

PLF sheet label feeder user manual

Applies to **PLF-100 · PLF-200 · PLF-300**

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Screen Operation Page Introduction

1. Production count: one row of labels fed counts as 1; long press the reset button to clear.
2. Alarm reset: clears alarm issues that occur during the production process.
3. UPH: production count per hour.
4. Film not peeled: film peeling status, can be manually selected. If no film is applied on the sheet material, click this button to change to film peeled, and the film peeling action will not be executed in the next operation.
5. Homing start: each motor returns to the home position; homing must be executed once at first power-on.
6. Auto: automatic process starts.
7. Manual: manual process starts, manual loading, select this mode for testing cylinder operation.
8. Pause: pauses the next action in the automatic process.

Manual screen: manually test the working status of various cylinders and motors.

Parameter screen password: 2222

Parameter Screen 1

1. Feeding speed: label feeding speed of sheet material.
2. Material head feeding length: the distance for the sheet material head from the material change sensor to the material platform cylinder clamping.
3. First-stage feeding length: the distance the sheet material travels to the fiber optic position.
4. Second-stage feeding length: the distance the sheet material travels after being sensed by the fiber optic.
5. First-stage feeding acceleration/deceleration: first-stage feeding accelerates or decelerates from standstill to the target speed.



6. Second-stage feeding acceleration/deceleration: second-stage feeding accelerates or decelerates from standstill to the target speed.
7. Lifting platform manual speed: the lifting/lowering speed for manual testing of the lifting platform.
8. Lifting platform auto speed: the lifting/lowering speed during lifting platform operation.
9. Lifting platform initial rise speed: the speed of the first rise after the lifting platform returns to home.
10. Lifting platform initial rise step: the step distance of the first rise after the lifting platform returns to home.
11. Lifting platform rise step: the step distance for each subsequent rise after the initial rise step is completed.
12. Sheet material change signal no-material delay: after the sheet material change signal is disconnected, the next action is executed after this delay.

Parameter Screen 2

1. Lifting platform no-material detection delay: after the lifting platform detection signal detects no material, the next action is executed after this delay.
2. Lifting platform material detection delay: after the lifting platform detection signal detects material, the next action is executed after this delay.
3. Lifting platform cyclic rise count: after the lifting platform completes the initial step, the number of rise cycles for each segment of the lifting platform.
4. Upper film suction cylinder descent time: the dwell time after the upper film suction cylinder descends.
5. Upper film suction vacuum OK delay: during upper film suction, the vacuum generator delays sending the signal.
6. Film suction shaking time: the time for the film suction cylinder to shake up and down.
7. Film suction shaking count: the number of shakes of the film suction cylinder within the shaking time.
8. Film discard blow time: the time for executing the blow action after discarding the upper film.
9. Post-discard suction time: the time for executing the blow action after discarding the upper film.
10. Sheet material suction descent time: the dwell time after the sheet material suction cylinder descends.
11. Sheet material suction vacuum OK delay: during sheet material suction, the vacuum generator delays sending the signal.
12. Sheet material release time: the dwell time of the cylinder when releasing sheet material.

Parameter Screen 3

1. Sheet material suction shaking time: after sheet material suction, the time for the cylinder to shake up and down.
2. Sheet material suction shaking count: after sheet material suction, the number of shakes of the cylinder within the shaking time.
3. Material platform cylinder rise time: the dwell time of the material platform cylinder when rising.
4. Feeding stepper start delay: delayed start of the feeding motor.
5. Pre-suction feeding count: when the first-stage feeding cannot sense material, the cumulative count before pre-suction starts.
6. Material tail pressing time: the time required for the cylinder to lower the material tail pressing mechanism.
7. Material head feeding timeout alarm delay: if the material change signal is not detected within this time, an alarm will be triggered.
8. First-stage feeding timeout alarm delay: when the material platform clamps material, if the material presence fiber optic does not detect sheet material within this time, an alarm will be triggered.
9. Feeding detection no-material delay: when there is no material, the next row of material is fed after this delay.
10. Feeding detection material delay: refers to outputting the OK signal only after this delay following completion of feeding.
11. Feeding OK disconnect delay: refers to disconnecting the feeding OK signal only after this delay when there is no material.

Switch Screen

1. Lifting platform material detection: detects the material presence signal of the lifting platform.
2. Sheet material suction vacuum detection: sheet material suction vacuum detection function.
3. Upper film suction vacuum detection: upper film suction vacuum detection function.
4. External feeding: when enabled, each label feed requires receiving an external feeding signal before executing the feeding action.
5. Auto homing: when enabled, homing is performed automatically at power-on.
6. Film peeling: when enabled, the film peeling function starts.
7. Pre-suction: when enabled, after the sheet material change signal is disconnected, the pre-suction sheet material function can be executed.
8. Rotary pressing material: available when a rotary pressing material platform is installed.

Alarm screen: alarm records can be queried.

Input monitoring

Output monitoring

Wiring Instructions

1. Pin: 24v
2. Pin: 0v
3. Pin feeding OK signal: 0v output, the material platform outputs a signal after peeling one row of labels.
4. Pin labeler material request signal: 0v input, the labeler gives the feeder a signal to peel one row of labels.
5. Pin auto signal: 0v output, feeder auto mode enabled signal.
6. Pin no-material reminder: 0v output, the material magazine is out of material, reminding to replace material.

Maintenance Precautions

1. Check whether the nozzle opening is deformed due to impact, and confirm whether there is debris blocking the inside of the nozzle.
2. Check whether there is dust or debris on the pressing sheet material roller shaft, and clean with a cotton swab or cloth if necessary.
3. Check whether there are leftover components or other debris on the material platform and fiber optic, and clean if necessary.
4. Check whether the winding wheel is loose and whether each cylinder operates normally.
5. Visually inspect the machine and lifting platform for foreign objects; if any foreign objects are present, handle them promptly.