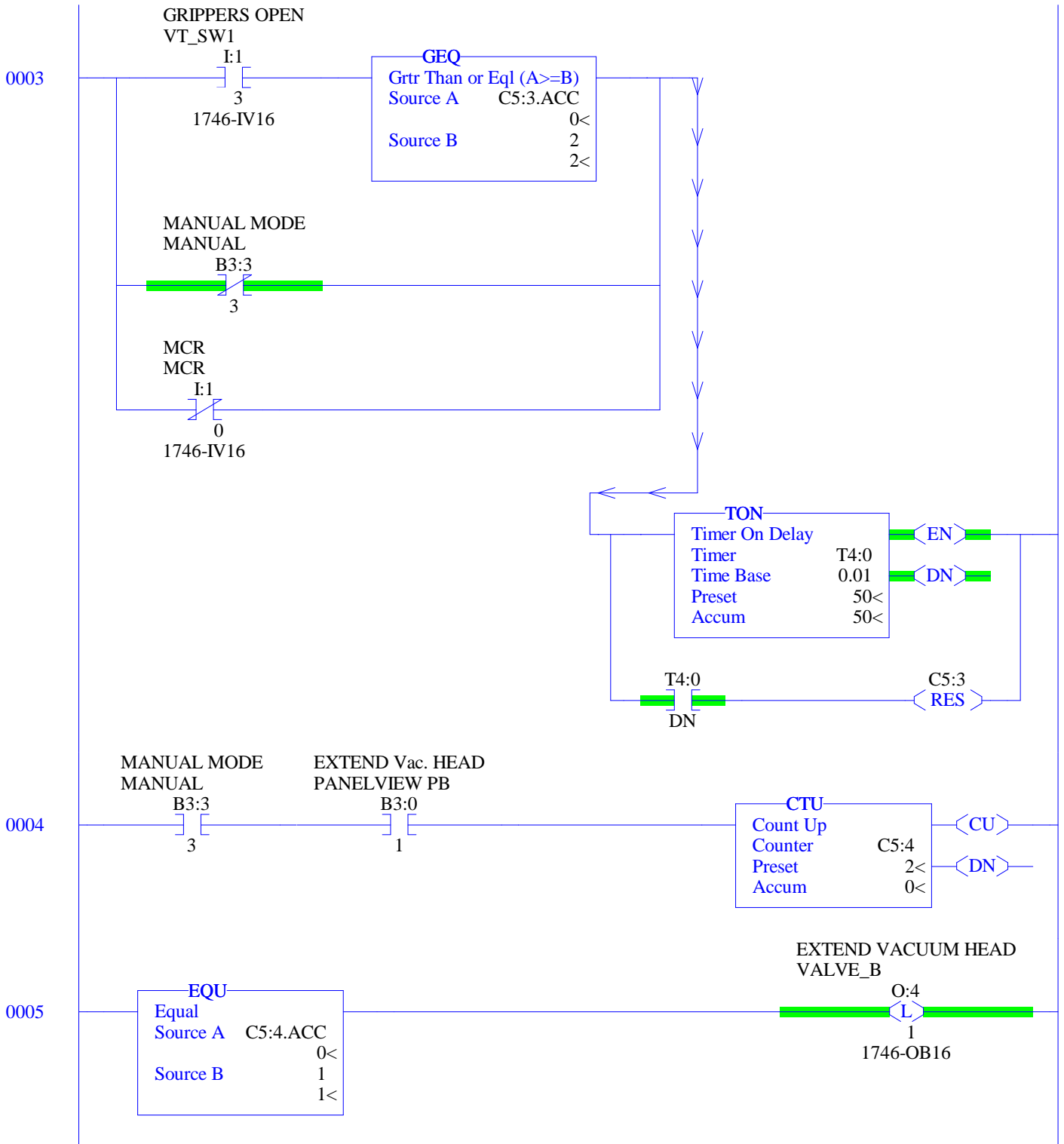


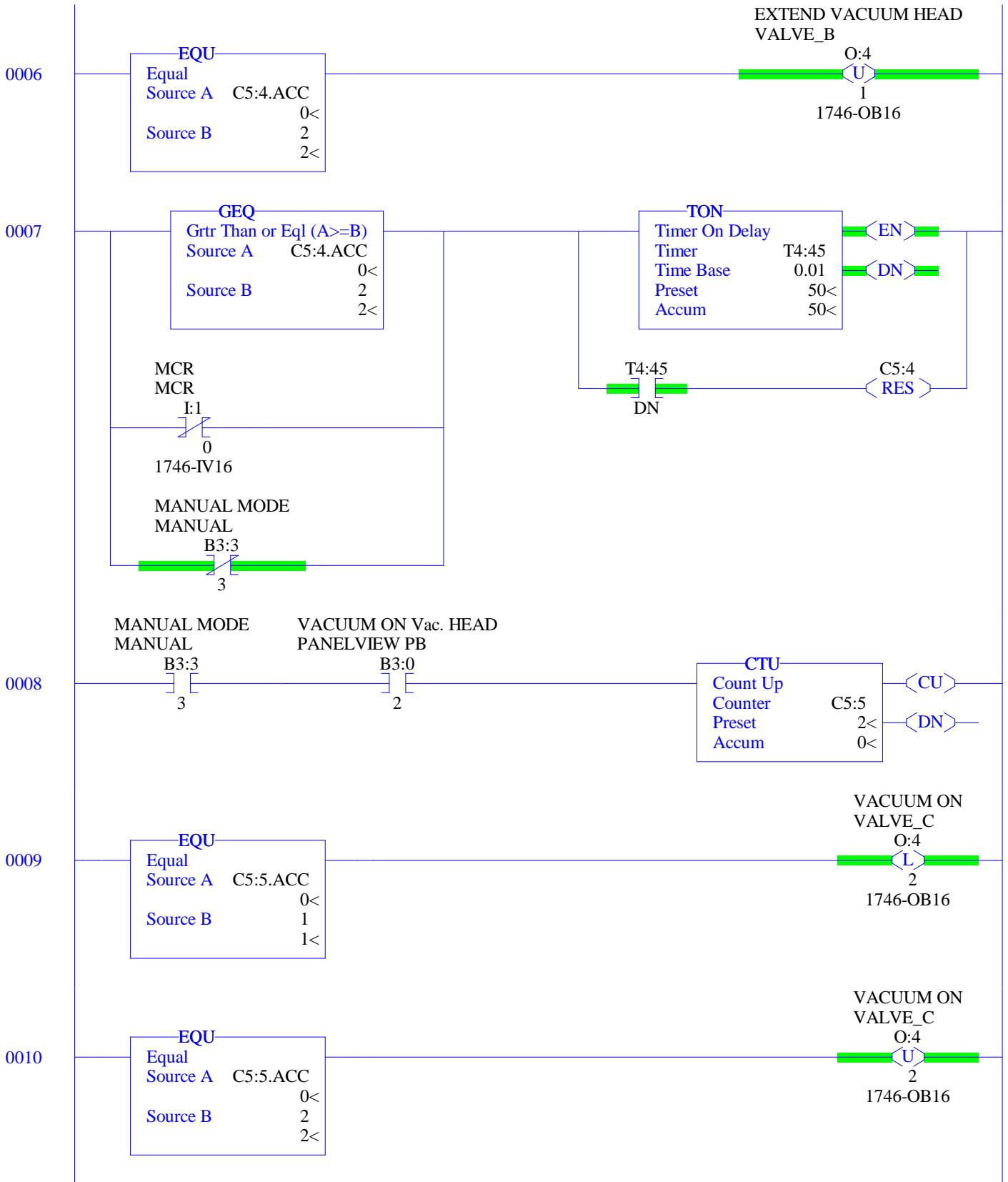


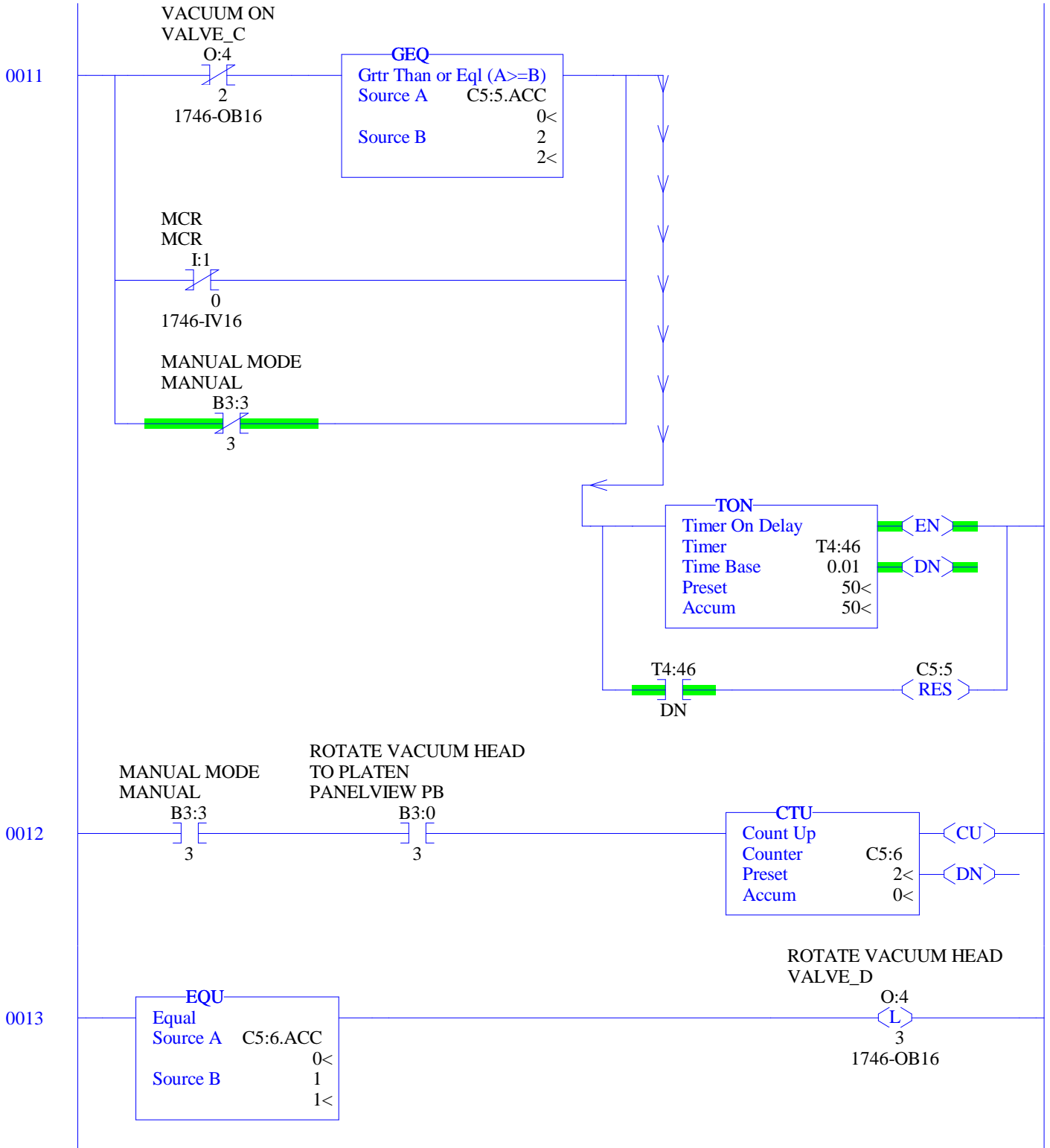


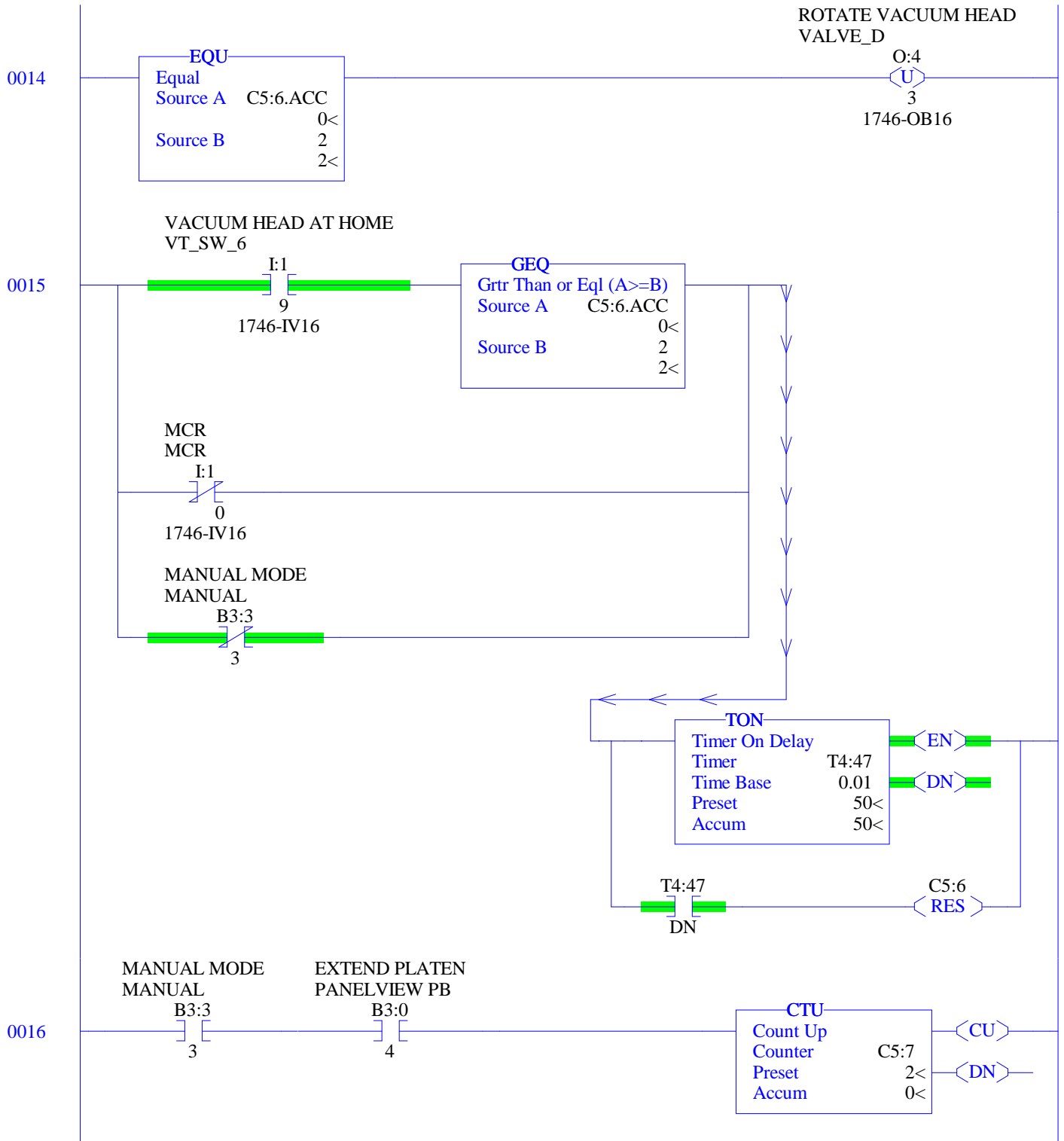


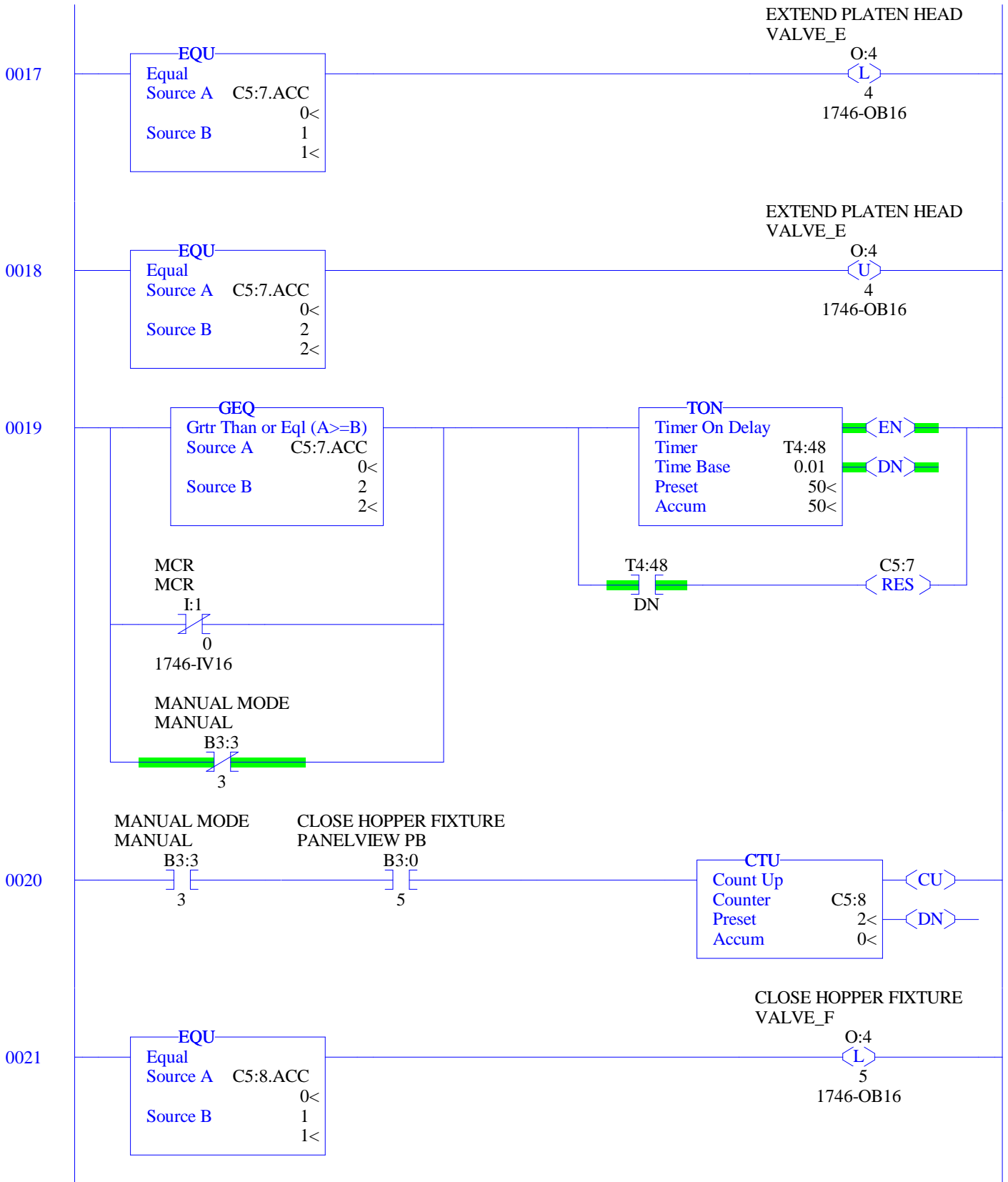


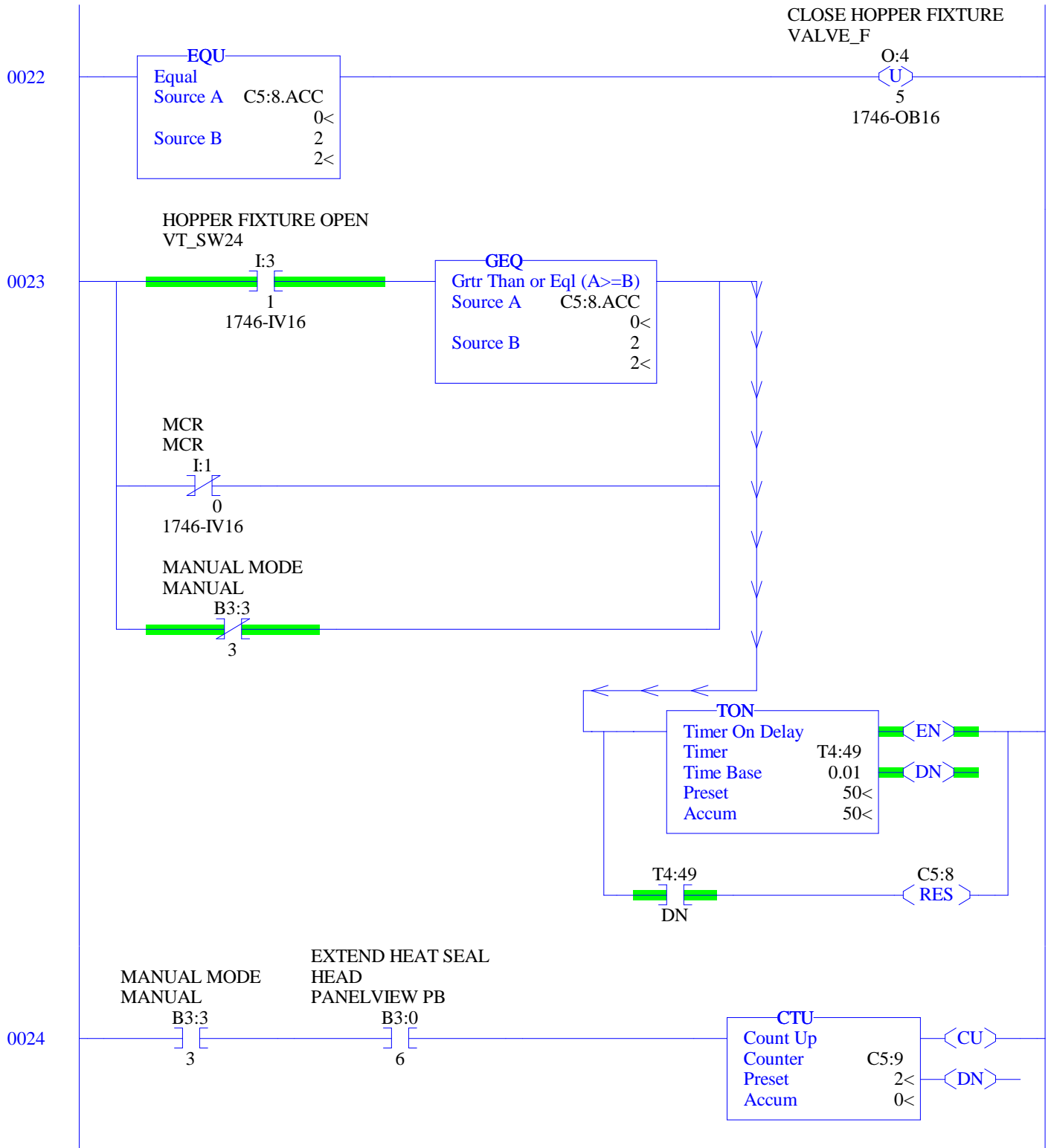


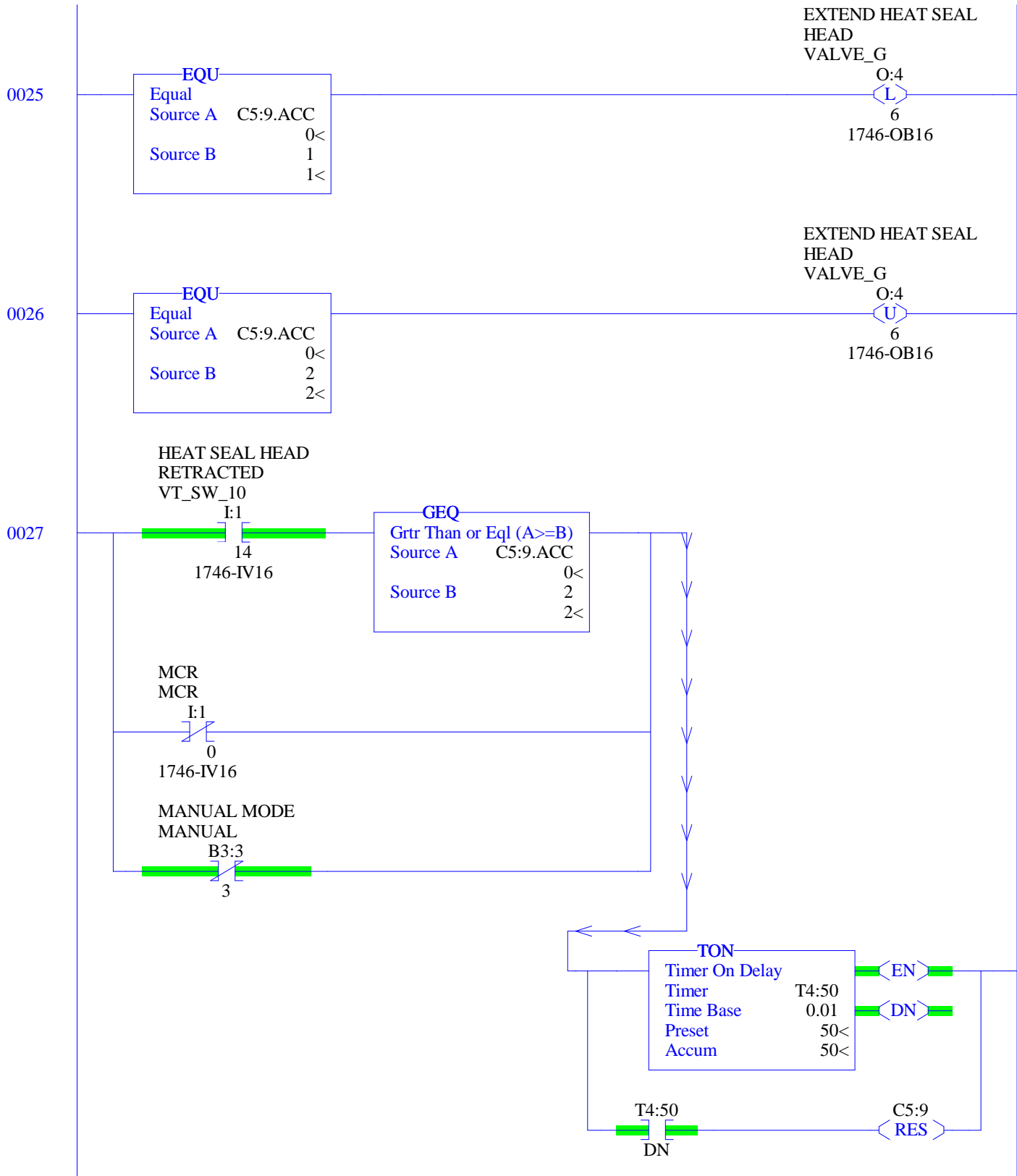


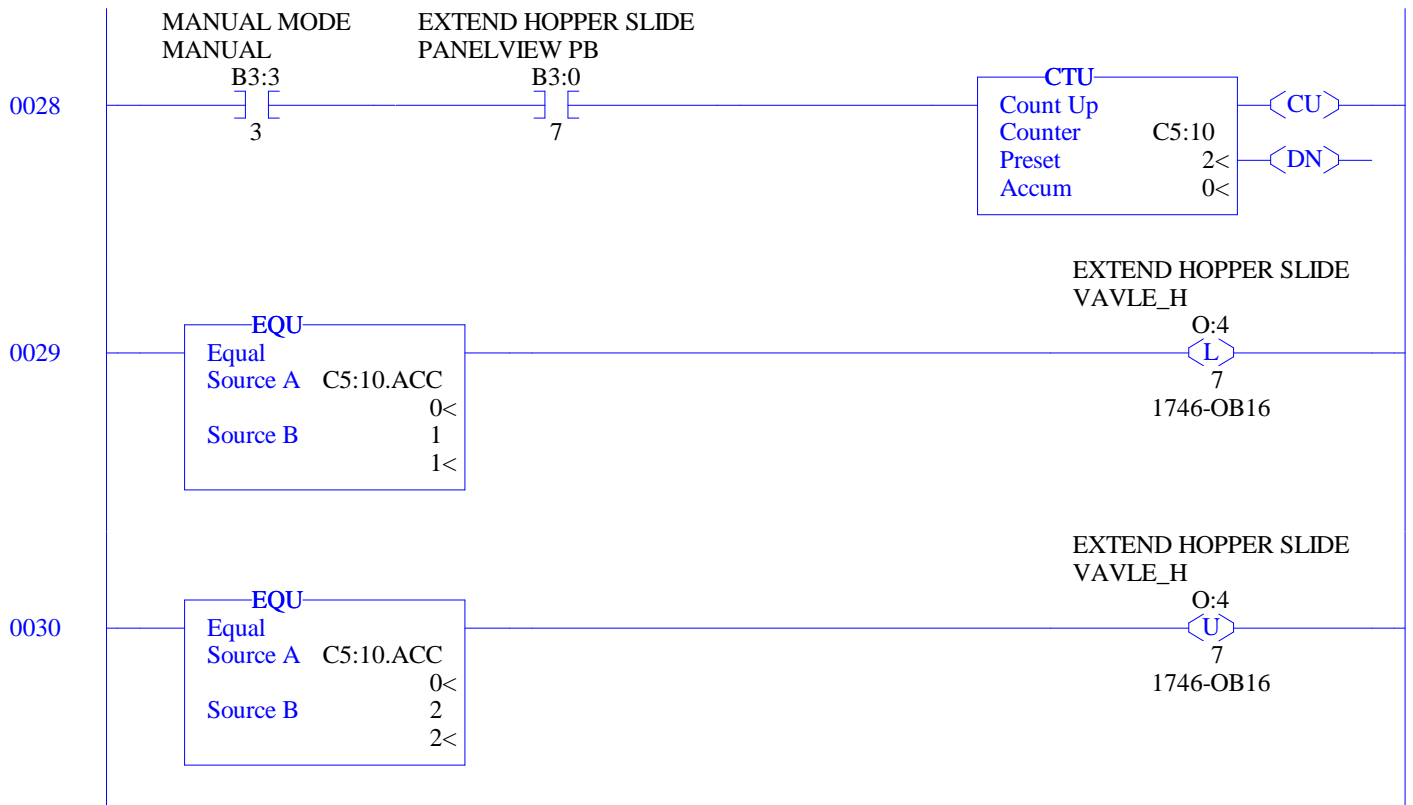


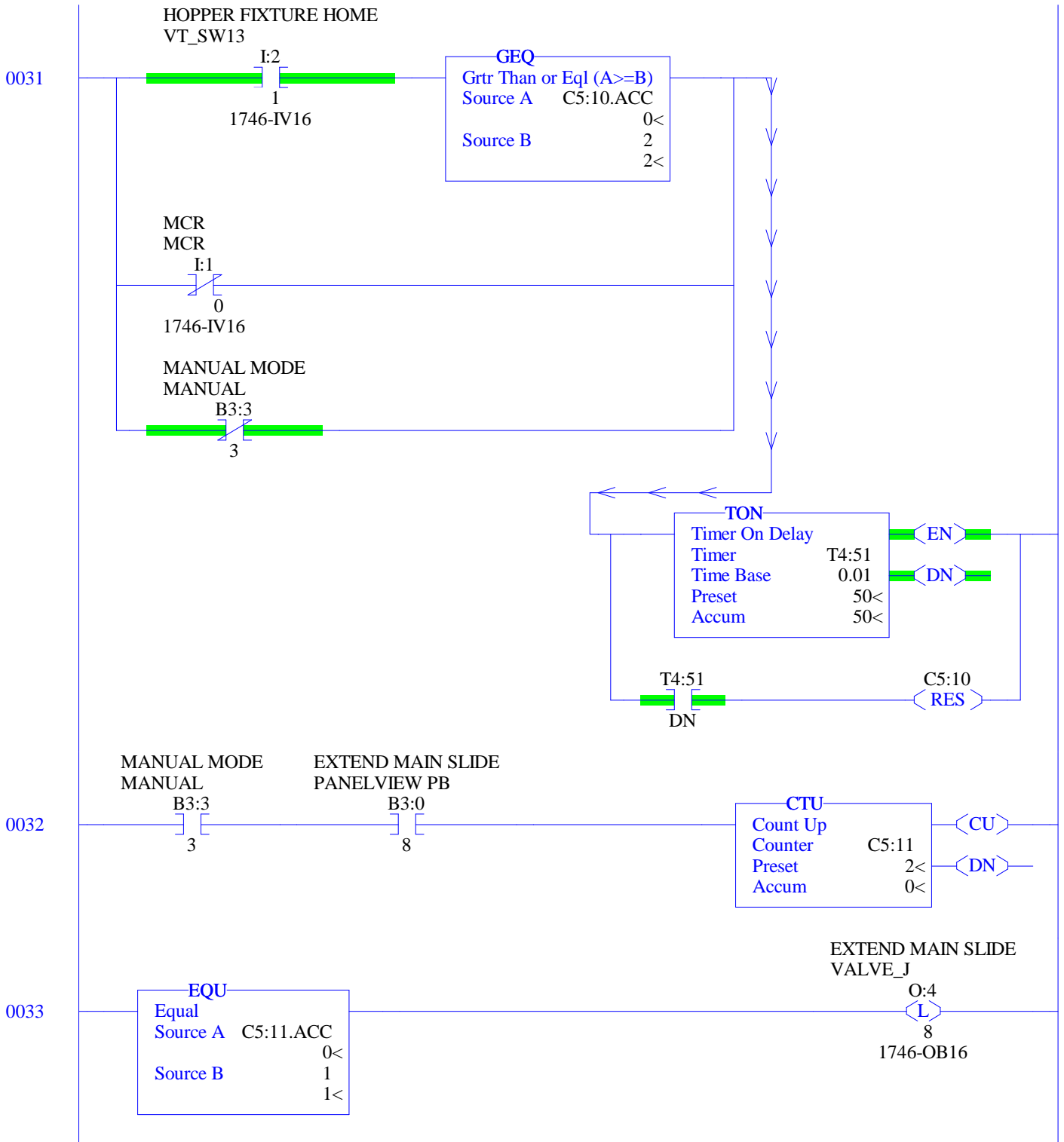


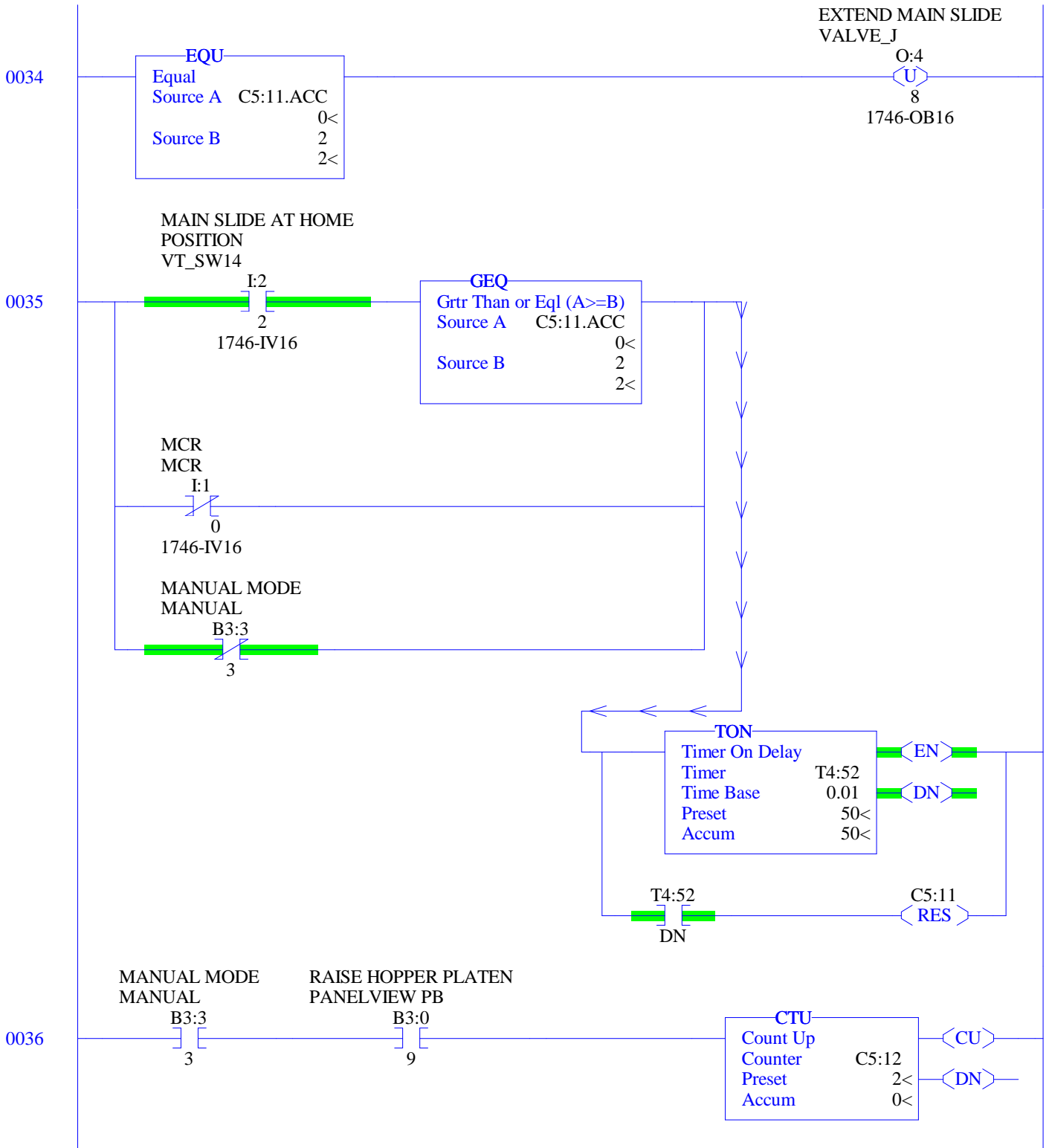


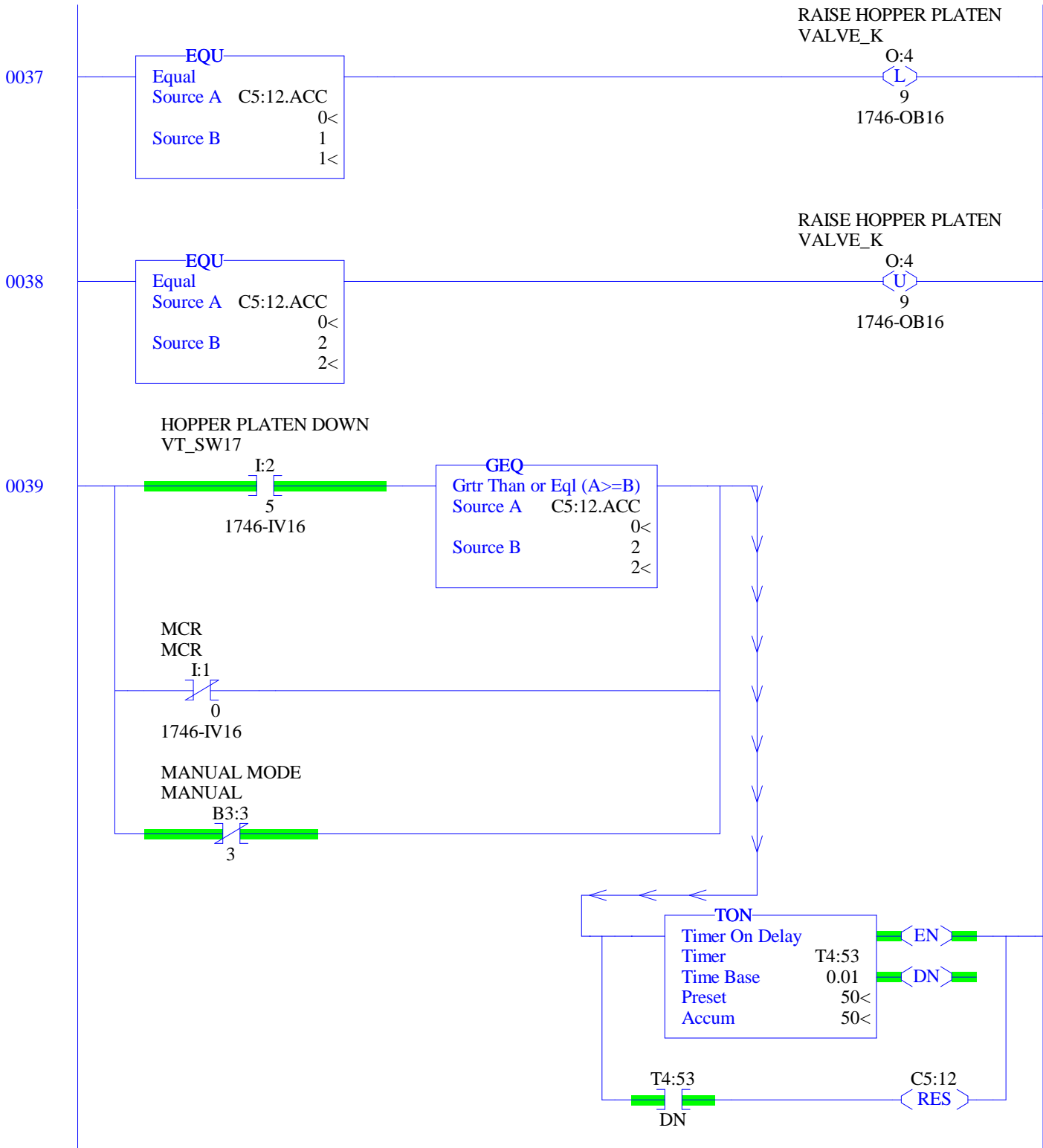


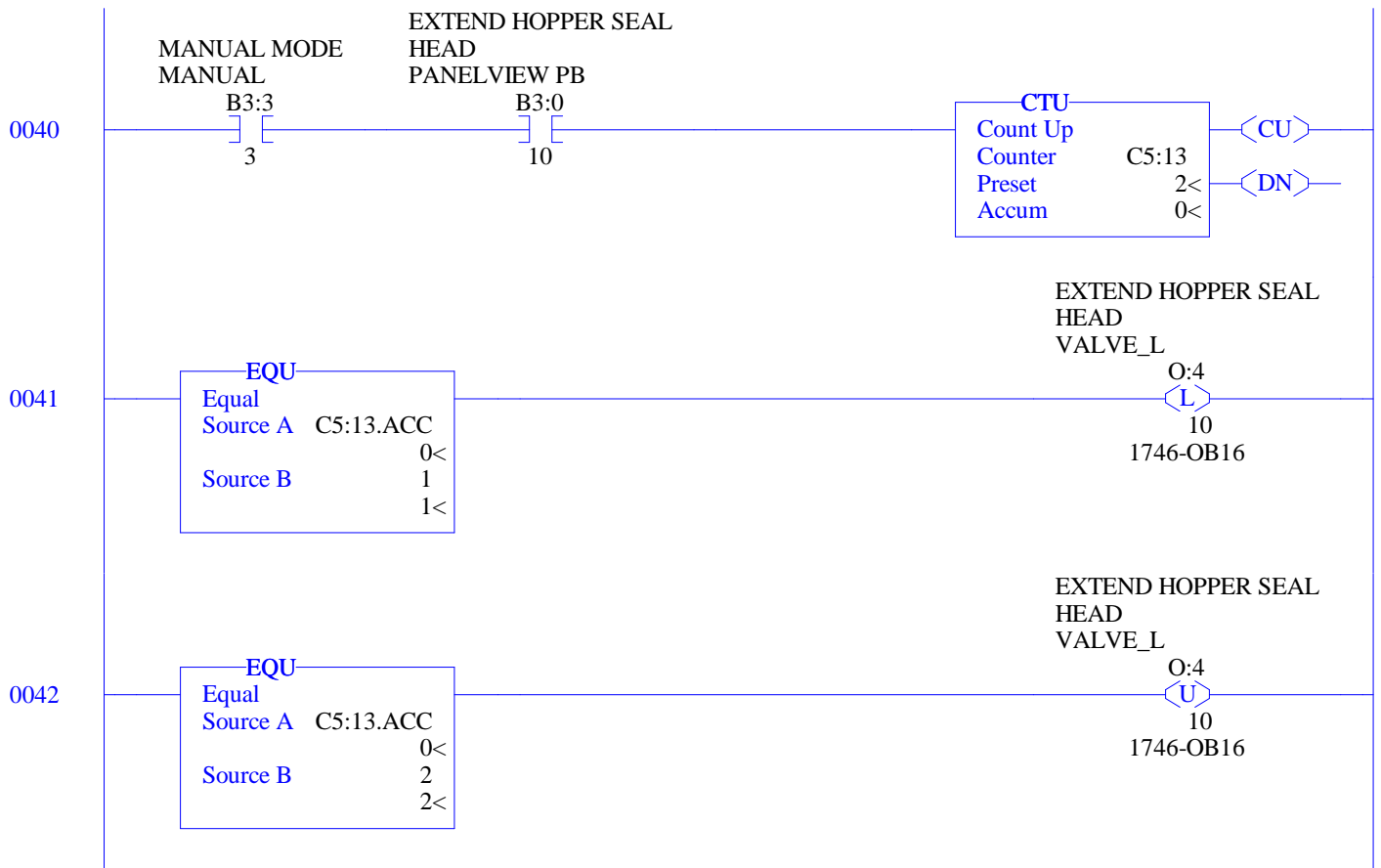


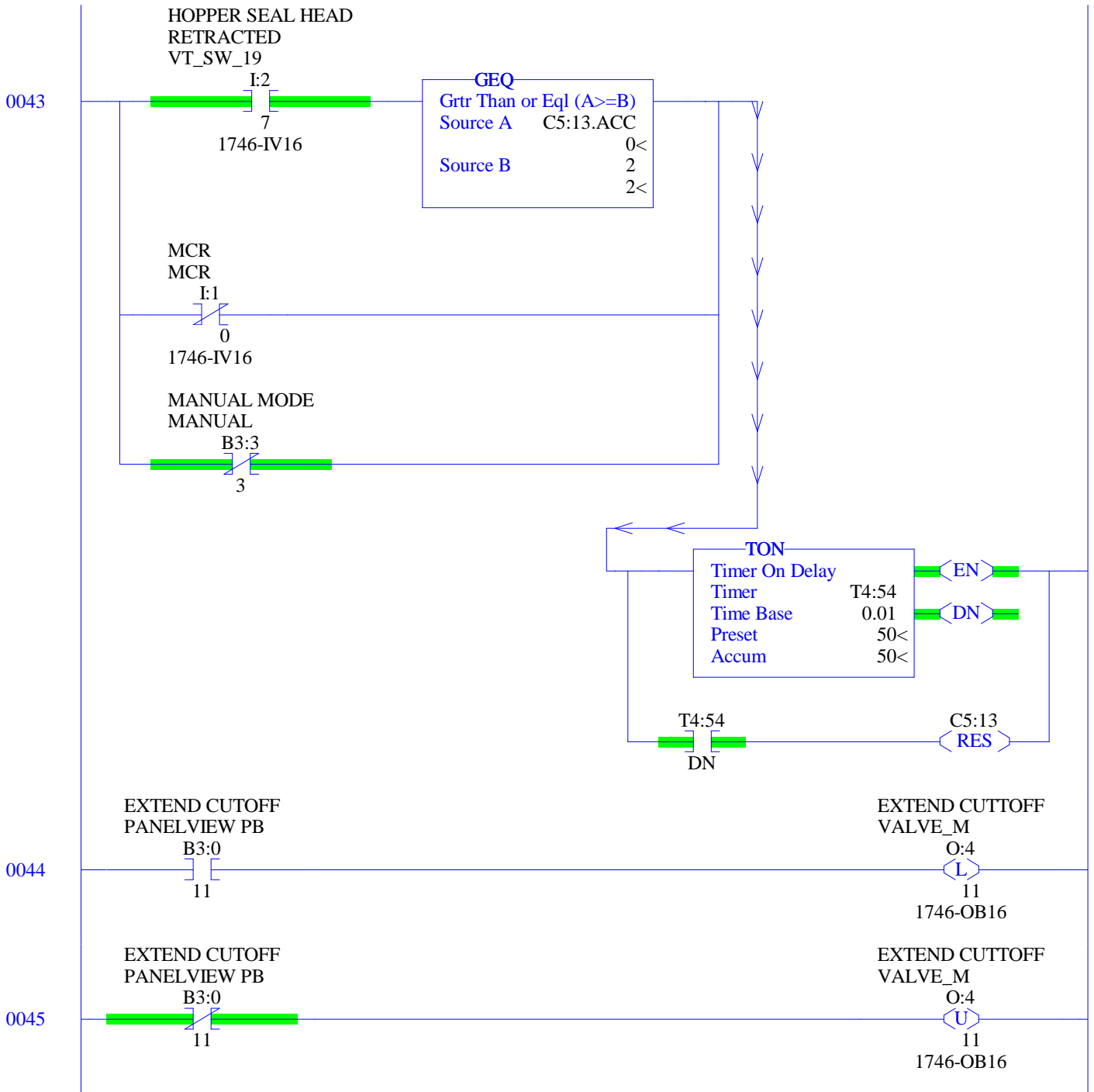


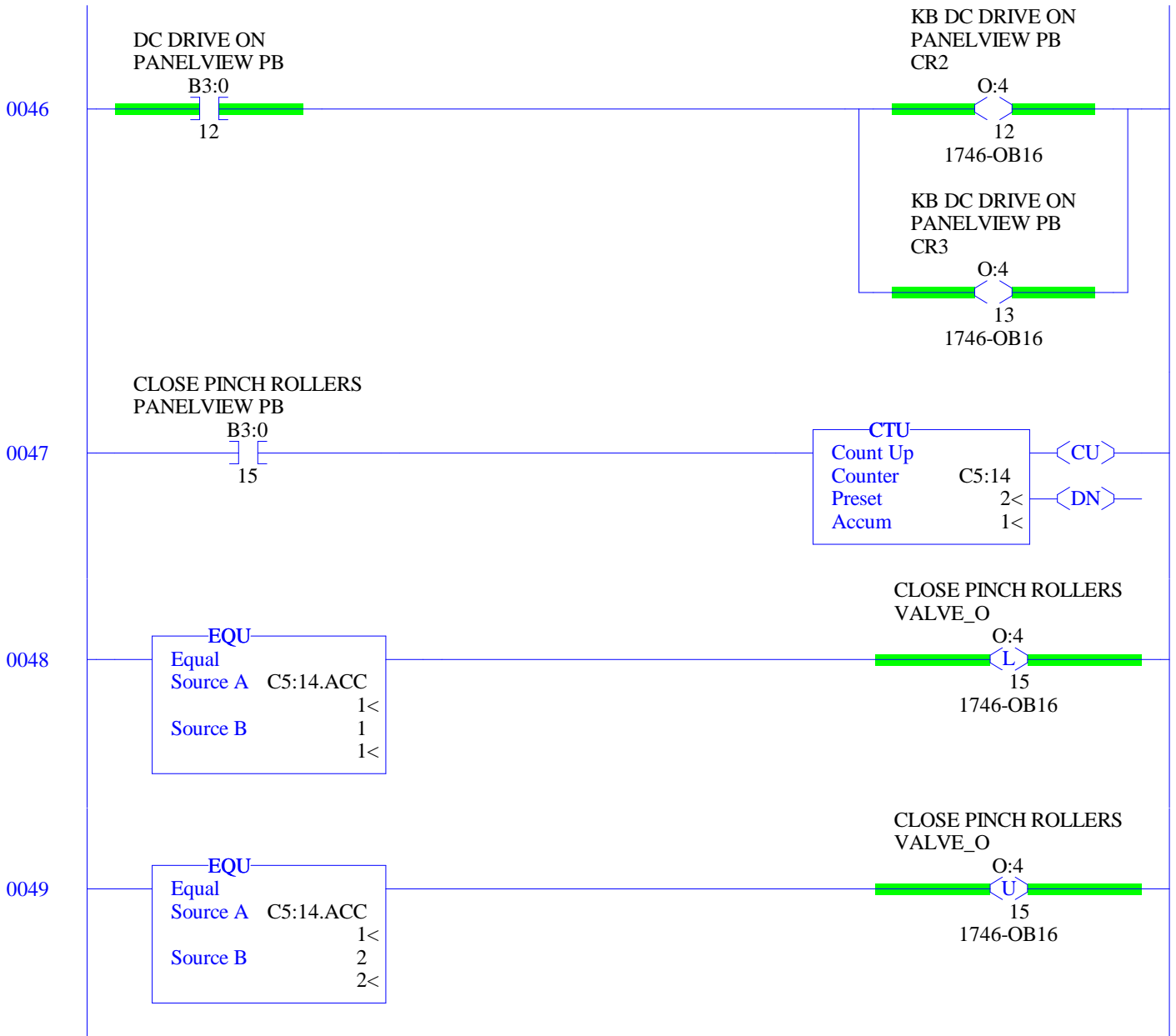


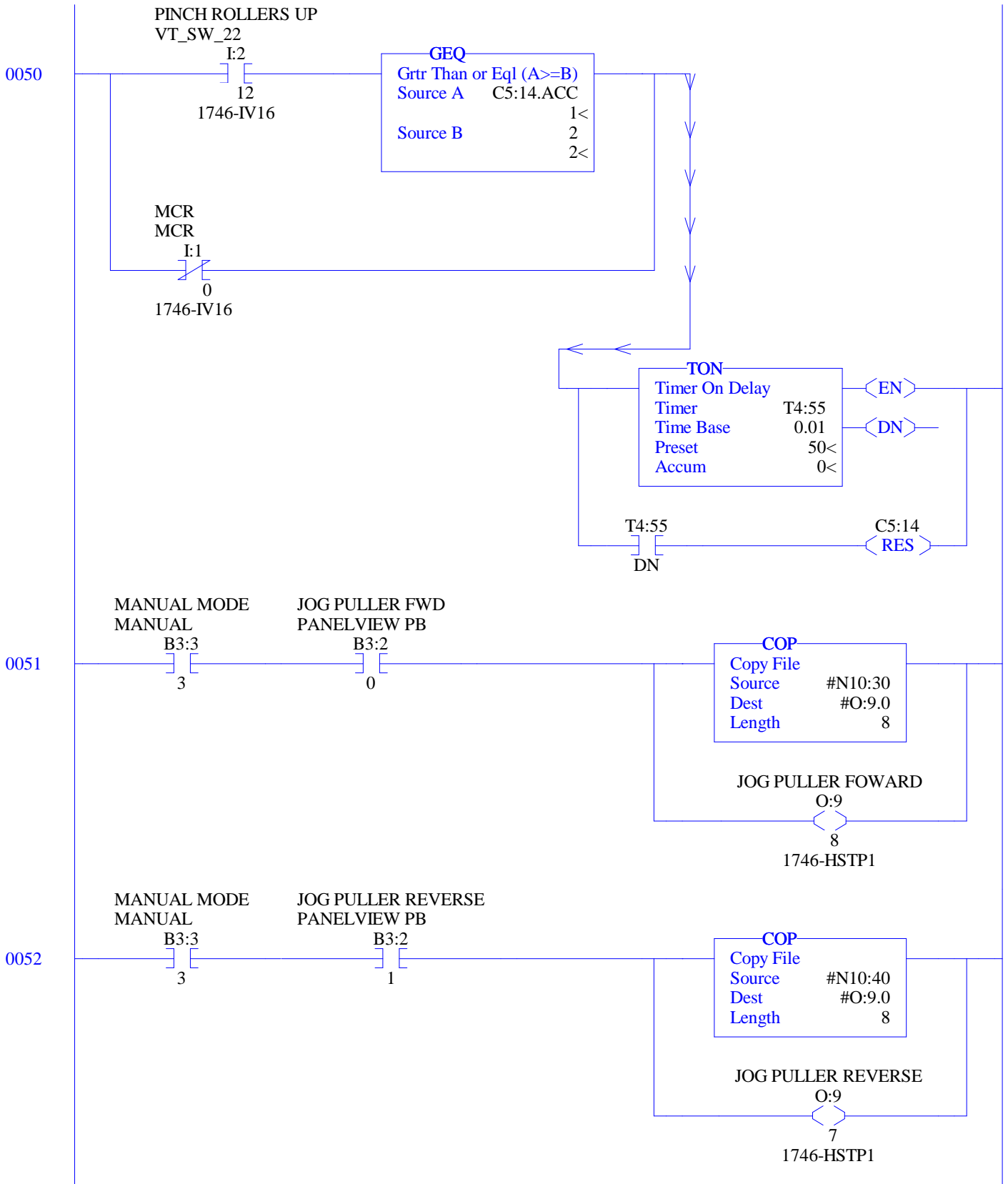


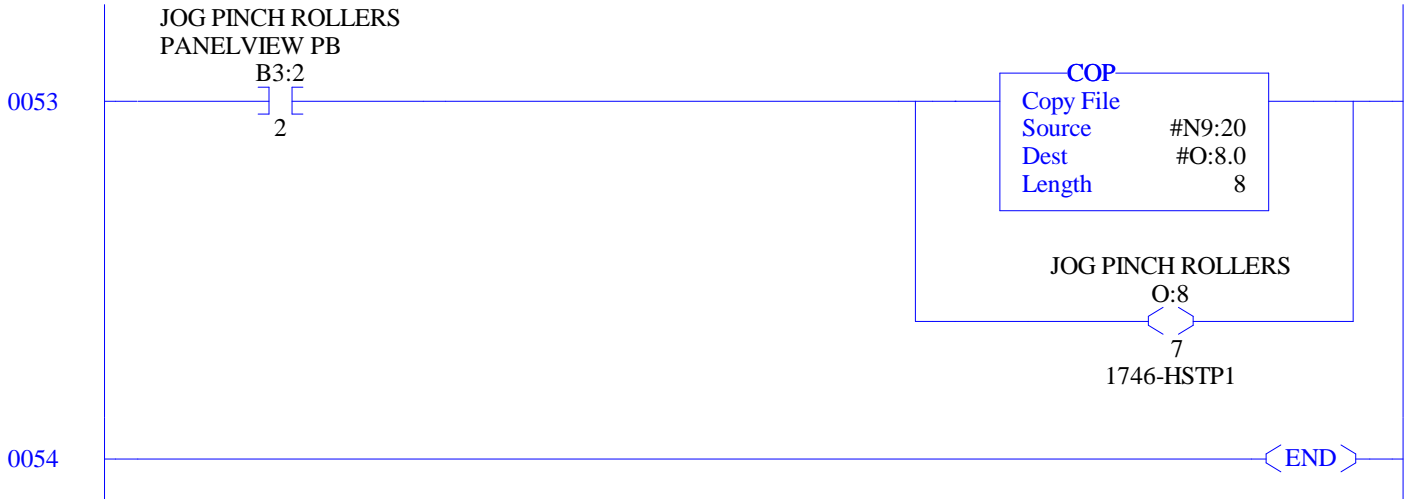


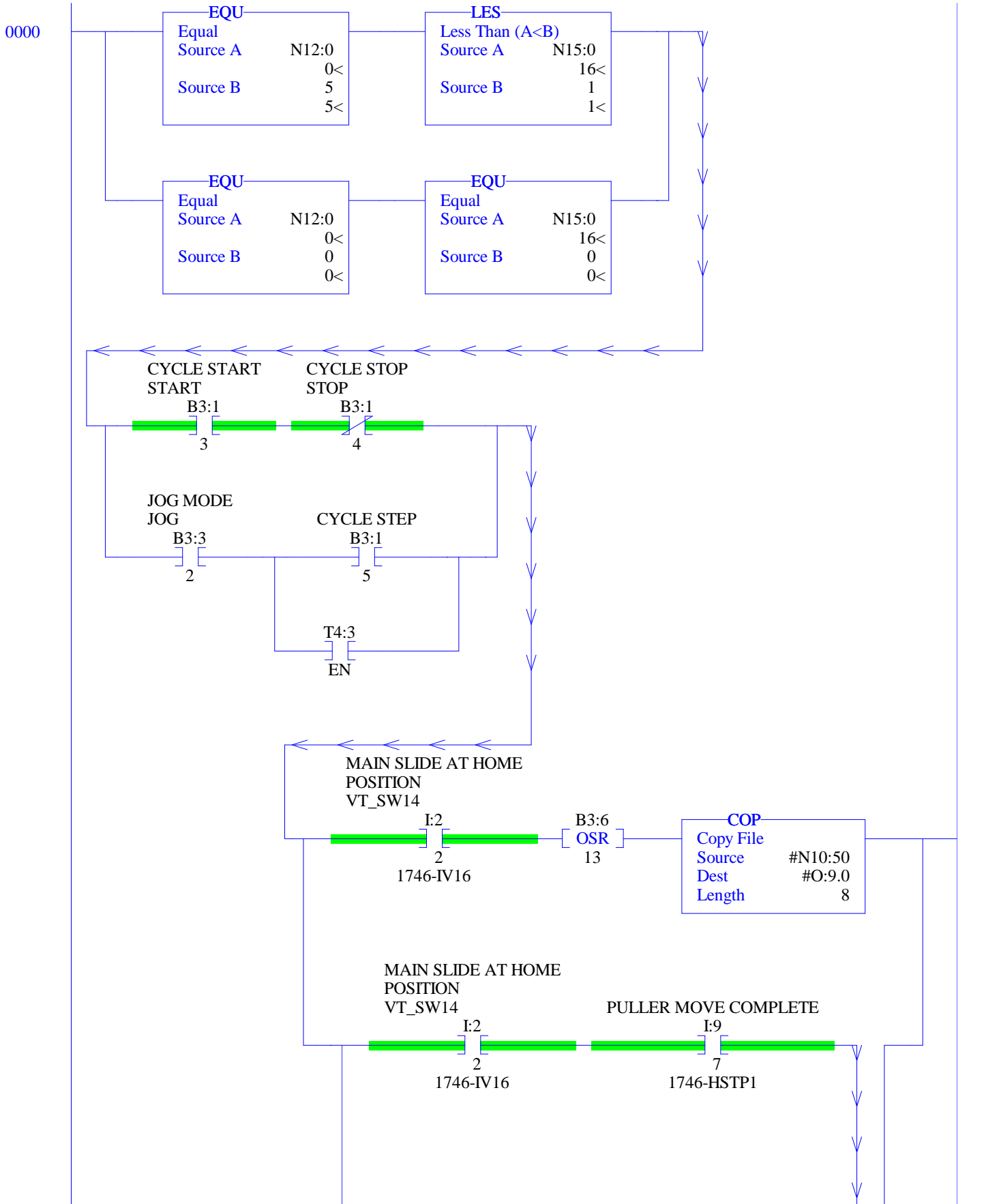


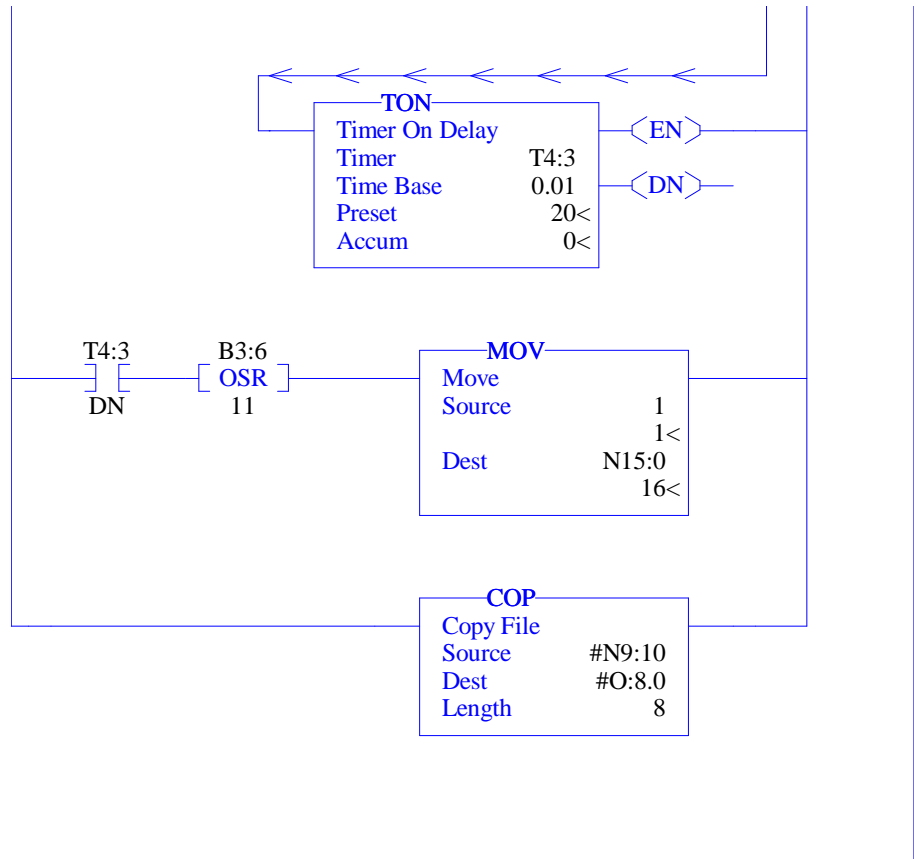


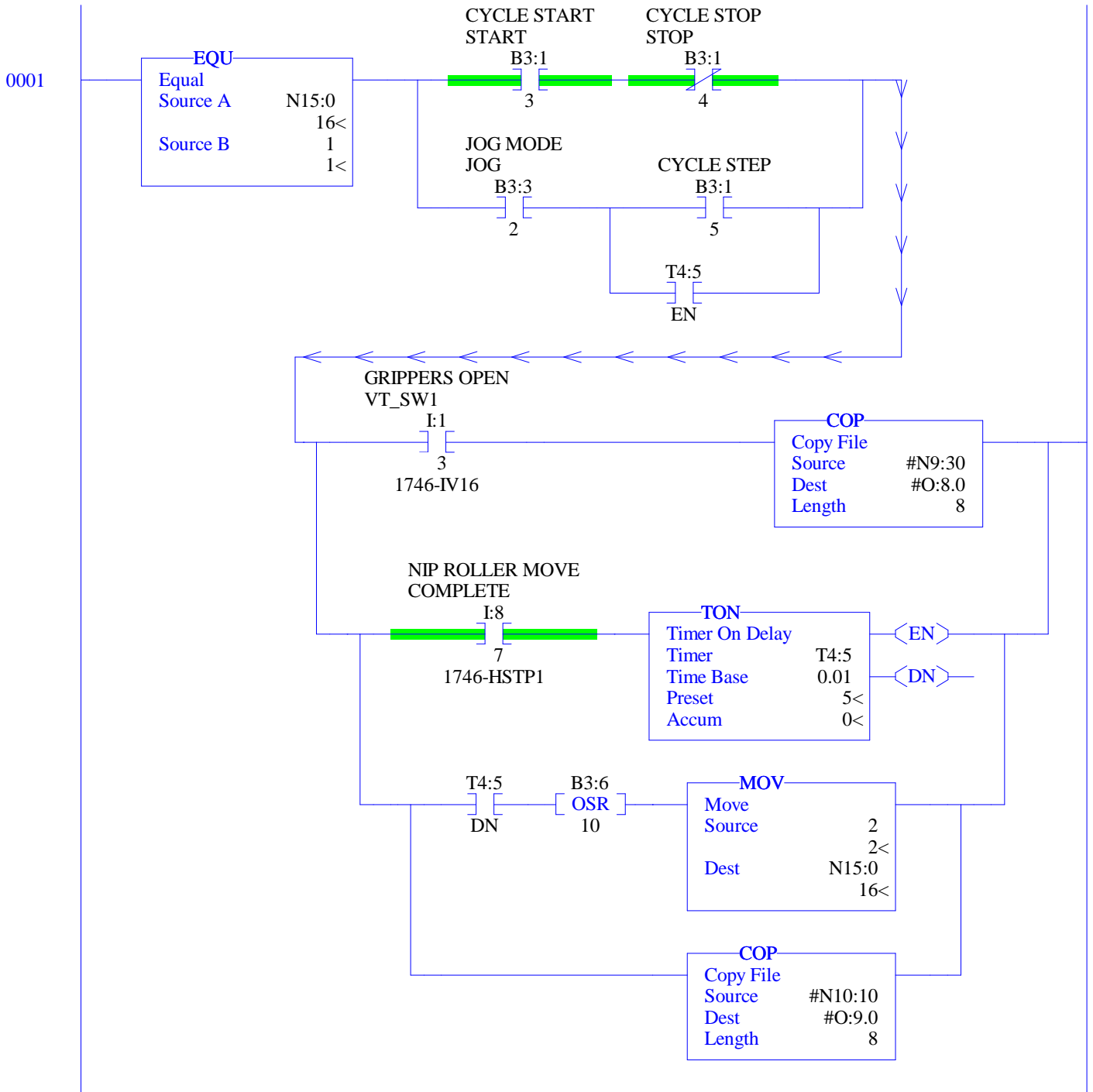




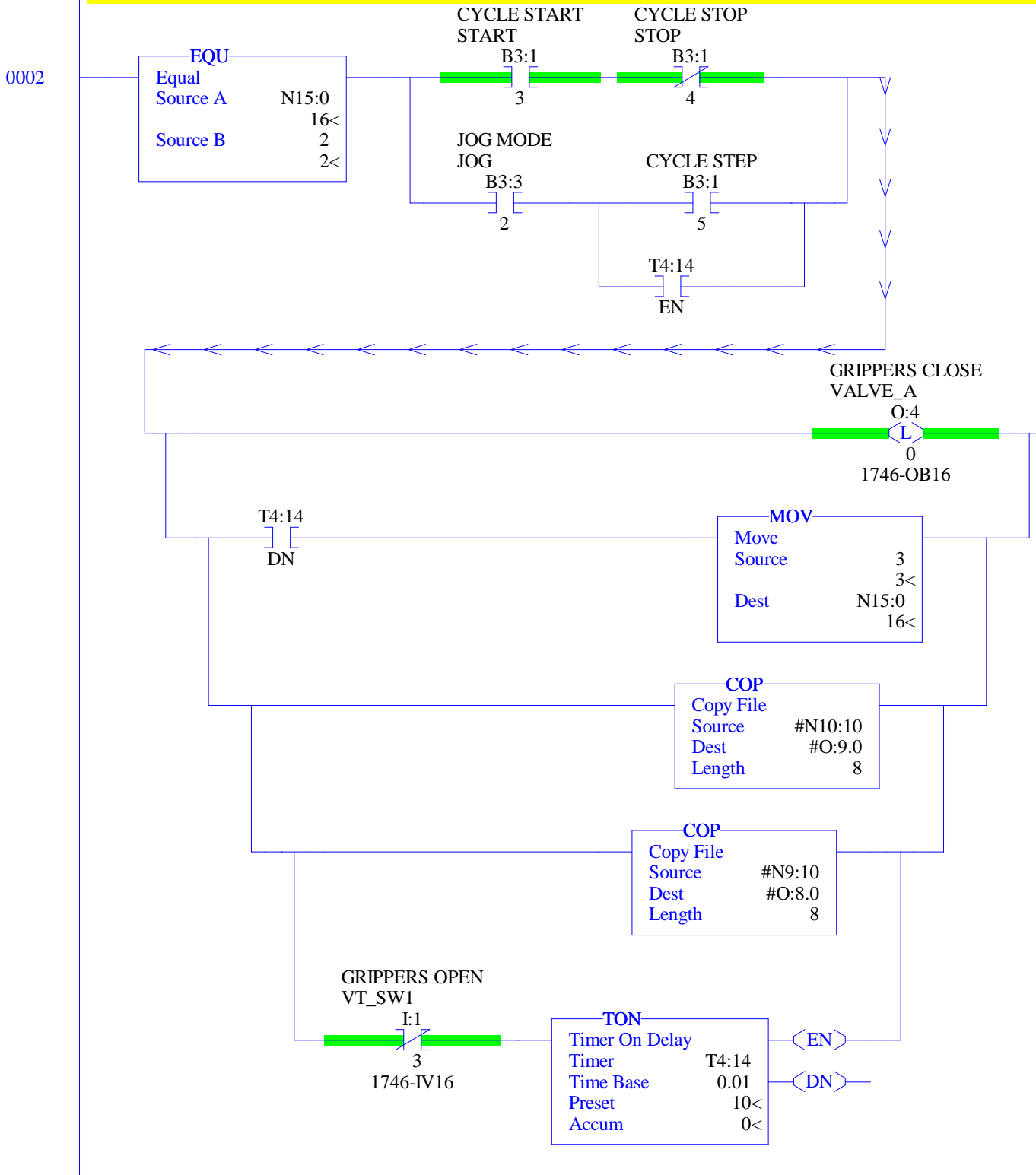


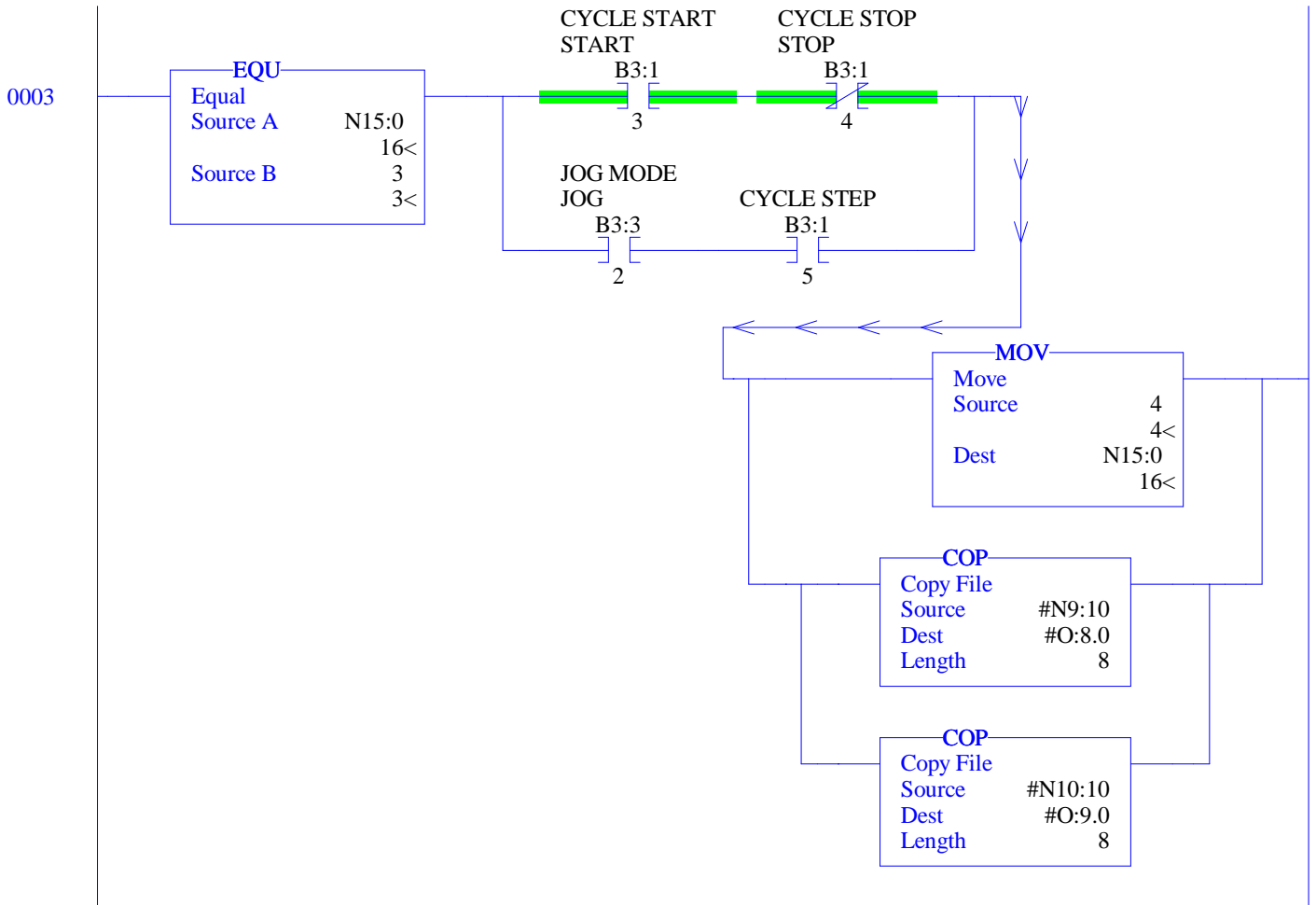




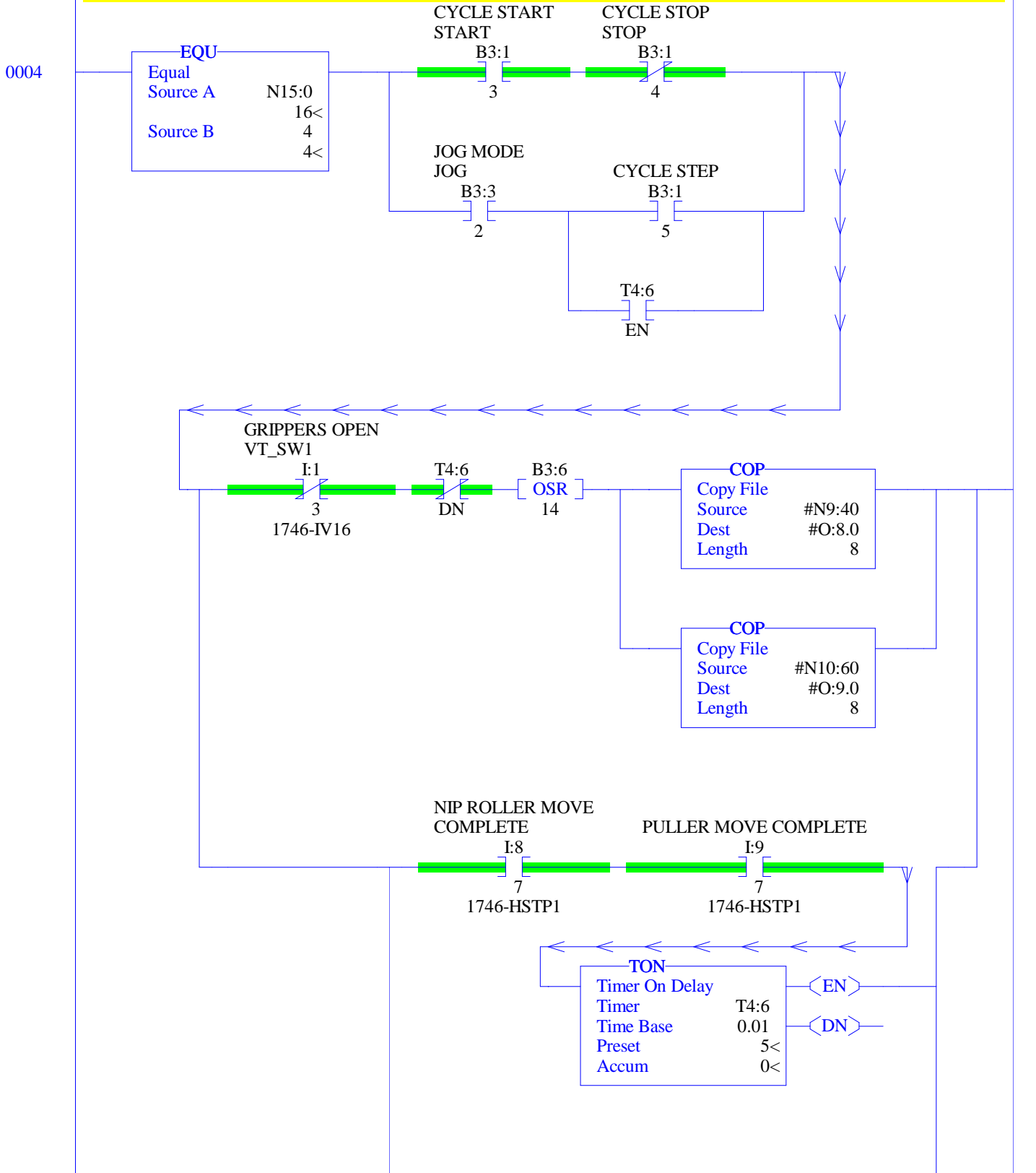


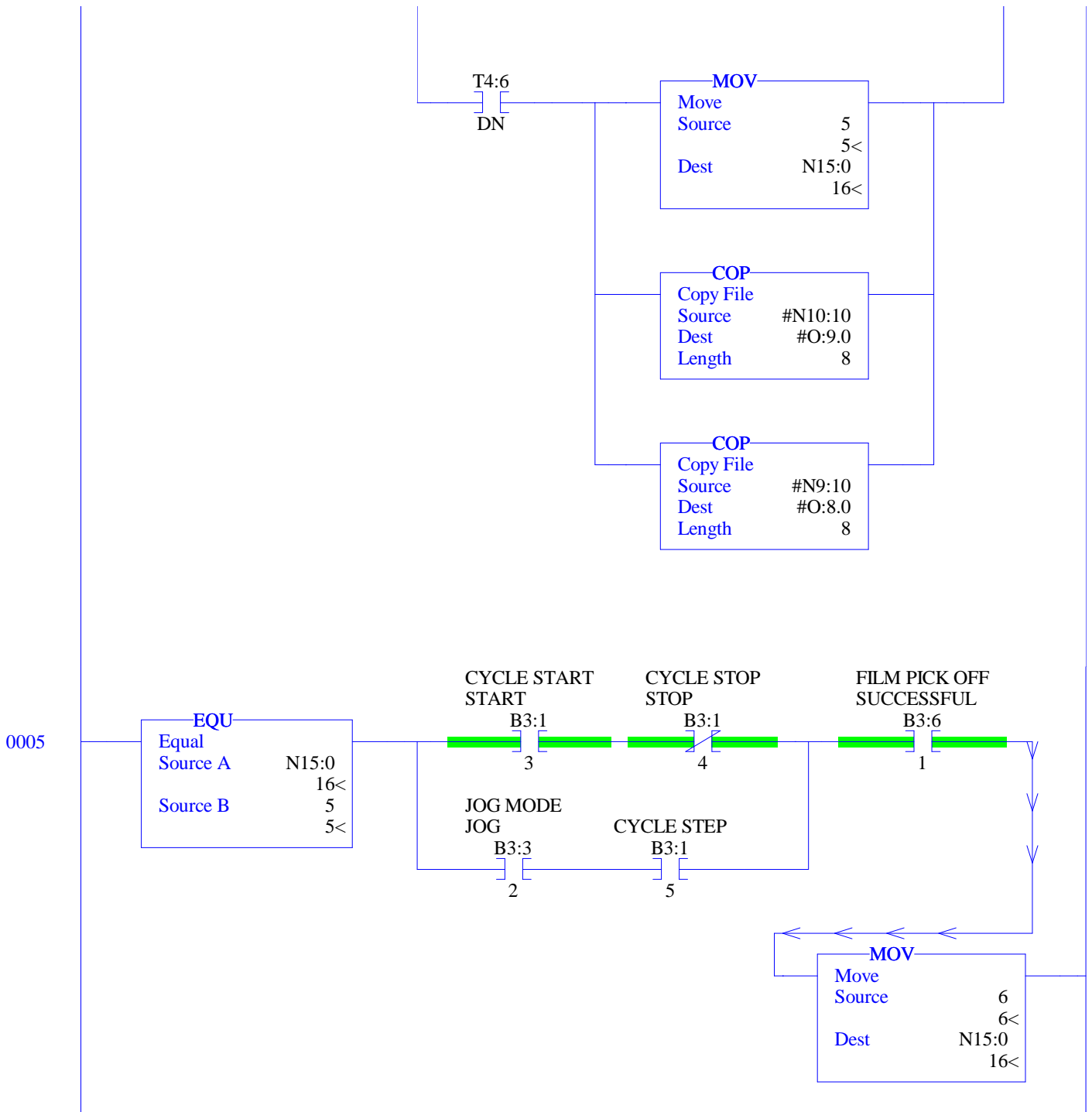
THIS RUNG CLOSSES THE GRIPPERS AFTER 1" OF MATERIAL IS FED IN.

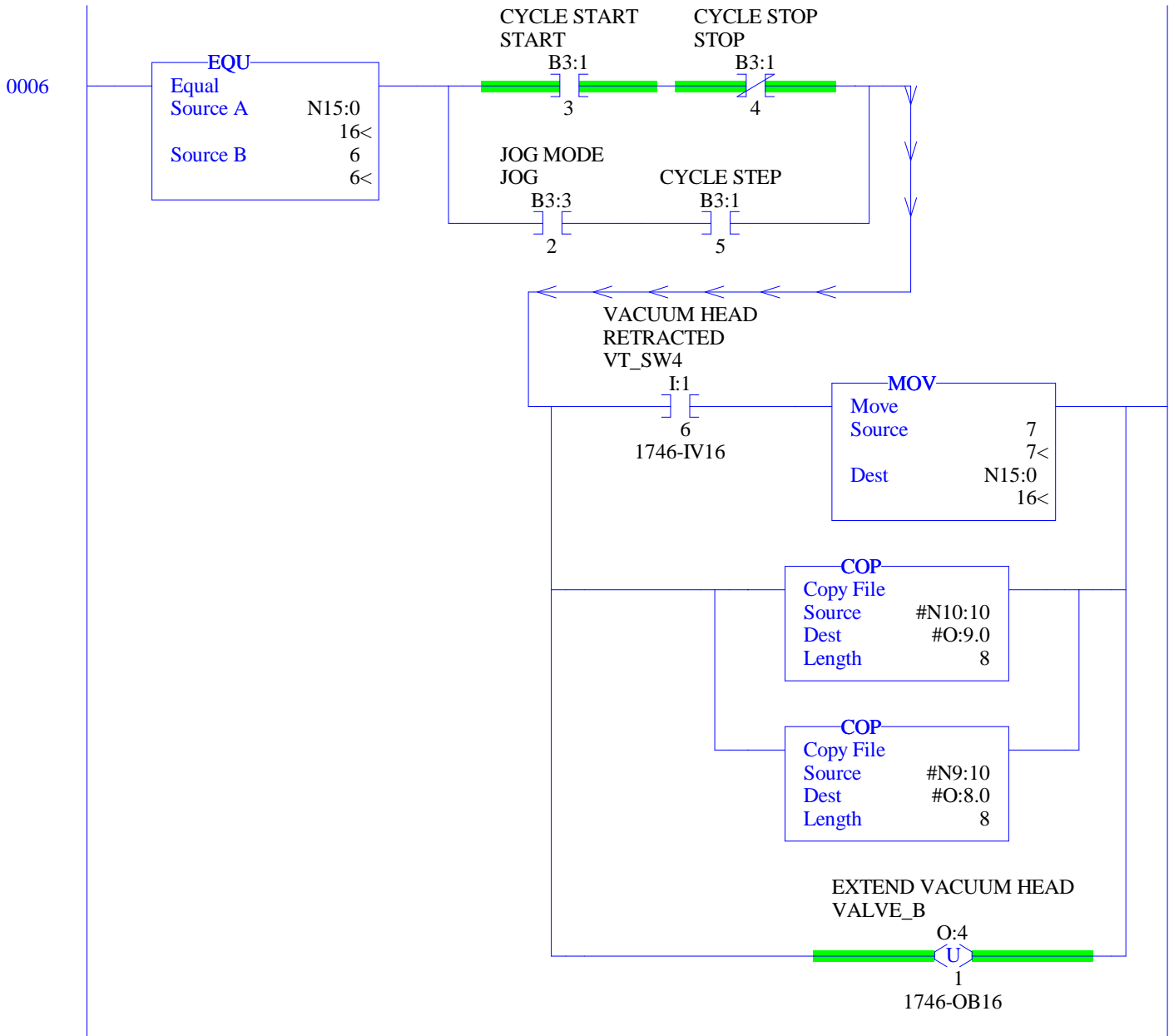




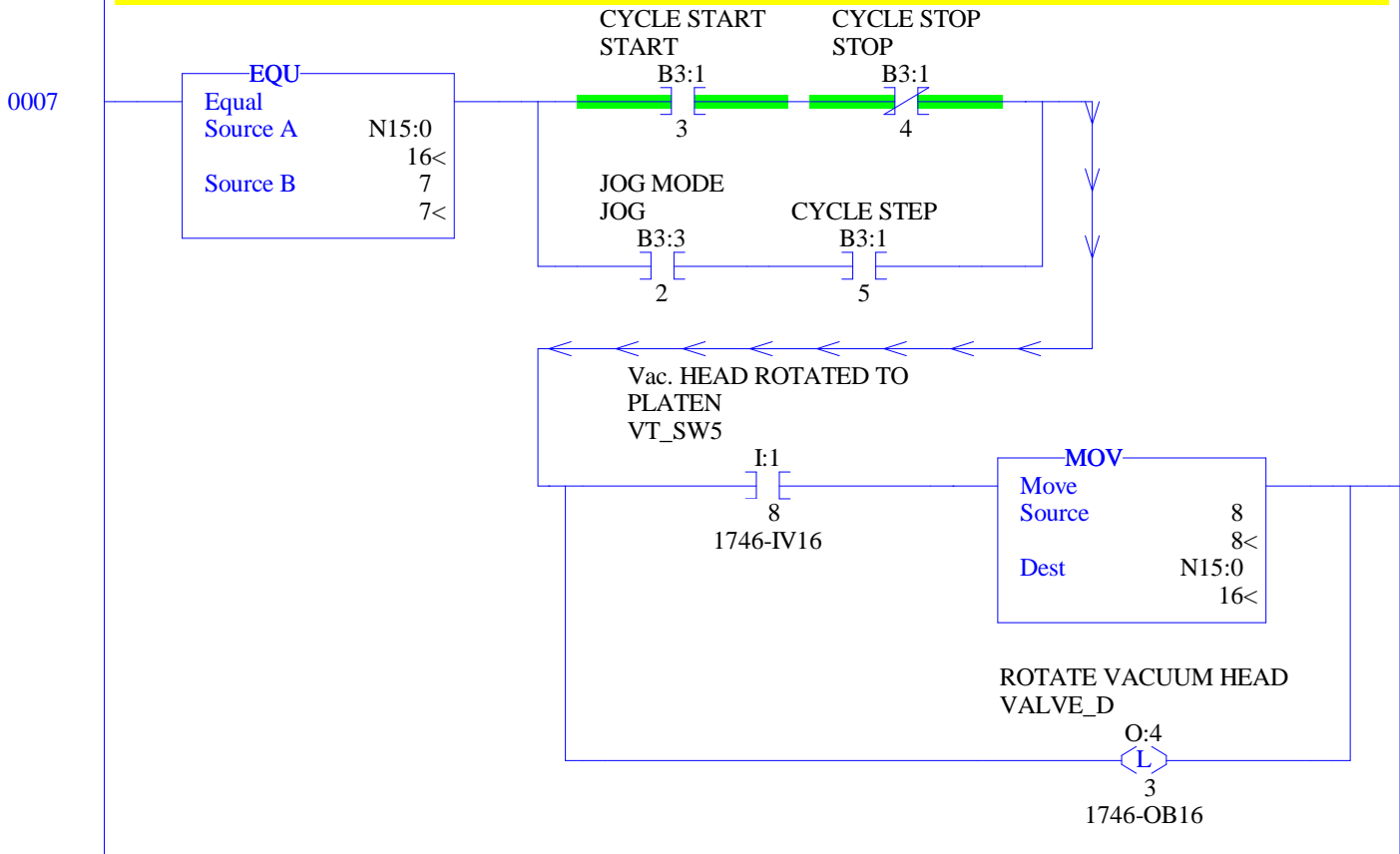
THIS RUNG MOVES THE NIP ROLLERS AND PULLER 22.625" FOR THE LENGTH OF THE RIBBON



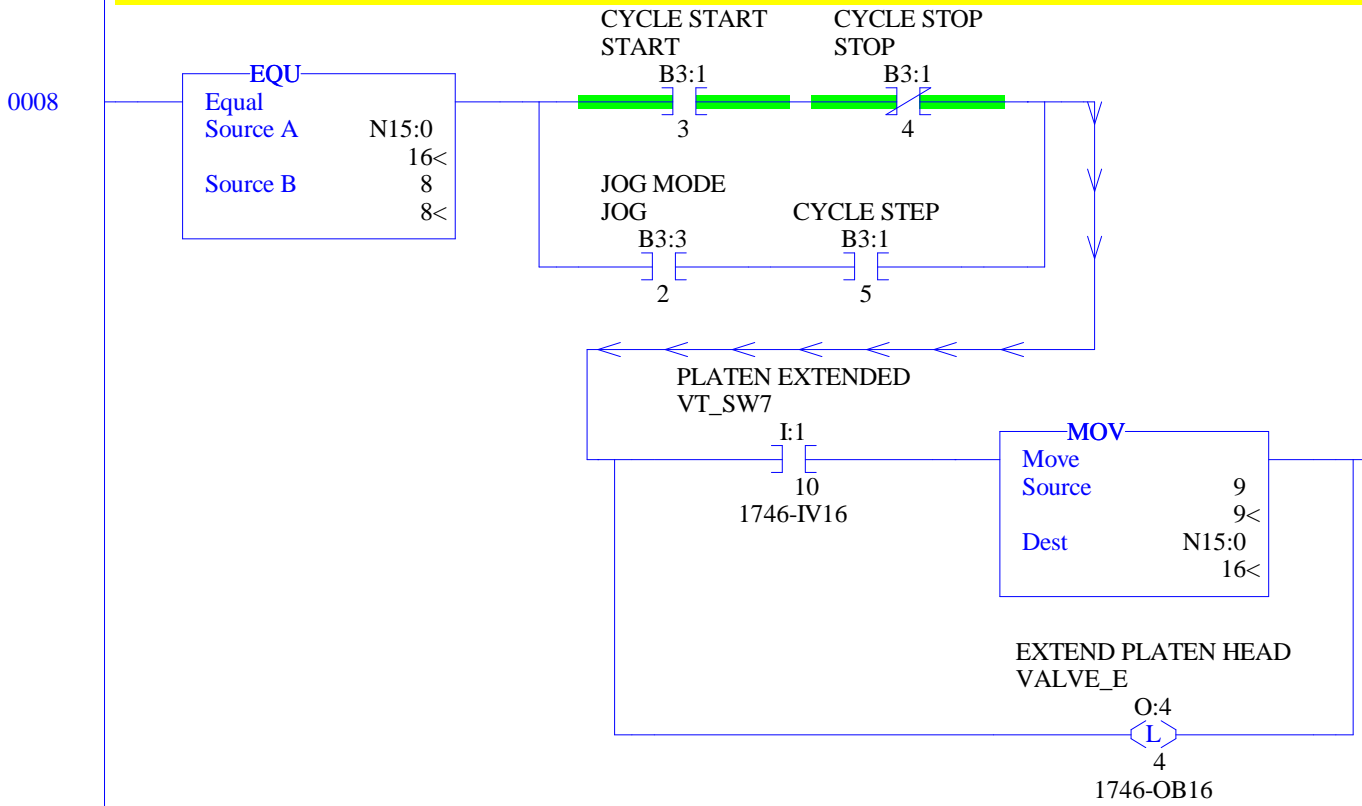




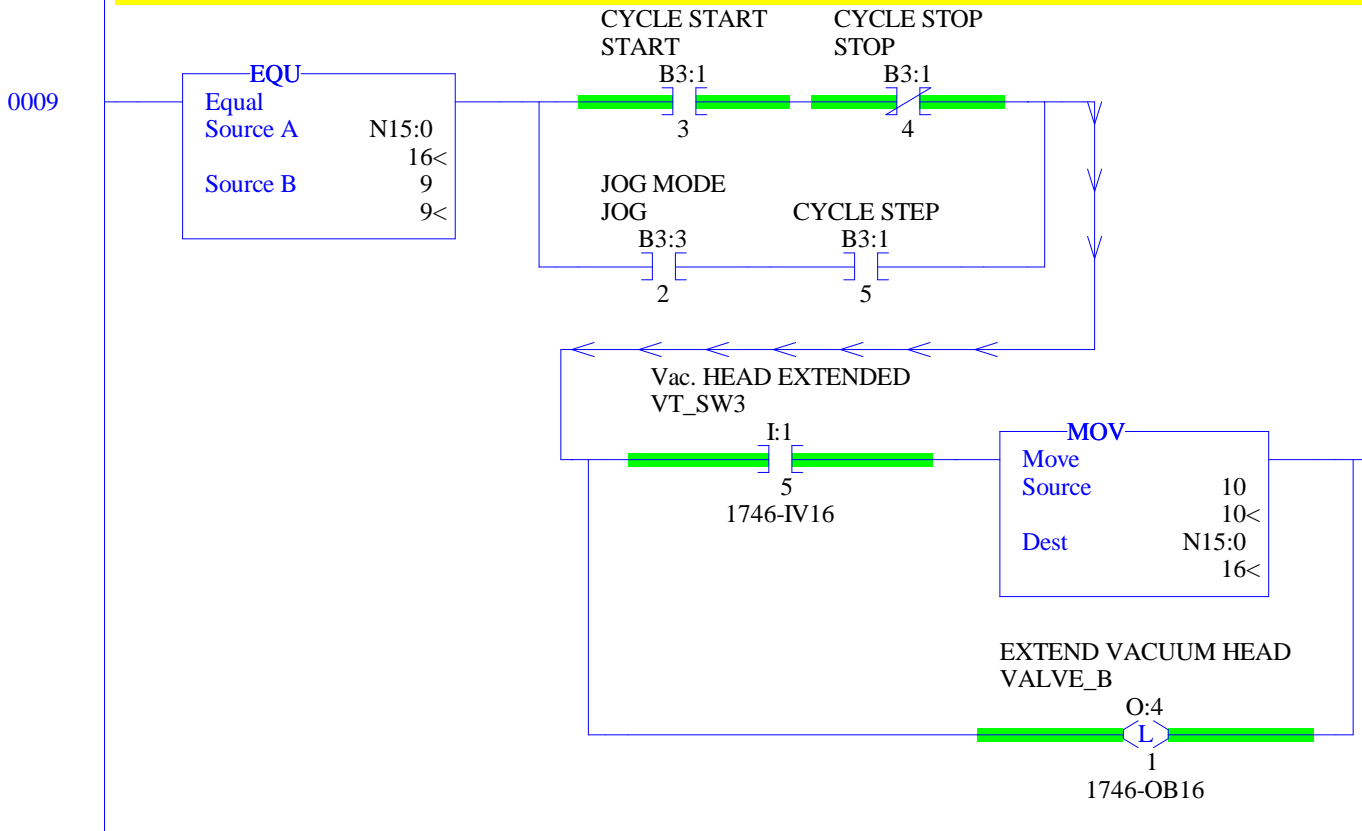
THIS RUNG ROTATES VACUUM HEAD TO THE PLATEN



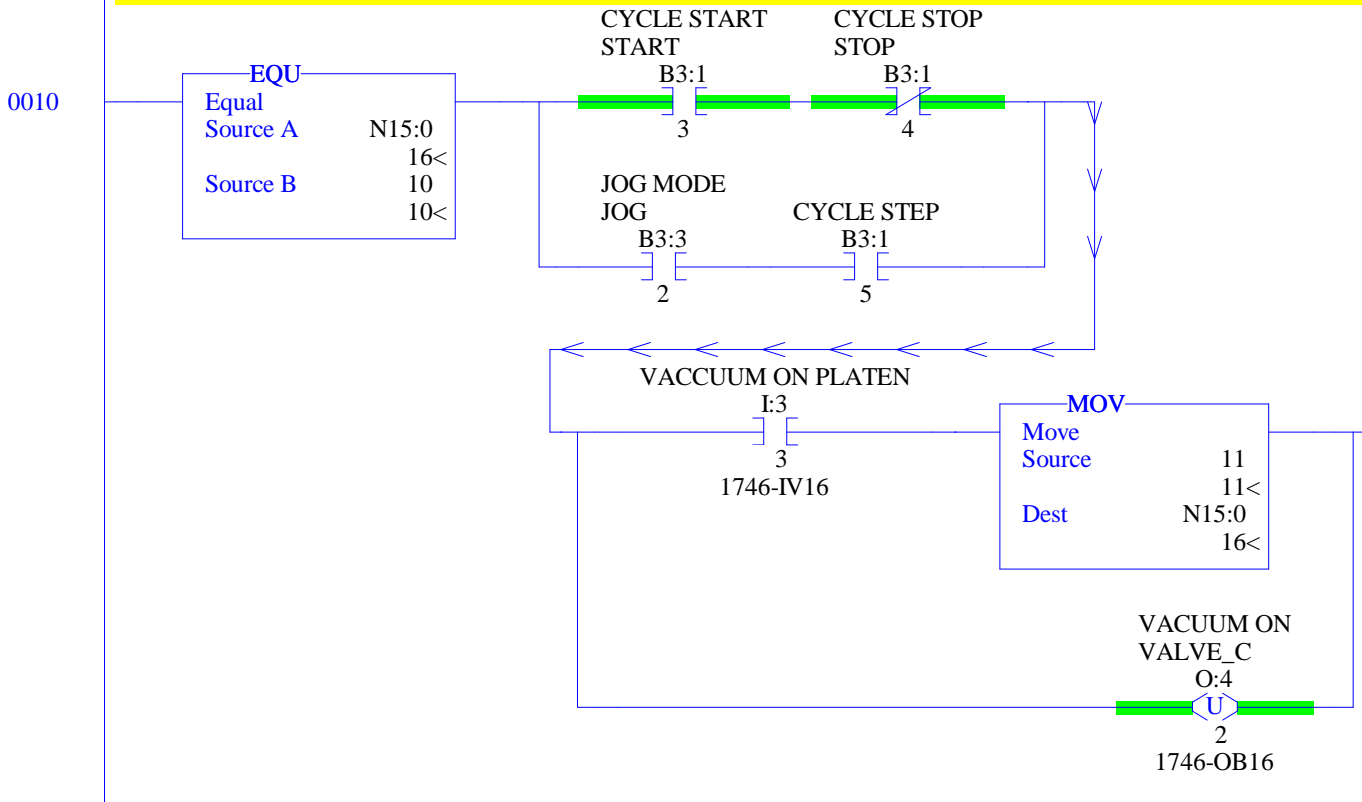
THIS RUNG EXTENDS TEH PLATEN TO THE VACUUM HEAD FOR FILM PLACEMENT

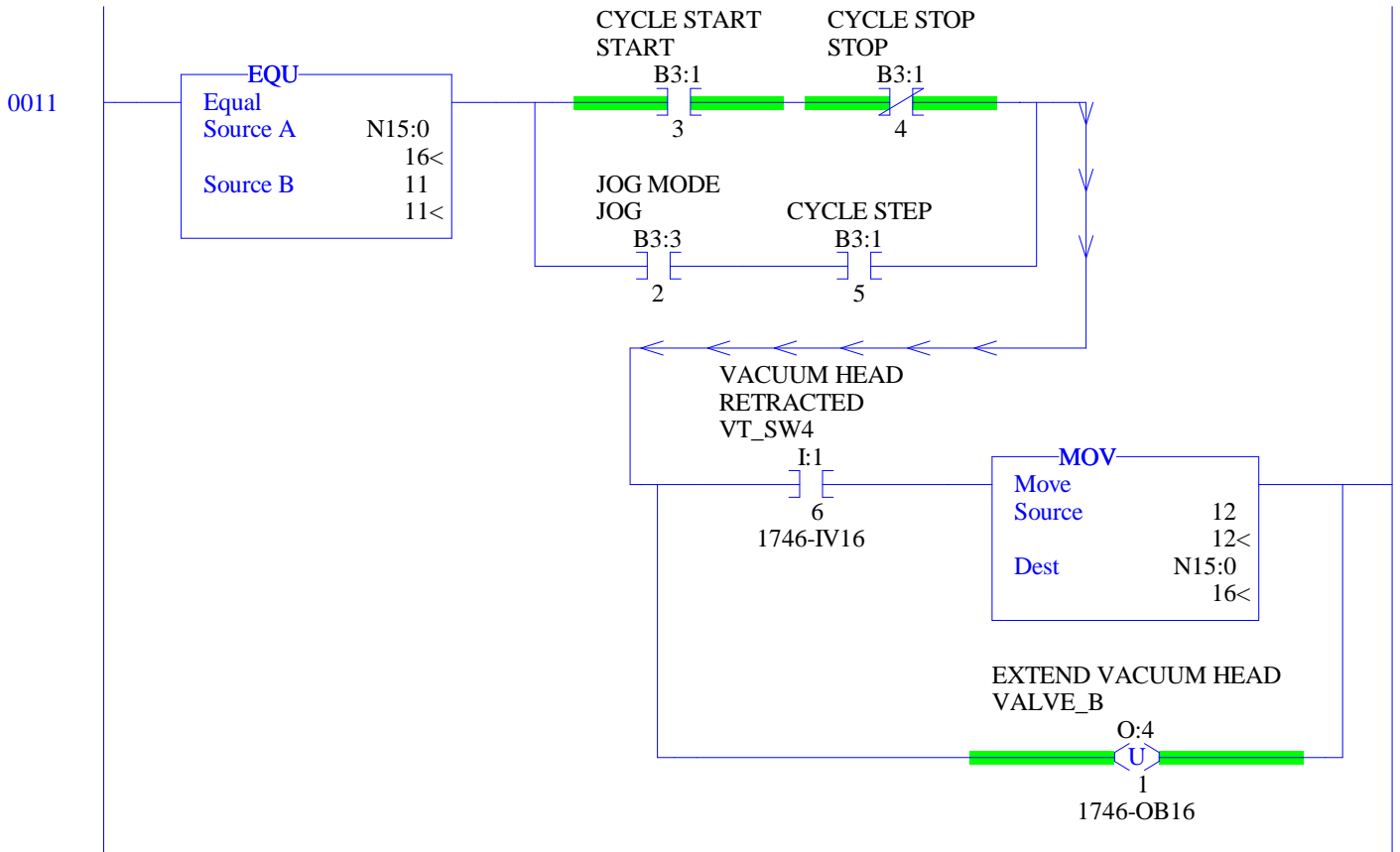


THIS RUNG EXTENDS THE VACUUM HEAD TO THE PLATEN



THIS RUNG CUTS THE VACUUM OFF OF THE ROTATOR HEAD AND CUTS IT ON THE PLATEN HEAD.





THIS RUNG RETURNS THE ROTATOR BACK TO THE MAGAZINE

0012

EQU	
Equal	N15:0
Source A	16<
Source B	12<

CYCLE START
START

CYCLE STOP
STOP

B3:1
3

B3:1
4

JOG MODE
JOG

CYCLE STEP

B3:3
2

B3:1
5

ROTATOR AWAY FROM
SEAL HEAD
VT_SW26

I:3
9

1746-IV16

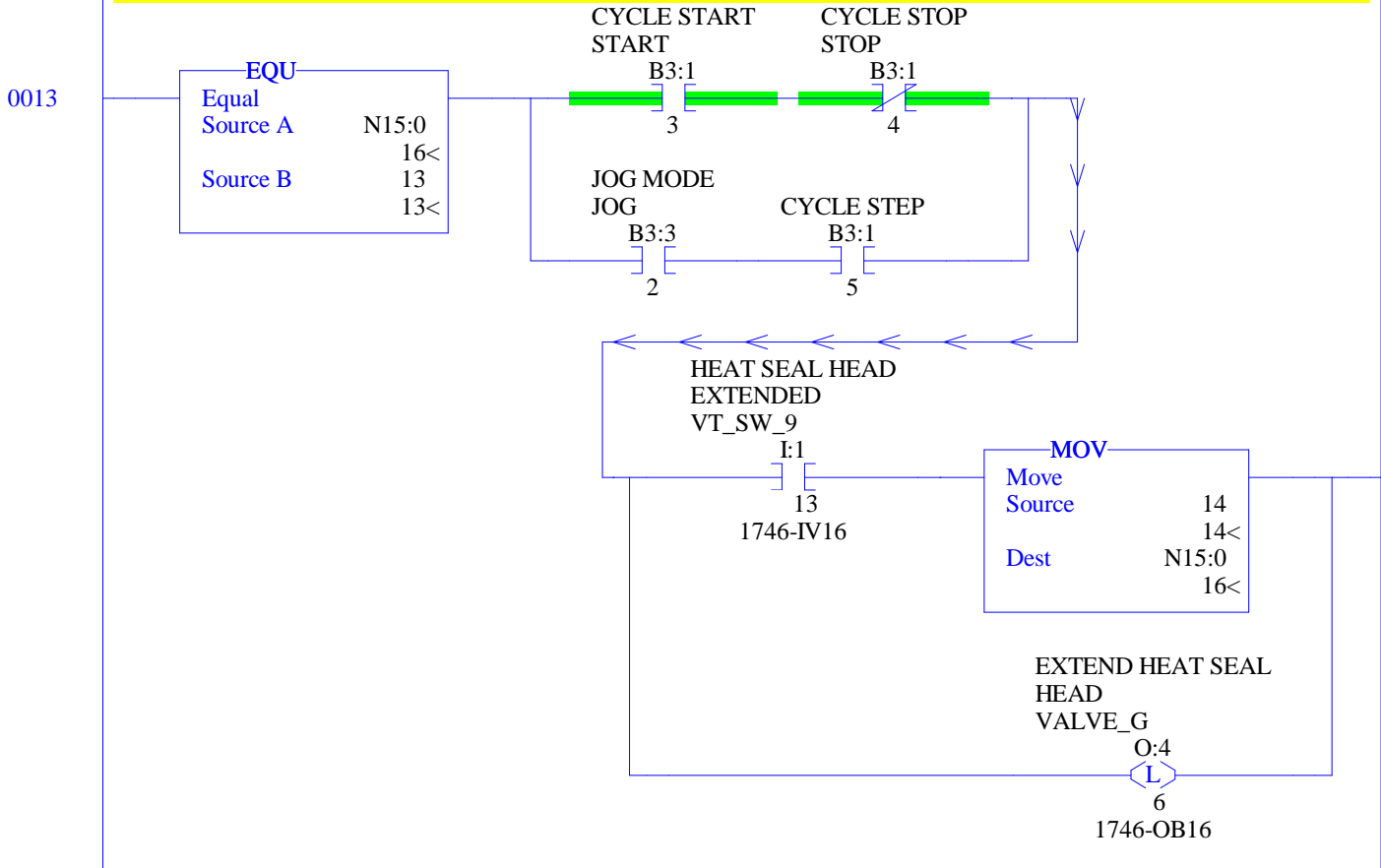
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ROTATE VACUUM HEAD
VALVE_D

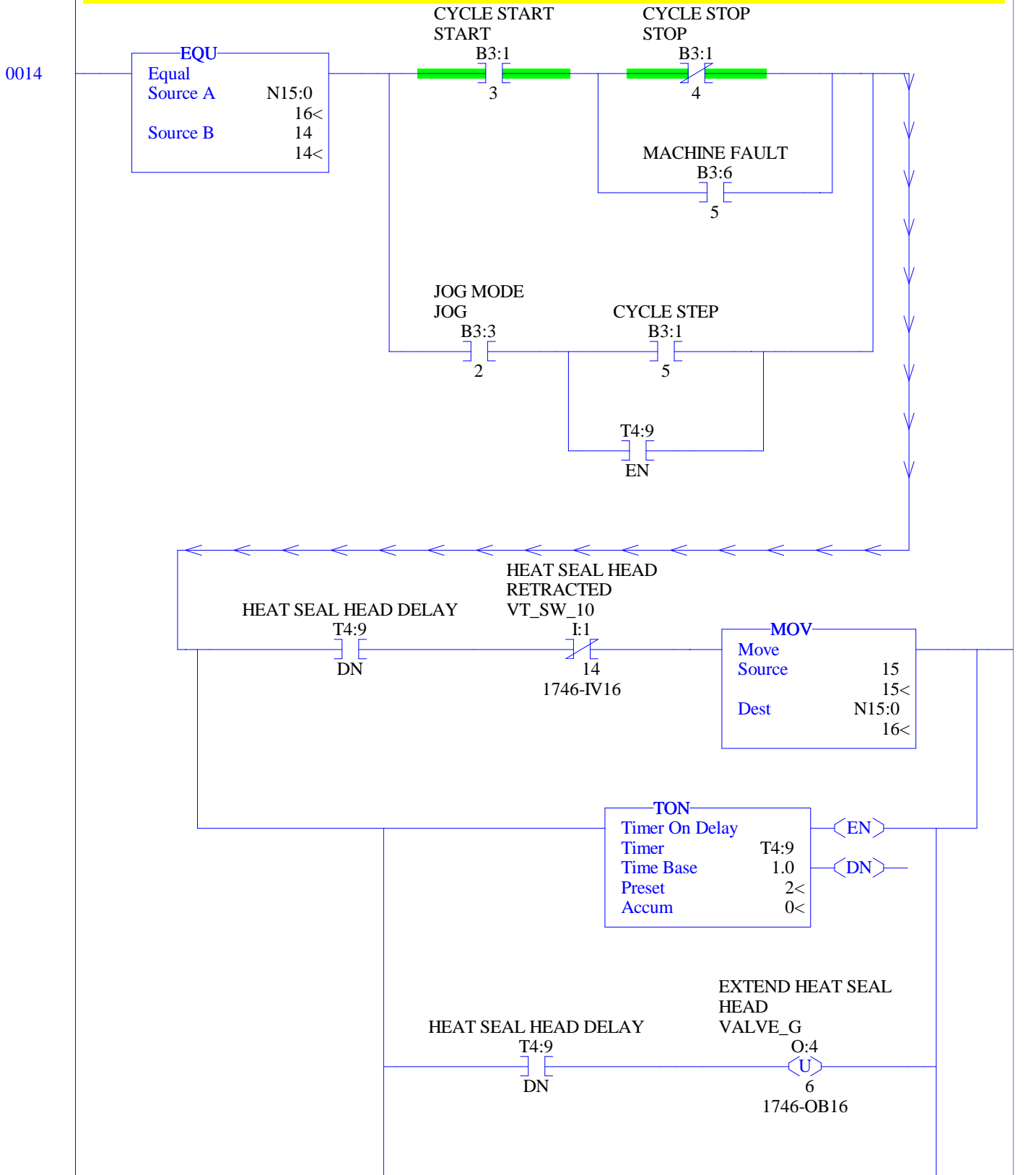
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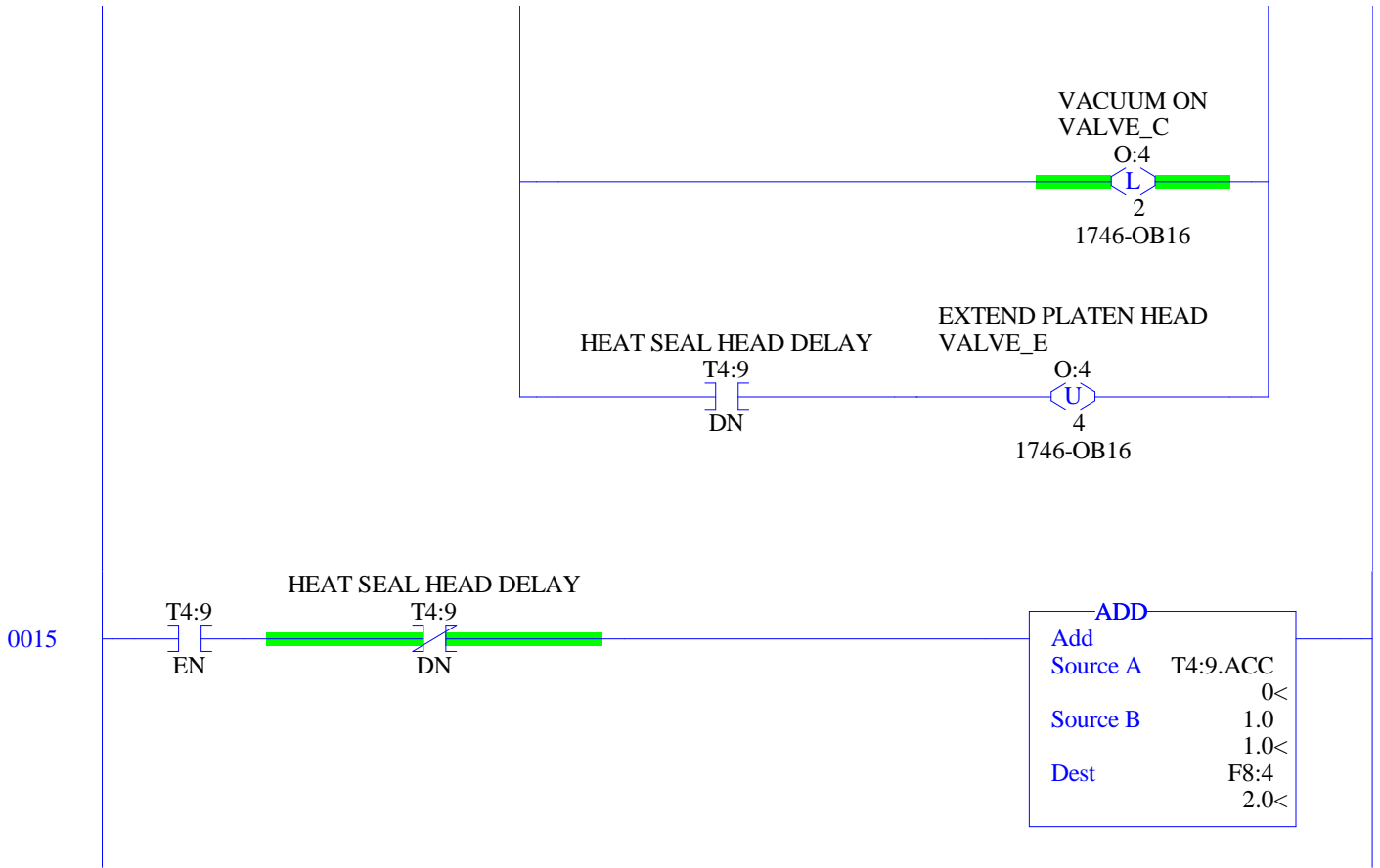
1746-OB16

THIS RUNG EXTENDS THE HEAT SEAL HEAD TO SEAL THE FILM TO THE RIBBON

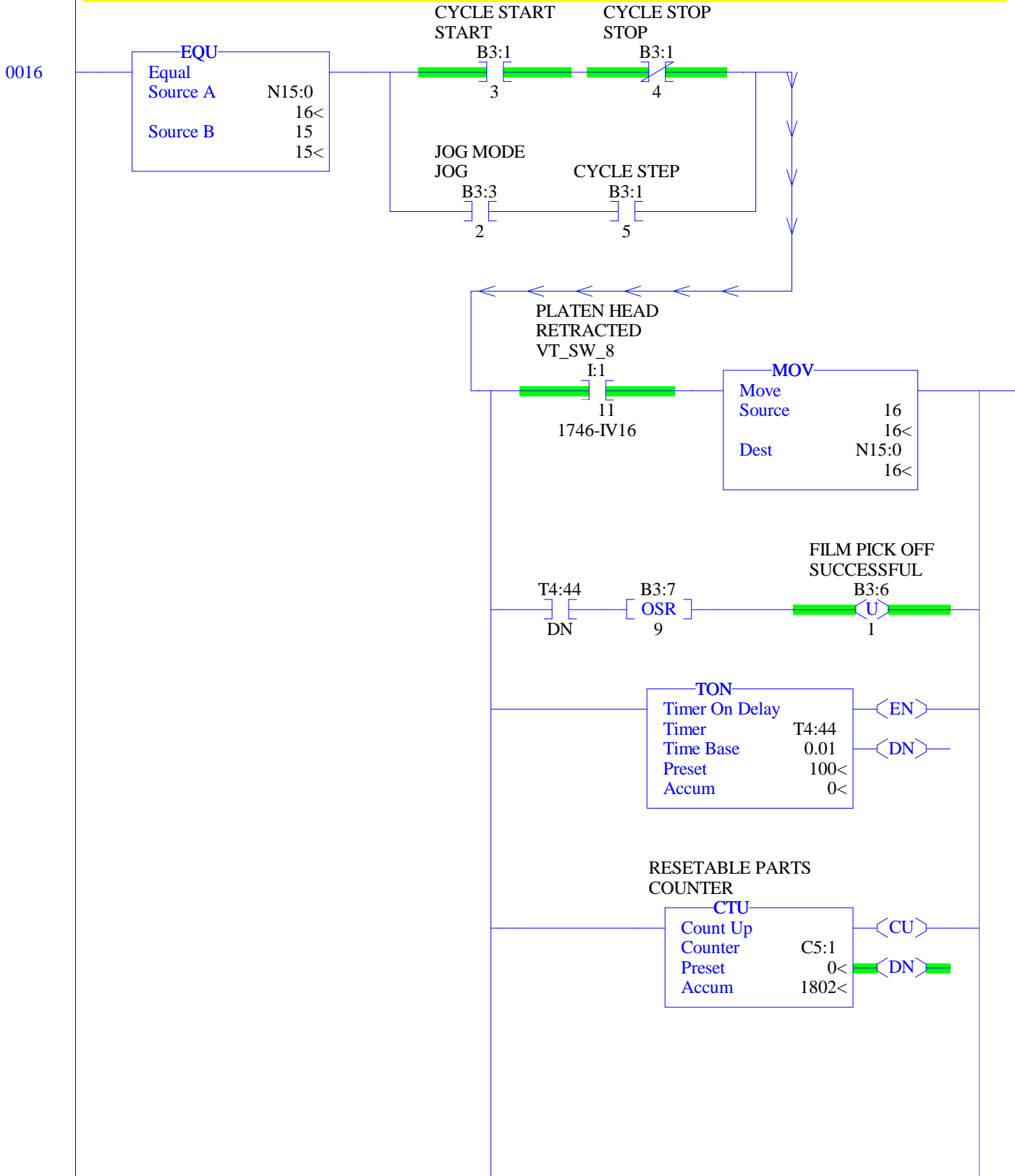


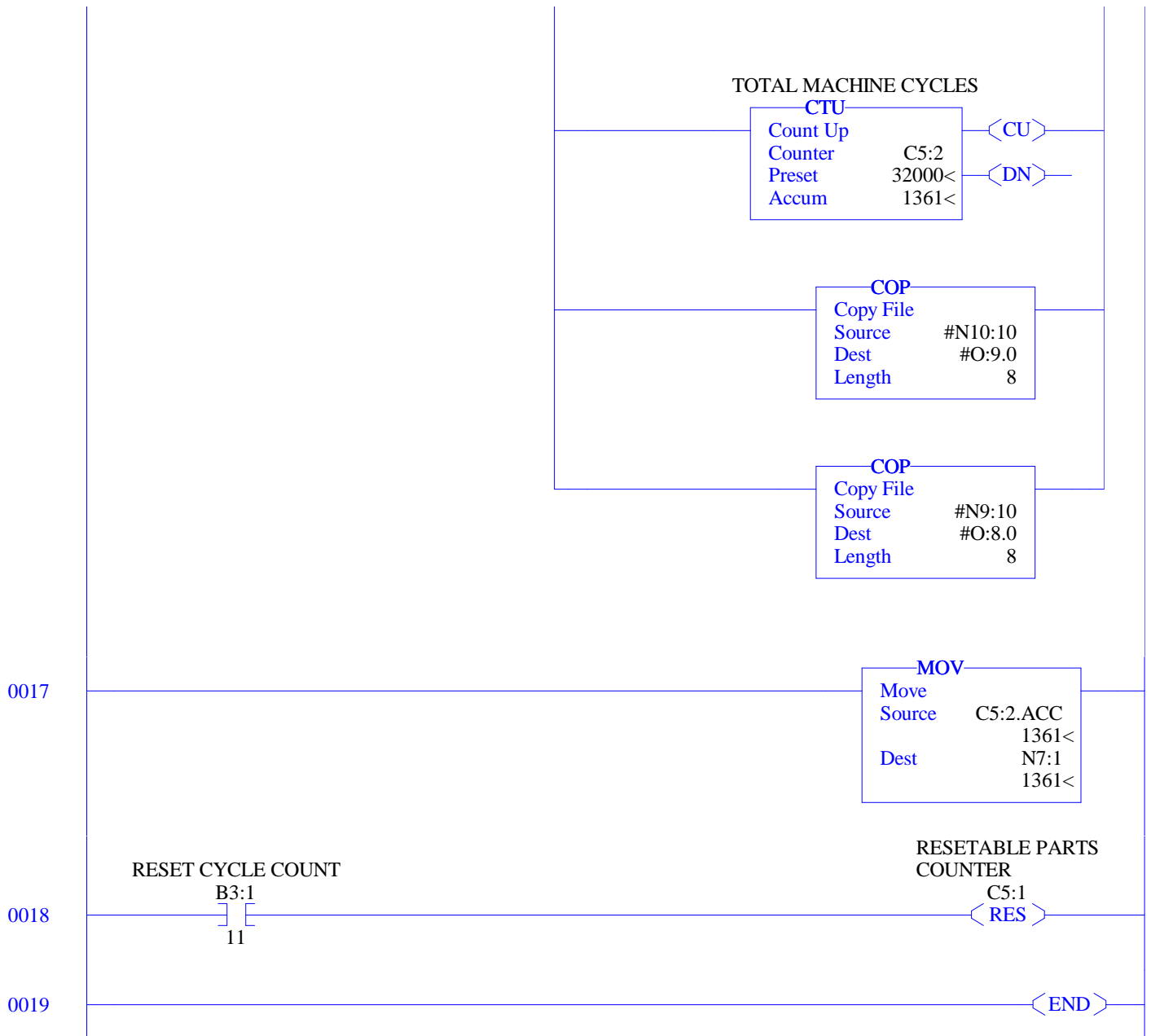
THIS RUNG DELAYS THE RETURNING OF THE HEAT SEAL HEAD FOR 2 SECONDS

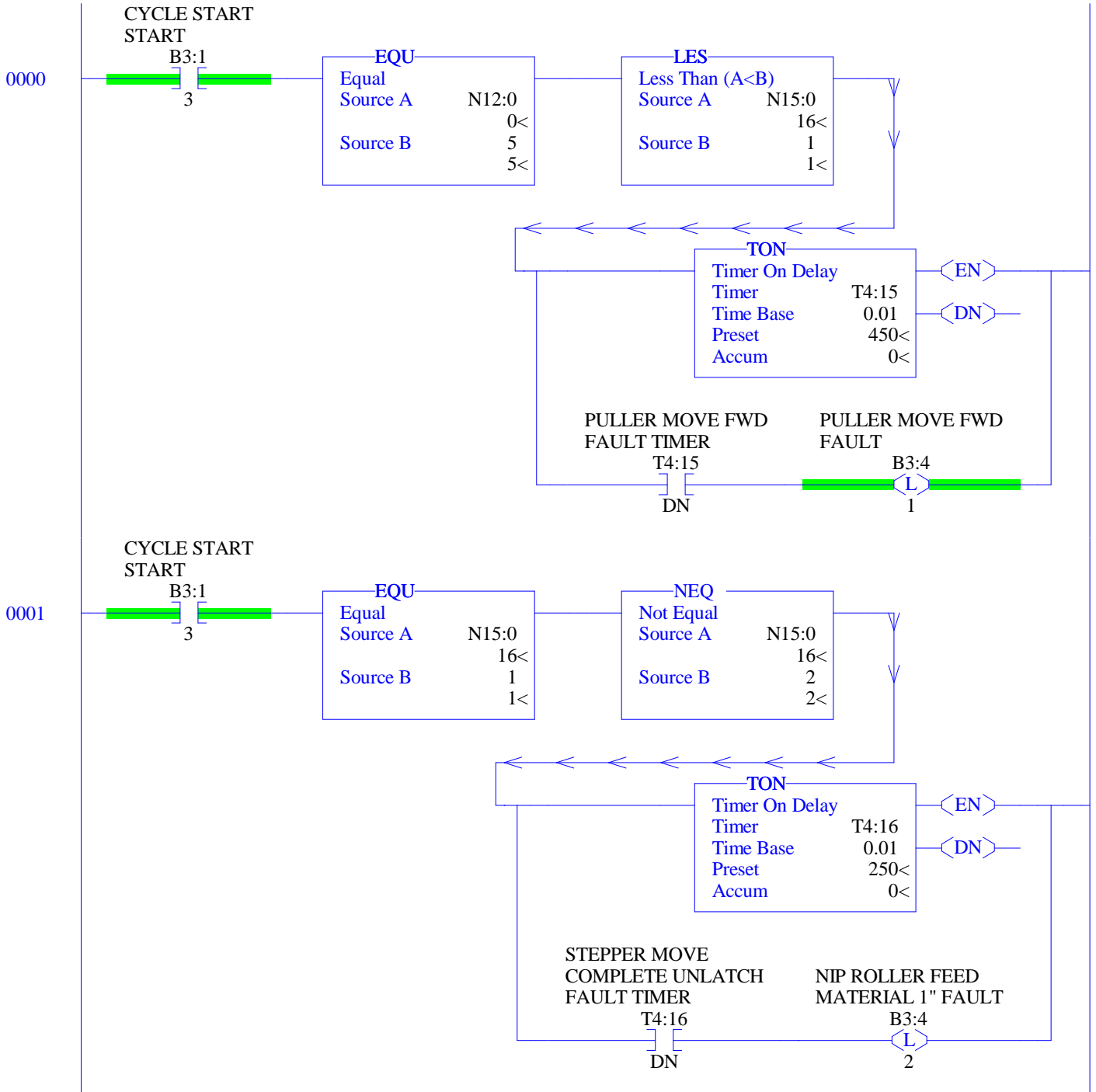


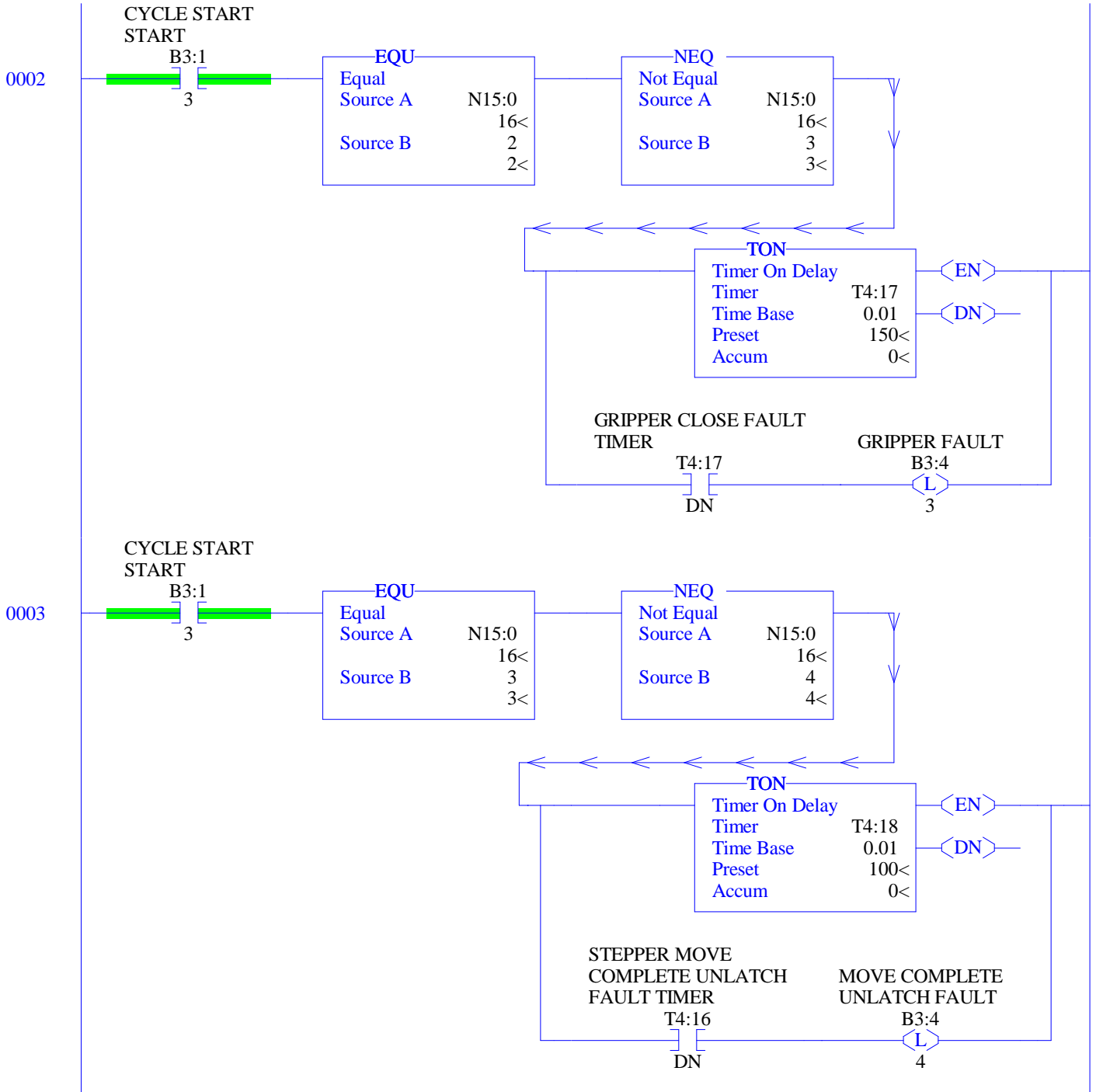


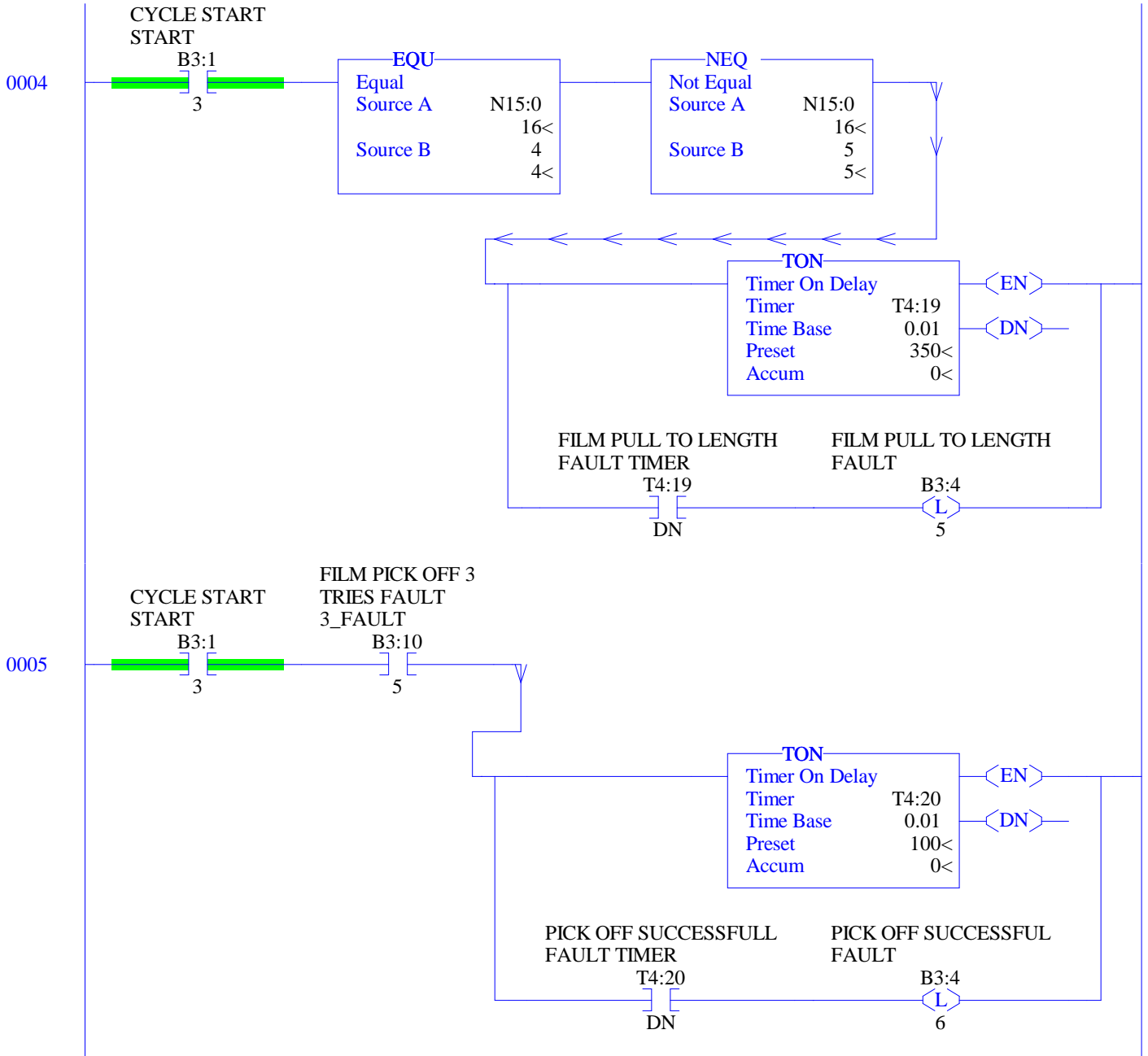
THIS RUNGS RETRACTS THE PLATEN HEAD BACK TO HOME POSITION

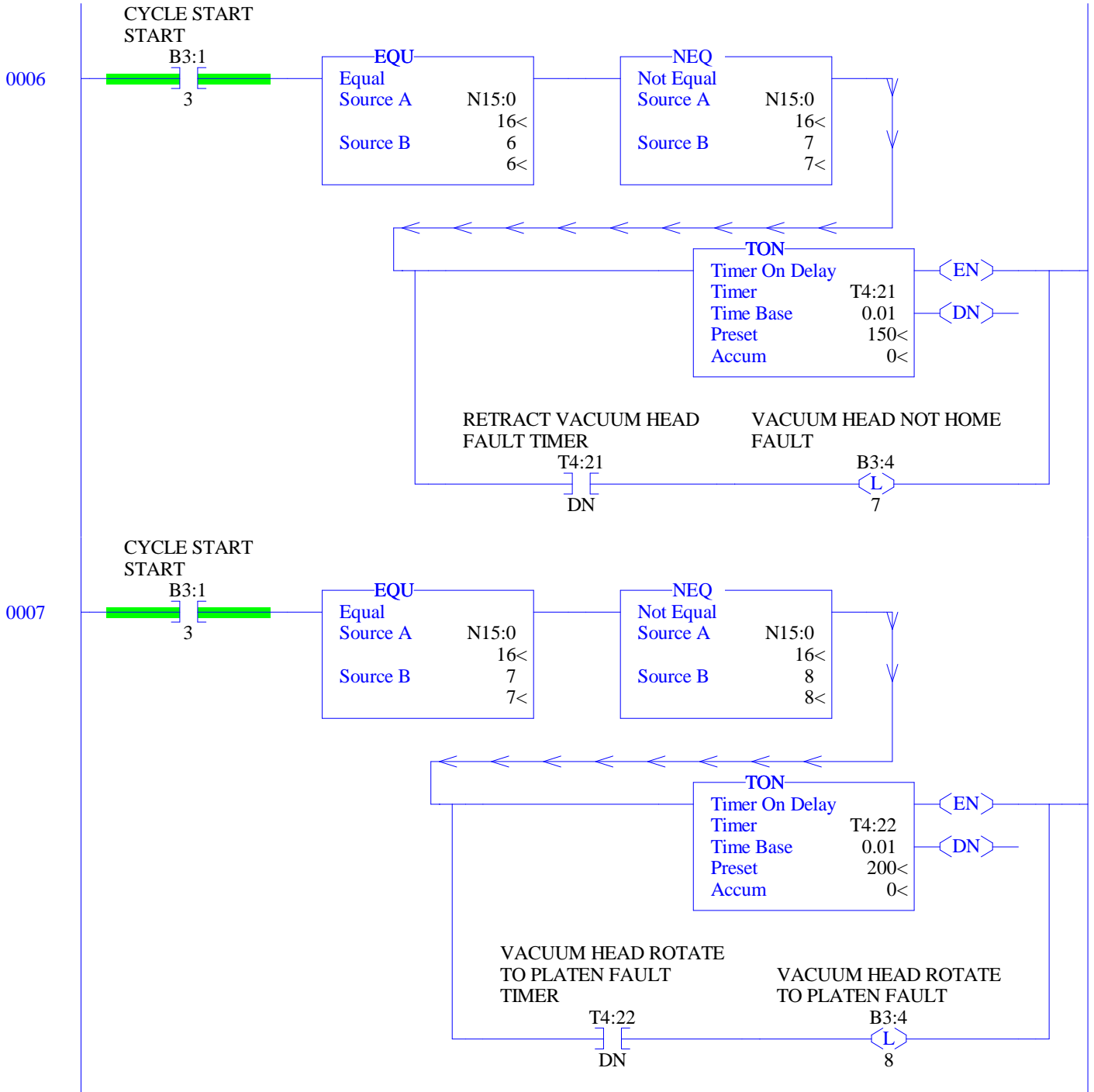




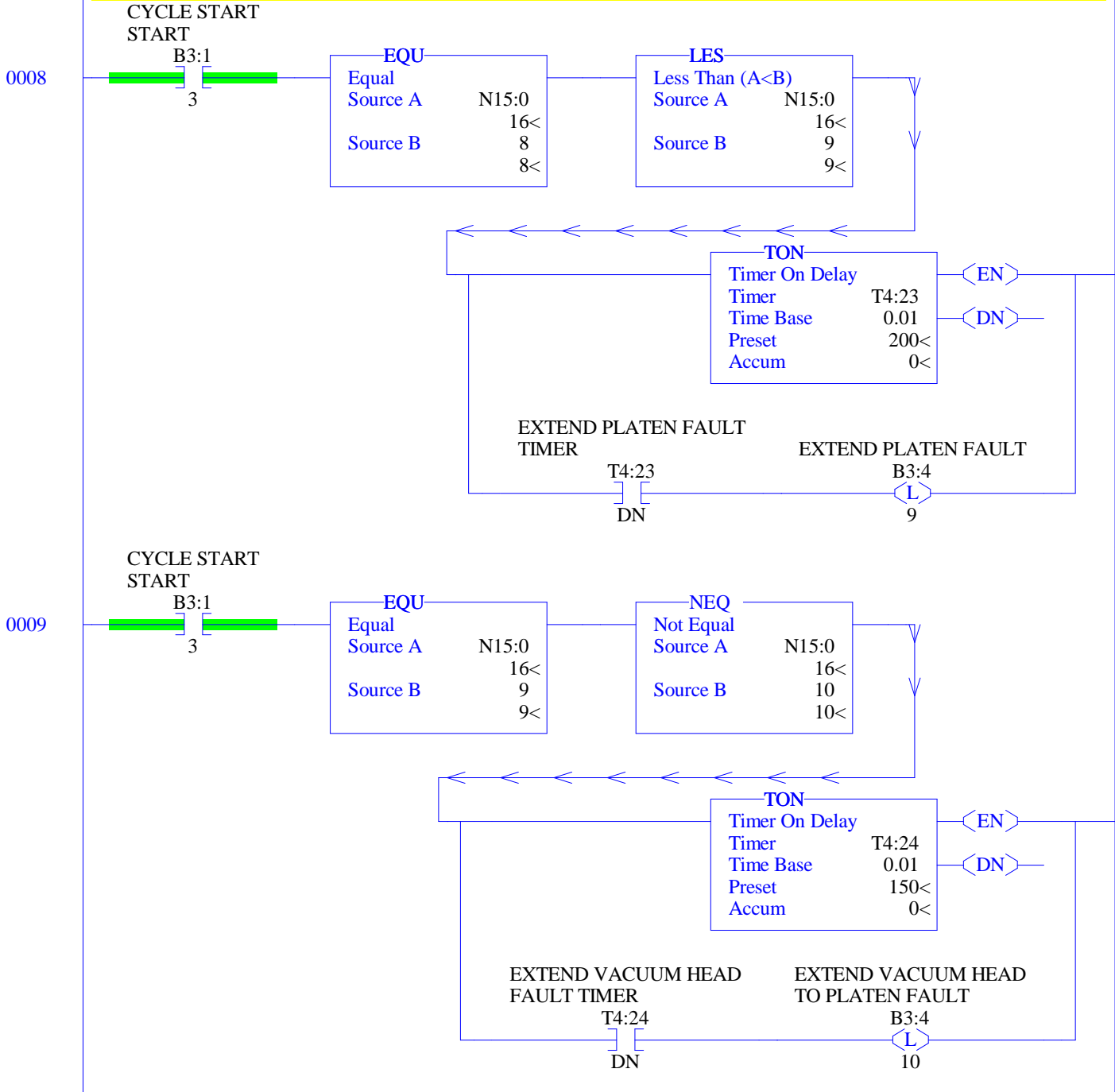


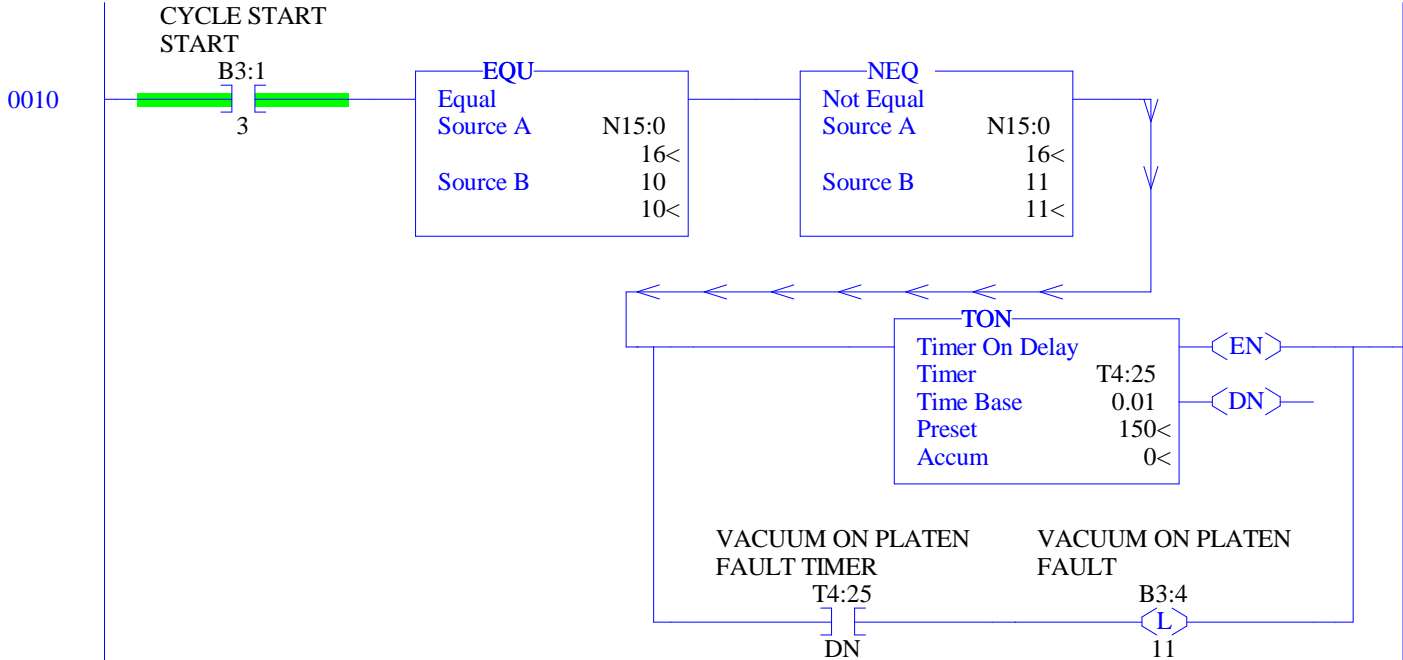




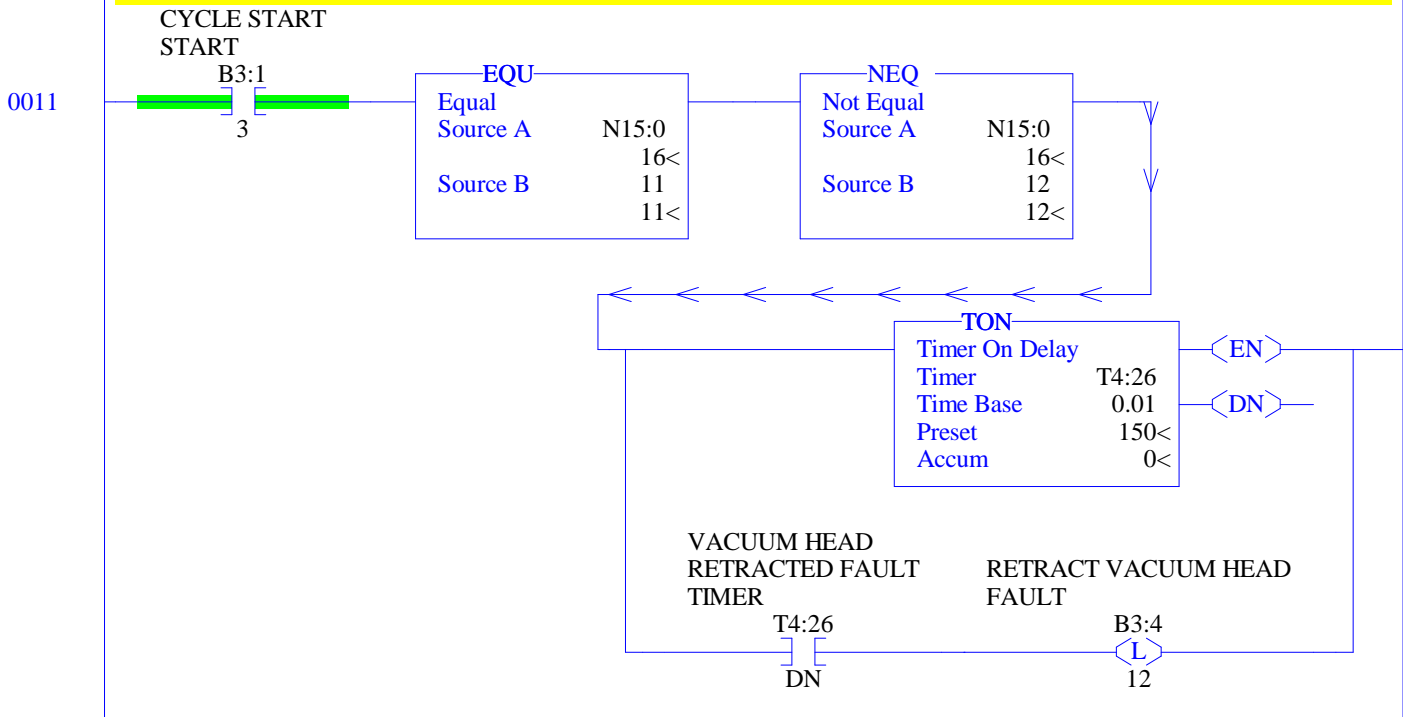


THIS RUNG RETRACTS THE HOPPER SEAL HEAD AFTER 5 SECONDS

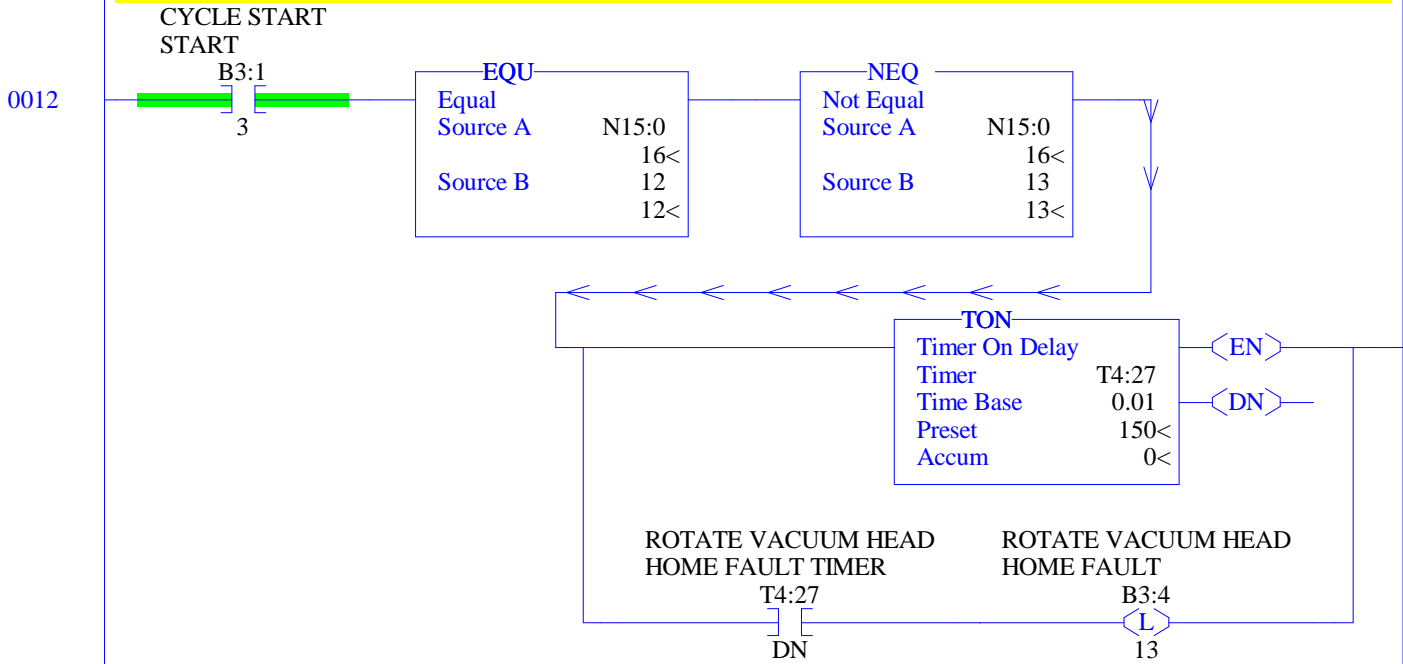




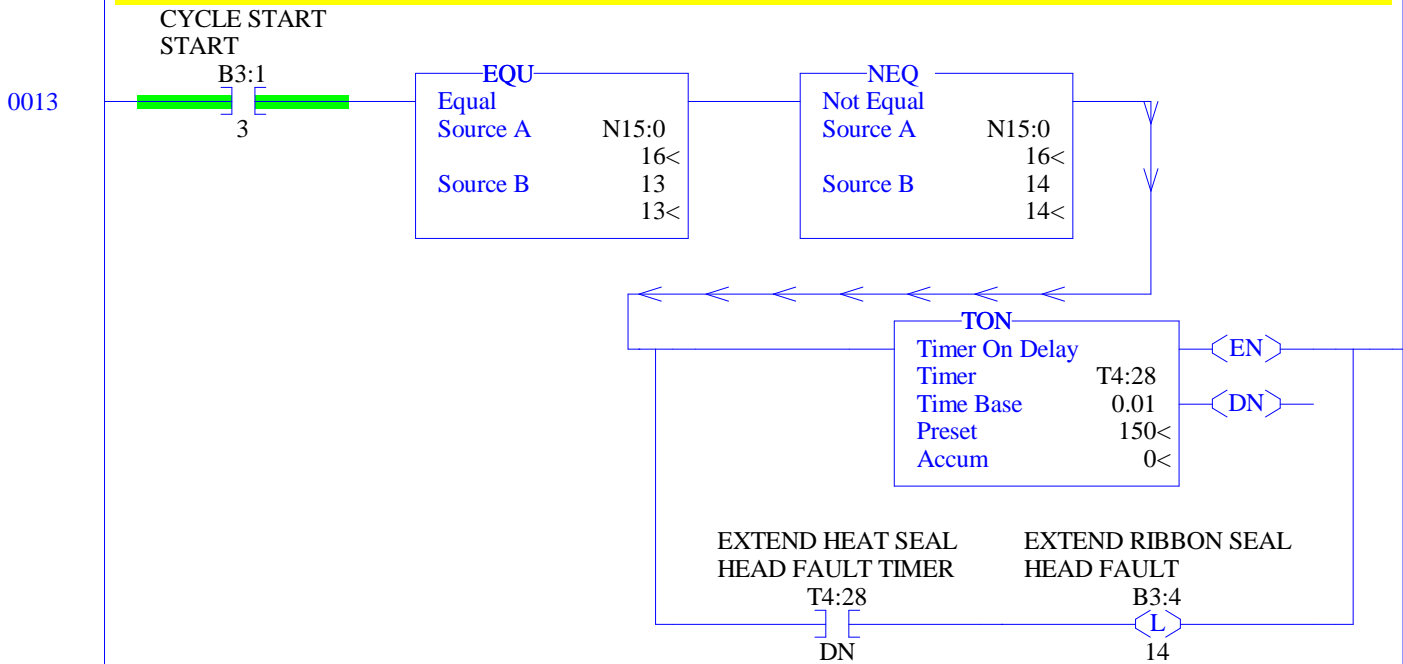
THIS RUNG OPENS THE GRIPPERS AFTER THE HOPPER SEAL SEQUENCE IS THRU



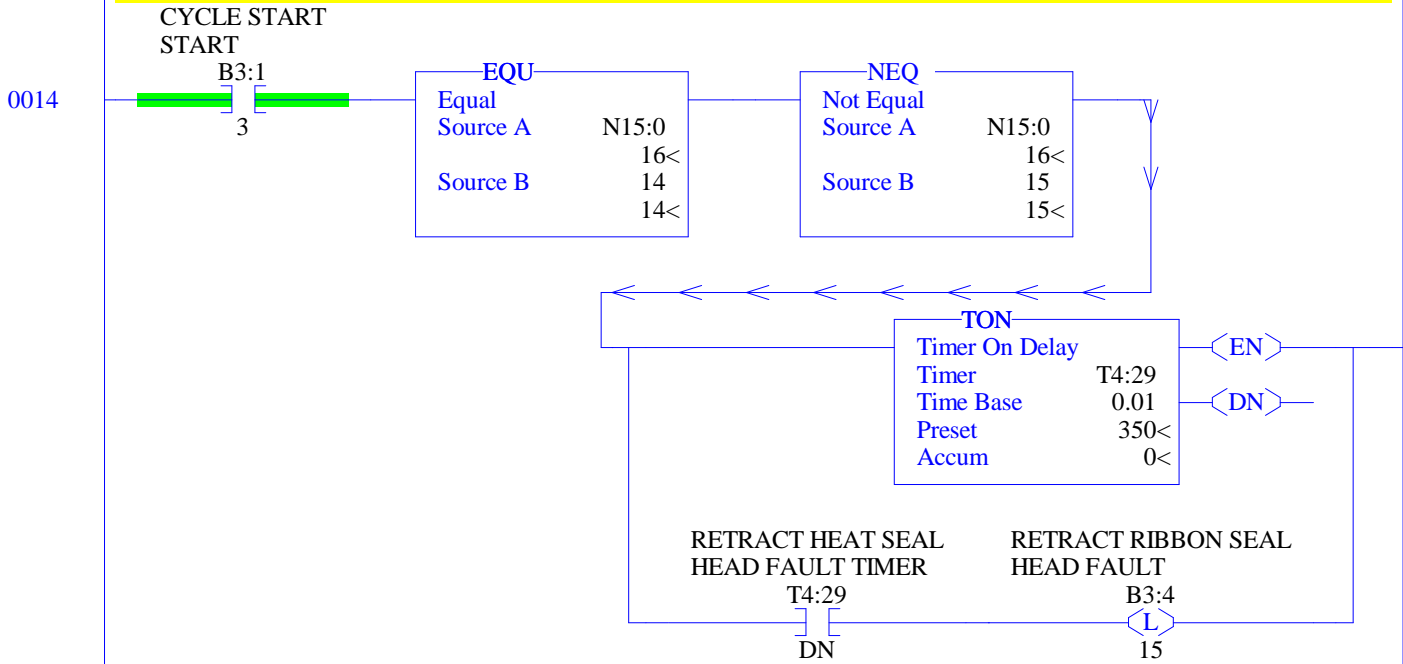
THIS RUNG RETRACTS THE HOPPER PLATEN



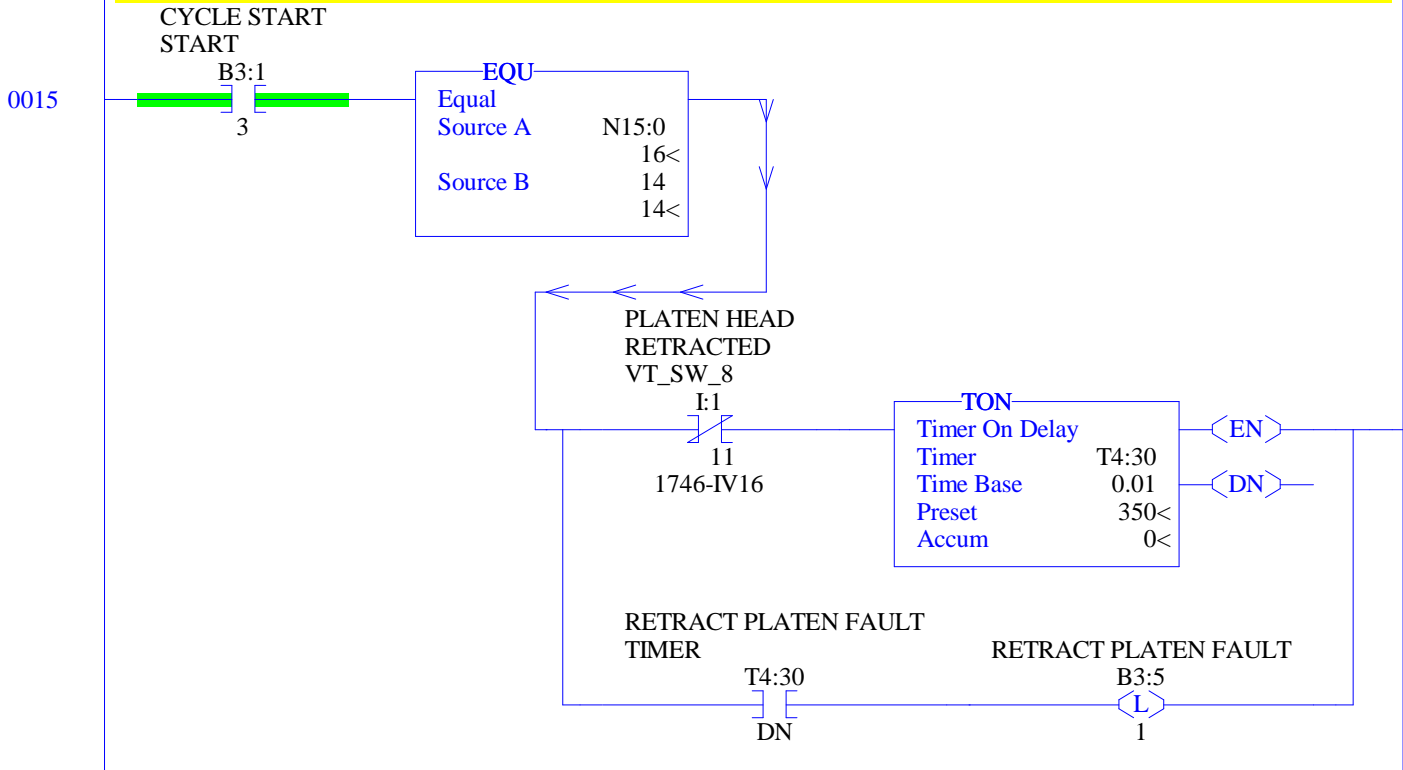
THIS RUNG RETRACT THE MAIN SLIDE BACK TO THE OPERATOR



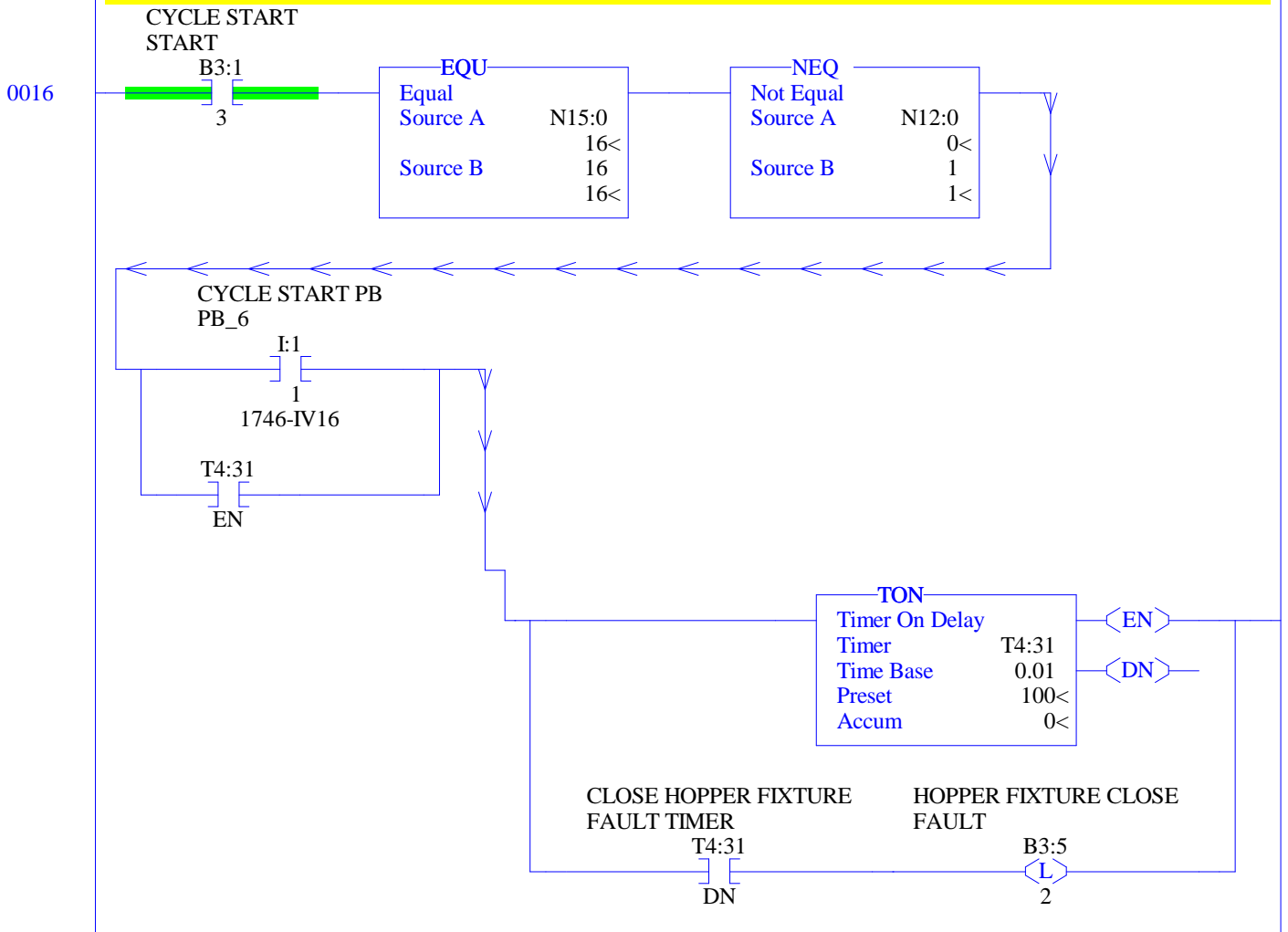
THIS RUNG RETRACTS THE HOPPER SLIDE BACK TO THE OPERATOR



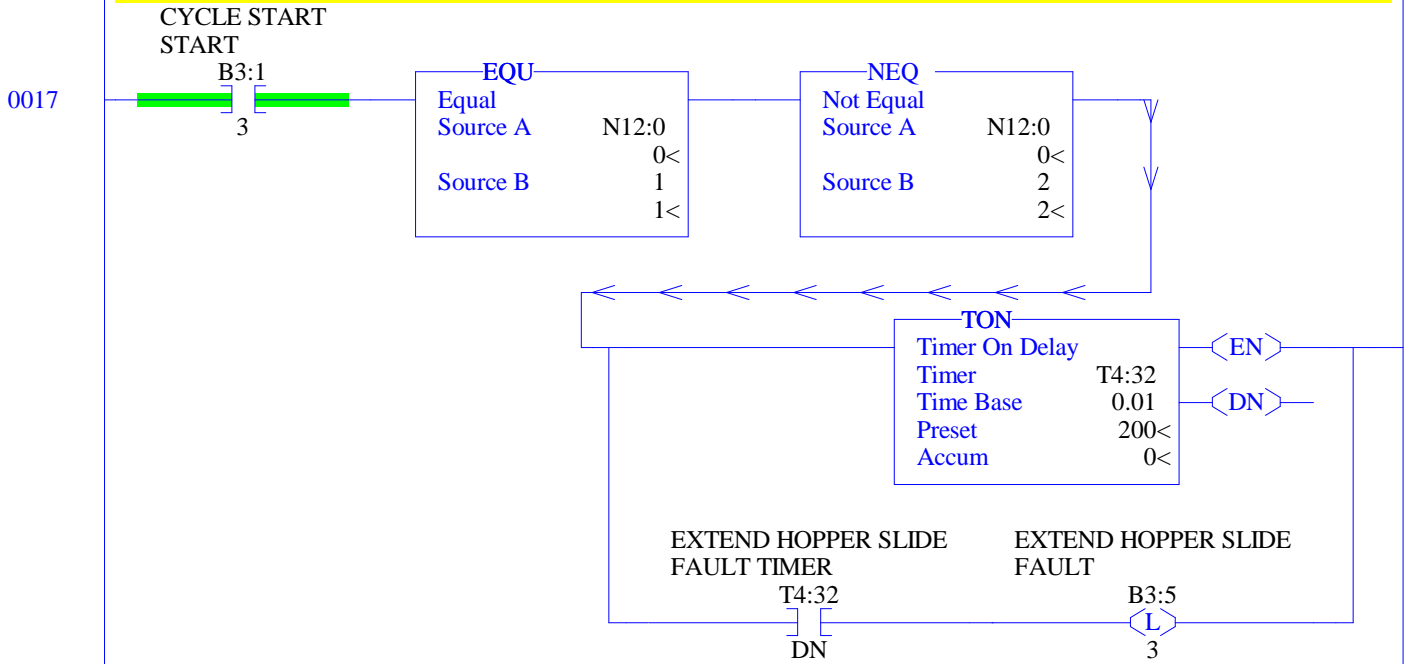
THIS RUNG OPENS THE HOPPER FIXTURE AFTER CYCLE IS COMPLETE



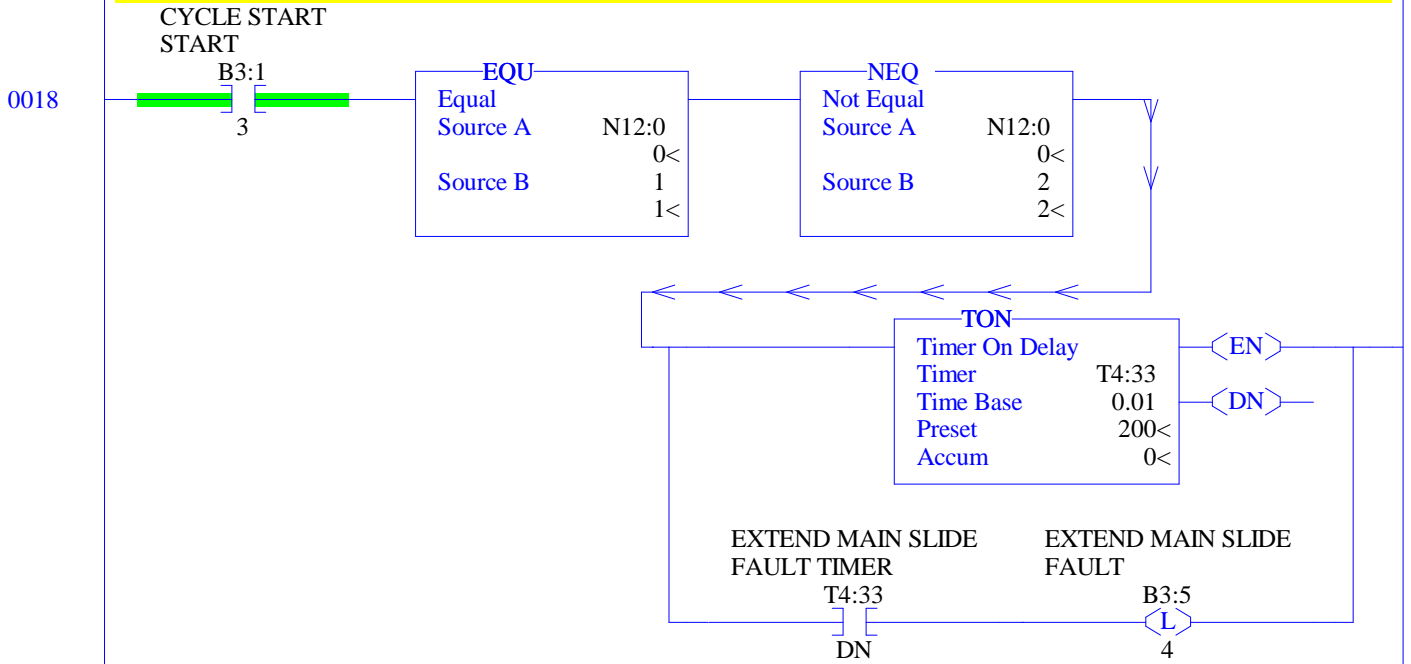
THIS RUNG MOVES THE PULLER TO THE CUTOFF

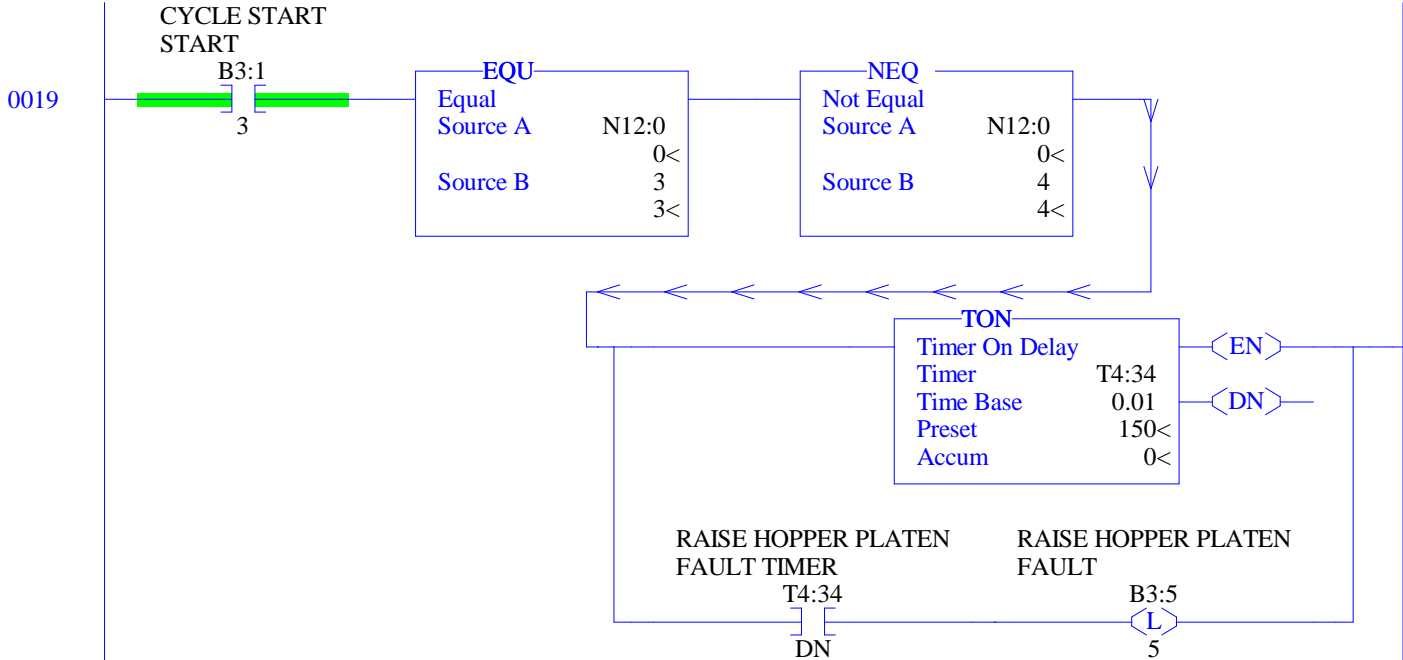


THIS RUNG MOVES THE NIP ROLLERS FOR A 1" FEED OF MATERIAL INTO THE GRIPPERS

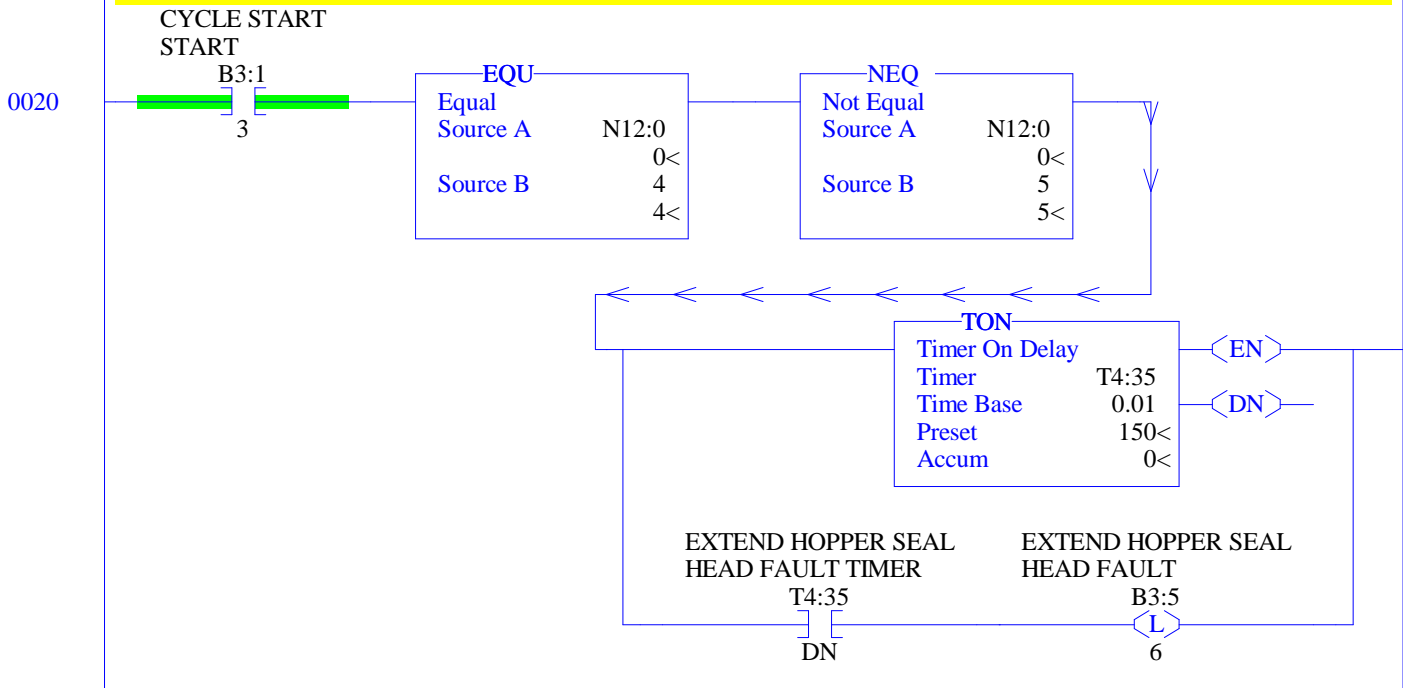


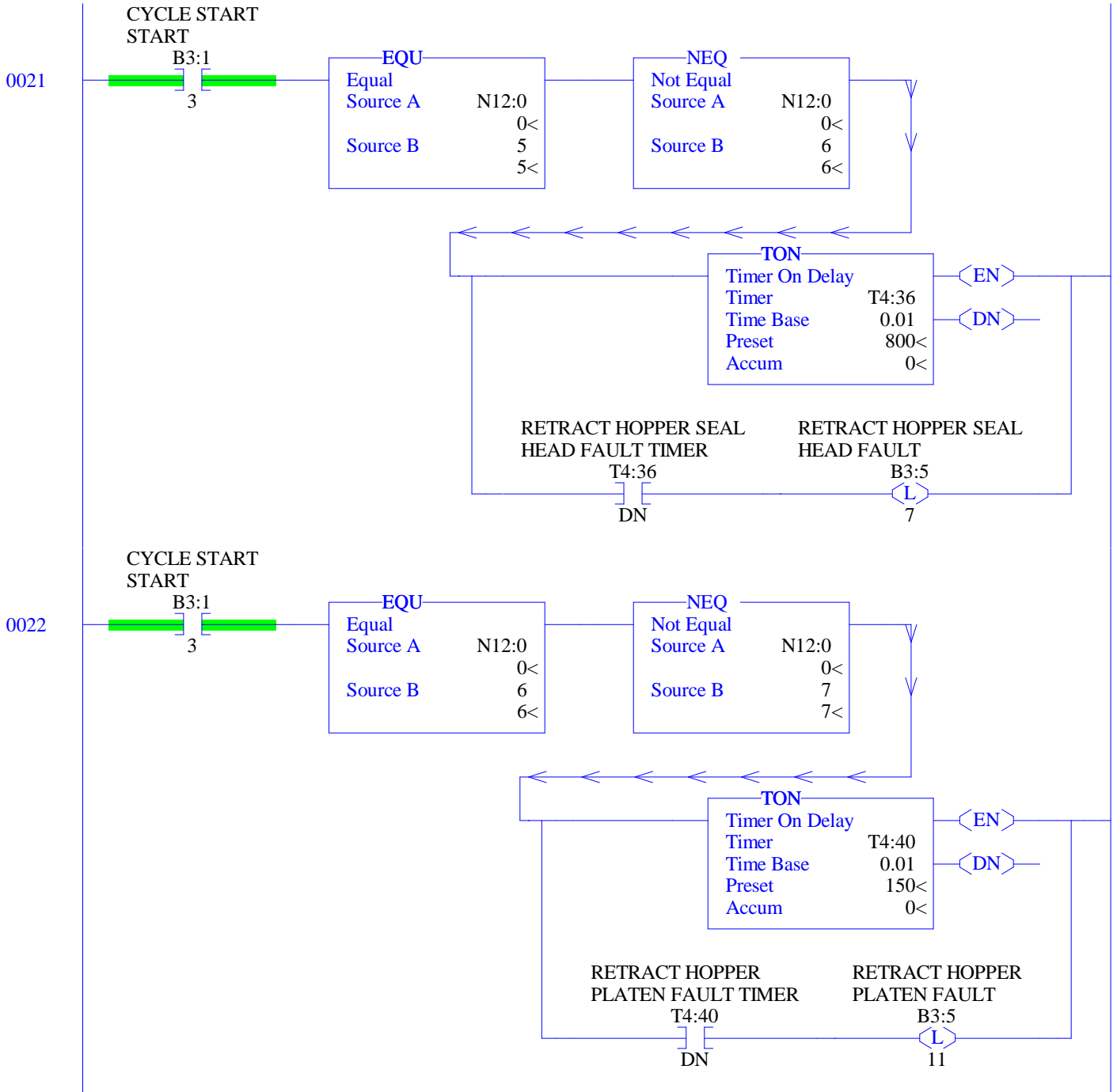
THIS RUNG CLOSES THE GRIPPERS AFTER 1" OF MATERIAL IS FED IN.



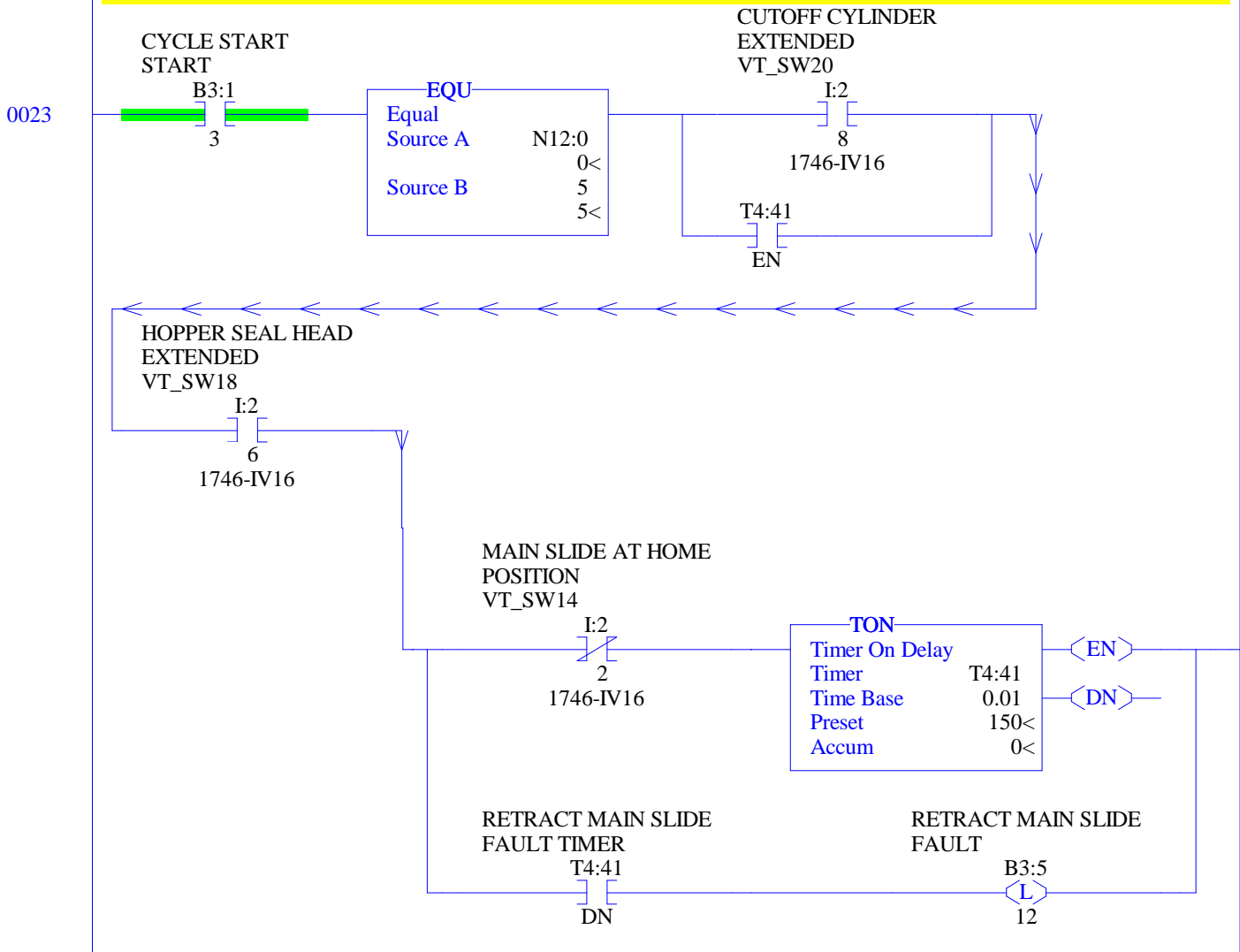


THIS RUNG MOVES THE NIP ROLLERS AND PULLER 22.625" FOR THE LENGTH OF THE RIBBON

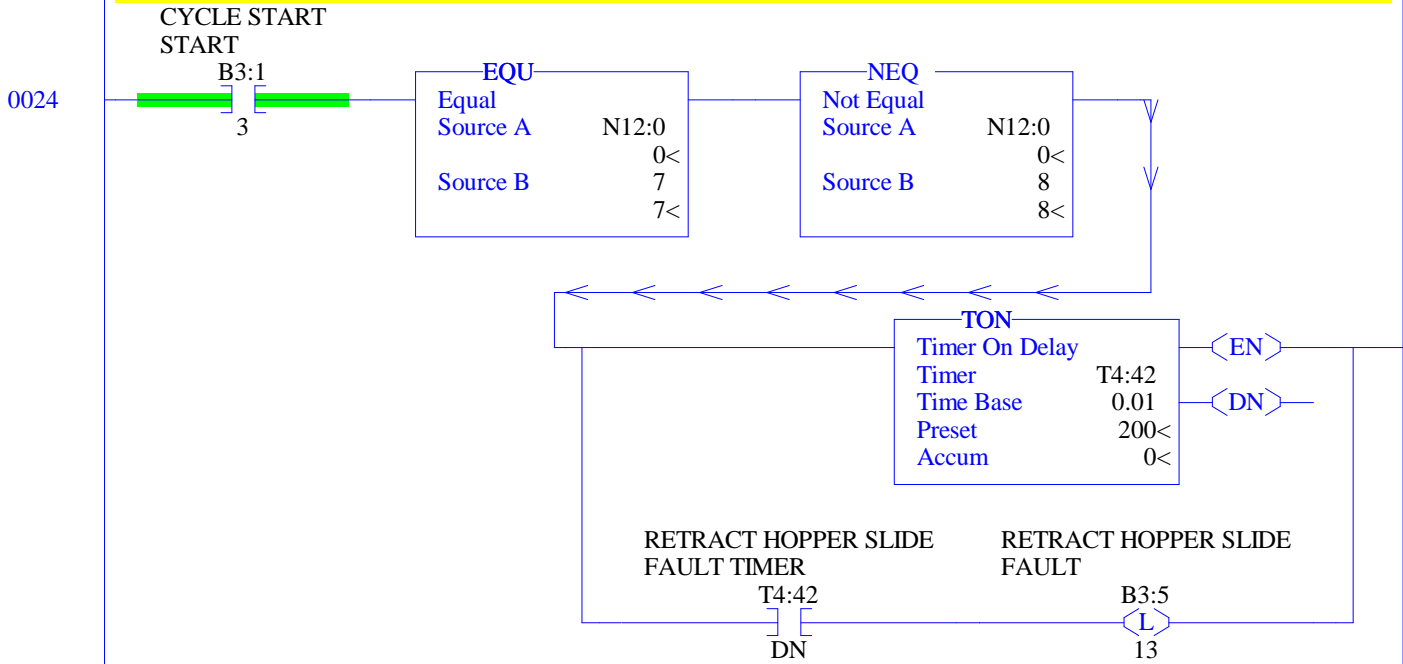




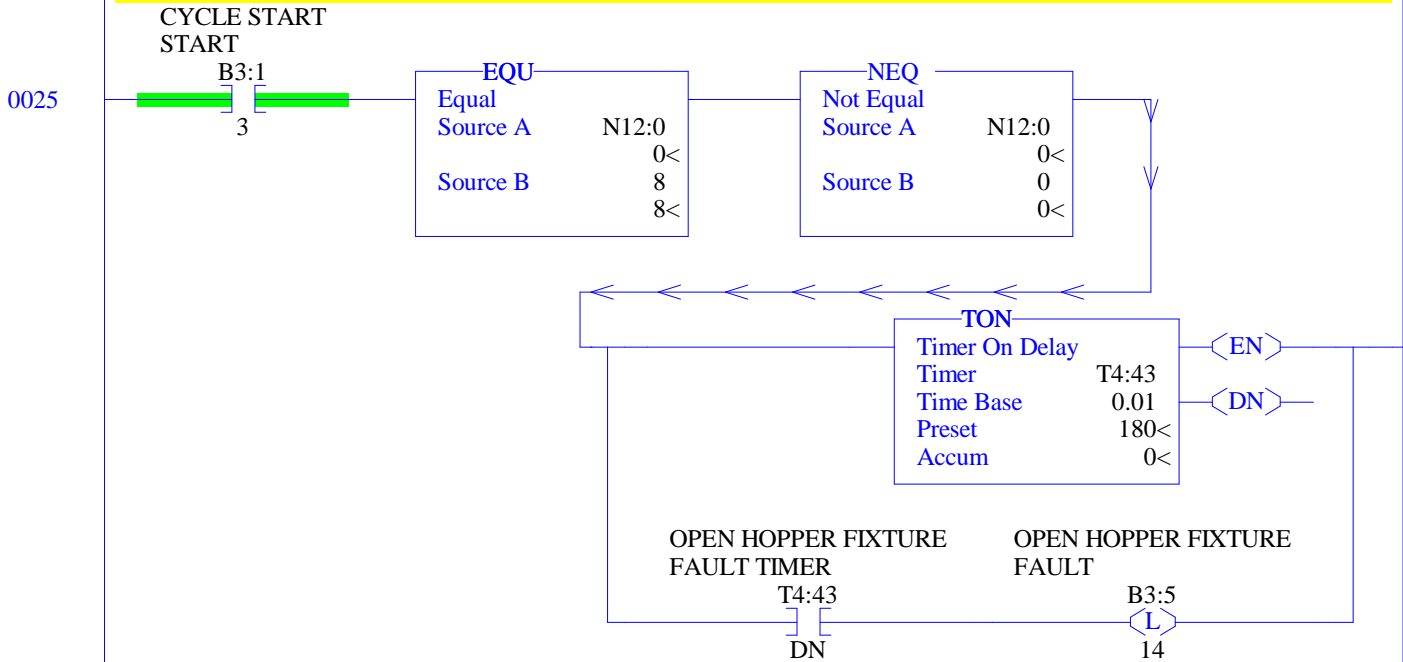
THIS RUNG ROTATES VACUUM HEAD TO THE PLATEN



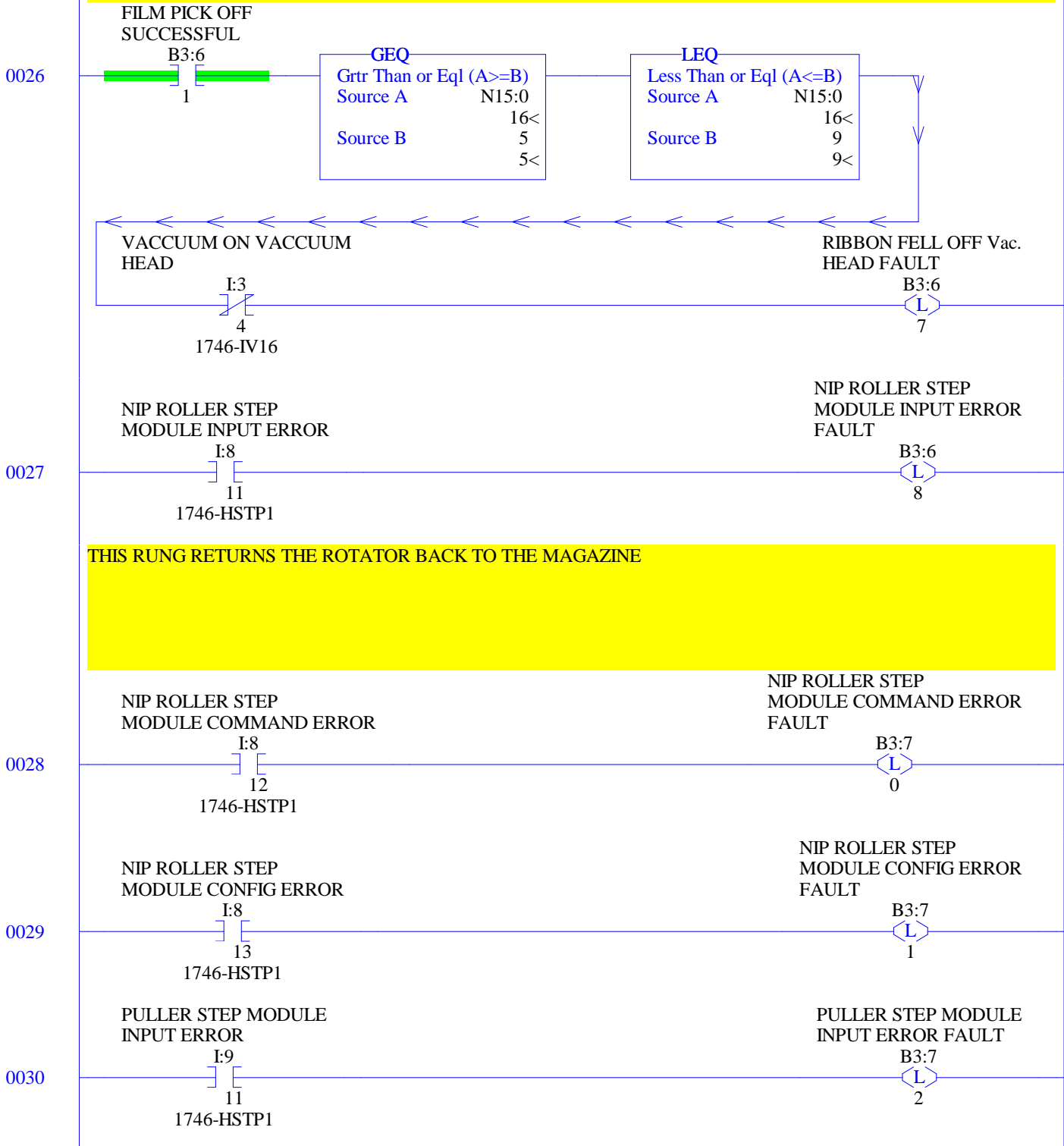
THIS RUNG EXTENDS THE VACUUM HEAD TO THE PLATEN

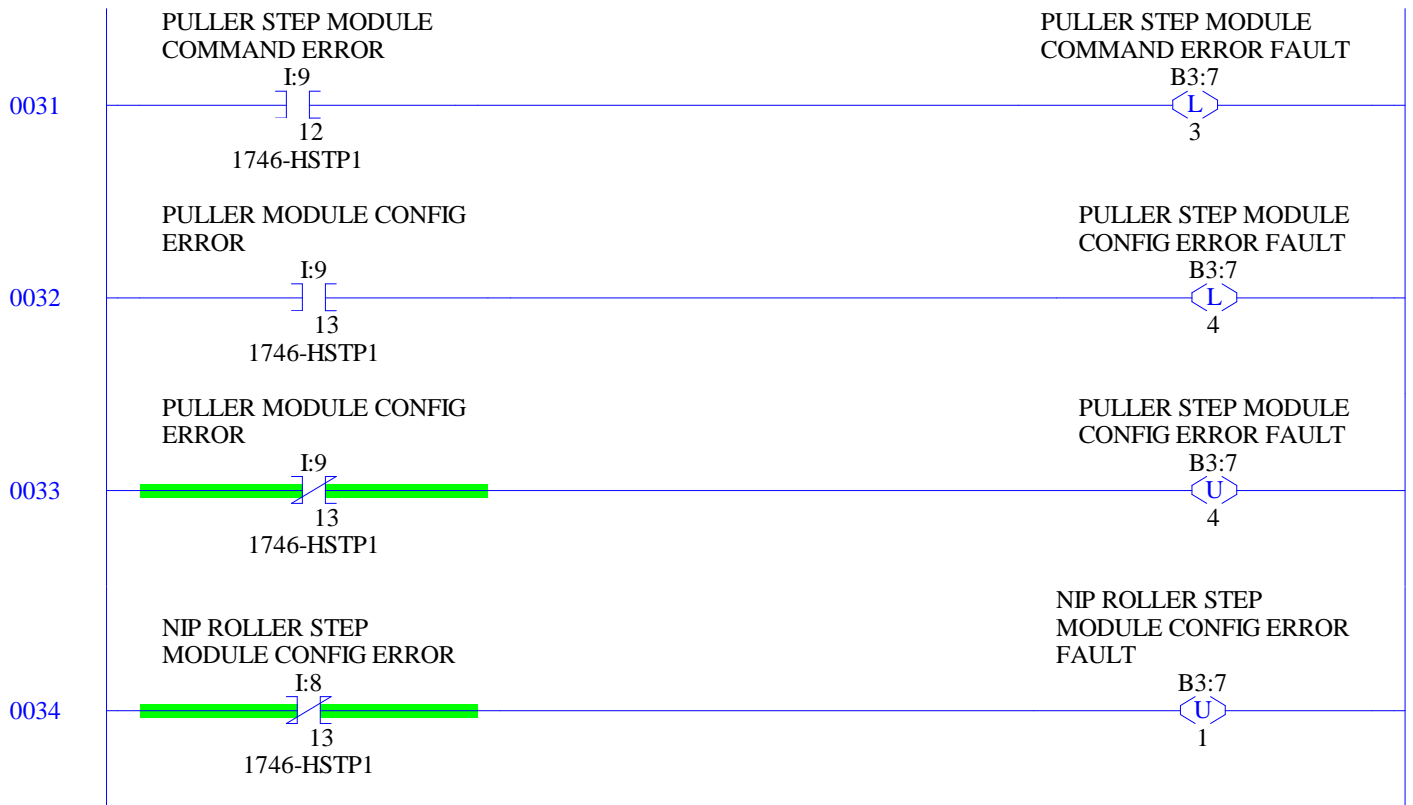


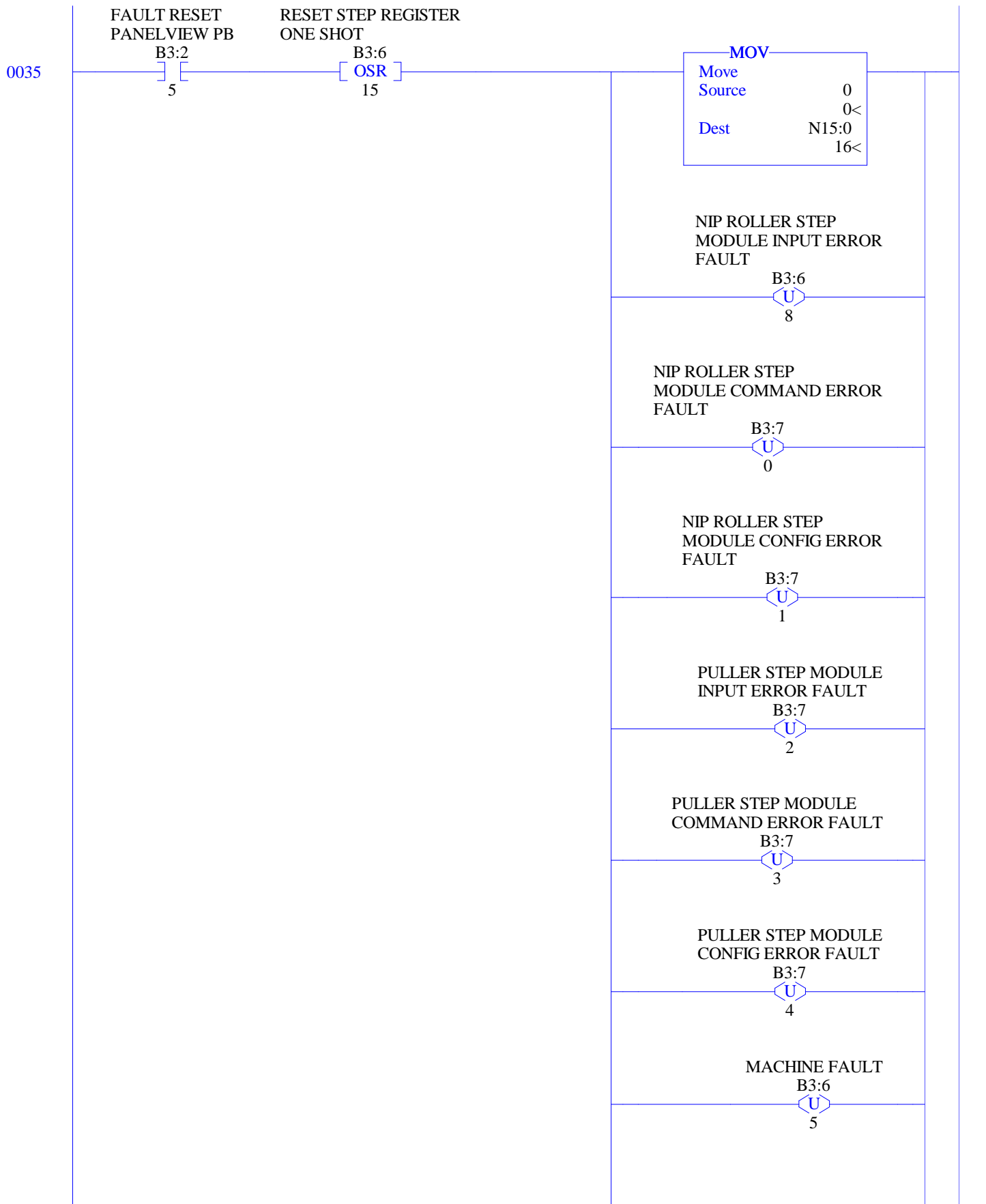
THIS RUNG EXTENDS TEH PLATEN TO THE VACUUM HEAD FOR FILM PLACEMENT



THIS RUNG CUTS THE VACUUM OFF OF THE ROTATOR HEAD AND CUTS IT ON THE PLATEN HEAD.







NIP ROLLER FEED
MATERIAL 1" FAULT

B3:4



2

GRIPPER FAULT

B3:4



3

MOVE COMPLETE
UNLATCH FAULT

B3:4



4

FILM PULL TO LENGTH
FAULT

B3:4



5

PICK OFF SUCCESSFUL
FAULT

B3:4



6

VACUUM HEAD NOT HOME
FAULT

B3:4



7

VACUUM HEAD ROTATE
TO PLATEN FAULT

B3:4



8

EXTEND PLATEN FAULT

B3:4



9

EXTEND VACUUM HEAD
TO PLATEN FAULT

B3:4



10

VACUUM ON PLATEN
FAULT

B3:4

11

RETRACT VACUUM HEAD
FAULT

B3:4

12

ROTATE VACUUM HEAD
HOME FAULT

B3:4

13

EXTEND RIBBON SEAL
HEAD FAULT

B3:4

14

RETRACT RIBBON SEAL
HEAD FAULT

B3:4

15

RETRACT PLATEN FAULT

B3:5

1

HOPPER FIXTURE CLOSE
FAULT

B3:5

2

EXTEND HOPPER SLIDE
FAULT

B3:5

3

EXTEND MAIN SLIDE
FAULT

B3:5

4

RAISE HOPPER PLATEN
FAULT

B3:5



5

EXTEND HOPPER SEAL
HEAD FAULT

B3:5



6

RETRACT HOPPER SEAL
HEAD FAULT

B3:5



7

RETRACT HOPPER
PLATEN FAULT

B3:5



11

RETRACT MAIN SLIDE
FAULT

B3:5



12

RETRACT HOPPER SLIDE
FAULT

B3:5



13

OPEN HOPPER FIXTURE
FAULT

B3:5



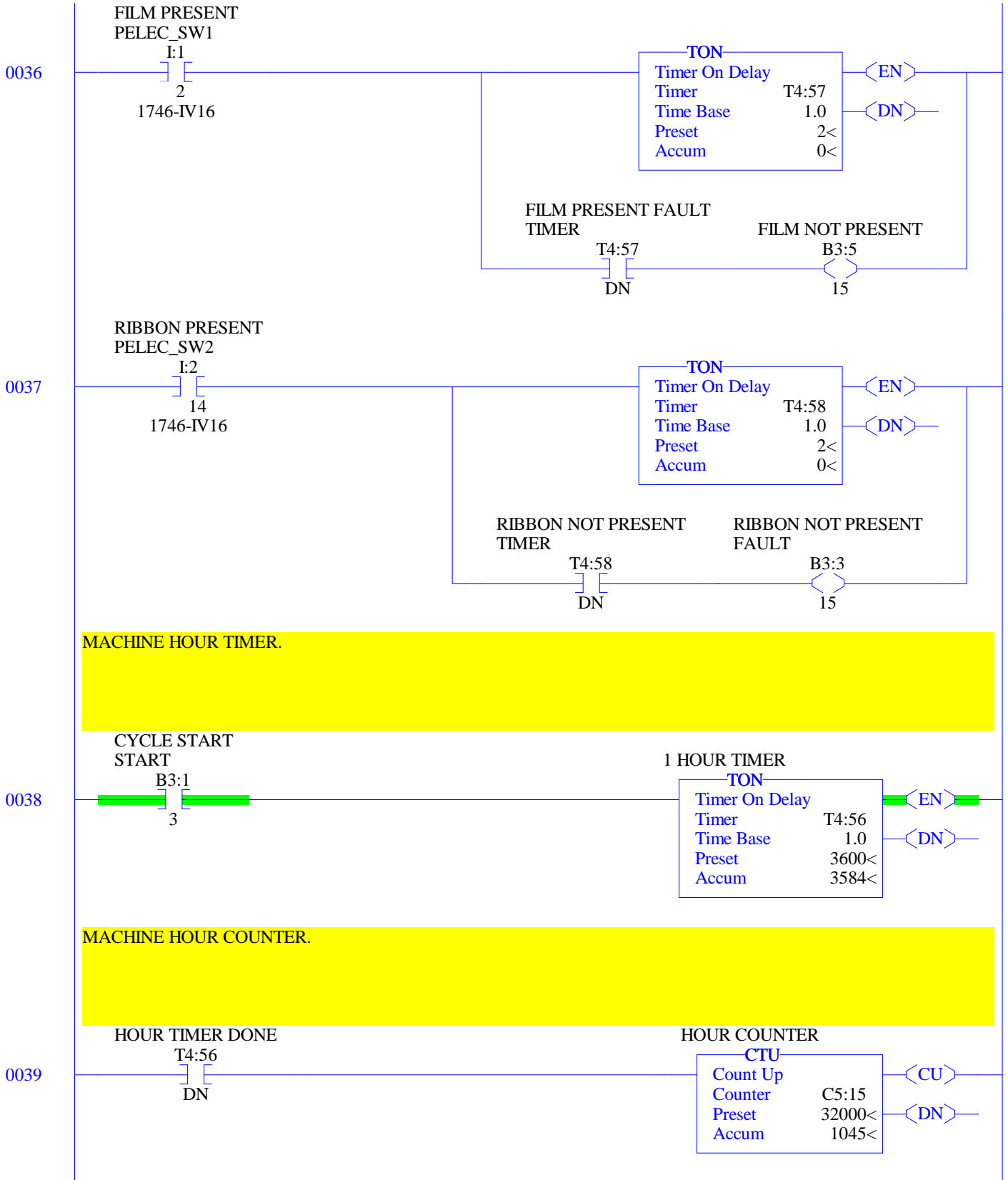
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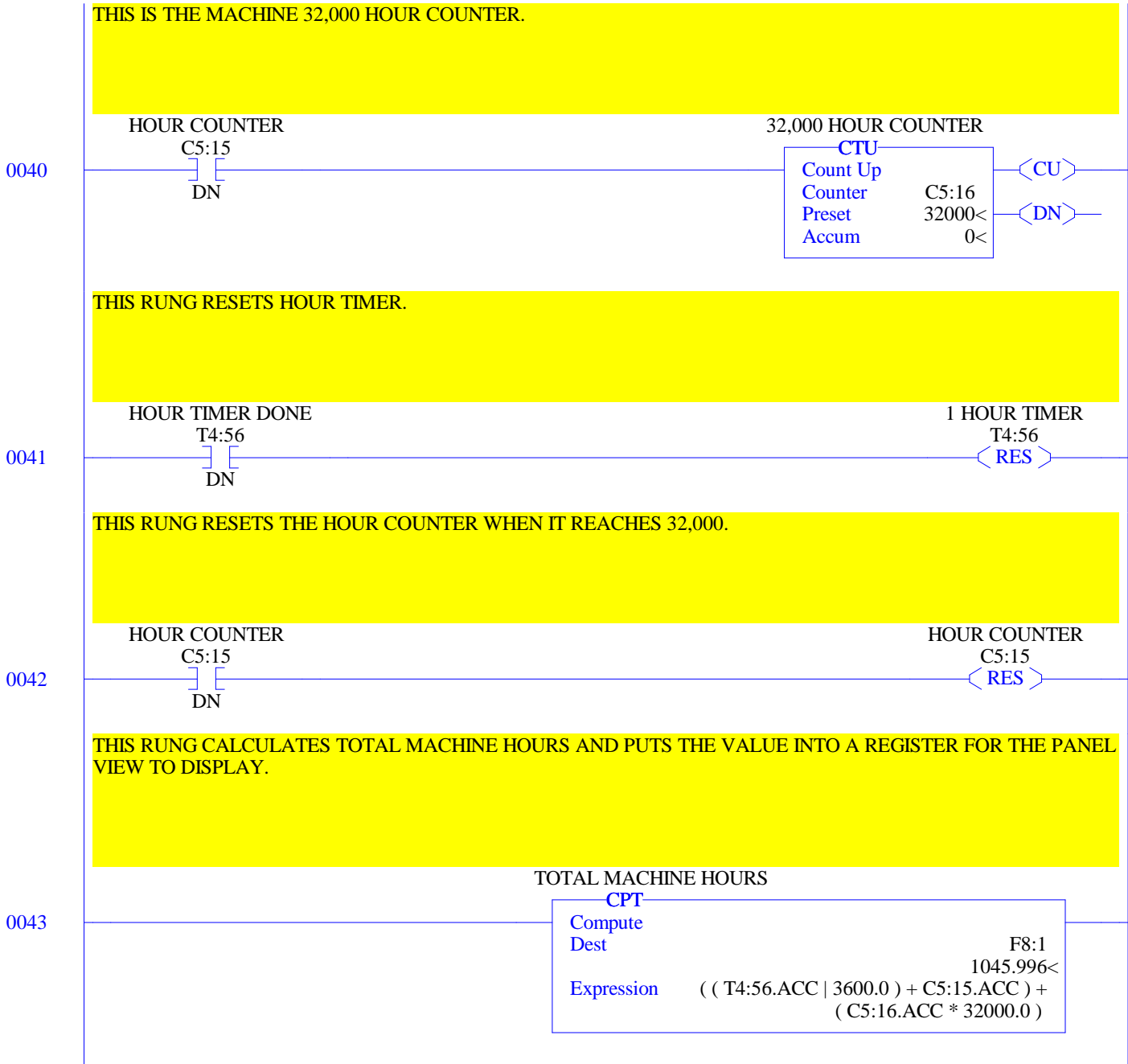
RIBBON FELL OFF Vac.
HEAD FAULT

B3:6



7





0044

RIBBON NOT PRESENT
FAULT

B3:3
15

MACHINE FAULT

B3:6
5

NIP ROLLER STEP
MODULE INPUT ERROR
FAULT

B3:6
8

NIP ROLLER STEP
MODULE COMMAND ERROR
FAULT

B3:7
0

PULLER STEP MODULE
INPUT ERROR FAULT

B3:7
2

PULLER STEP MODULE
COMMAND ERROR FAULT

B3:7
3

RETRACT PLATEN FAULT

B3:5
1

RIBBON FELL OFF Vac.
HEAD FAULT

B3:6
7

HOPPER FIXTURE CLOSE
FAULT

B3:5
2

EXTEND HOPPER SLIDE
FAULT

B3:5
3

EXTEND MAIN SLIDE
FAULT

B3:5
] [
4

RAISE HOPPER PLATEN
FAULT

B3:5
] [
5

EXTEND HOPPER SEAL
HEAD FAULT

B3:5
] [
6

RETRACT HOPPER SEAL
HEAD FAULT

B3:5
] [
7

RETRACT HOPPER
PLATEN FAULT

B3:5
] [
11

RETRACT MAIN SLIDE
FAULT

B3:5
] [
12

RETRACT HOPPER SLIDE
FAULT

B3:5
] [
13

OPEN HOPPER FIXTURE
FAULT

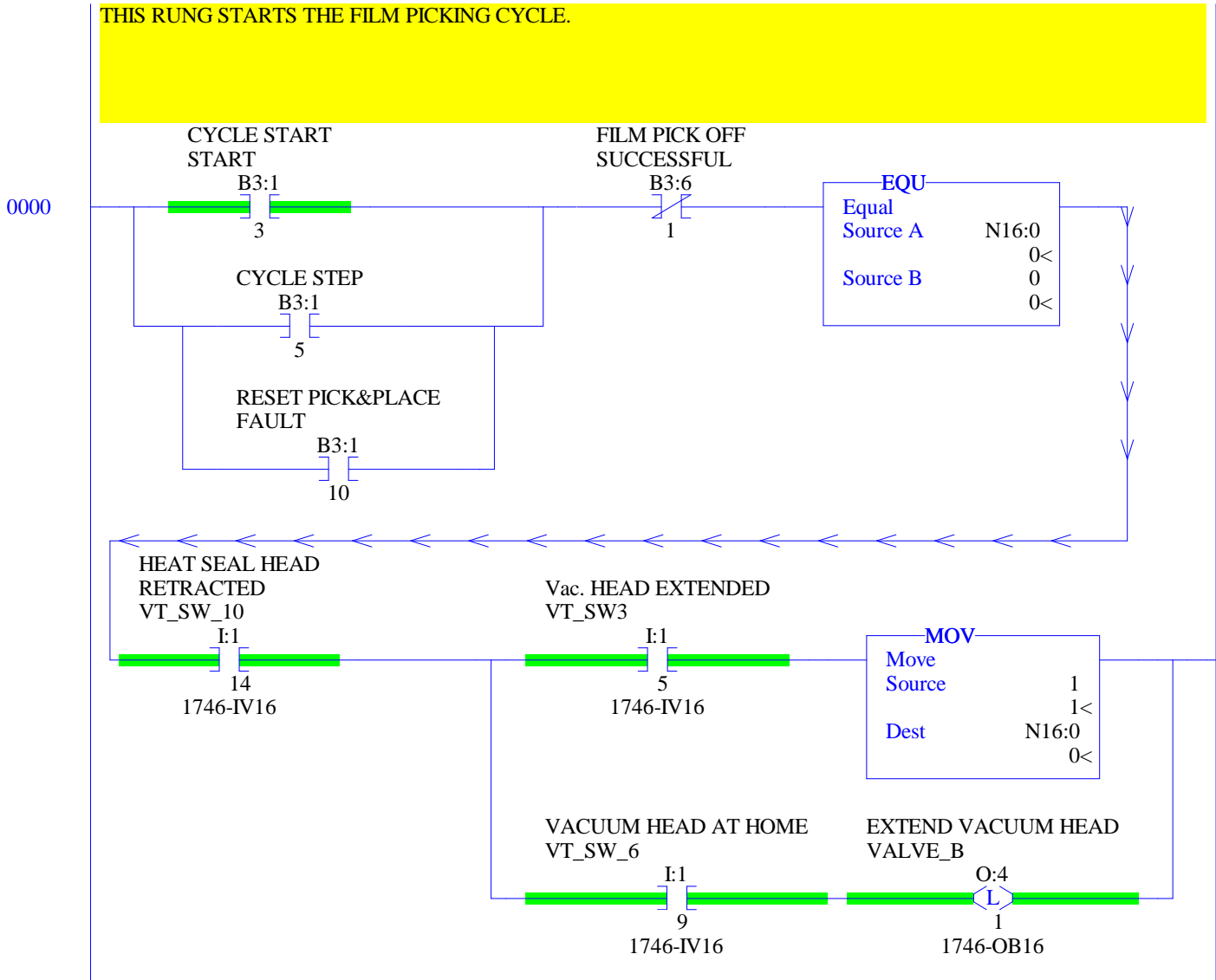
B3:5
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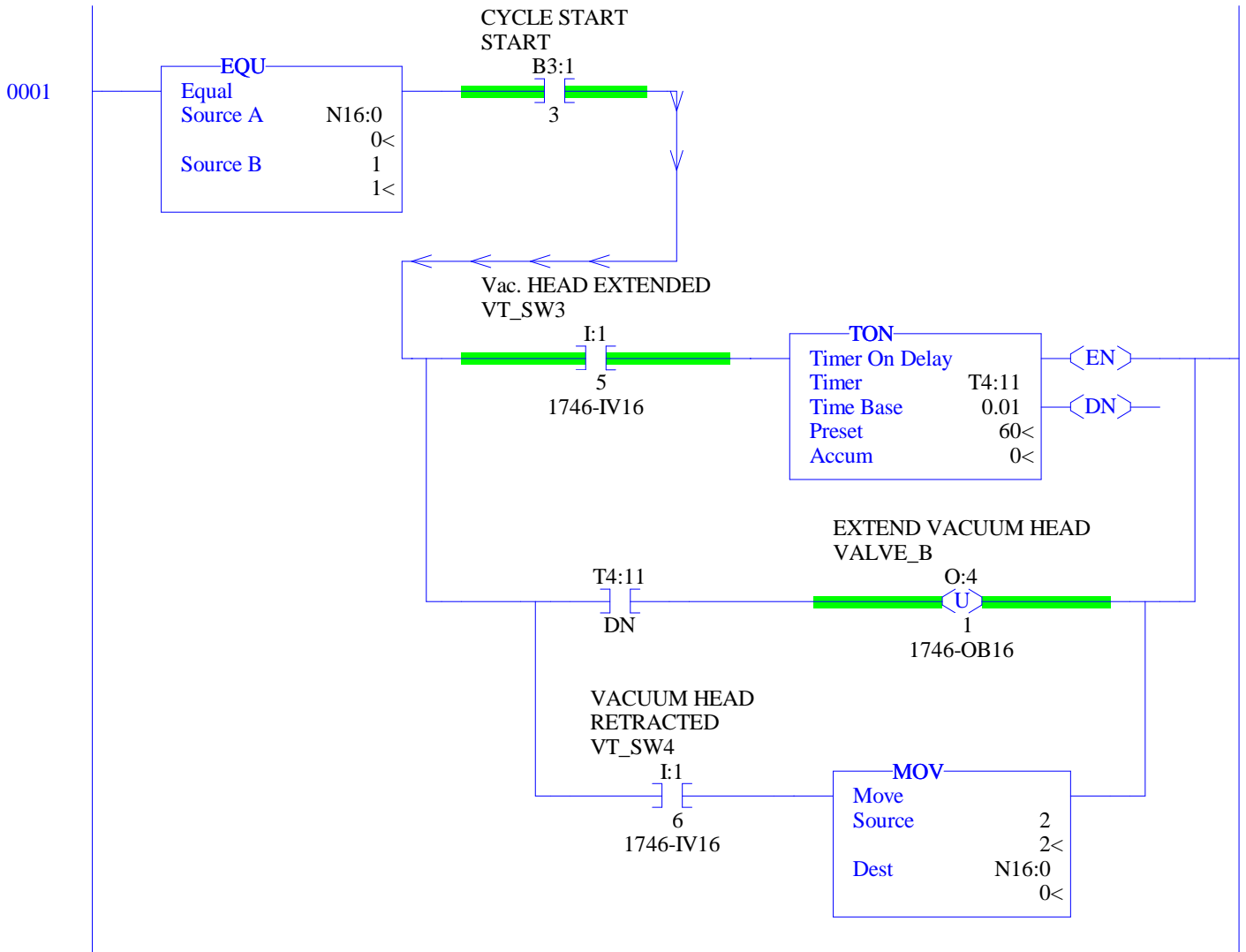
FILM NOT PRESENT

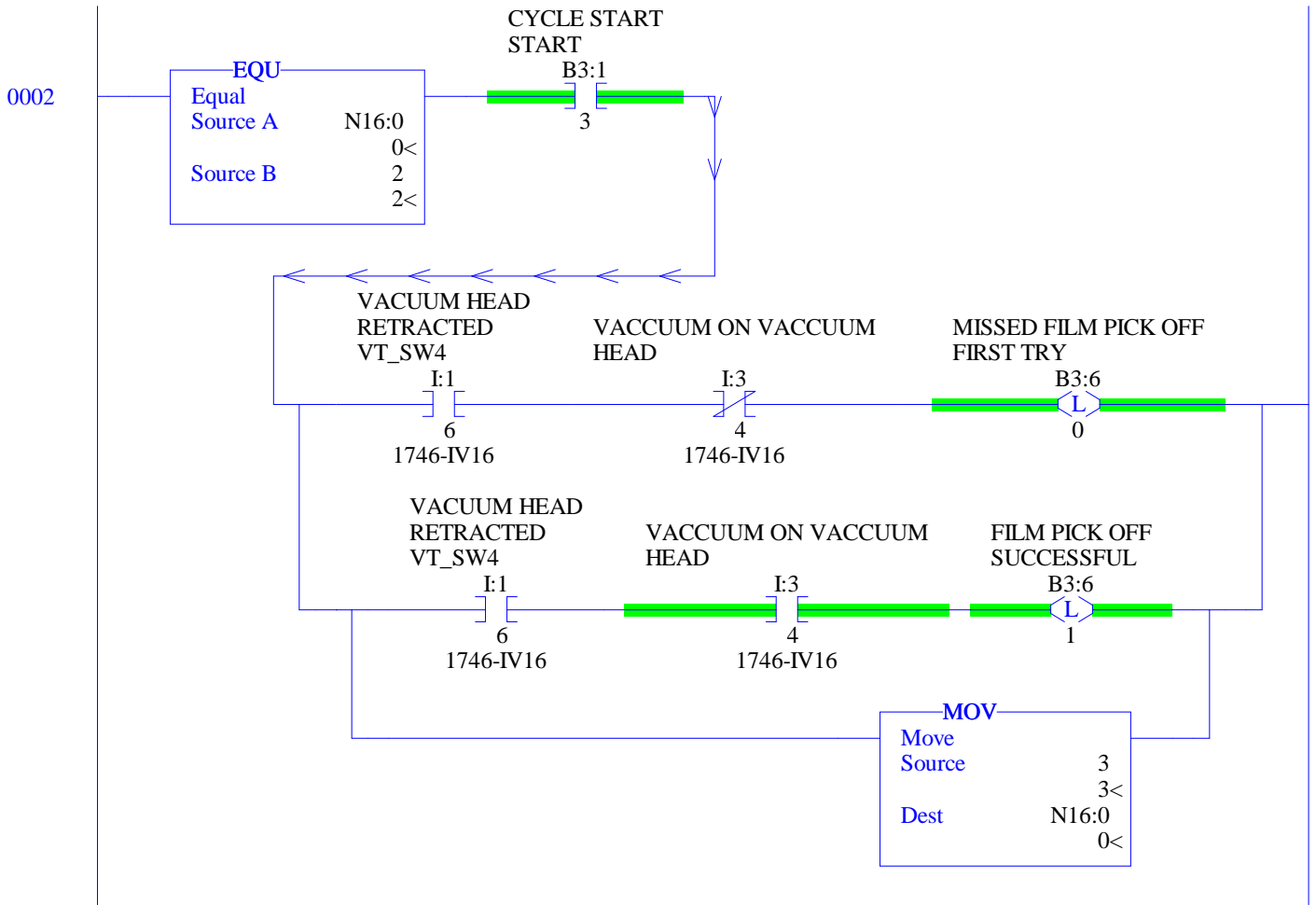
B3:5
] [
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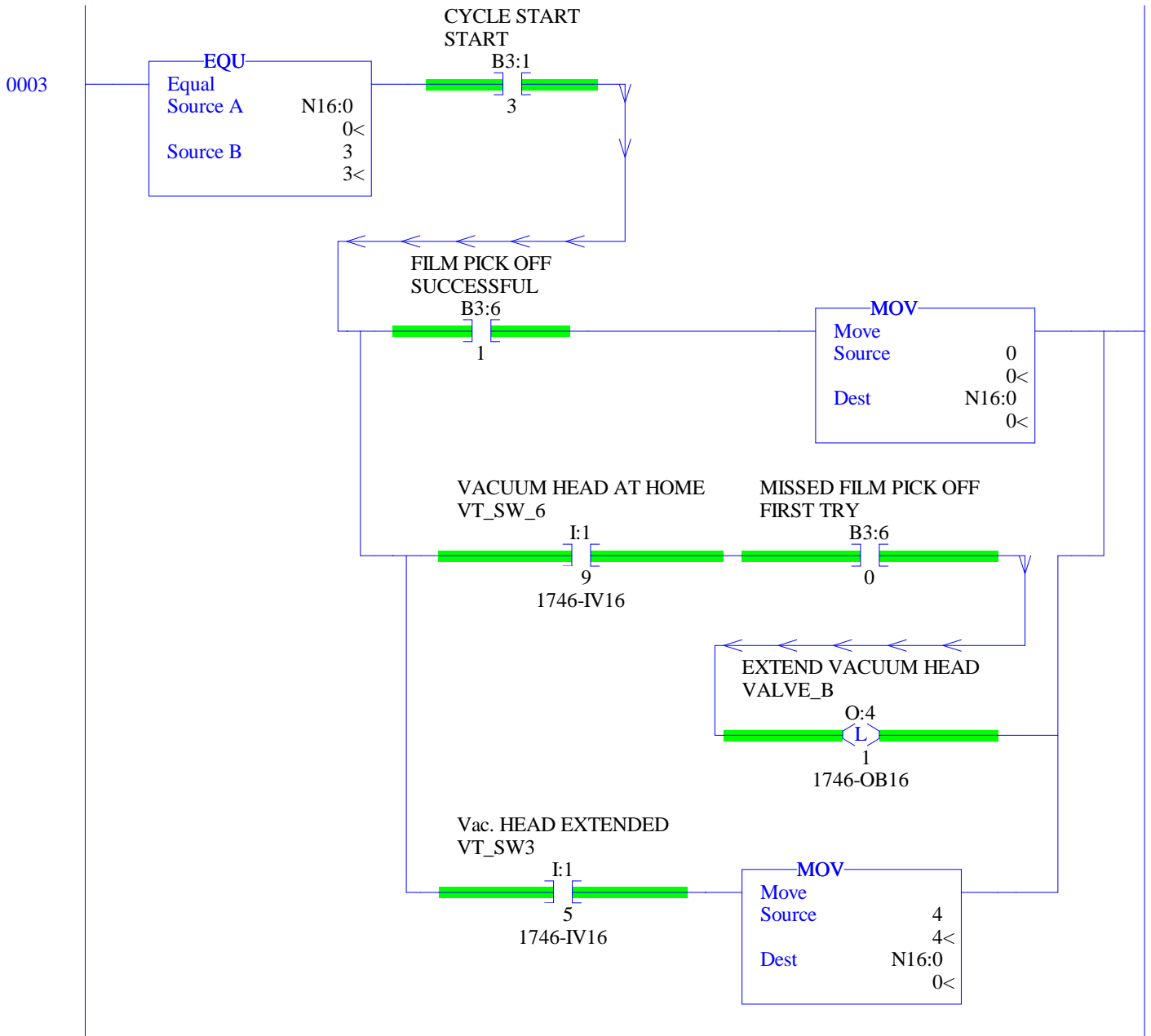
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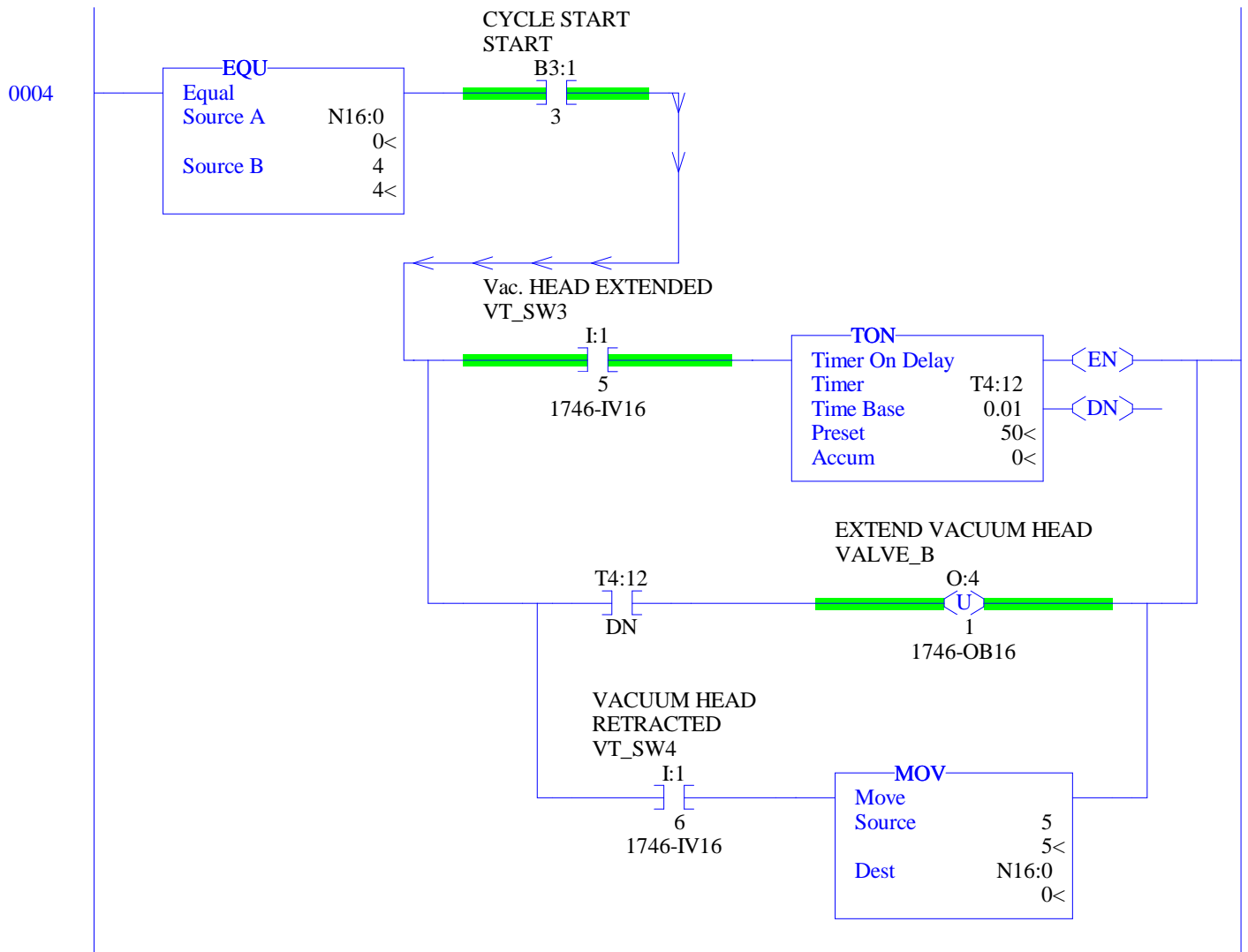
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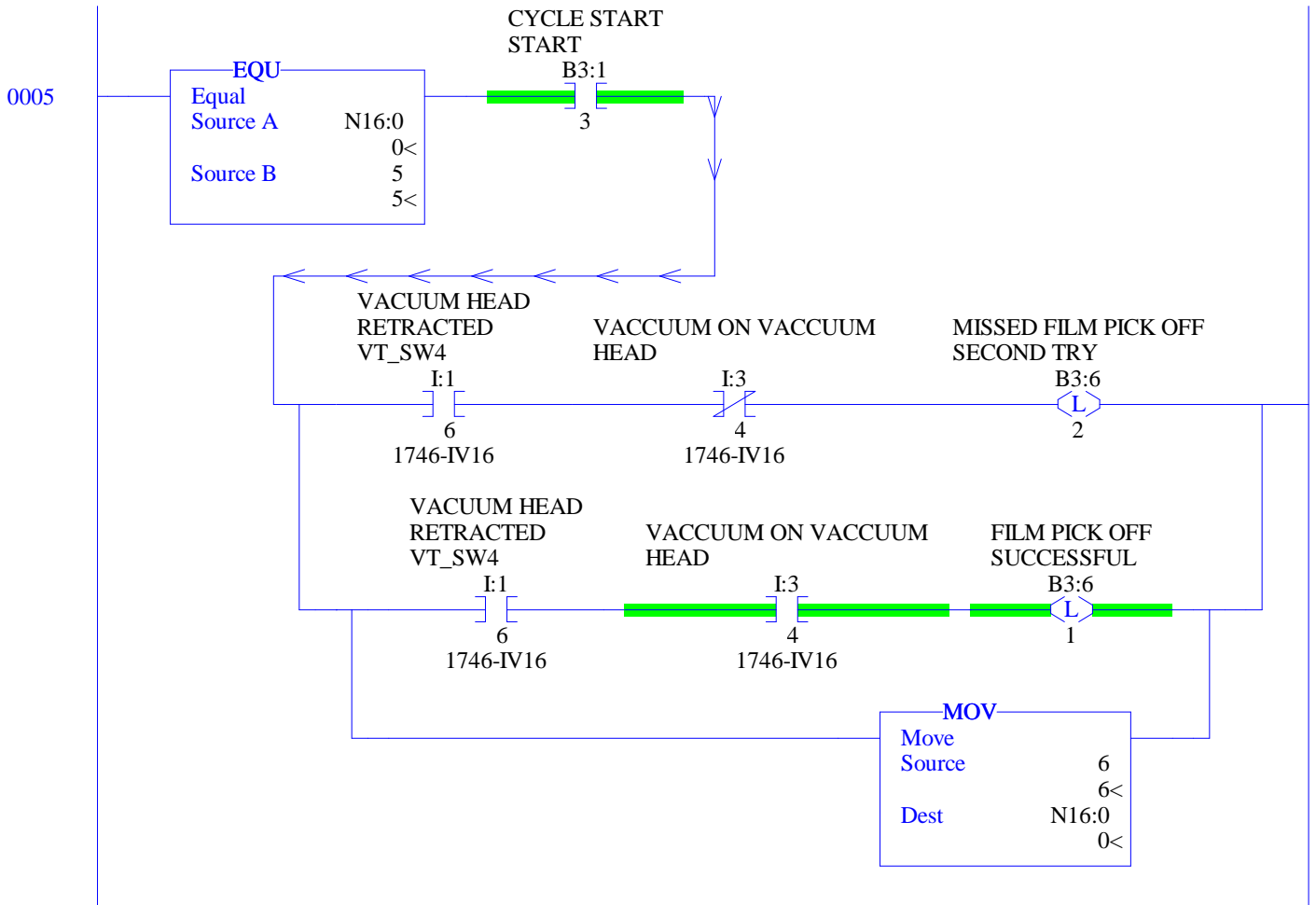


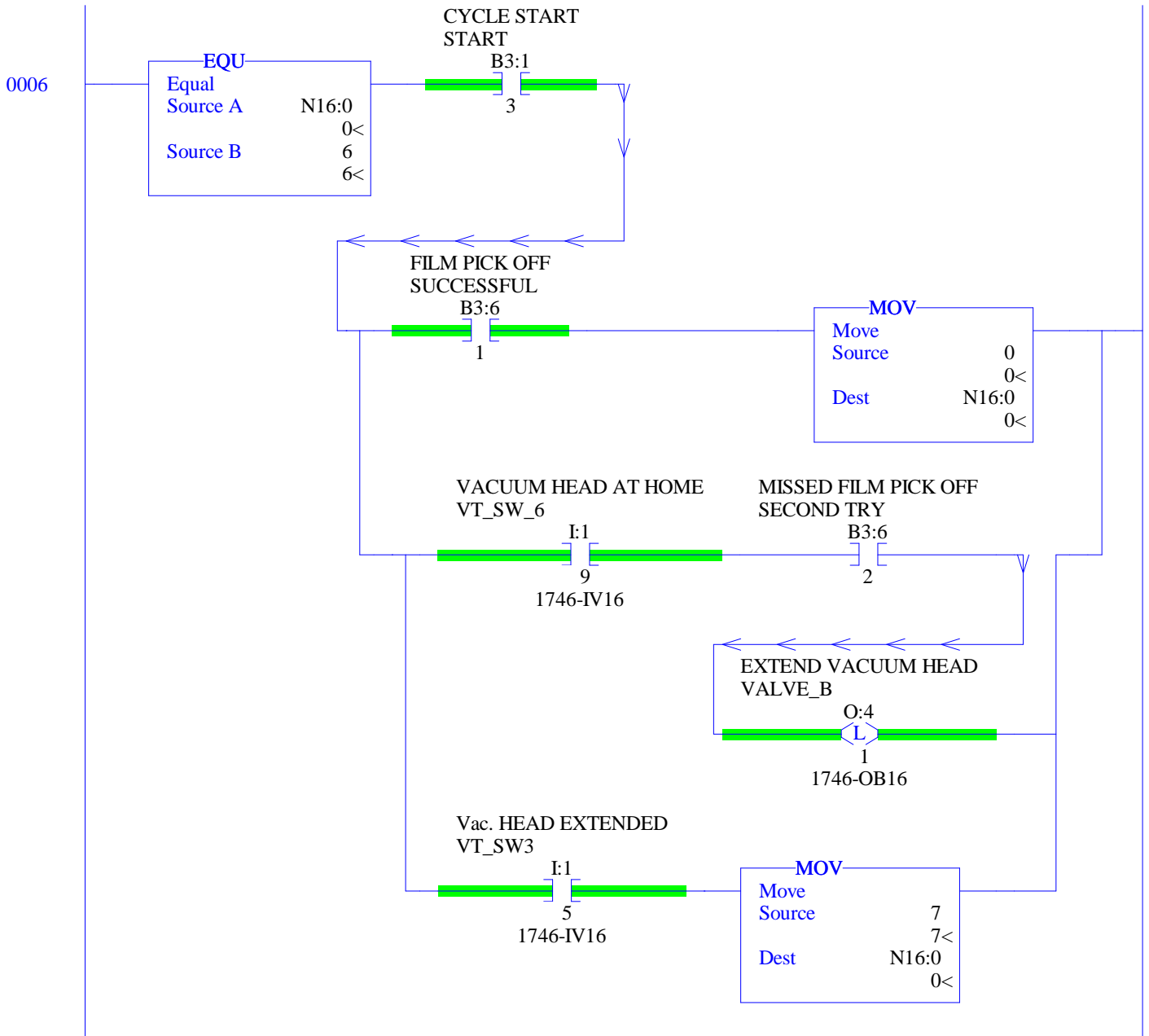


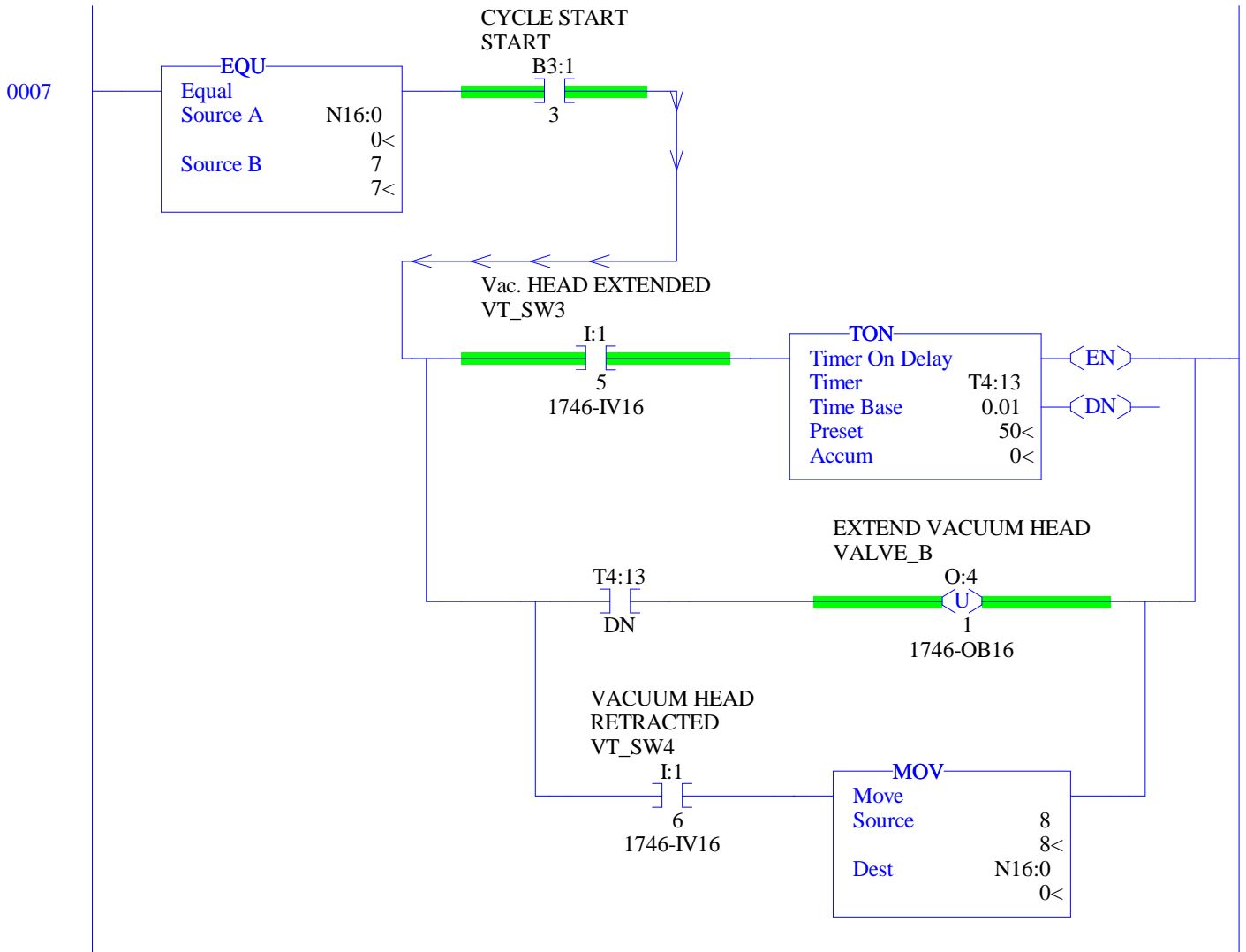


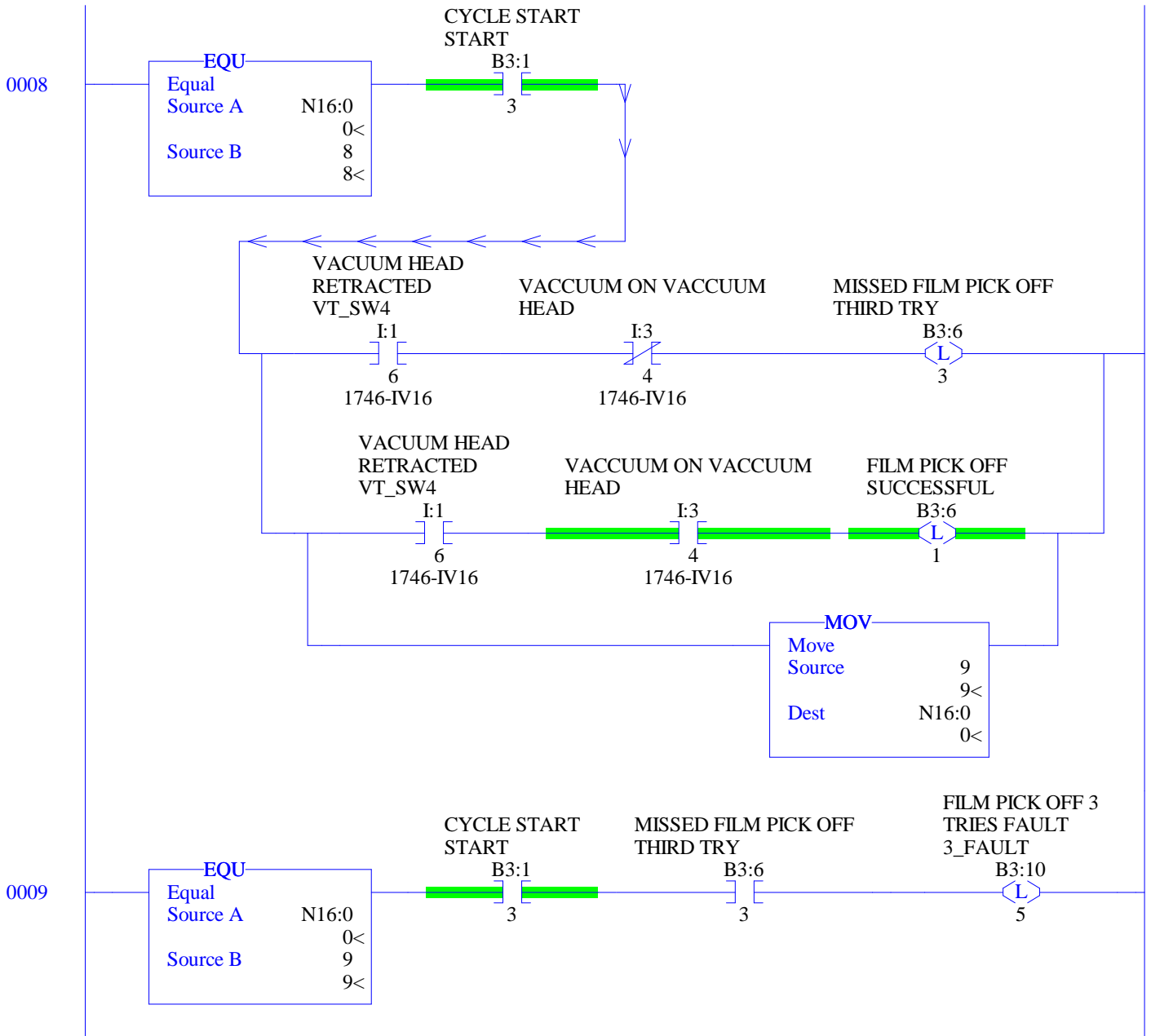


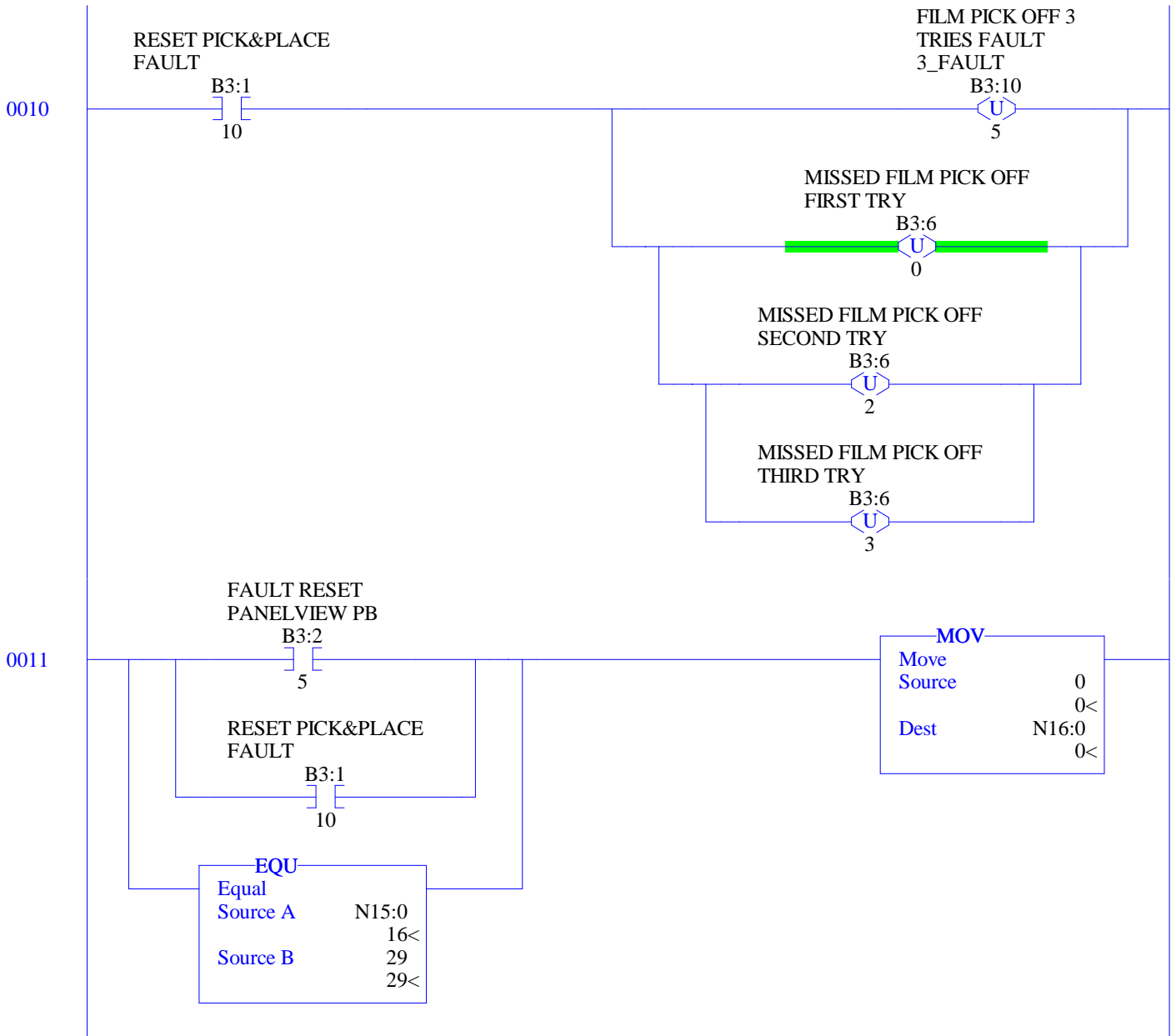


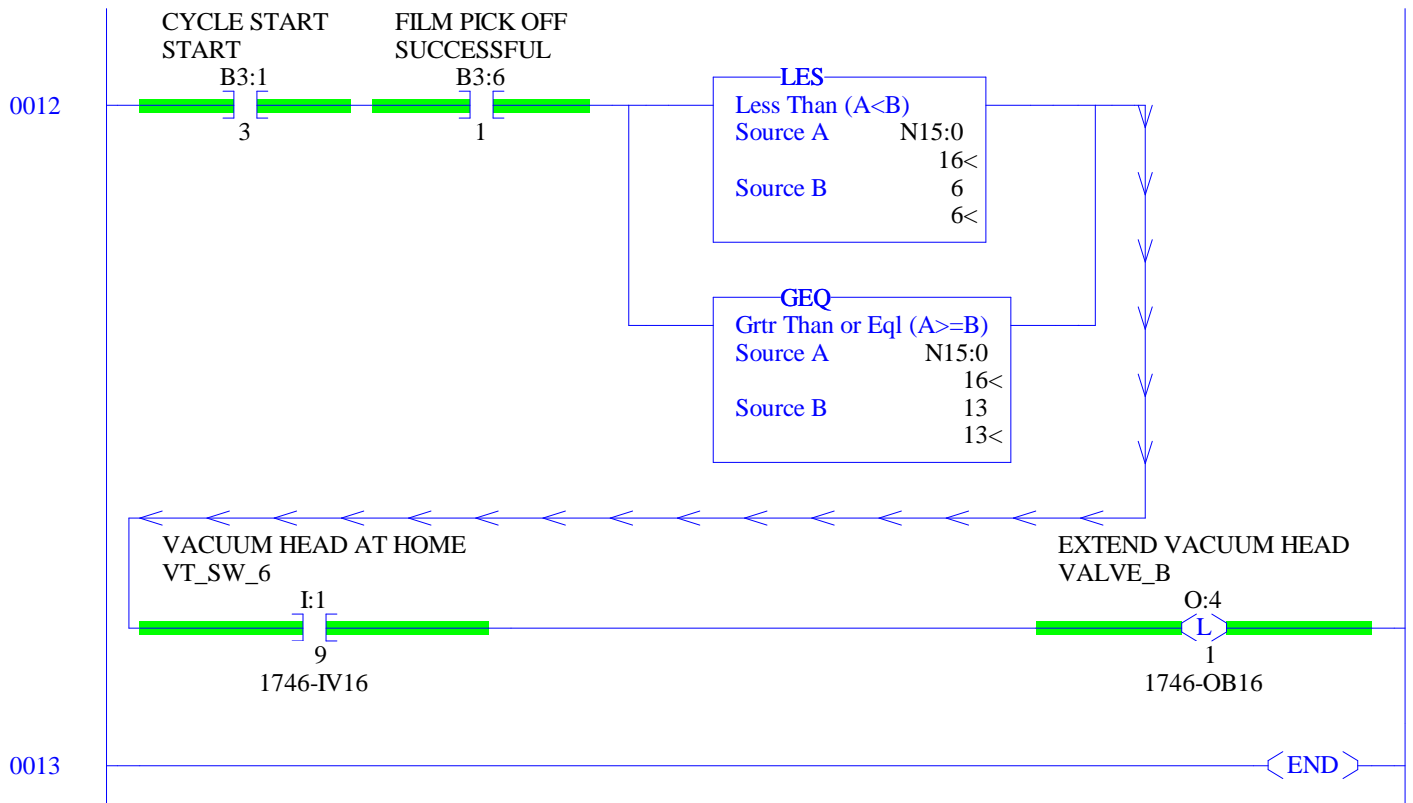


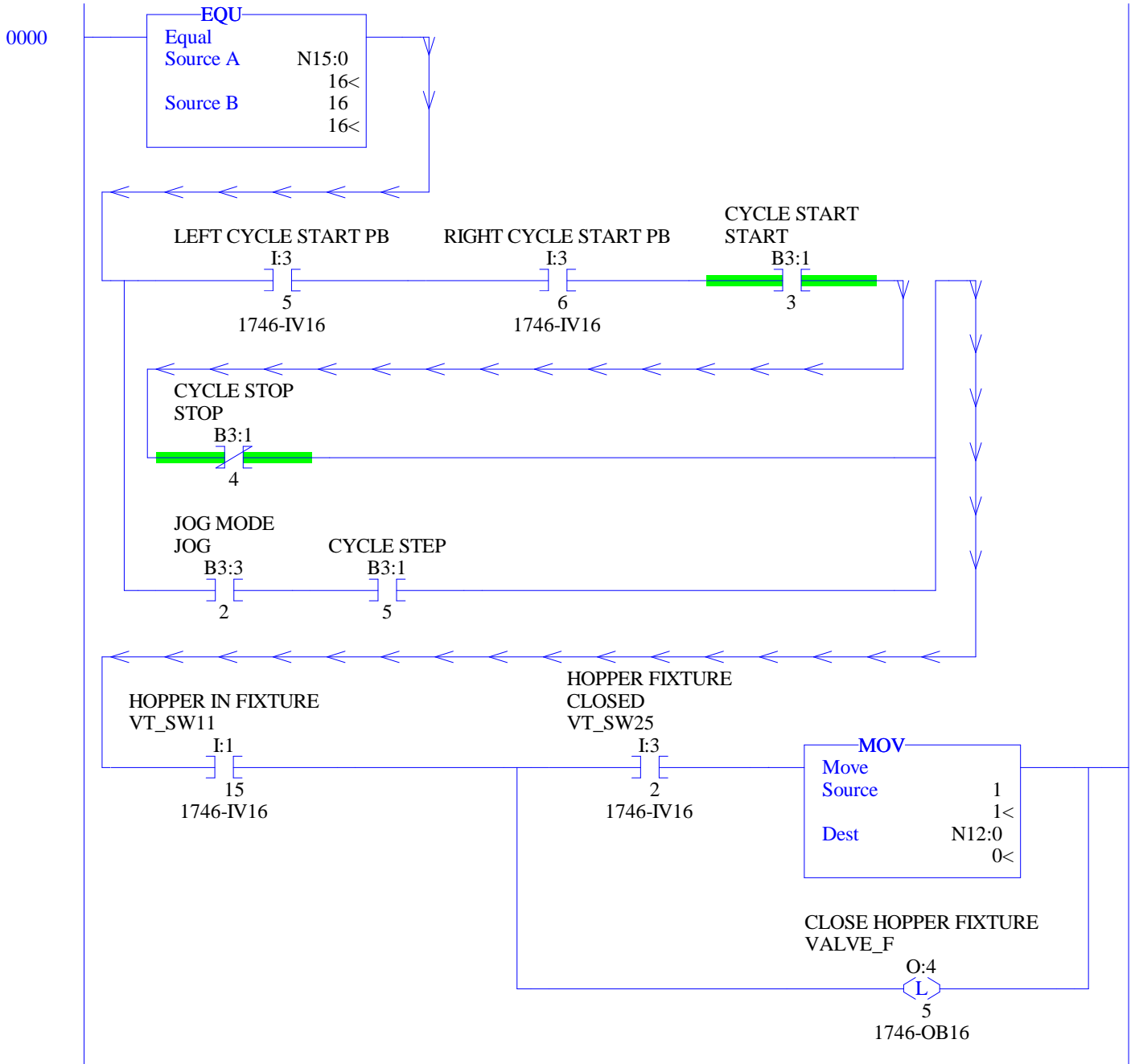


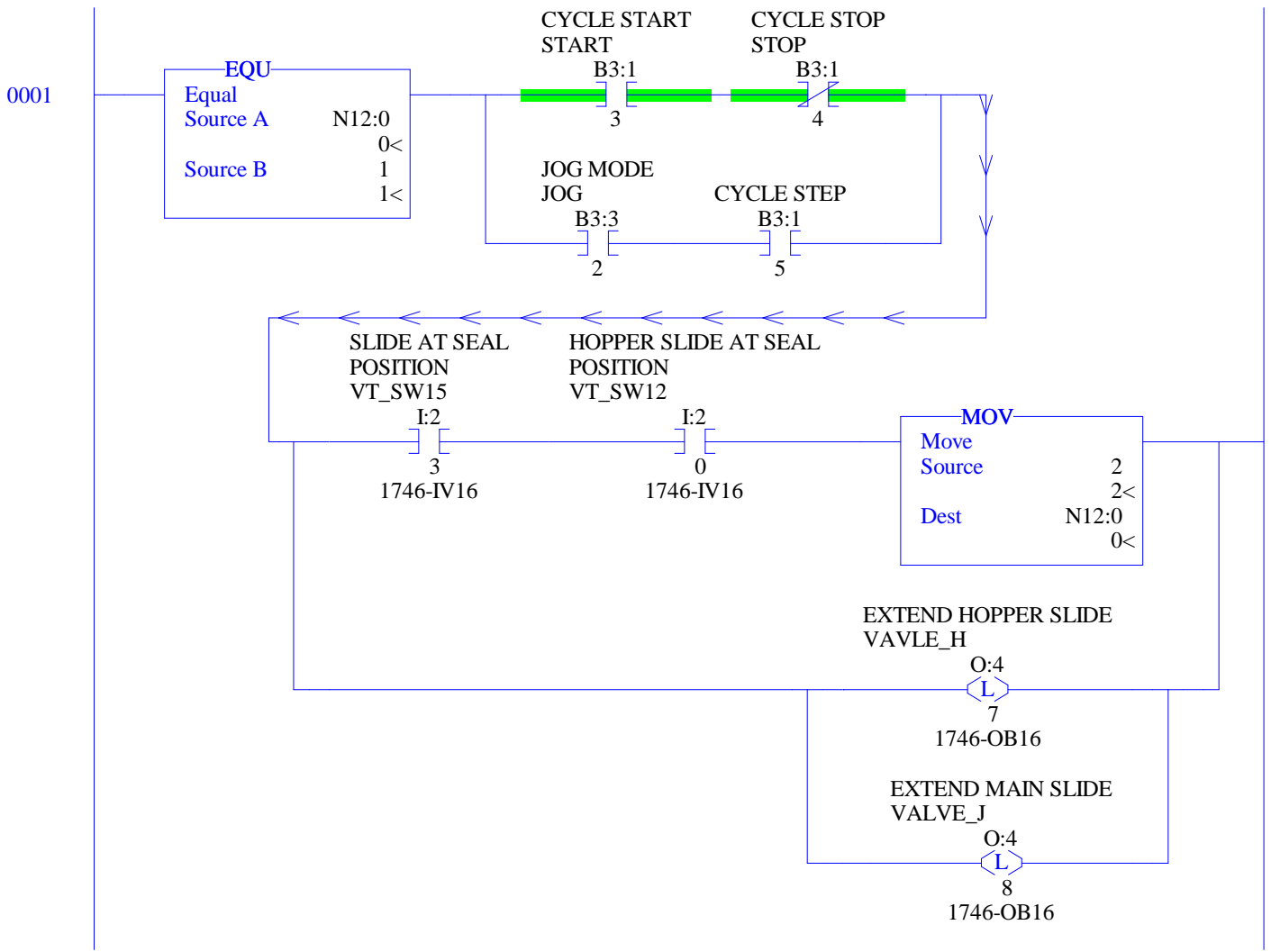


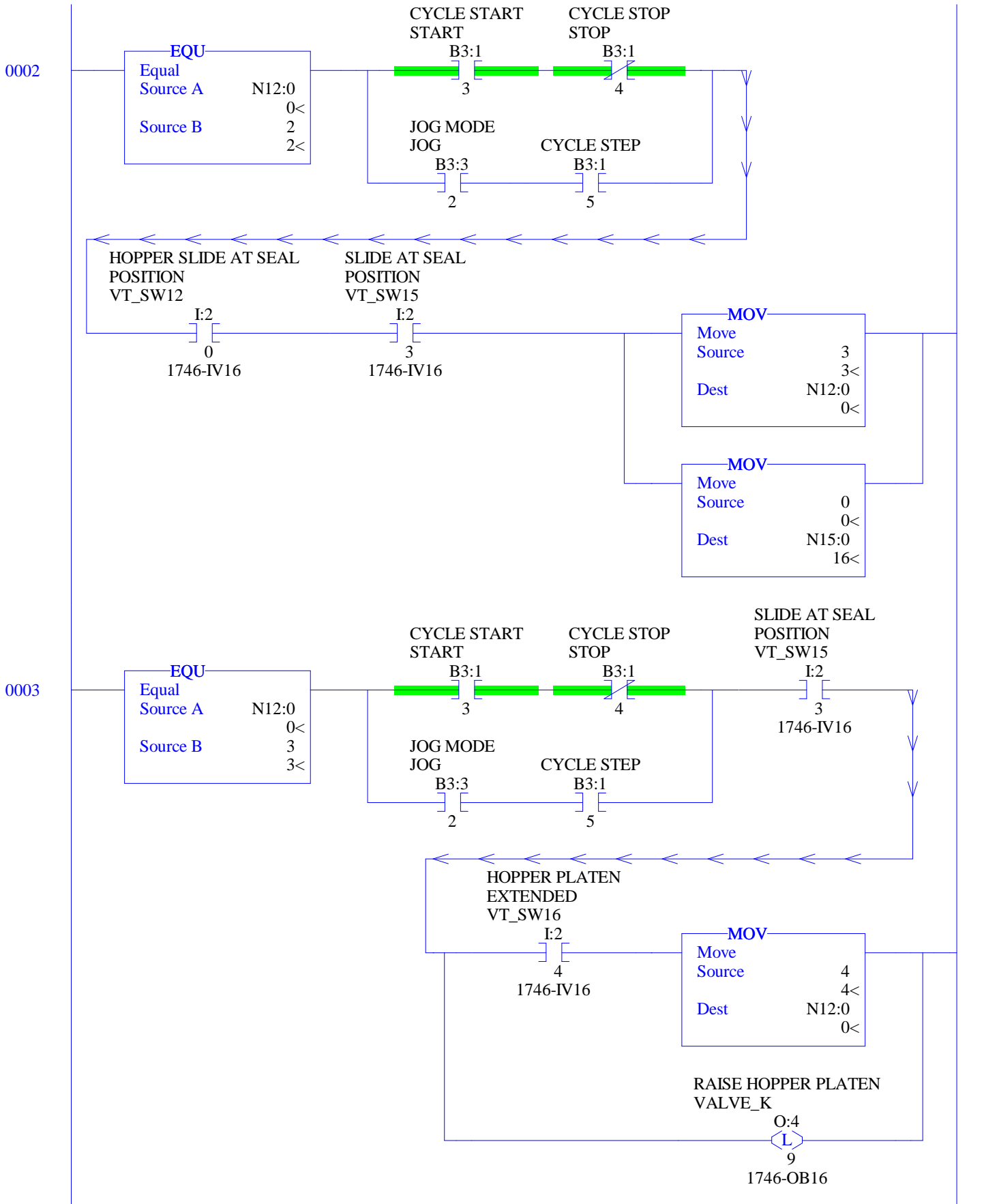


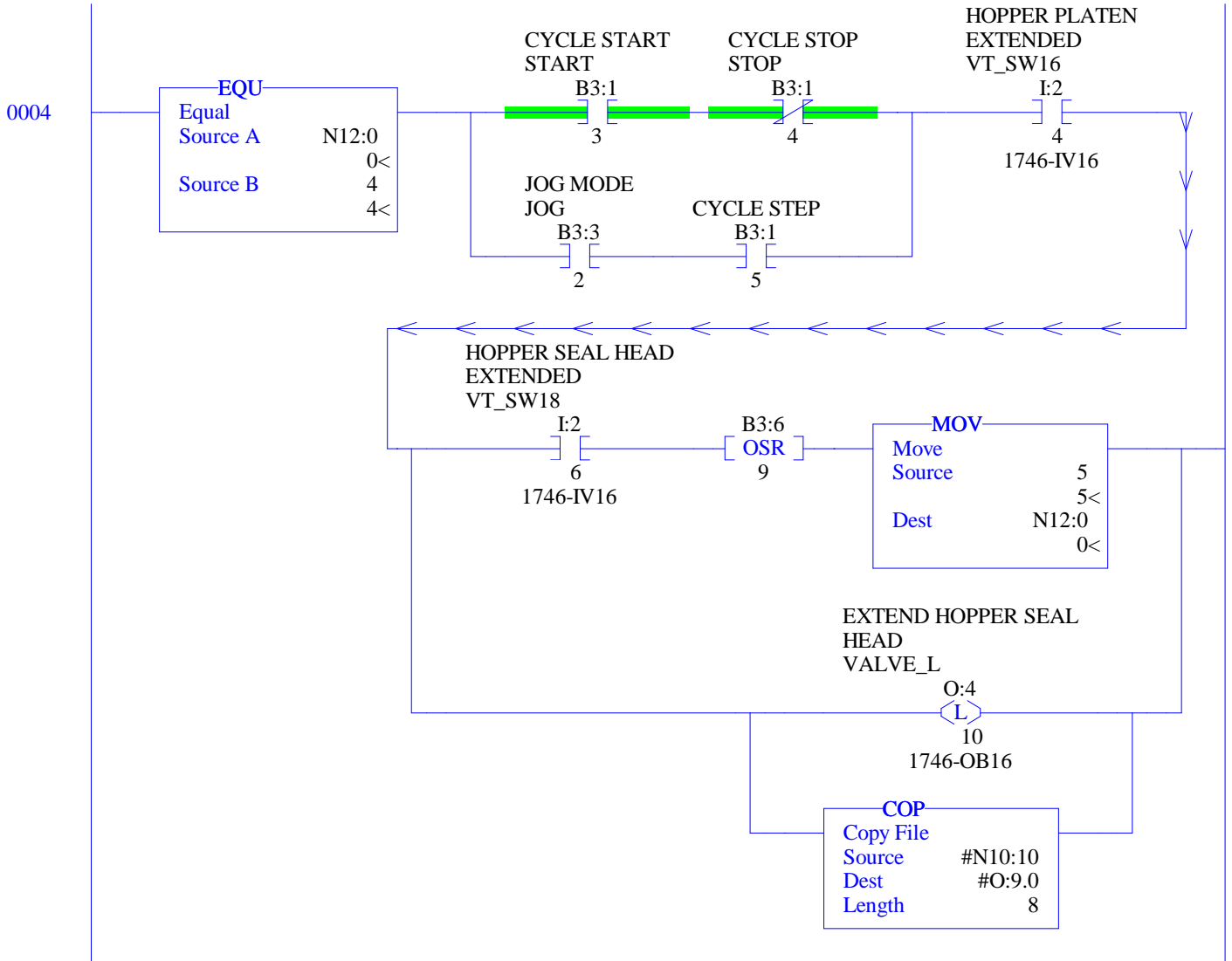




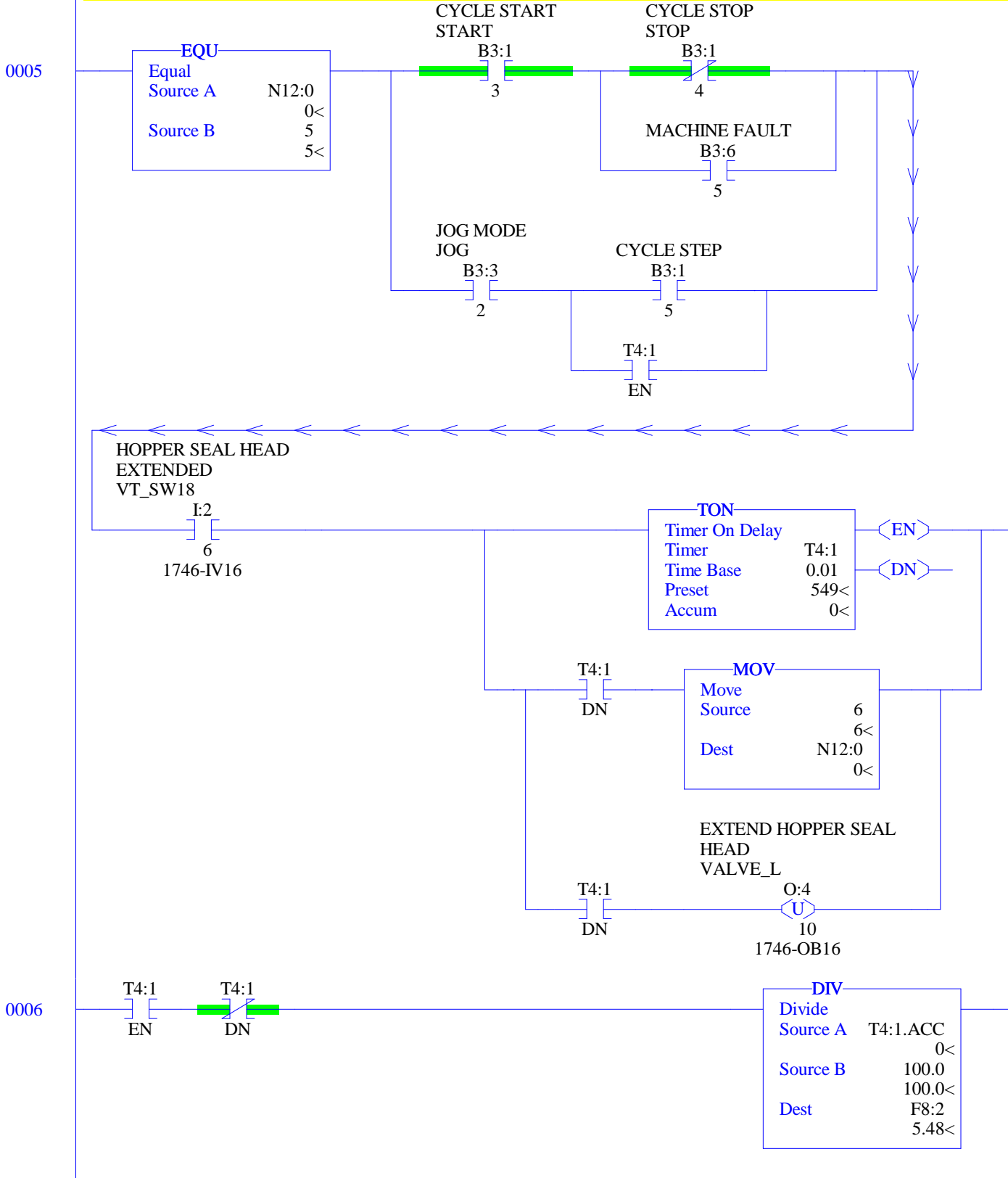


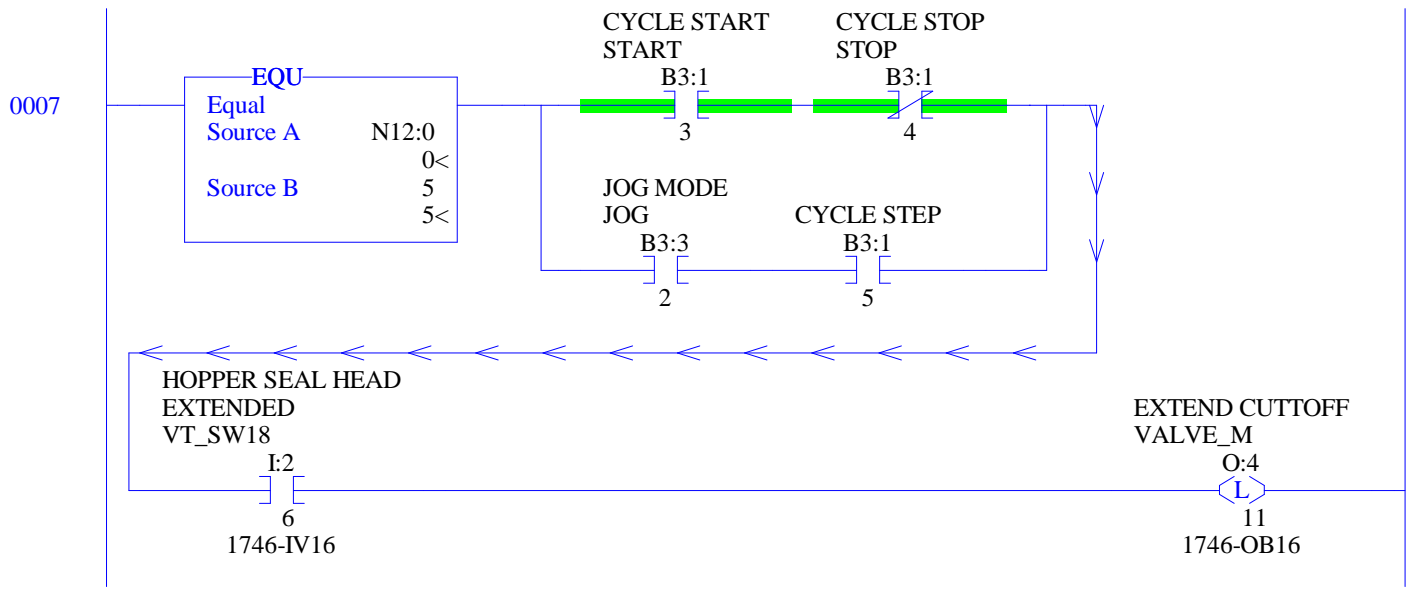


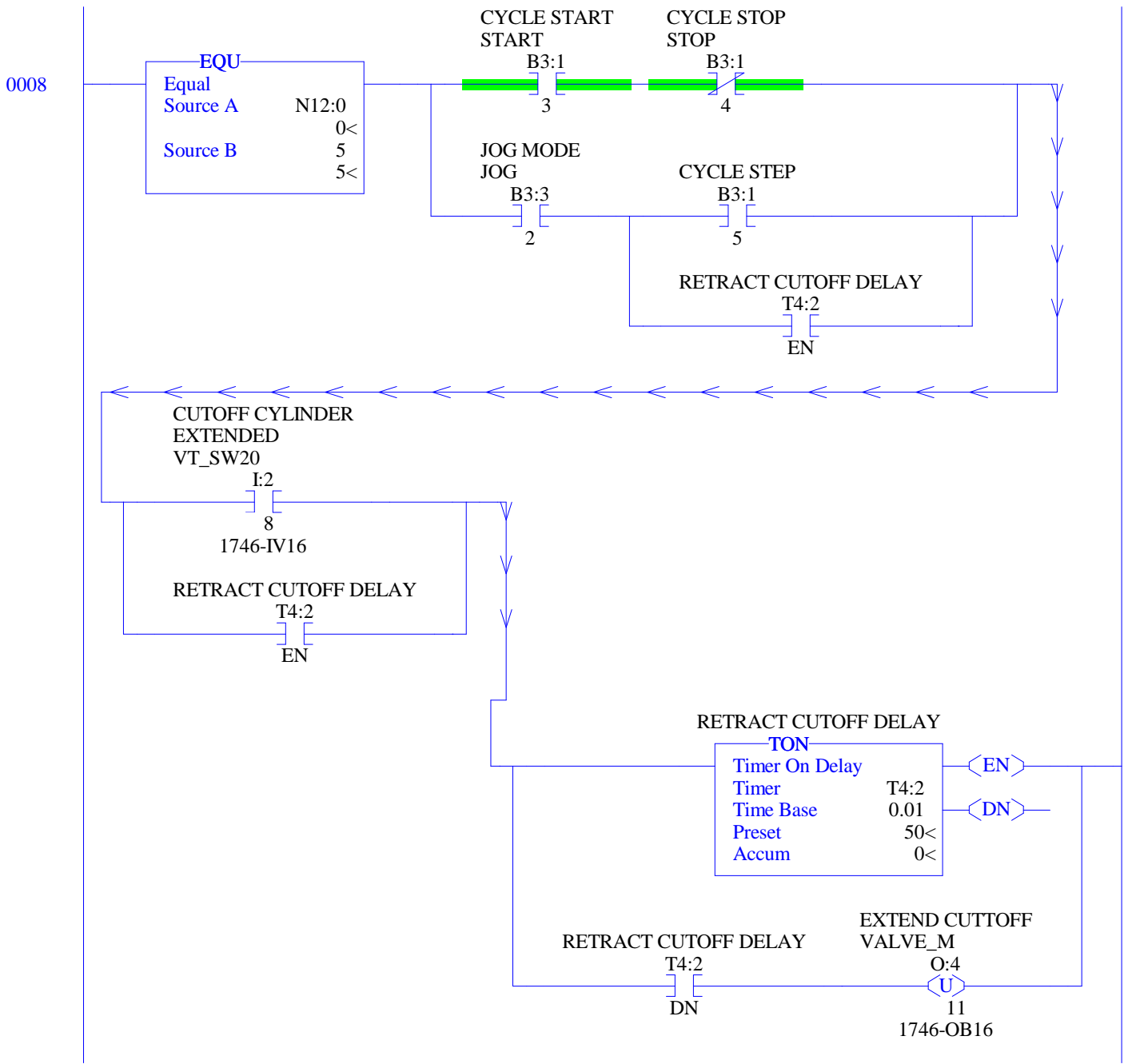




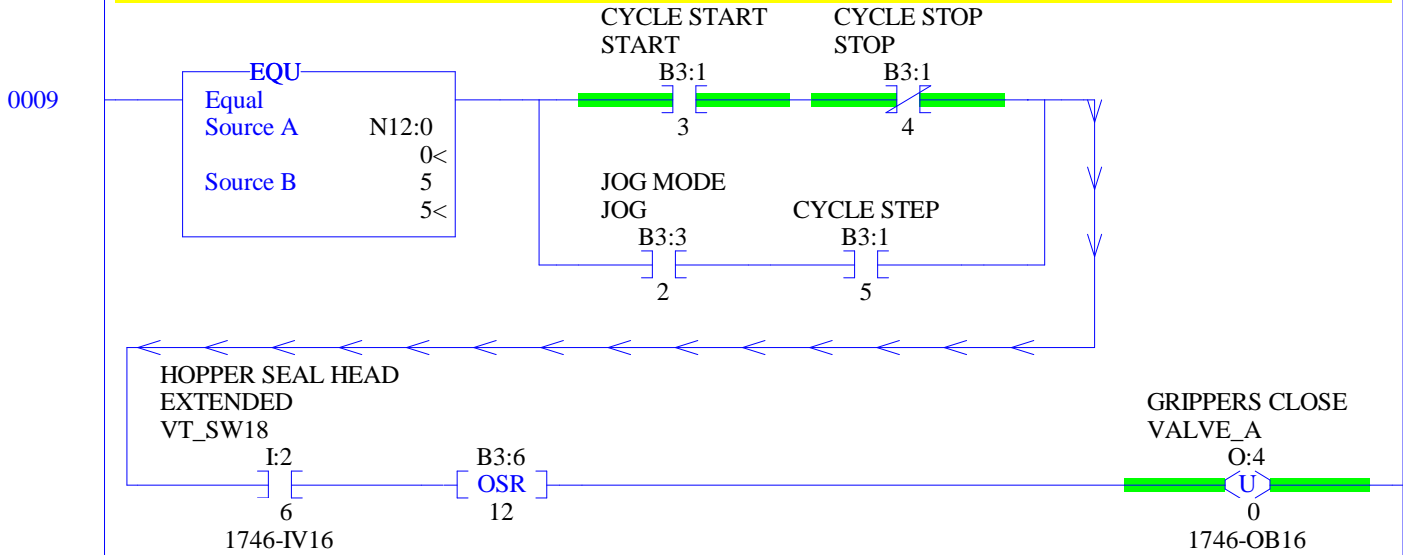
THIS RUNG RETRACTS THE HOPPER SEAL HEAD AFTER 5 SECONDS



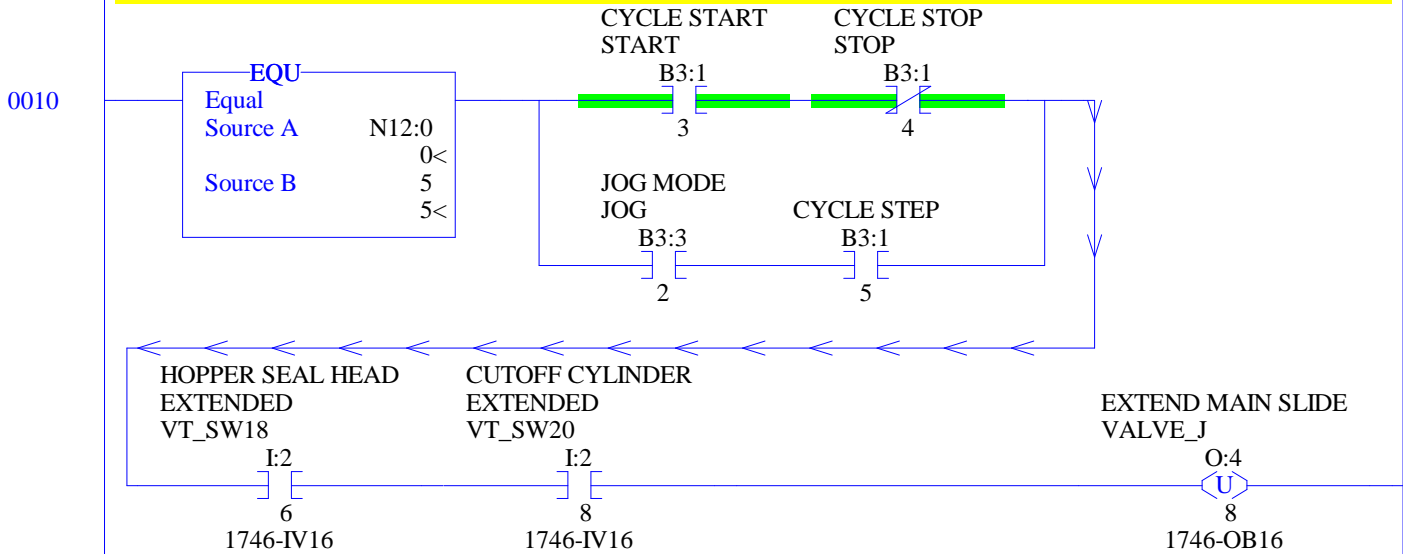




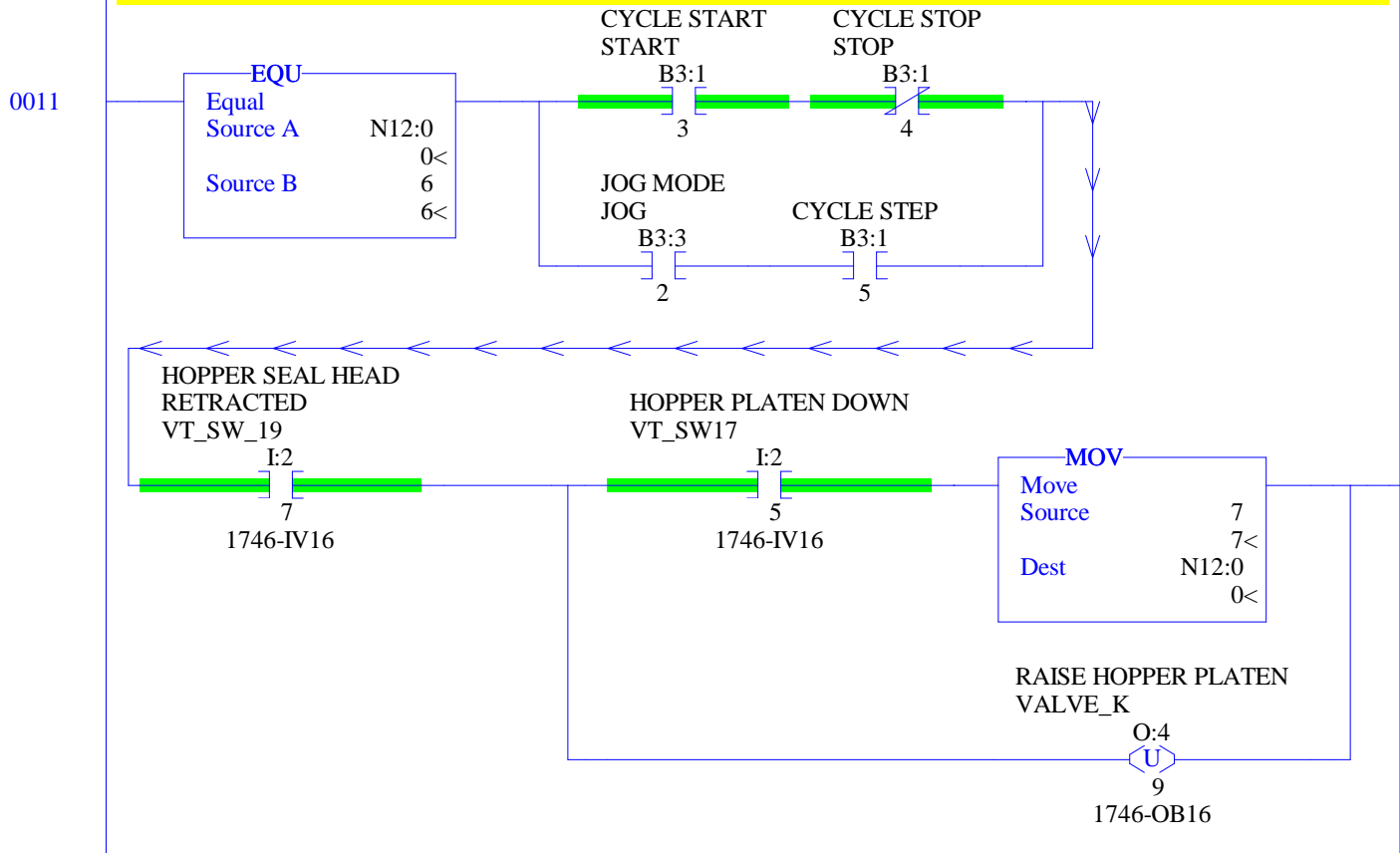
THIS RUNG OPENS THE GRIPPERS AFTER THE HOPPER SEAL SEQUENCE IS THRU



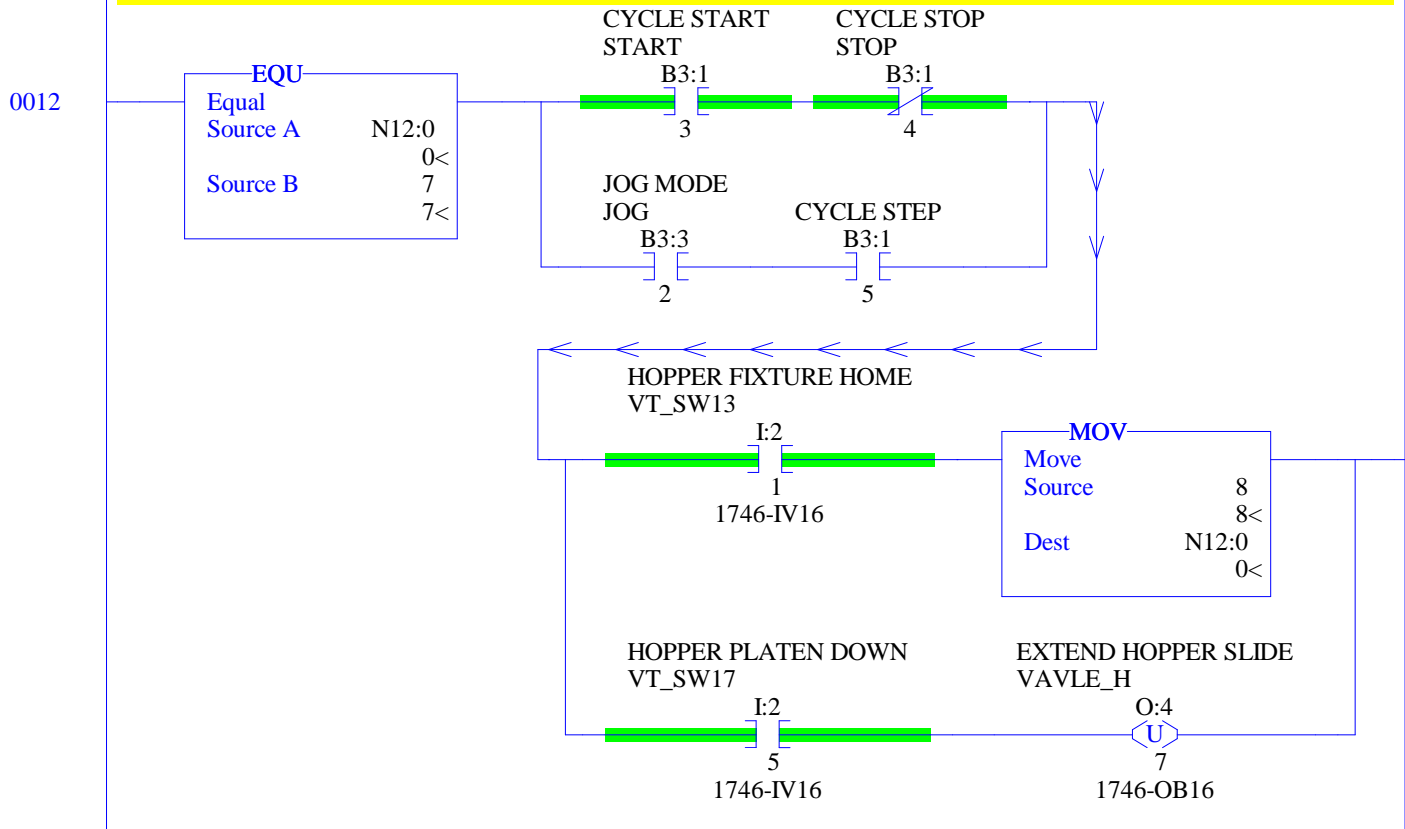
THIS RUNG RETRACT THE MAIN SLIDE BACK TO THE OPERATOR



THIS RUNG RETRACTS THE HOPPER PLATEN



THIS RUNG RETRACTS THE HOPPER SLIDE BACK TO THE OPERATOR



THIS RUNG OPENS THE HOPPER FIXTURE AFTER CYCLE IS COMPLETE

