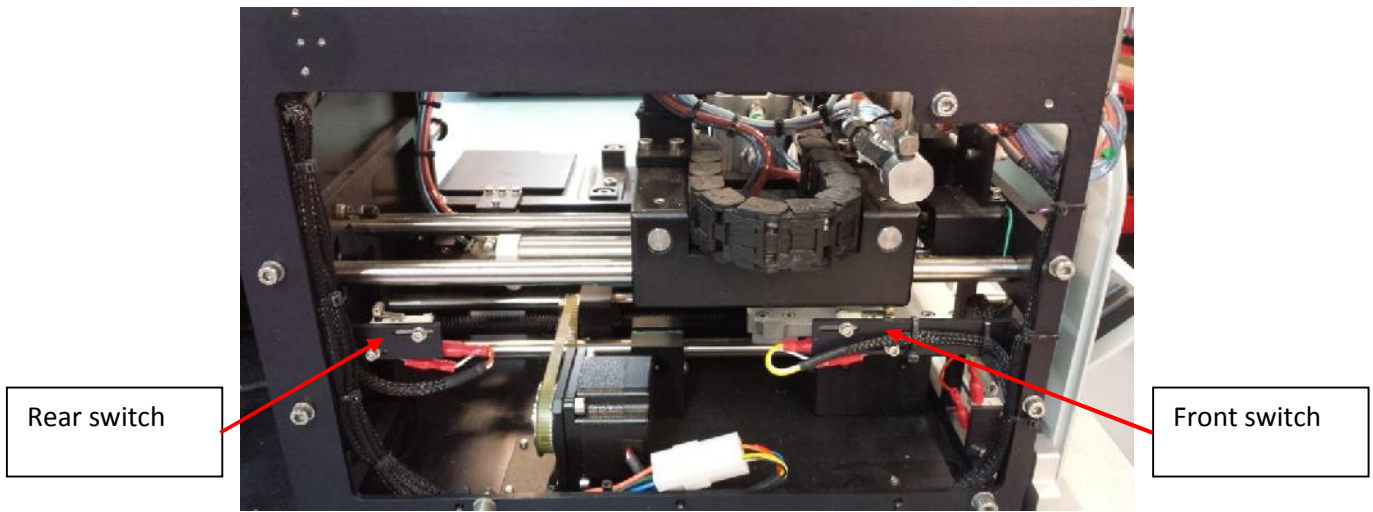
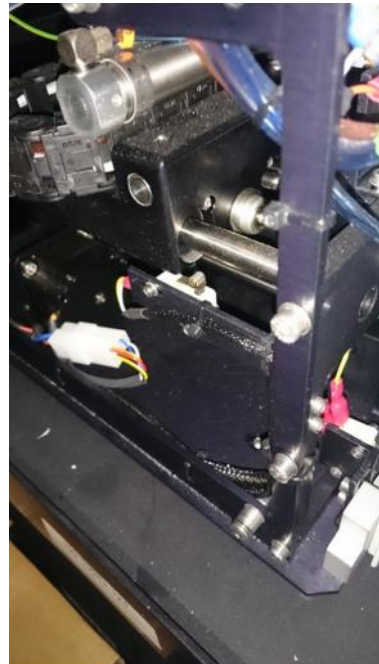


**KAPS 500 Shuttle Axis Front and Rear Switch operation**



The forward shuttle that transfers the seal from the roll through the cutter to the front of the system, this should activate a shuttle forwards switch located to the left hand side of the system, this switch tells the system the shuttle is fully forwards and to carry out the cut procedure.

With the pneumatic and power supply off, check that the shuttle can easily reach this switch with no obstructions.

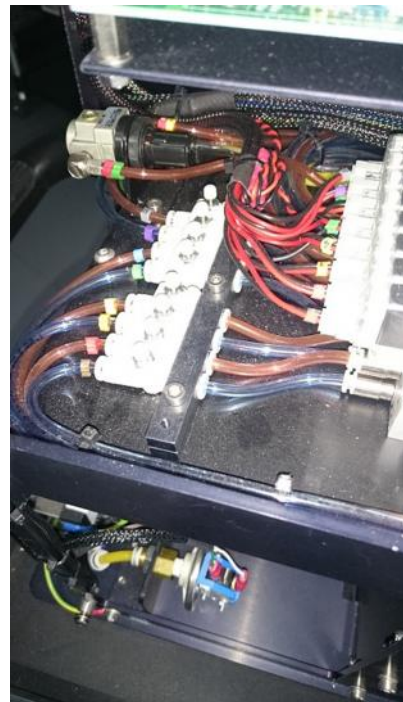
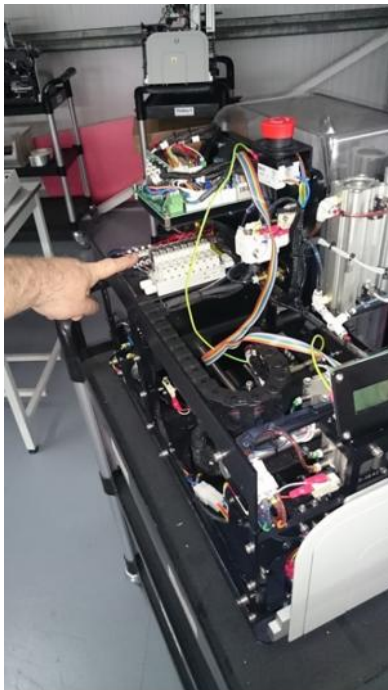


The shuttle unit carriage will activate this switch, it also time sensitive, so if the air pressure is low or the shuttle is traveling too slowly then the time taken to activate the switch can also cause a 'time out' error, the timer is hard coded into the software so cannot be adjusted.



Both Front and Rear switches are activated by the shuttle axis as shown

To adjust the forwards and back speed of the foil transfer system this is carried out by two flow controllers for the cylinder that operates this movement. These Flow controllers are mounted under the Main Pcb adjacent to the pneumatic manifold. (as shown)



Speed adjustment is carried out by the two flow controllers 1 & 2 these are very sensitive to adjust and small adjustment can make big difference, do not adjust speed too fast as the foil will slip during the pull off process and cause short seals or failed seal transfer.

The Aim of adjustment is to get a smooth controlled 'Pull' of the foil from the foil backing at a reasonably slow speed. And obtain a controlled carriage return action.