

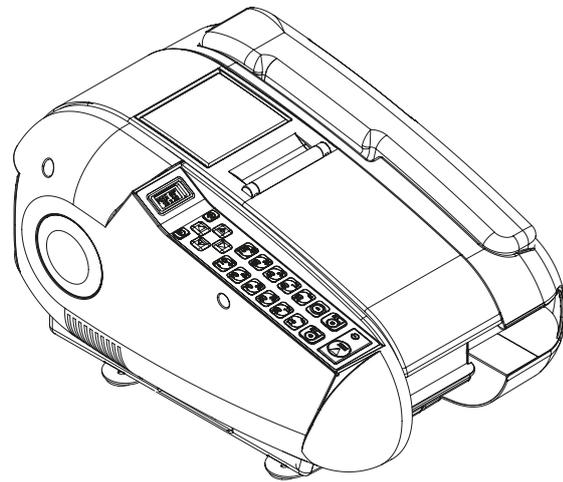


Gummed paper tape dispenser

SMARTY 2

Operator Panel

Translation of the original instructions



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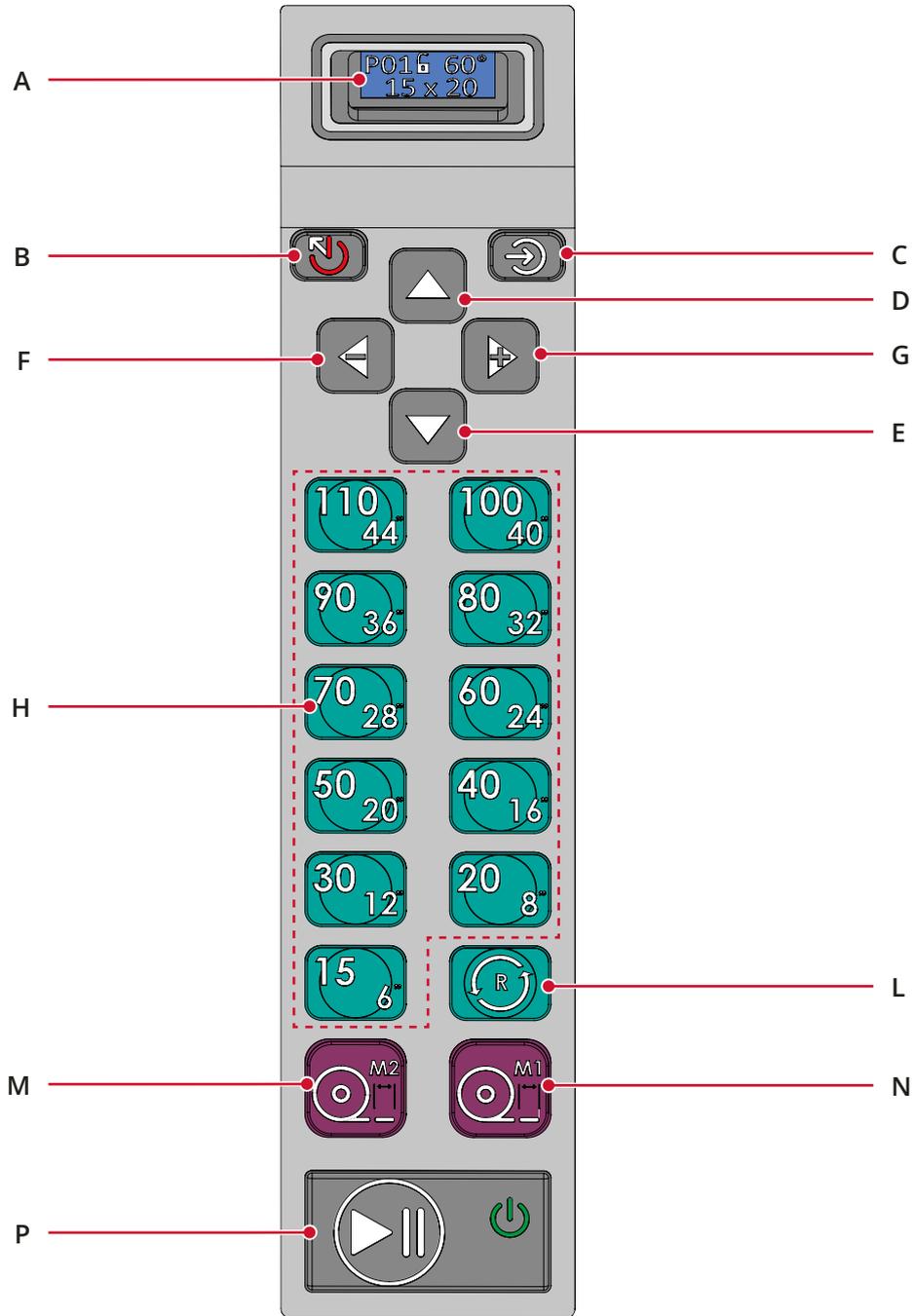


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1 GENERAL CONTROLS



Picture 1

1.1 CONTROLS DESCRIPTION

- A** Display that shows different information about the work program in use.
- B** **ESC** | Return button.
Press to return to the top-level page while navigating the display pages.
POWER OFF (only for version with battery) - Button to turn off the machine.
- C** **ENTER** | Confirm button.
Press to access the low-level page while navigating the display pages.
- D** **UP ARROW** | Button to scroll up the pages.
Press the button to go to the next page while navigating the display pages.
- AND** **DOWN ARROW** | Button to scroll down the pages.
Press the button to go to the previous page while navigating the display pages.
- F** **LEFT ARROW - MINUS** | Button to scroll left or decrease a value in the display.
- G** **RIGHT ARROW - PLUS** | Button to scroll to the right or increase a value in the display.
- H** Quick buttons group with preset sizes.
Press to dispense a strip of paper of the indicated size.
The size corresponding to the button is shown in millimetres in the top left corner and in inches in the bottom right corner.
- L** **RANDOM** - Button for paper dispensing.
By pressing and holding the button it keeps on dispensing paper at a speed slower than normal operation. Once the button is released, the paper is cut.
If the button is kept pressed longer than the set time limit (end of scale) the paper is cut automatically when the limit length is reached.

- M** **M2** - Button for dispensing paper stored in “M2”.
Press to deliver a strip of paper of the size set through the display for “M2”.
- N** **M1** - Button for dispensing paper stored in “M1”.
Press to deliver a strip of paper of the size set through the display for “M1”.
- P** **START/PAUSE** - Press to start or stop the set work program.
POWER ON (only for version with battery) - Press to turn on the machine.

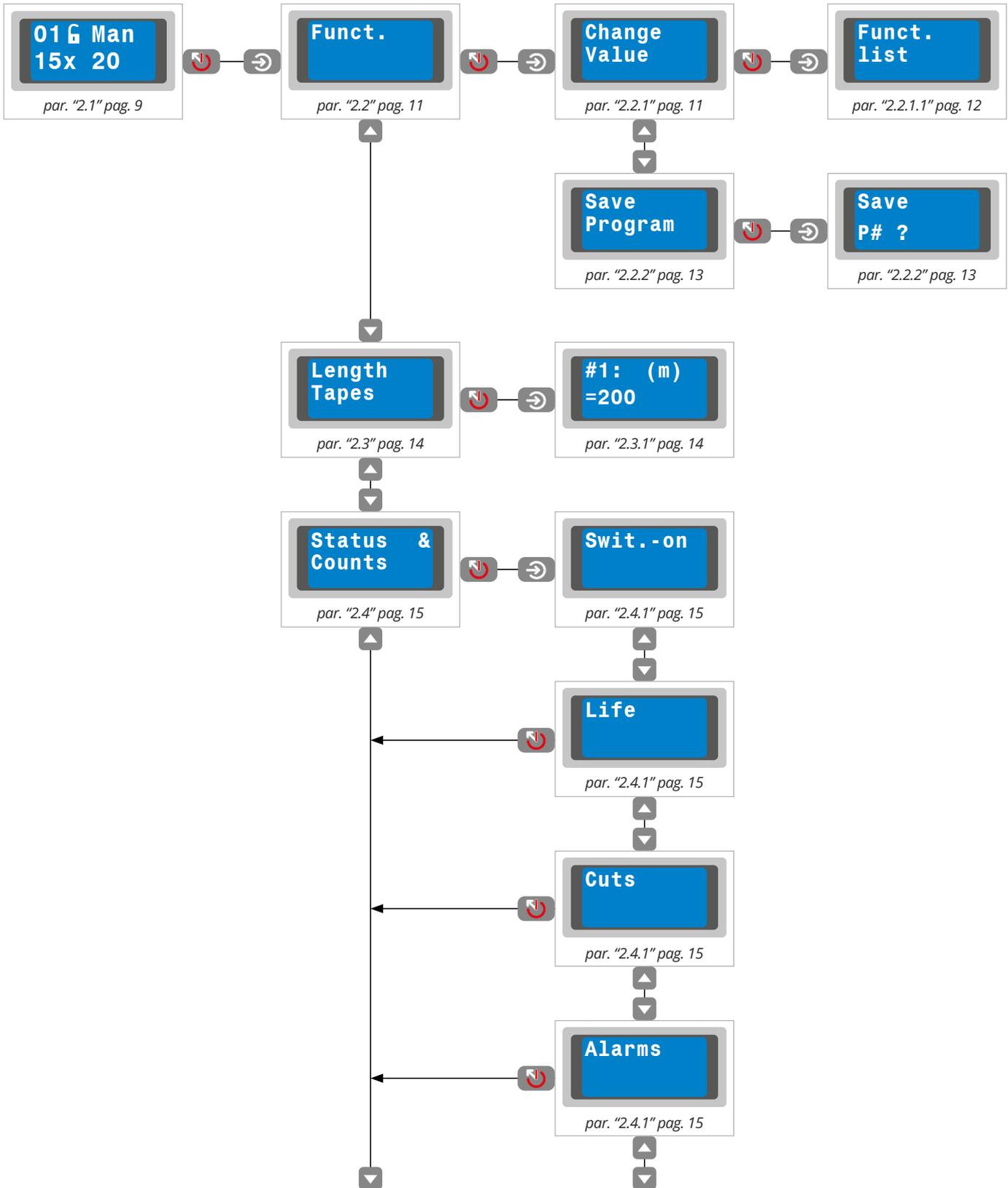
INFORMATION

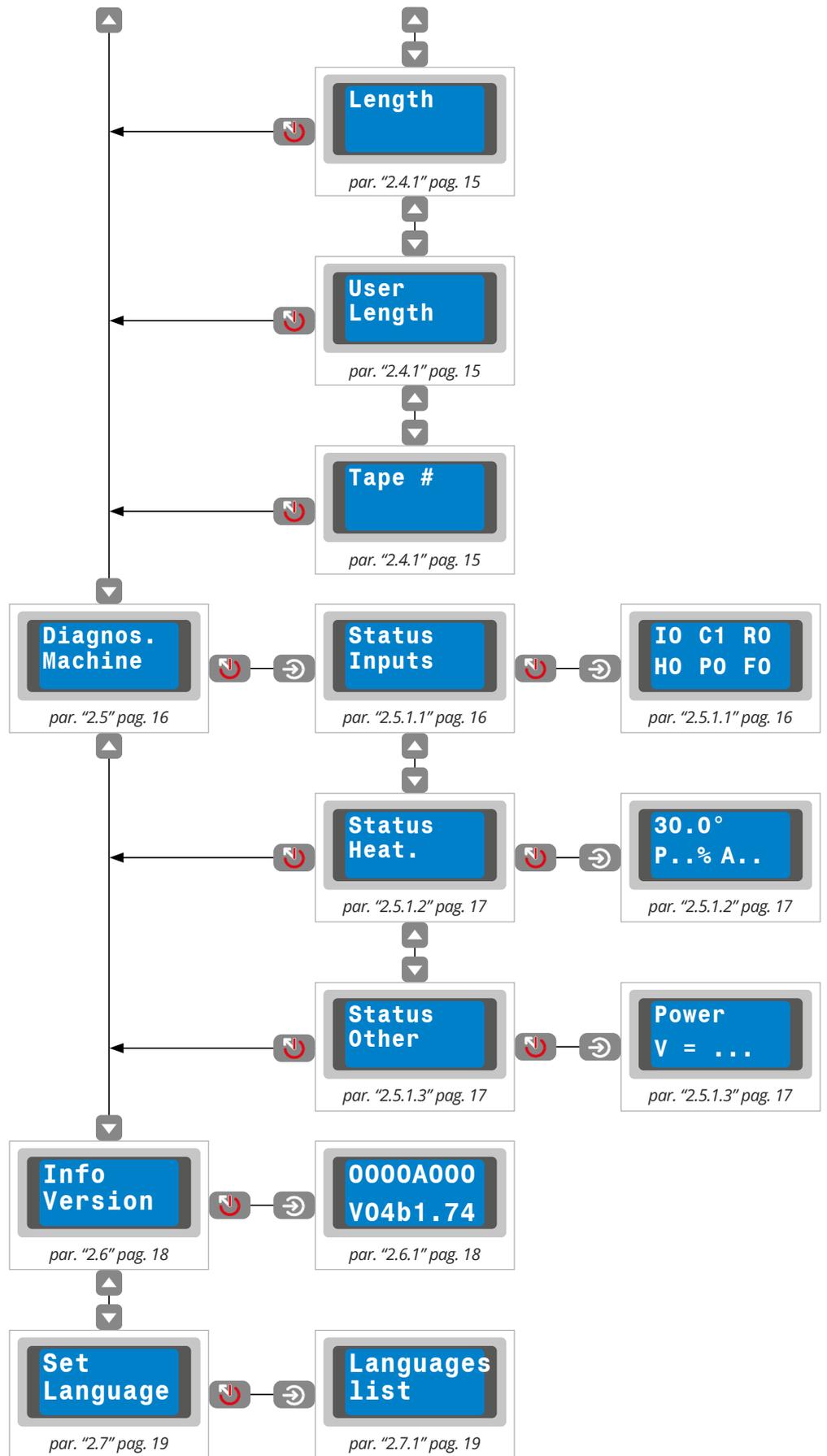


When any of the buttons on the push-button panel is pressed, the machine emits a feedback sound.

2 DISPLAY OPERATION

Page Navigation Scheme





INFORMATION



The display screens shown in the previous pages are indicative and made for illustrative purposes. They may vary depending on the parameter changes implemented on the machine in your possession.

INFORMATION



*It is possible to navigate the display pages using the UP ARROW (D) and DOWN ARROW (E) buttons.
To access a sub-level of a given page, if available, you need to press the ENTER button (C).
To return to the previous level of a given page you need to press the ESC button (B).*

INFORMATION



*When the machine is first switched on, the display shows the "SET LANGUAGE" page where it is requested to set the display language.
After setting the desired language, the display shows the "HOME PAGE".*

INFORMATION



In case of inactivity, if a page other than the "HOME PAGE" is displayed on the display, the user is automatically taken back to the top-level page they came from.

2.1 HOME PAGE



When switched on after the first switch-on, the machine always displays the "HOME PAGE" on the display.

In zone **(1)** of the page the number of the currently active work program is displayed.

- Pressing the **MINUS** button **(F)** changes the work program set downwards.
- Pressing the **PLUS** button **(G)** changes the work program set upwards.
- When the machine is first switched on, the active program is "P01". All programs have the same settings as the "P00" program, i.e. the one with the factory settings.
- When the work program number flashes, it means that changes have been made to the program (see "CHANGE VALUE" page) but have not been saved.
 - If you want to lose the unsaved changes, simply scroll between programmes, or turn the machine off and on again using the dedicated switch on the back.
 - If you want to save changes not previously saved access the "FUNCT." page, scroll down with the button **(E)** to access the "SAVE PROGRAM" page (see *par. "2.2.2" pag. 13*).
- If an open padlock appears on the right of the program number, it means that the program is editable and savable.
- If a closed padlock appears on the right of the program number, it means that the program is editable but cannot be saved.

The working mode set for the program is displayed in zone **(2)** of the page.

- **MAN**: indicates the manual working mode.
- **M1 M2 M2**: indicates the semi-automatic working mode in which the tapes with stored lengths are dispensed in succession for **M1**, then **M2** and then **M2** again.
- **M1 M2**: indicates the semi-automatic working mode in which the tapes with stored lengths are dispensed in succession for **M1** and then **M2**.
- **M1 M2 M3** (optional activated only by the Manufacturer): indicates the semi-automatic working mode in which the tapes with stored lengths are dispensed in succession for **M1**, then **M2** and then **M3**.

The tape stored for "**M1**" is displayed in zone **(3)** of the page.

The tape stored for "**M2**" is displayed in zone **(4)** of the page.

2.2 FUNCT.



From this page you can access the one for changing the values of the functions of the currently active work program (see "HOME PAGE").

2.2.1 Change Value



Page providing access to the list of functions for setting them.

Once the values in the functions have been changed and the **ESC** button (**B**) has been pressed to return to this page, the system requests these changes to be saved through the "SAVE PROGRAM" page, see *par. "2.2.1" pag. 11*.

INFORMATION



*If a change has been made to the work program but it has not been saved, you can return to this page and, by pressing the DOWN ARROW button (E), view the "SAVE PROGRAM" page. From this page proceed as indicated in *par. "2.2.2" pag. 13*.*

INFORMATION



You can edit a program that shows a closed padlock but you cannot save it.

2.2.1.1 Machine funct.



INFORMATION



The display screen shown is indicative and used for illustrative purposes.

These pages contain the list of the machine functions, whose value can be varied.

To scroll from one function to another, press the **UP ARROW (D)** and **DOWN ARROW (E)** buttons.

To change the value of a function, press the **MINUS (F)** and **PLUS (G)** buttons.

For the various functions available, see *par. "3" pag. 20*.

2.2.2 Save Program



By changing the functions from the "MACHINE FUNCT." list and exiting to the "CHANGE VALUE" page, the system automatically opens this page choose whether to save the changes or not. In this case, by confirming the save, is executed on the active program.

- To save, press the **ENTER** button (**C**).
- To not save, press the **ESC** button (**B**). In this case, the indication of the program in use on the "HOME PAGE" will flash to indicate that the changes have not been saved.
- If you intend to change the work program on which to save the changes made, you need to access the page "SAVE PROGRAM and select the work program by using on the **MINUS (F)** and **PLUS (G)** buttons.

INFORMATION



The work program "P00" is not overwritable and the default values are stored in it.

The limit of storable programs is 6, with the possibility of increasing it to 99 with a special option to be requested from the Manufacturer.

2.3 LENGTH TAPES



Page providing access to the page for setting the lengths of the rolls. In this way it is possible to use and set the funct. **F09** "ROLL END ALARM" and **F14** "ROLL END WARNING".

2.3.1 Length funct.



- 1) Roll memory.
 - 2) Unit of measurement of the value given in field **(3)**.
 - 3) Roll length set and editable for the type of roll indicated in field **(1)**.
- To move over the length of the roll to be changed press the **DOWN ARROW** button **(E)**.
 - Press the **MINUS (F)** and **PLUS (G)** buttons to change the value by +/- 1 metre; alternatively, you can type the value directly using the group buttons **(H)**.
 - When the change has been made, press the **ENTER** button **(C)** to save the value.
 - To not save, press the **ESC** button **(B)** or press the **UP ARROW** button **(D)** to return to the roll memory.

INFORMATION



The variation in the lengths of the rolls is unrelated to the work programs. The roll type can only be recalled when setting up work programmes.

2.4 STATUS & COUNTS



Page providing access to the pages where the machine activity counters are shown after the first start-up.

To scroll from one counter to another press the **UP ARROW (D)** and **DOWN ARROW (E)** buttons.

2.4.1 Status & Counts Info



INFORMATION



The display screen shown is indicative and used for illustrative purposes.

- 1) Counter type; the counters that can be displayed are listed below in the same display order:
 - **Switch-on:** number of total switch-on times of the machine (not resettable).
 - **Life:** total operating hours of the machine (not resettable).
 - **Cuts:** number of roll cuts made (not resettable).
 - **Alarms:** total number of alarms activated during machine operation (not resettable).
 - **Length:** total length of tape consumed expressed in meters (not resettable).
 - **User Length:** Length of the consumed tape expressed in meters resettable by the user. To reset the counter press the **ENTER** button (**C**).
 - **Tape #:** For each type of tape (from 1 to 9), the meters used for each individual roll stored and used in the **F09** funct. (not resettable) are counted.
- 2) Value corresponding to the counter.

2.5 DIAGNOS. MACHINE



Page providing access to the view-only pages where the machine statuses are reported.

To scroll from page to page, press the **UP ARROW (D)** and **DOWN ARROW (E)** buttons.

2.5.1 Diagnosis Info

2.5.1.1 Status Inputs



- I Mark reading photocell status input index.
0 = not engaged.
1 = engaged.
- C Lid sensor status input cover.
0 = lid open.
1 = lid closed.
- R Status reserve and input for reserve.
0 = not engaged.
1 = engaged.
- H Water for water level probes.
0 = not engaged.
1 = engaged.

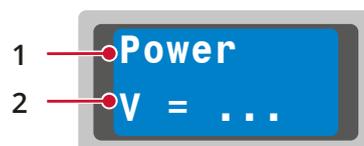
- P** Presence of paper status input photocell detecting paper coming out.
 0 = not engaged.
 1 = engaged.
- F** Pedal status input.
 0 = no pedal pressed.
 1 = pedal 1 pressed.
 2 = pedal 2 pressed.
 3 = pedals 1 and 2 pressed.

2.5.1.2 Heating Status



- 1) Temperature read on the machine heating element.
- 2) Power applied to the machine heating element; if it is equal to 0%, it indicates that the heating element is off.
- 3) Absorption.

2.5.1.3 Status Other



- 1) Supply voltage detected by the motherboard. For the correct operation of the machine the voltage supplied must be about 24V.

INFORMATION



The voltage shown in the display does not correspond to that in the power cable.

2.6 INFO VERSION



Page providing access to the view-only page where the installed software version is shown.

2.6.1 Software Version



Page providing access to the view-only page where the installed software version is shown.

- 1) Motherboard ID number.
- 2) Software installed.

2.7 SET LANGUAGE



Page providing access to the list of selectable languages of the system.

2.7.1 Languages



To scroll from one language to another press the **MINUS (F)** and **PLUS (G)** buttons.

- Scroll through the available languages and then press the **ENTER** button (**C**) to apply the choice.
- Below are the languages available in the order they are displayed in:
 - Italian
 - German
 - Spanish
 - English
 - French
 - Portuguese

3 FUNCT.

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X	F00 Program Unlock
X	<p>F01 Cycle type</p> <p>This function allows the choice of the type of cycle to be set for the work program:</p> <p>MANUAL: indicates the manual working mode.</p> <p>M1 - M2 - M2: indicates the semi-automatic working mode in which the tapes with stored lengths are dispensed in succession for M1, then M2 and then M2 again.</p> <p>M1 - M2: indicates the semi-automatic working mode in which the tapes with stored lengths are dispensed in succession for M1 and then M2.</p> <p>M1 - M2 - M3 (optional activated only by the Manufacturer): indicates the semi-automatic working mode in which the tapes with stored lengths are dispensed in succession for M1, then M2 and then M3.</p>
OPT	<p>F02 Repeater (with optional paper repeater photocell)</p> <p>off: Repeater mode off.</p> <p>on: Repeater mode active.</p> <p>This function, if activated, combined with the F01 working modes and the addition of a photocell installed on the front of the machine, allows the paper to be dispensed in an automatic cycle based on the sequence and the individual delays set.</p>
OPT	<p>F03 Repeat delay (with optional paper repeat photocell)</p> <p>This function must be combined with F01 = MANUAL and F02 = on and allows setting a delay between a paper dispensing repetition and the other in the manual cycle. The value must be between 1" and 120".</p>
OPT	<p>F04 M1 Repeat delay (with optional paper repeat photocell)</p> <p>This function must be combined with F01 = M1; M2; M2 or F01 = M1; M2 or F01 = M1; M2; M3 (optional) and F02 = on and allows setting a delay between a paper dispensing repetition and the other in semi-automatic cycle for M1. The value must be between 0" and 120".</p>

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OPT	<p>F05 M2 Repeat delay (with optional paper repeat photocell)</p> <p>This function must be combined with F01 = M1; M2; M2 or F01 = M1; M2 or F01 = M1;M2;M3 (optional) and F02 = on and allows setting a delay between a paper dispensing repetition and the other in semi-automatic cycle for M2. The value must be between 0" and 120".</p>
OPT	<p>F05 M3 Repeat delay (with optional paper repeat photocell and unlock funct. F01 = M1-M2-M3)</p> <p>This function must be combined with F01 = M1; M2; M3 and F02 = on and allows setting a delay between a paper dispensing repetition and the other in the semi-automatic cycle for M3. The value must be between 0" and 120".</p>
OPT	<p>F07 Auto off time (optional only in version with battery)</p> <p>This function allows you to set a time, in minutes, after which the machine goes into standby for inactivity, preserving the battery charge.</p>
X	<p>F09 Tape used selection</p> <p>0: funct. disabled.</p> <p>> 0: The function is enabled by selecting the type of roll.</p> <p>This function is used to generate a end of roll alarm (E05).</p> <p>For setting the function see <i>par. "3.1.1" pag. 25</i>.</p>
X	<p>F10 Length increase</p> <p>This function allows you to increase the length of the sizes selected on the push-button panel by the value that is set, in centimetres.</p> <p>For setting the function see <i>par. "3.1.2" pag. 26</i>.</p>
X	<p>F11 M1 Preset length</p> <p>This function allows you to set the length for M1.</p> <p>For setting the function see <i>par. "3.1.3" pag. 27</i>.</p>

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X	F12 M2 Preset length This function allows you to set the length for M2 . For setting the function see <i>par. "3.1.4" pag. 27</i> .
OPT	F13 M3 Preset length (optional) This function allows you to set the length for M3 . For setting the function see <i>par. "3.1.5" pag. 28</i> .
X	F14 Paper running out warning threshold 0: funct. disabled. 20: funct. enabled. This function is used to generate a running out of paper alert when the threshold is reached. For setting the function see <i>par. "3.1.6" pag. 28</i> .
X	F50 Engine acceleration ramp time View-only parameter.
X	F51 Maximum engine speed View-only parameter.
X	F52 Final approach length in slow speed View-only parameter.
X	F53 Slow speed in final approach View-only parameter.
X	F54 Random mode dispensing speed View-only parameter.
X	F60 Heater activation off: Heater off. on: Heater on. Allows you to activate or deactivate the heater mode. For setting the function see <i>par. "3.1.7" pag. 29</i> .

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X	<p>F61 Nominal heater temperature</p> <p>View-only parameter. It reports the actual temperature, in degrees centigrade. The heating element will stop once this temperature is reached.</p>
X	<p>F62 Heater temperature in fast pre-heating mode</p> <p>0: funct. disabled. > 0: funct. enabled.</p> <p>View-only parameter. Report the pre-heating temperature, in degrees centigrade, to reach the nominal temperature threshold (F61) faster.</p> <p>In factory settings the function is disabled.</p>
X	<p>F63 Pre-heating time</p> <p>0: funct. disabled. > 0: funct. enabled.</p> <p>View-only parameter. It shows the time, expressed in minutes, during which the pre-heating temperature (F62) will be active to reach the nominal temperature threshold (F61).</p> <p>In factory settings the function is disabled.</p>
X	<p>F64 Heater temperature in power saving mode</p> <p>0: funct. disabled. > 0: funct. enabled.</p> <p>View-only parameter. It shows the temperature, in degrees centigrade, at which the heating element drops after a period of machine inactivity. In this way, the machine is always ready to work even in cold environments, as the humectant unit always lukewarm.</p>

GT-250D

x

F65 Heater temperature in power saving mode**0**: funct. disabled.**> 0**: funct. enabled.

View-only parameter. It shows the time, expressed in minutes, after which the power saving mode will be enabled for inactivity. In this mode the machine will lower the temperature of the heating element (**F64**).

To bring the temperature of the heating element back to the nominal one (**F61**) and then exit the power saving mode, simply press any button on the push-button panel.

In factory settings the function is set to 30 minutes.

3.1 FUNCT. SETTINGS

3.1.1 F09 - Tape used selection

From funct. **F09** it is possible to select the type of tape used previously set using the "LENGTH FUNCT." page; see *par. "2.3.1" pag. 14*.

From the moment the function is enabled (**F09 > 0**) the machine, the "HOME PAGE", will alternately display the stored sizes, the roll type number **(1)** and the counter of the roll length dispensed by the machine **(2)**.

By combining funct. **F09** with funct. **F14 > 0**, a warning for the operator is generated when the roll recalled in funct. **F09** reaches the threshold set for **F14**; see *par. "3.1.6" pag. 28*.



At each dispensing of paper, the counter **(2)** is updated with the length dispensed.

Once the maximum length set for the roll recalled by **F09** has been reached, the display will signal an end of roll alarm (**E05**).

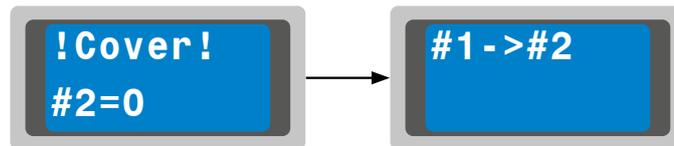


When the machine lid is opened, a counter reset request will appear on the display unit, showing the type of roll used and giving the possibility of choosing whether or not to reset the counter.



- If you open the lid, which acts as an inspection compartment, to check the paper and do not intend to reset the counter, press the **ESC** button (**B**).
- If you open the lid to replace the finished roll with one of equal length, simply press the **ENTER** button (**C**) to reset the counter.

- If you intend to change roll but without resetting the counter of the previously used roll (for example by replacing a roll stored as #1 with a roll stored as #2), you can press the **MINUS (F)** and **PLUS (G)** buttons to select the desired roll type and press the **ESC** button (**B**).
- The warning that the roll used has been changed will appear on the display.



- If you intend to change roll, without resetting the counter of the previously used roll, (for example by replacing a roll stored as #1 with a roll stored as #2), but you want to reset the counter of the new roll inserted, you can press the **UP ARROW (D)** and **DOWN ARROW (E)** buttons to select the desired roll type and press the **ENTER** button (**B**).
- The counter reset warning will appear on the display and pressing the **ESC** button (**B**) will display the warning that the roll used has been changed.

3.1.2 F10 - Length increase

From the moment this function is enabled (**F10 > 0**) the machine, the "HOME PAGE", will display the word **F10** to indicate that the function is actually enabled.



The value was increased from 5 cm to 110 cm, with an increase of +5 cm at a time, thus bringing the machine to be able to dispense up to 220 cm.

The length increase is applied to the sizes on the push-button panel but is not applied to the stored sizes **M1**, **M2** and **M3** (optional).

It is recommended to use an increment of 5 cm to close the gap between the sizes on the push-button panel. Otherwise the sizes value would deviate by 10 cm from each other (except for 15 cm and 20 cm).

It is recommended not to use double settings, for example by setting an increment of 20 cm and pressing the button for a length of 20 cm, so as to have a length of 40 cm of dispensing, despite the button for the direct dispensing of a 40 cm strip is already present. This way of working would become confusing for the operator.

It is recommended to use the increment to reach sizes that are out-of-scale with respect to the buttons on the push-button panel. Use a shared approach so as not to create confusion.

3.1.3 F11 - M1 Preset length

By pressing the button **M1 (N)** and/or during semi-automatic cycles in which the length **M1** is present, a strip of paper of the length set in this function is dispensed.

The value can be set from 15 cm to 110 cm, with an increase of +5 cm at a time and this value is displayed on the "HOME PAGE" in the field **(3)**.



3.1.4 F12 - M2 Preset length

By pressing the **M2 (M)** button and/or during semi-automatic cycles in which the **M2** length is present, a strip of paper of the length set in this function is dispensed.

The value can be set from 15 cm to 110 cm, with an increase of +5 cm at a time and this value is displayed on the "HOME PAGE" in the field **(4)**.



3.1.5 F13 - M3 Preset length (optional)

During semi-automatic cycles where the **M3** length is present (optional), a strip of paper of the length set in this function is dispensed.

The value can be set from 15 cm to 110 cm, with an increment of +5 cm at a time.

3.1.6 F14 - Paper running out warning threshold

By combining funct. **F14** with funct. **F09 > 0**, a warning for the operator is generated when the roll recalled in funct. **F09** reaches the threshold set for **F14**; see *par. "3.1.1" pag. 25*.

The factory setting of the function is **F14 = 20** and it is not editable. When the function is enabled an alert for the operator generates when the roll reaches the threshold of 20 meters.

Once the threshold set with **F14** has been reached, the message "LOW!" appears on the displayed.



3.1.7 F60 - Heater activation

Access funct. **F60** to enable or disable the heater function.

If the heater mode is enabled, a special icon will be displayed on the "HOME PAGE" indicating the function is enabled.



It is recommended to use this setting for working environments below +15° and always in the presence of water to avoid overheating that decreases the life or damages the components in the humectant unit.

WARNING



NEVER keep the heater on when there is no water in the humectant unit, when there are high temperatures in the working environment or when the operator is not present and the machine is therefore unattended. At the end of the shift, or when no longer necessary, the heater function must always be disabled.

4 OPERATIONAL CYCLES

F01 = MAN

From the "HOME PAGE" follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set the manual working mode using the funct. **F01**.

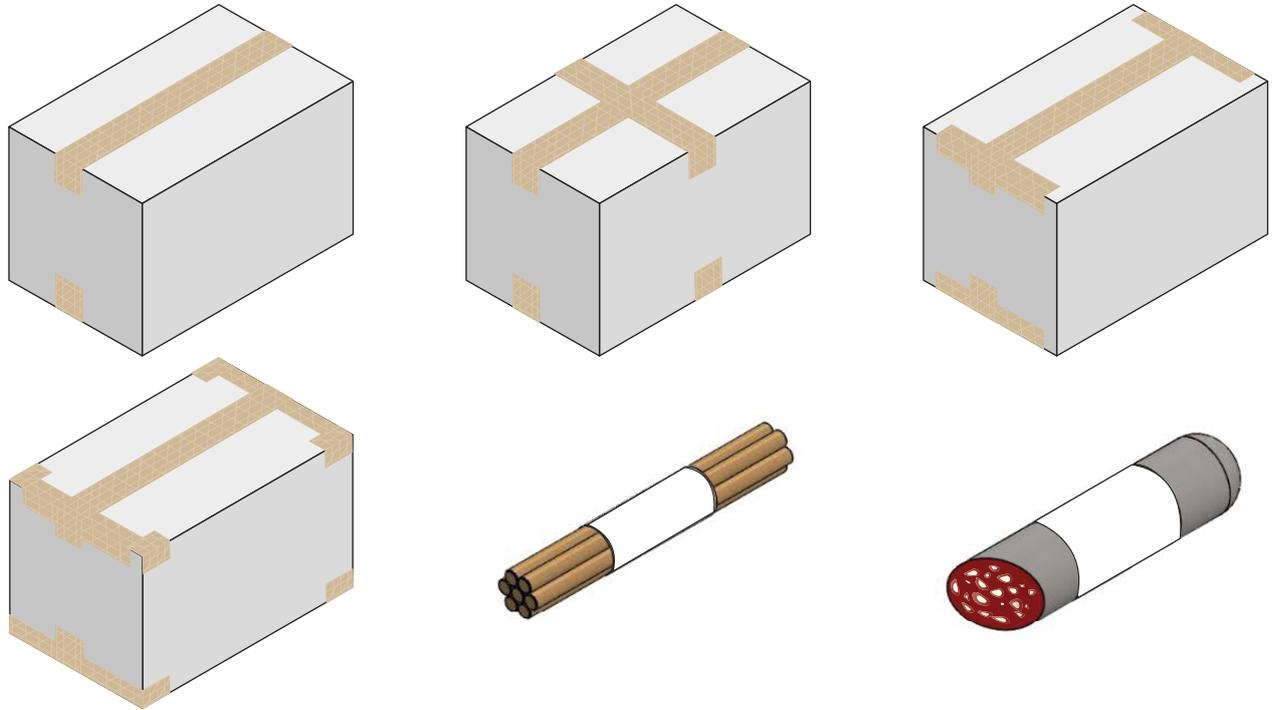
- Dispense the paper only once by pressing one of the buttons **(H)** with the preset sizes or the buttons **M2 (M)** and **M1 (N)**.
- By pressing the **START/PAUSE** button **(P)** the machine repeats the last command used between those with the preset sizes **(H)** or those with the stored length **M2 (M)** and **M1 (N)**.
- Once the machine is switched off and on again, no paper is dispensed by pressing the **START/PAUSE** button **(P)** alone. It will be necessary to press again the button for the paper size you intend to dispense.

If necessary, it is still possible to set defined sizes for the **M2 (M)** and **M1 (N)** buttons using the **F11** and **F12** funct. and save the customization in a work program (see *par. "2.2.1" pag. 11*).

The size stored on the **M1** can be recalled using the single pedal (optional).

The sizes stored on **M2** and **M1** can be recalled using the double pedal (optional).

The manual working mode allows the operator to dispense strips of paper in mixed lengths according to their needs, and is indicated to close packages of the types shown below:



F01 = M1 - M2 - M2

From the “HOME PAGE” follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set semi-automatic working mode **M1; M2; M2** through funct. **F01**.

For this mode it is necessary to have set the defined sizes for **M1** and **M2** through the funct. **F11** and **F12** and to save the customization in a work program (see *par. “2.2.1” pag. 11*).

- By pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal) the machine delivers a strip of paper of stored length for **M1**. Subsequently, with each press of the button/pedal, the machine delivers a strip of length **M2** and then **M2**, and goes back again to **M1**.
- On the display, on the “HOME PAGE”, the sequence set in **F01** is displayed in the top right-hand corner. The stored length that will be executed by pressing the **START/PAUSE** button (**P**) is the one that is flashing on the display, so that the operator can always know which phase of the work cycle he is in.

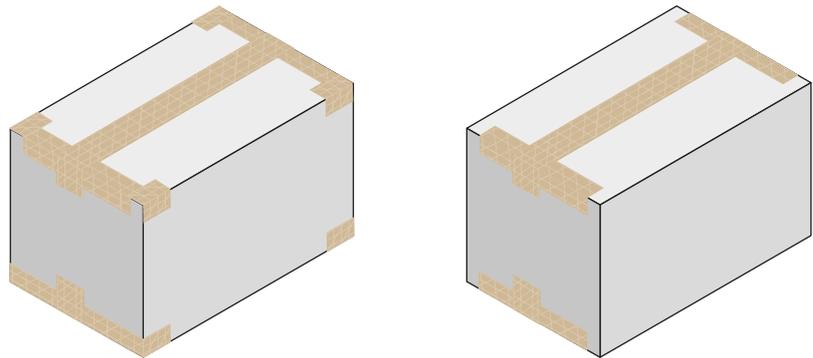


- If the dispensed paper strip is not compliant (low glue humidification, no cutting, paper jamming, finished roll, etc.) it is possible to interrupt the semi-automatic cycle sequence by pressing one of the preset size buttons (**H**), **M2 (M)**, **M1 (N)** or **ESC (B)**; by doing so, the cycle returns to its initial length **M1**.
- To resume the cycle from where it was interrupted, should the situation require the machine to be reset to its correct working setting first, you can move between the phases of the sequence by using the **UP ARROW (D)** and **DOWN ARROW (E)** buttons; the corresponding phase will flash on the display.

If necessary, by using the buttons with the preset sizes **(H)**, or **M2 (M)** and **M1 (N)**, you can still use the machine in manual mode.

It is advisable to estimate the size of the packages present in the company and save them on the appropriate work programs, so that based on the package to be taped, the operator always has a reference work program.

The **M1-M2-M2** working mode allows the operator to close the packages faster, and is indicated for the following types:



F01 = M1 - M2

From the "HOME PAGE" follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set the semi-automatic working mode **M1**; **M2** through funct. **F01**.

For this mode it is necessary to have set the defined sizes for **M1** and **M2** through the funct. **F11** and **F12** and to save the customization in a work program (see *par. "2.2.1" pag. 11*).

- By pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal) the machine delivers a strip of paper of stored length for **M1**. Subsequently, with each press of the button/pedal, the machine delivers a strip of length **M2**, and goes back again to **M1**.
- On the display, on the "HOME PAGE", the sequence set in **F01** is displayed in the top right-hand corner. The stored length that will be executed by pressing the **START/PAUSE** button (**P**) is the one that is flashing on the display, so that the operator can always know which phase of the work cycle he is in.

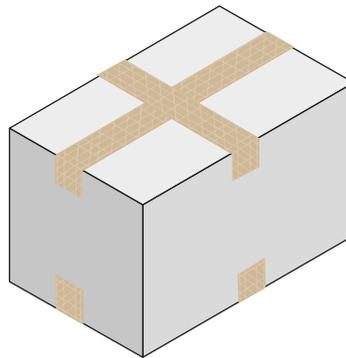


- If the dispensed paper strip is not compliant (low glue humidification, no cutting, paper jamming, finished roll, etc.) it is possible to interrupt the semi-automatic cycle sequence by pressing one of the preset size buttons (**H**), **M2 (M)**, **M1 (N)** or **ESC (B)**; by doing so, the cycle returns to its initial length **M1**.
- To resume the cycle from where it was interrupted, should the situation require the machine to be reset to its correct working setting first, you can move between the phases of the sequence by using the **UP ARROW (D)** and **DOWN ARROW (E)** buttons; the corresponding phase will flash on the display.

If necessary, by using the buttons with the preset sizes **(H)**, or **M2 (M)** and **M1 (N)**, you can still use the machine in manual mode.

It is advisable to estimate the size of the packages present in the company and save them on the appropriate work programs, so that based on the package to be taped, the operator always has a reference work program.

The **M1-M2** working mode allows the operator to close the packages faster, and is indicated for the following types:



F01 = M1 - M2 - M3 (optional can only be activated by the Manufacturer)

From the "HOME PAGE" follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set semi-automatic working mode **M1; M2; M3** through funct. **F01**.

For this mode it is necessary to have set defined sizes for **M1, M2** and **M3** using the funct. **F11, F12** and **F13** and save the customization in a work program (see *par. "2.2.1" pag. 11*).

- By pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal) the machine delivers a strip of paper of stored length for **M1**. Subsequently, with each press of the button/pedal, the machine delivers a strip of length **M2** and then **M3**, and goes back again to **M1**.
- On the display, on the "HOME PAGE", the sequence set in **F01** is displayed in the top right-hand corner. The stored length that will be executed by pressing the **START/PAUSE** button (**P**) is the one that is flashing on the display, so that the operator can always know which phase of the work cycle he is in.

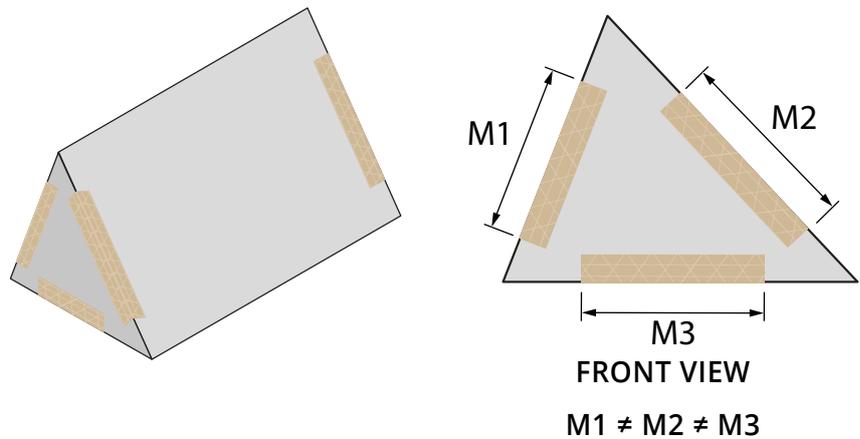


- If the dispensed paper strip is not compliant (low glue humidification, no cutting, paper jamming, finished roll, etc.) it is possible to interrupt the semi-automatic cycle sequence by pressing one of the preset size buttons (**H**), **M2 (M)**, **M1 (N)** or **ESC (B)**; by doing so, the cycle returns to its initial length **M1**.
- To resume the cycle from where it was interrupted, should the situation require the machine to be reset to its correct working setting first, you can move between the phases of the sequence by using the **UP ARROW (D)** and **DOWN ARROW (E)** buttons; the corresponding phase will flash on the display.

If necessary, by using the buttons with the preset sizes **(H)**, or **M2 (M)** and **M1 (N)**, you can still use the machine in manual mode.

It is advisable to estimate the size of the packages present in the company and save them on the appropriate work programs, so that based on the package to be taped, the operator always has a reference work program.

The **M1-M2-M3** working mode allows the operator to close the packages faster, and is indicated for the following types:



F01 = MAN**F02 = on (optional paper repeat photocell)**

From the "HOME PAGE" follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set the manual working mode using the funct. **F01**.

Enable the paper repeat mode using the funct. **F02**.

- Dispense the paper by pressing one of the buttons **(H)** with the preset sizes or the buttons **M2 (M)** and **M1 (N)**; then, by pressing the **START/PAUSE** button **(P)**, the machine continues to automatically dispense strips of paper of the previous sizes at a time interval set through the funct. **F03**.
- During automatic dispensing, dispensing can be paused by pressing the **START/PAUSE** button **(P)** or **ESC (B)**. Press the **START/PAUSE** button **(P)**/pedal again to resume dispensing the paper.
- To completely stop the automatic dispensing press **RANDOM** button **(L)**; the machine will dispense one last strip of paper and then the sequence will reset and stop.
- If the automatic dispensing is in progress and one of the buttons **(H)** with the preset sizes is pressed or the buttons **M2 (M)** and **M1 (N)** are pressed, the machine will replicate the pressed button, overwriting the one previously stored for automatic dispensing.
- Once the machine is switched off and on again, no paper is dispensed by pressing the **START/PAUSE** button **(P)** alone. It will be necessary to press again the button relating to the size of the paper to be dispensed in sequence.

With **F02 = off** the repeat function is disabled but the machine will still signal through the display (**E07** paper presence) the presence of paper or foreign objects present in the paper guide unit which, if not removed, could hinder the outflow of a new piece of paper creating jams.



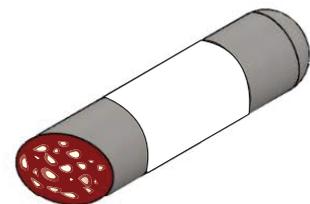
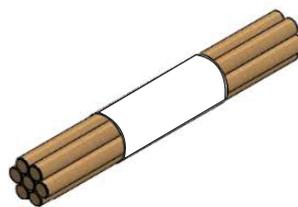
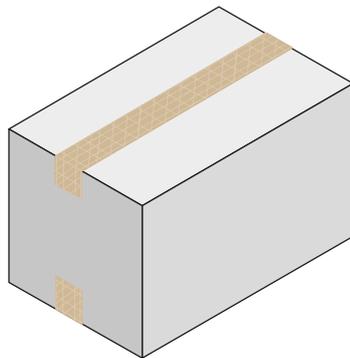
In this case, thanks to the error report, the machine will not deliver the next flap until the photocell is released.

If necessary, it is still possible to set the defined sizes for the **M2 (M)** and **M1 (N)** buttons using the **F11** and **F12** funct. and save the customization in a work program (see *par. "2.2.1" pag. 11*).

The size stored on the **M1** can be recalled using the single pedal (optional) or by the **M1 (N)** button.

The sizes stored on **M2** and **M1** can be recalled using the double pedal (optional) or by the **M2 (M)** and **M1 (N)** buttons.

The manual working mode with repeater enabled allows the operator to recall the strip of gummed paper in mixed lengths according to their needs, and is indicated to close packages of the types shown below:



INFORMATION



It is important to set the delay properly: if it is too short compared to the production time, the gummed paper dries and becomes unusable. On the contrary, if it is excessively prolonged with respect to production times, the operator will have to wait for the the paper to be dispensed by the machine, increasing production times.

F01 = M1 - M2 - M2

F02 = on (optional paper repeat photocell)

From the "HOME PAGE" follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set semi-automatic working mode **M1; M2; M2** through funct. **F01**.

Enable the paper repeat mode using the **F02** funct..

For this mode it is necessary to have set the defined sizes for **M1** and **M2** through the funct. **F11** and **F12** and to save the customization in a work program (see *par. "2.2.1" pag. 11*).

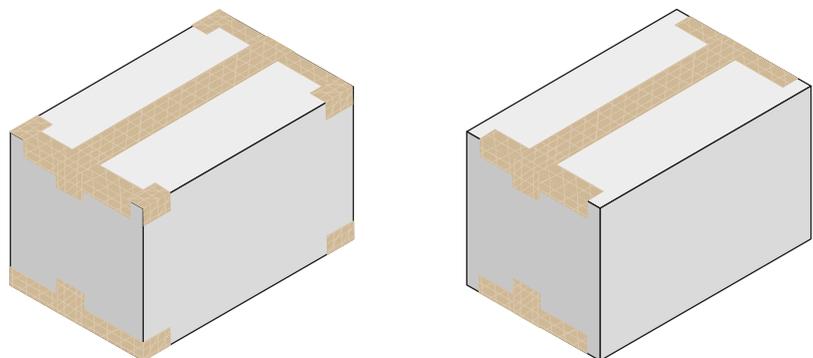
- By pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal) the machine delivers a first strip of paper of stored length for **M1**. Subsequently, at a time interval set through the functions inherent in the delays, the machine continues to automatically dispense strips of paper of stored length for **M2** (with delay **F05**) and then **M2** (with delay **F05**), and goes back again to **M1** (with delay **F04**).
- If **F04 = 0**, once the sequence is finished and the machine returns to **M1**, the automatic dispensing stops.
- If **F05 = 0**, the dispensing rate of paper with length set to **M2** (**F12**) will be given by the operator pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal).
- On the display, on the "HOME PAGE", the sequence set in **F01** is displayed in the top right-hand corner. The stored length that will be dispensed automatically according to the set delay is the one that is flashing on the display, so that the operator can always know which phase of the work cycle he is in.



- During automatic dispensing, dispensing can be paused by pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal). Press the button/pedal again to resume dispensing the paper.
- By pressing the **ESC** button (**B**) it is possible to exit the automatic dispensing and use the machine in manual mode. To completely stop the automatic dispensing press **RANDOM** button (**L**); the machine will dispense one last strip of paper and then the sequence will reset and stop.
- If the dispensed strip of paper is not compliant (little humidification of the glue, no cutting, paper jamming, finished roll, etc.) it is possible to interrupt the automatic dispensing by pressing a button between those with the preset sizes (**H**), **M2 (M)**, **M1 (N)**, in this way the machine will dispense a strip of the required length and return to **M1** at the beginning of the cycle.
- To resume the cycle from where it was interrupted, should the situation require the machine to be reset to its correct working setting first, you can move between the phases of the sequence by using the **UP ARROW (D)** and **DOWN ARROW (E)** buttons; the corresponding phase will flash on the display.
- If the automatic dispensing is in progress and one of the buttons (**H**) with the preset sizes is pressed or the buttons **M2 (M)** and **M1 (N)** are pressed, the machine will dispense a strip of the required length and return to **M1** at the beginning of the cycle.

It is advisable to estimate the size of the packages present in the company and save them on the appropriate work programs, so that based on the package to be taped, the operator always has a reference work program.

The **M1-M2-M2** working mode with repeater enabled allows the operator to close the packages faster, and is indicated for the following types:



If you are aware of the filling times of the box or the forming time, it is advisable to set **F04** according to your needs, so that the machine repeats the initial strip **M1** when the filling is finished and the operator will have to close the upper part or when a new box to be formed will be in preparation.

INFORMATION



If you are not aware of these times or the box filling time or the forming times of a new carton board are not compatible (e.g. filling a box 20" forming a new one 5"), it is advisable to work with $F04 = 0$ and restart the sequence when deemed appropriate using the START/PAUSE button (P) / pedal.

INFORMATION



Usually the closing times of the sides of the box (H closure) are faster than the first closure that requires to lay a strip of gummed paper on the central part, which must be set on M1. To optimize production times, we recommend a configuration in which the value of F05 is lower than the value of F04.

INFORMATION



It is important to set the delay properly: if it is too short compared to the production time, the gummed paper dries and becomes unusable. On the contrary, if it is excessively prolonged with respect to production times, the operator will have to wait for the the paper to be dispensed by the machine, increasing production times.

F01 = M1 - M2

F02 = on (optional paper repeat photocell)

From the "HOME PAGE" follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set the semi-automatic working mode **M1**; **M2** through funct. **F01**.

Enable the paper repeat mode using the funct. **F02**.

For this mode it is necessary to have set the defined sizes for **M1** and **M2** through the funct. **F11** and **F12** and to save the customization in a work program (see *par. "2.2.1" pag. 11*).

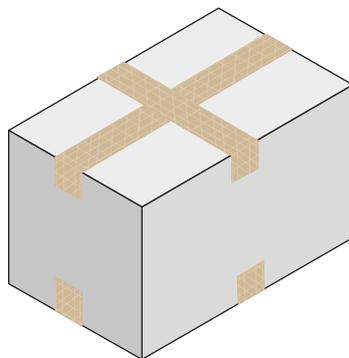
- By pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal) the machine delivers a first strip of paper of stored length for **M1**. Subsequently, at a time interval set by the functions inherent in the delays, the machine continues to automatically dispense strips of paper of stored length for **M2** (with delay **F05**), and goes back again to **M1** (with delay **F04**).
- If **F04 = 0**, once the sequence is finished and the machine returns to **M1**, the automatic dispensing stops.
- If **F05 = 0**, the dispensing rate of paper with length set to **M2** (**F12**) will be given by the operator pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal).
- On the display, on the "HOME PAGE", the sequence set in **F01** is displayed in the top right-hand corner. The stored length that will be dispensed automatically according to the set delay is the one that is flashing on the display, so that the operator can always know which phase of the work cycle he is in.



- During automatic dispensing, dispensing can be paused by pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal). Press the button/pedal again to resume dispensing the paper.
- By pressing the **ESC** button (**B**) it is possible to exit the automatic dispensing and use the machine in manual mode. To completely stop the automatic dispensing press **RANDOM** button (**L**); the machine will dispense one last strip of paper and then the sequence will reset and stop.
- If the dispensed strip of paper is not compliant (little humidification of the glue, no cutting, paper jamming, finished roll, etc.) it is possible to interrupt the automatic dispensing by pressing a button between those with the preset sizes (**H**), **M2 (M)**, **M1 (N)**, in this way the machine will dispense a strip of the required length and return to **M1** at the beginning of the cycle.
- To resume the cycle from where it was interrupted, should the situation require the machine to be reset to its correct working setting first, you can move between the phases of the sequence by using the **UP ARROW (D)** and **DOWN ARROW (E)** buttons; the corresponding phase will flash on the display.
- If the automatic dispensing is in progress and one of the buttons (**H**) with the preset sizes is pressed or the buttons **M2 (M)** and **M1 (N)** are pressed, the machine will dispense a strip of the required length and return to **M1** at the beginning of the cycle.

It is advisable to estimate the size of the packages present in the company and save them on the appropriate work programs, so that based on the package to be taped, the operator always has a reference work program.

The **M1-M2** working mode with repeater enabled allows the operator to close the packages faster, and is indicated for the following types:



If you are aware of the filling times of the box or the forming time, it is advisable to set **F04** according to your needs, so that the machine repeats the initial strip **M1** when the filling is finished and the operator will have to close the upper part or when a new box to be formed will be in preparation.

INFORMATION



If you are not aware of these times or the box filling time or the forming times of a new carton board are not compatible (e.g. filling a box 20" forming a new one 5"), it is advisable to work with $F04 = 0$ and restart the sequence when deemed appropriate using the button / pedal.

INFORMATION



Usually the closing times of the sides of the box (H closure) are faster than the first closure that requires to lay a strip of gummed paper on the central part, which must be set on M1. To optimize production times, we recommend a configuration in which the value of F05 is lower than the value of F04.

INFORMATION



It is important to set the delay properly: if it is too short compared to the production time, the gummed paper dries and becomes unusable. On the contrary, if it is excessively prolonged with respect to production times, the operator will have to wait for the the paper to be dispensed by the machine, increasing production times.

F01 = M1 - M2 - M3 (optional can only be activated by the Manufacturer)

F02 = on (optional paper repeat photocell)

From the "HOME PAGE" follow the path:

- 1) FUNCT.
- 2) CHANGE VALUE
- 3) Funct. list

Set semi-automatic working mode **M1; M2; M3** through funct. **F01**.

Enable the paper repeat mode using the **F02** funct..

For this mode it is necessary to have set the defined sizes for **M1, M2** and **M3** through the funct. **F11** and **F12** and to save the customization in a work program (see *par. "2.2.1" pag. 11*).

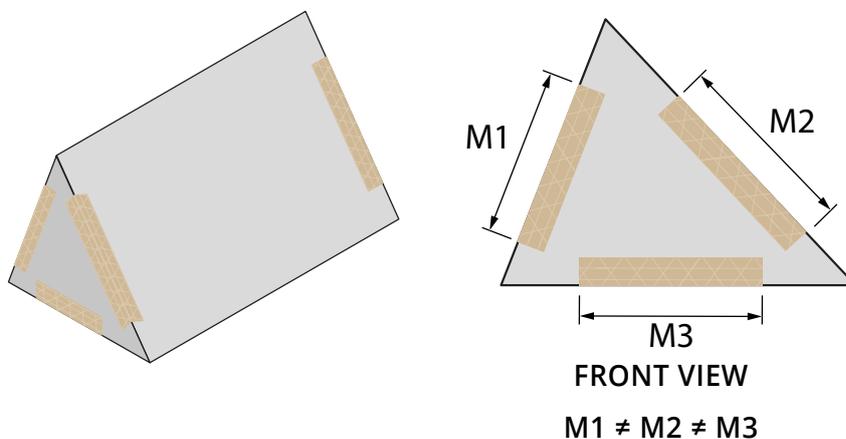
- By pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal) the machine delivers a first strip of paper of stored length for **M1**. Subsequently, at a time interval set through the functions inherent in the delays, the machine continues to automatically dispense strips of paper of stored length for **M2** (with delay **F05**) and then **M3** (with delay **F06**), and goes back again to **M1** (with delay **F04**).
- If **F04 = 0**, once the sequence is finished and the machine returns to **M1**, the automatic dispensing stops.
- If **F05 = 0**, the dispensing rate of paper with length set to **M2** (**F12**) will be given by the operator pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal).
- If **F06 = 0**, the dispensing rate of paper with length set to **M3** (**F13**) will be given by the operator pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal).
- On the display, on the "HOME PAGE", the sequence set in **F01** is displayed in the top right-hand corner. The stored length that will be dispensed automatically according to the set delay is the one that is flashing on the display, so that the operator can always know which phase of the work cycle he is in.



- During automatic dispensing, dispensing can be paused by pressing the **START/PAUSE** button (**P**) (or by pressing the optional single pedal). Press the button/pedal again to resume dispensing the paper.
- By pressing the **ESC** button (**B**) it is possible to exit the automatic dispensing and use the machine in manual mode. To completely stop the automatic dispensing press **RANDOM** button (**L**); the machine will dispense one last strip of paper and then the sequence will reset and stop.
- If the dispensed strip of paper is not compliant (little humidification of the glue, no cutting, paper jamming, finished roll, etc.) it is possible to interrupt the automatic dispensing by pressing a button between those with the preset sizes (**H**), **M2 (M)**, **M1 (N)**, in this way the machine will dispense a strip of the required length and return to **M1** at the beginning of the cycle.
- To resume the cycle from where it was interrupted, should the situation require the machine to be reset to its correct working setting first, you can move between the phases of the sequence by using the **UP ARROW (D)** and **DOWN ARROW (E)** buttons; the corresponding phase will flash on the display.
- If the automatic dispensing is in progress and one of the buttons (**H**) with the preset sizes is pressed or the buttons **M2 (M)** and **M1 (N)** are pressed, the machine will dispense a strip of the required length and return to **M1** at the beginning of the cycle.

It is advisable to estimate the size of the packages present in the company and save them on the appropriate work programs, so that based on the package to be taped, the operator always has a reference work program.

The **M1-M2-M3** working mode with repeater enabled allows the operator to close the packages faster, and is indicated for the following types:



If you are aware of the filling times of the box or the forming time, it is advisable to set **F04** according to your needs, so that the machine repeats the initial strip **M1** when the filling is finished and the operator will have to close the upper part or when a new box to be formed will be in preparation.

INFORMATION



If you are not aware of these times or the box filling time or the forming times of a new carton board are not compatible (e.g. filling a box 20" forming a new one 5"), it is advisable to work with F04 = 0 and restart the sequence when deemed appropriate using the button / pedal.

INFORMATION



Usually the closing times of the sides of the box (H closure) are faster than the first closure that requires to lay a strip of gummed paper on the central part, which must be set on M1. To optimize production times, we recommend a configuration in which the value of F05 is lower than the value of F04.

INFORMATION



It is important to set the delay properly: if it is too short compared to the production time, the gummed paper dries and becomes unusable. On the contrary, if it is excessively prolonged with respect to production times, the operator will have to wait for the the paper to be dispensed by the machine, increasing production times.

5 ALARM LIST

INFORMATION



If an error is reported on the display, it is possible to press the ESC button (B) to reset it, only if it has been previously resolved.

PROBLEM	CAUSE	SOLUTION
Error code E01 Hatch open	Hatch not closed properly	Close the hatch correctly
	Absence of the magnet	Check for the presence of magnet and sensor
Error code E04 Low battery (battery-powered version only)	Absence or malfunction of the closed lid detection sensor	Contact the Assistance Service regarding electrical anomalies
	Low battery	Recharge the battery
Error code E05 Paper depleted Only if F09 > 0 ("end of roll" working mode)	Battery pack anomaly	Contact the Assistance Service regarding electrical anomalies
	Paper finished	Replace the paper roll
Error code E07 Presence of tape in output (only version with paper repetition photocell assembled)	Data entered in F09 "Length tapes" are inconsistent	Check the set roll and check the data entered in the key length menu
	Presence of paper or residual material that prevents correct dispensing	Remove paper or residues from the paper guide unit
	Photocell reading fault	Check that the photocell works correctly and that it is in its seat Contact the Assistance Service regarding electrical anomalies

PROBLEM	CAUSE	SOLUTION
Error code E50 Motor block	Mechanical impediments that do not allow the drag wheel to turn	Remove paper or material accumulated under the drag wheel
	Motor connector disconnected	Connect the motor
	Worn motor brushes	Contact the Assistance Service regarding electrical anomalies
Error code E51 Motor overload	Mechanical impediments that do not allow the drag wheel to turn	Remove paper or material accumulated under the drag wheel
	Motor shorted	Contact the Assistance Service regarding electrical anomalies
	Damaged motherboard	
Error code E60 Missing tray detected	Tray not connected correctly	Check the electrical connection
	Rusty, dirty or damaged contacts	Contact the Assistance Service regarding electrical anomalies
	Tray went into protection due to overtemperature (not detectable from the motherboard)	
Error code E61 Heater shorted	Electronic board short circuit	Replace humectant unit and/or motherboard
		Contact the Assistance Service regarding electrical anomalies
Error code E62 Heater temperature anomaly	The temperature does not increase	Replace humectant unit and/or motherboard
		Contact the Assistance Service regarding electrical anomalies

PROBLEM	CAUSE	SOLUTION
Error code E63 Overtemperature	Humectant unit overtemperature	Stop the machine immediately, let the tray cool and remove it, being careful not to burn yourself <hr/> Replace the humectant unit and/or the motherboard <hr/> Contact the Assistance Service regarding electrical anomalies



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