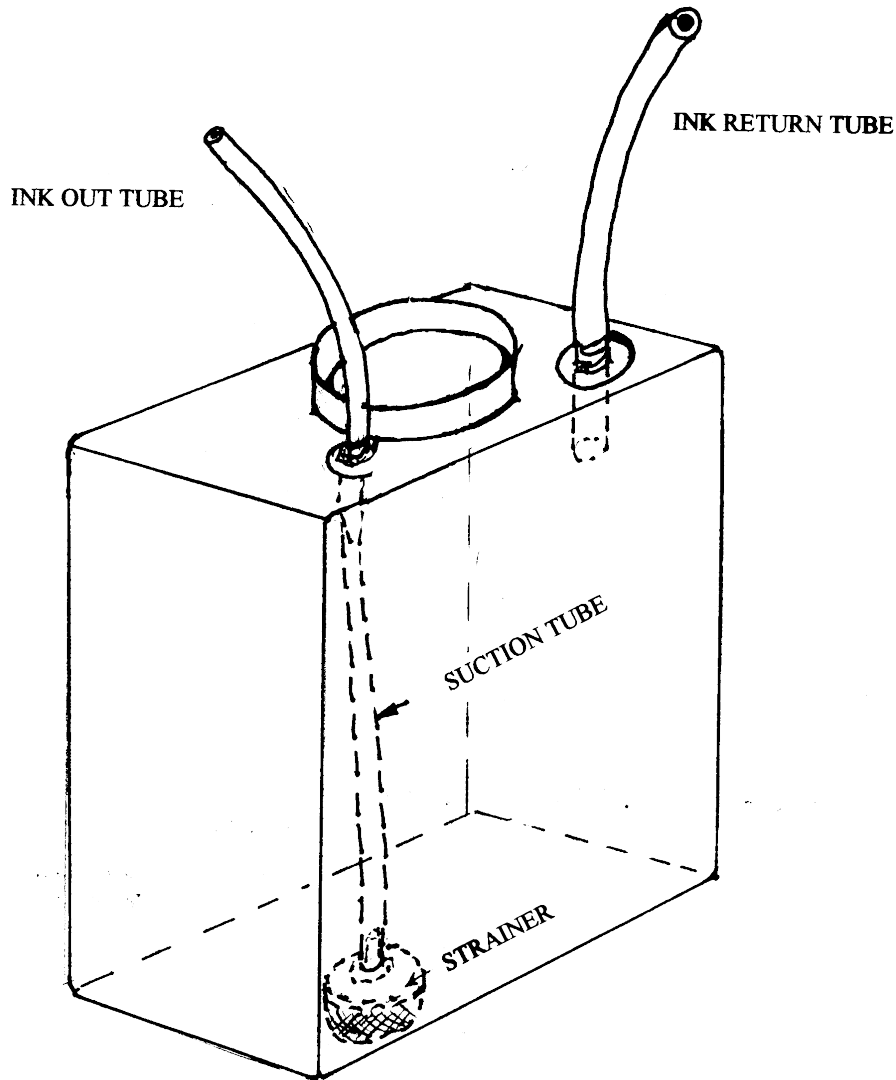


***Ink Bottle with Strainer***

In order to keep fibers from being drawn into the suction tube and into the print cylinder, there is a strainer at the end of the suction tube. Over a period of time, fibers could accumulate in the bottom of the ink bottle, and eventually reduce the flow of ink to the cylinder. We recommend the strainer be checked for fiber build up every two months. If substantial, the bottle should be emptied (when ink is at a low level) and wiped out or washed out. Also, the strainer should be cleaned before putting it back into service.

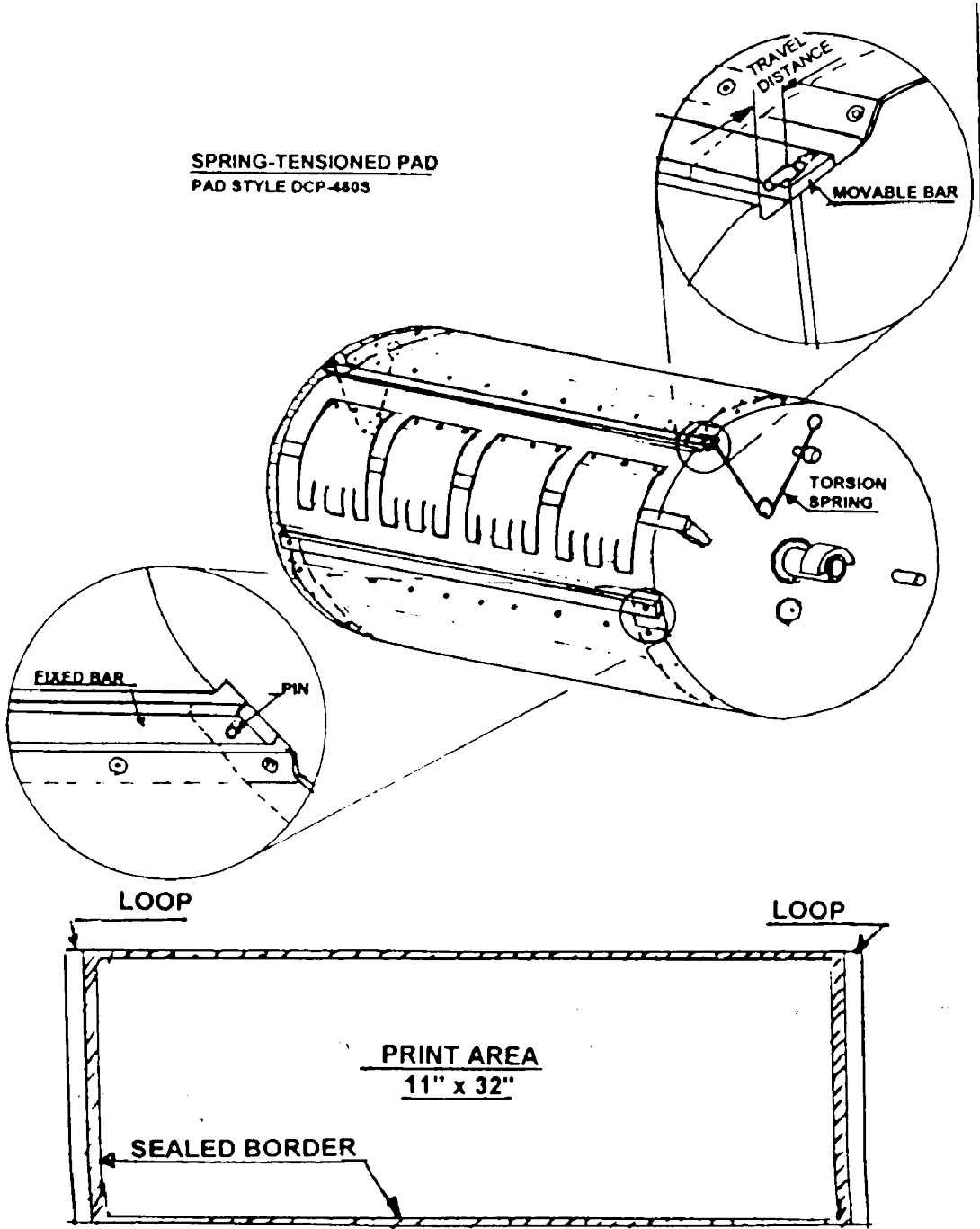


## **ICONOTECH INK PADS**

Ink pads for the Case Printer are made by Iconotech specifically for our ink and print cylinder design. They consist of two parts, a felt body and a silk screen top. Each pad has a sealed border that keeps the ink from leaking when held tightly against the print cylinder. There is a loop at each end to hold the tensioning bars.

### ***Installing a New Pad on a Clean or New Cylinder***

- 1 Bring the print cylinder to HOME position.
- 2 Fill the ink container with 1 gallon of ink.
- 3 Remove the stencil loading device.
- 4 Jog cylinder until the leading edge bar is at the 11 o'clock position.
- 5 Put the bar with round holes through the loop at one end of the pad. Center it and put the bar on the two pins. Rotate the cylinder while keeping tension on the pad, to keep the bar from falling off the pins, until the trailing loop is at the 11 o'clock position. Insert the bar with slotted holes through the loop. Center the pad. Tilt the bar to insert the spring hooks. With hooks inserted, make sure the bar lays flat. Lift the spring over the screw on both sides, giving tension to the pad. Make sure the bar is free to move and that the pad is straight and centered all around the cylinder.
- 6 Reinstall the stencil loading device.
- 7 Put on a new imaged stencil. (It will be necessary to tape the free trailing end to keep it in place.) Set the speed knob to 10, and hold the "JOG" button for 15 seconds or more, which will cause the print cylinder to rotate continuously until "STOP" is pushed. Set the "INK MANAGEMENT" switch to "MAN" and push the "INK IN" and "INK OUT" buttons. In general, for a new or clean cylinder, allow 1/2 hour to fill the print cylinder with ink.
- 8 If an ink leak develops, make sure the spring loaded end of the pad is free to move, and that the bar has not reached the end of its possible travel.



Spring Tensioned Pad – Part # DCP - 460S (12" cylinder)

### ***Removing a Used and Installing a New Ink Pad***

- 1 With the print cylinder in HOME position and the ink selector switch on MANUAL, pump ink out of the cylinder by pushing the INK OUT button and letting it run until the return flow into the ink jug is air bubbles. Normally this should take about 10 minutes unless there is excess ink in the cylinder.
- 2 Remove the stencil loading device. Put a used corrugated box under the print cylinder to catch any dripping ink.
- 3 Rotate print cylinder 180° from HOME position so the stencil clamping area is up.
- 4 Leave the stencil on the pad. Lift the torsion springs off the tensioning screws and remove movable bar from pad.
- 5 Lift the fixed bar from the two pins (three pins for the 24" print cylinder) and remove it from the pad. Note the pins are set at an angle and the holes in the bar are also drilled at an angle. Set the bar down so the right and left sides are in the same orientation as when the bar was on the cylinder. Start rolling up the old pad by rolling it inward with the stencil out to clear the area near the pins that hold the fixed bar.
- 6 Put the fixed bar through the loop at one end of the new pad maintaining the right and left orientation explained in the previous step. Note the holes in the end of the bar should be at the same angle as the pins so that the bar can lay flat on the cylinder. Center the pad on the bar and put the bar on the two pins (three pins on the 24" print cylinder).
- 7 With one hand, keep tension on the new pad by pulling down on its free end while you slowly JOG the print cylinder around. Continue to roll up (inward with the stencil out) the old pad. Make sure the new pad goes on straight.
- 8 When the print cylinder has completed a revolution, discard the rolled up old pad. While maintaining tension on the new pad, insert the movable bar through the pad loop. Center the pad on the bar. Tilt the bar to insert the torsion spring hooks in the bar slits. With hooks inserted, make sure the bar lays as flat possible. Lift the spring over the tensioning screw on both sides, giving tension to the pad. Make sure the bar is free to move and that the pad is straight and centered all around the cylinder. The movable bar may not lay totally flat in its slot on the print cylinder until the pad is inked. Wipe off edges and clamping fingers if necessary.

### ***Maintaining the Pad***

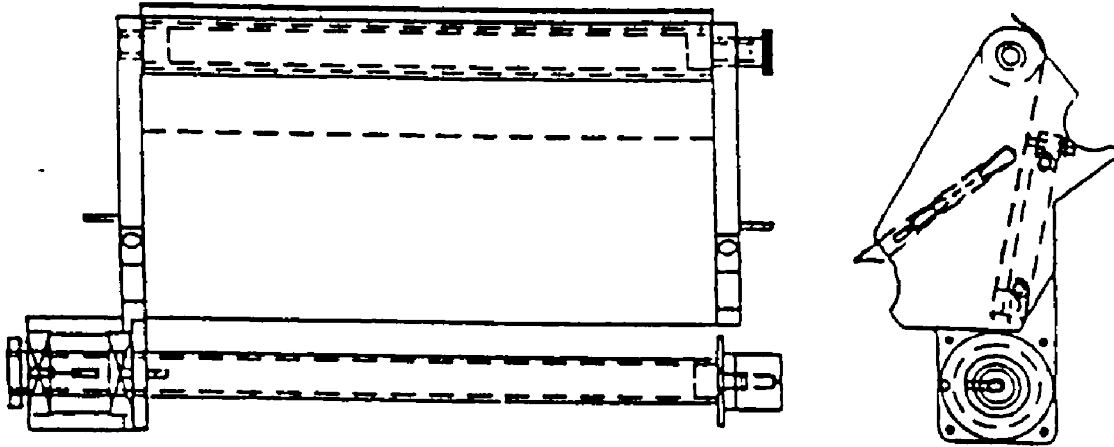
Every so often, check the pad for cuts or tears. If you observe any, replace the pad. Check weekly that the pad is under sufficient tension and that the tensioning bar has not reached the end of its possible travel. The life of the pad is dependent on those two things.

***Inking the New Pad***

- 1 Place the core containing a new imaged stencil in the stencil loader and load it onto the print cylinder. Because there is no ink in the new pad for the stencil to adhere to, it will be necessary to tape the trailing end of the stencil to the finger clamping plate with cellophane tape. When the pad is inked, taping is not necessary. NOTE: always remove the tape before removing stencil.
- 2 Turn INK MANAGEMENT SELECTOR SWITCH to MANUAL and start the ink IN pump.
- 3 Set the speed to 10 CPM. Push JOG button down and hold for 15 seconds. The printer will stay running without activating the feeder. Normal filling cycle and inking of a new pad requires approximately 30 minutes.
- 4 After 25 minutes, or when the new pad is inked up almost to its full width, start the ink OUT pump. Run both pumps for another 5 minutes, then push STOP to stop the cylinder rotation. Finally, turn off both ink pumps. Run SAMPLE cycle to bring the cylinder to HOME position.
- 5 Use a sample case, preferably 36" long, and send it through the print cycle by pushing SAMPLE. This will help distribute the ink in the pad evenly and iron out the imaged stencil against the pad. Because the diameter of a newly applied pad is larger than a pad that has been used, wrinkles may appear on the stencil. By running a couple of sample cases, this condition will disappear and the stencil will be smooth and wrinkle free. The wrinkles can also be reduced by manually stretching the stencil.
- 6 The pad is now fully inked, and the printer is ready to start printing.
- 7 With the INK MANAGEMENT SELECTOR SWITCH on AUTO, both ink IN and ink OUT pumps will start when operation starts and stop at the end of a print run, or if the magazine runs out of cases. They also stop on E-STOP.
- 8 With the 24" print cylinder, follow the above procedure except double the filling time.

**THE STENCIL LOADING SYSTEM**

A semiautomatic stencil loader is included as part of the system. It allows you to load stencils onto the print cylinder under proper tension with the Plexiglas cover in place. You can begin the loading process when you receive a stencil rolled onto a paper core.



**STENCIL LOADER**

**Loading the Stencil**

- 1 Remove the used stencil from a previous run from the print cylinder. See Stencil Removal.
- 2 Push LOAD to bring the print cylinder into the proper position and then open the Plexiglas top of the printer.
- 3 Unscrew the knob (A) with the end plate (Note: left-hand threads), and push the core and stencil onto the shaft. Make sure the groove in the end of the core is on the inside and fits onto the pin at the bearing end. The imaged stencil should be unrolled from the bottom of the core with the shiny side up. See illustration on following page.