Condensed Operating Instructions

Overview:

The OptiFlex technology is the same for all Iconotech printers. This tech paper wil show you the proper startup, run and shut down proceedures necessary to produce optimum printed results.

START UP

1. Place the ink in and ink out tubes in the pumps and lock in place, taking care to not pinch the hose when the clamp is fully closed. (Fig 1.) Note the correct orentation of hose to pump as shown. (Fig. 2) Turn on the main power.
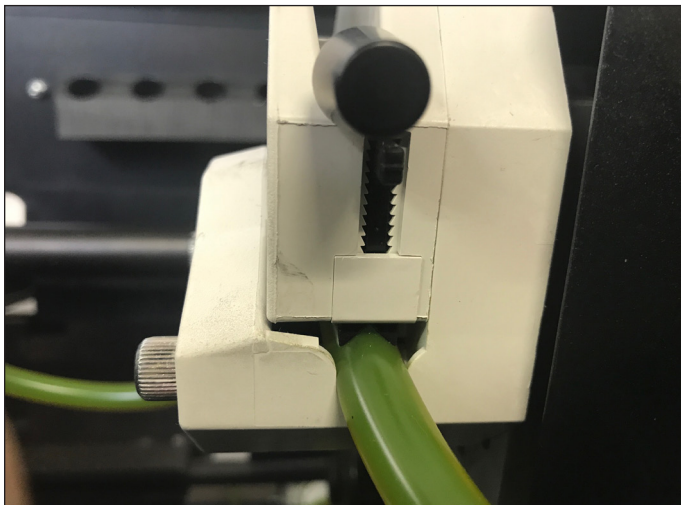

Fig. 1

INK OUT - PUMP

INK IN - PUMP

FLOW IN

Fig. 2

2. If a box was placed under the cylinder on shutdown, remove it now. Turn the pump selector switch to Auto and push the Ink In button. The pump will run for about 7 minutes. (Fig. 3) Set the speed dial to 20 and press and hold the Jog button for 20 seconds. The cylinder will stay rotating while the cylinder charges. Press stop when the pump has stopped stopped running.
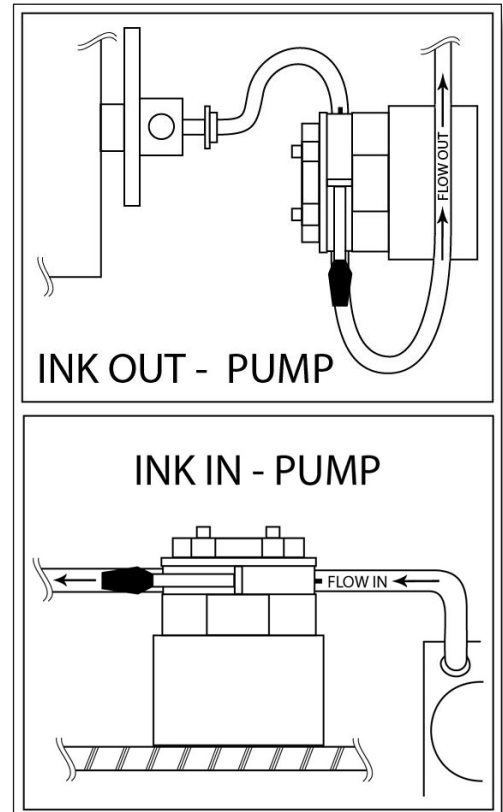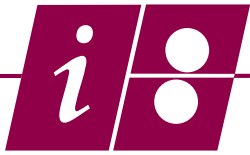

Fig. 3

Case Printing Systems

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3. Blot the cylinder. Create blotting material by opening up old RSC cases and stacking two on top of each other. You need a printable area of at least 34" x 12". (Fig. 4) Run them at a speed of 20 in the sample mode and "print" the full pad without a stencil in place. Depending on the condition of the pad you made need to do this 2 to 10 times. (Fig. 5) This process removes excess oil and brings fresh ink to the surface. The ink should look dull and uniform.
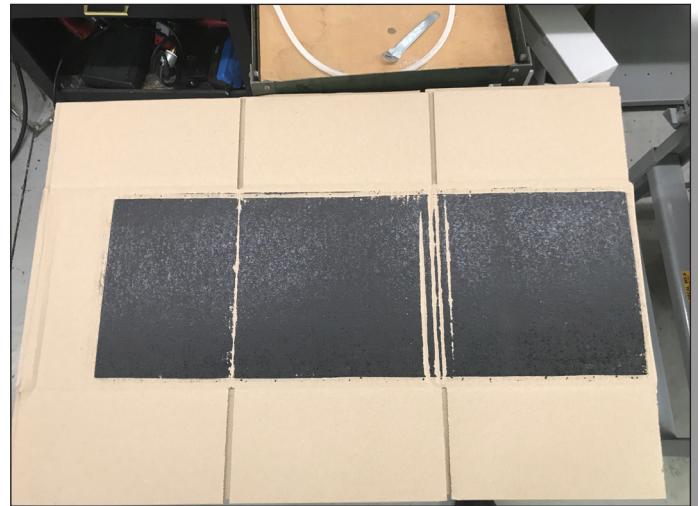

Fig. 4

Fig. 5

4. Load the new stencil.

5. Adjust the case magazine side walls to the size case to be printed. Load the magazine with cases

6. Set the guide walls in the restacker 1/2" wider than where they are set on the printer

7. Make sure the restacker is in position. Turn on the restacker

PRINTING

1. Run one case in Sample mode to verify print message and print placement is correct

2. Set the batch counter for the desired run number

3. Push the Run button

4. While printing:
    Note the print quality
        If poor - Check air pressure: min - 65 psi, max - 85 psi
        Increase bounce and or decrease run speed. Do not exceed 1/8" of bounce
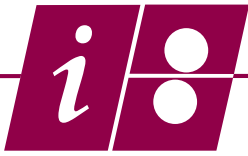
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If offset is noted - decrease bounce and or increase run speed

To help prevent jams
Do not try to load more cases if there are only a few cases left in the magazine
Maintain a fairly tight width on magazine walls to cases
Watch for cases that are glued together
Do not overload the magazine

5. After completing the print run:
Do the following
Unload unused cases from magazine
Remove the old stencil, wipe off any excess ink accumulations
Apply the new stencil
Set the case magazine and restacker for the new case
Sample new print message
Push the Run button when ready to print

SHUT DOWN

1. Turn off the restacker and return conveyor

2. Set the ink pump mode to manual and hit the ink out button. Run the pump until you see the return line blowing bubbles back into the tank. Turn the pump off and release the clamps on both the in and out pumps

3. Remove the old stencil. Make a pad with 4 paper towels, (Fig. 5) and jog the cylinder around while holding the pad in pressure with the print pad. (Fig. 6) This forces the residual ink in the pad back into the cylinder. This takes two passes, leave the cylinder in the home position without a stencil in place.

Fig. 5

Fig. 6

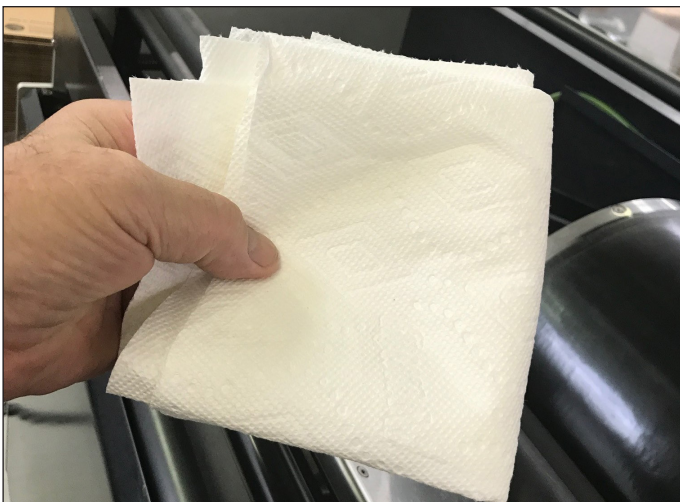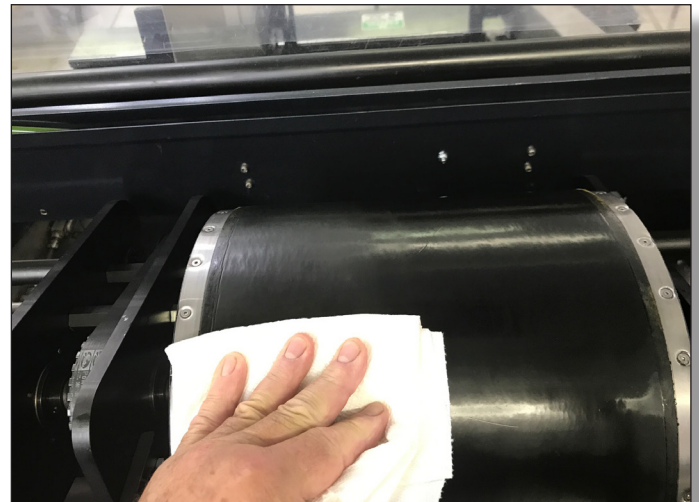## Condensed Operating Instructions

4. Blow off any dust

5. Place an old case under the cylinder and close lid

6. Turn off main power