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Cleaning and lubrication procedure for the Langguth E224 labeler.

This Standard Operating Procedure applies to the applicable controls and equipment involved in the cleaning and lubrication of the labeler

- 1.1 The labeler operator is responsible for the safe operation of the machine during cleaning, and that the following procedures are followed. The operator should report any equipment deficiencies to the on shift supervisor
- 1.2 The on shift supervisor is responsible for a post cleaning inspection to ensure the following procedures are followed
- 1.3 **Preparing Labeler for Cleaning**
 - Ensure the conveyors, glue roller, label magazine, and infeed screw have been stopped via the touch screen. Depress the E-stop
 - Turn off the glue pump, remove to a pail of warm wash water
 - Remove glue hose that is adjacent to the glue roller and plug end with plastic screw
 - Move the label magazine away from the glue system with the



handwheel

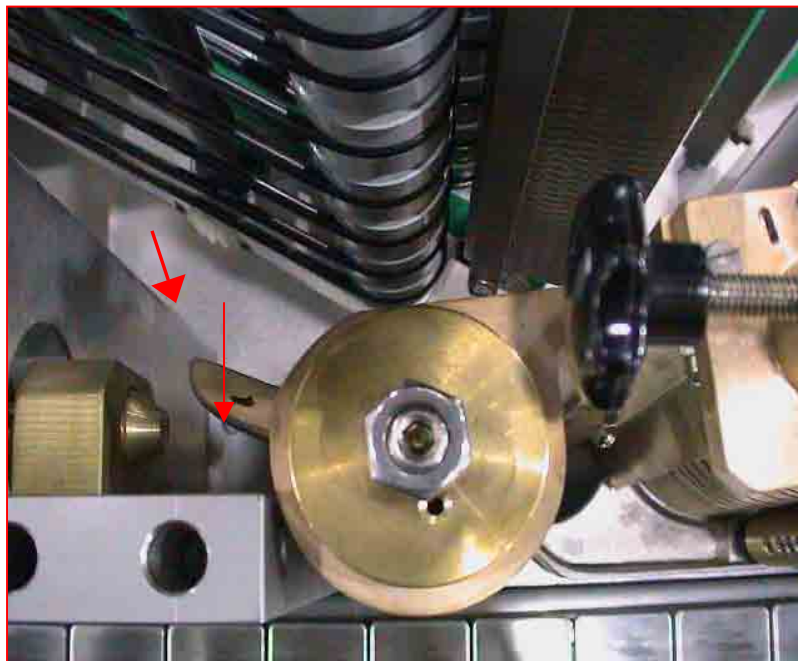
- 1.4 **Labeler Cleaning**
 - As each part of the glue system is removed, place it GENTLY in a sink of warm wash water. Do not use chemicals, high pressure water, or steam to clean. Warm wash water and scrubbing with a hand pad (“scrubby”) is sufficient

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- Remove the label deflector first, by pulling up on the hold down knob, then twisting to top towards you and then tilting the deflector away from the roll on belt as you pull it upwards. Be very careful not to scratch the roll on belt with the teeth on



- Remove the press on roller by first loosening the thumbscrew and removing it, then swinging the press on roller away from the glue roller. Pull the press on roller upwards to remove from machine.
- Next, prepare to remove the glue scraper by first turning the adjusting screw back. Swing the groove scraper teeth out of the glue roller and then lift the glue scraper straight upwards to remove



Swing in this direction

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- Loosen the thumbscrew on the glue roller, then lift it straight upwards to remove



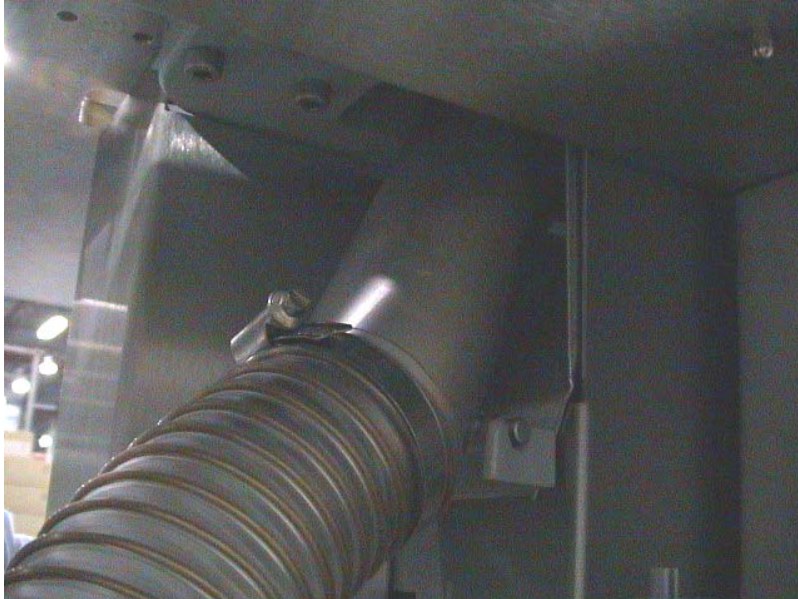
Watch the star grip on top and move it out of the way if necessary

- Lastly, remove the glue return tray that sits beneath the glue roller

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- **Remove the glue return hose from underneath the labeler and rinse it thoroughly. Soak and re-rinse as necessary**



- **While the glue system parts are soaking, clean all shafts that were previously covered by parts, and the surrounding area. Use the air gun to spray debris off the label bed and from underneath the infeed screw. Clean all glue off the roll on belt. There should be NO GLUE, cardboard or paper debris, or pieces of glass, anywhere on the labeler when you are done. Return the machine to like-new condition!**
- **Blot off excess water with paper towels when done**
- **Next, scrub the parts of the glue system with the tools provided. Be gentle – some of the parts are made of soft metal, some of the parts are delicate. The parts should be GLUE FREE when you are done. Set them aside on a paper towel to dry**

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1.5 Glue Pump Cleaning

- Before beginning the pump cleaning, disconnect the air from the pump.



- Lift the pump out as far as possible and scrape as much glue of the shaft as you can.



This is clean

- Place the glue pump in a bucket with clean water. Reconnect the air hose and start the machine, LABEL STATION ONLY, to make the pump work.

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- Place the hose inside the bucket and speed the pump strokes up if necessary to accomplish water flow.



Pump speed adjustment screw

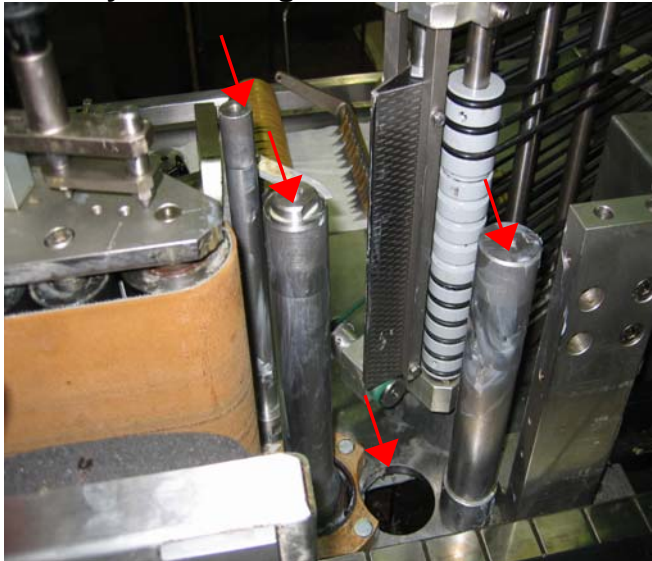
- Let the pump run for 1 hour. Disconnect the air. Rinse with clean water and clean the shafts with and the lid with a brush until all glue is gone. Lift the pump upside down and get all water out of the pump and hose. Place the pump in a bucket with clean water over the weekend and ensure that the hose connection is under water.

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1.6 Labeler Lubrication

- Start by lubricating all three shafts with a thin layer of grease



- Use a thin layer of grease to line the outside of the hole where the glue return tray sits (see above), and also to line the rubber seal on the glue return tray (see below)

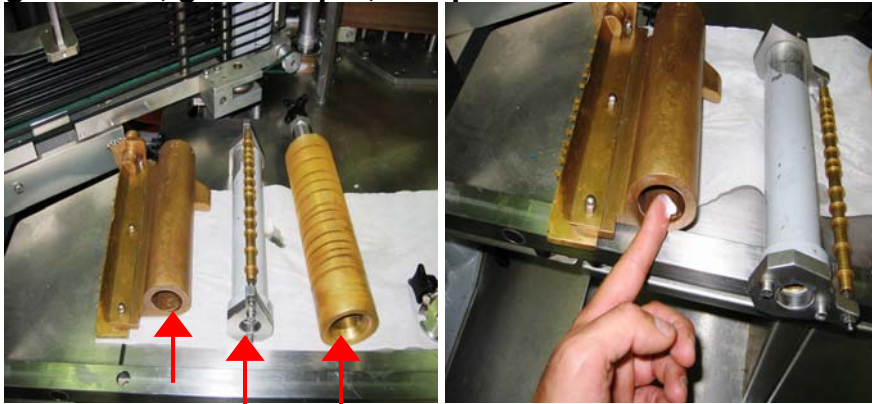
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- ONE drop of oil needs to be put on each end of the roller part of the press on roller. After oiling, the roller should move freely



- Lastly, put a thin layer of grease on the inside bottom of the glue roller, glue scraper, and press on roller



1.7 Labeler Reassembly

- Install glue return tray



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- Set the glue roller on the shaft. Turn the glue roller on the shaft until it sets down on the the square. There is almost no gap at the bottom of the glue roller.

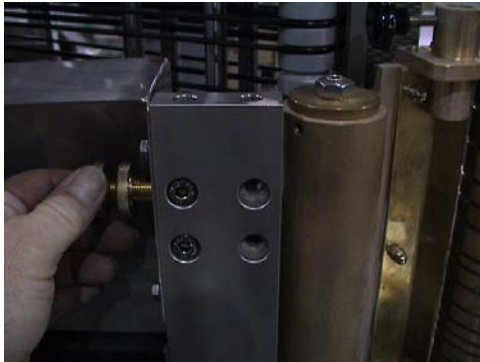


Install the glue return hose and reconnect the glue pump.

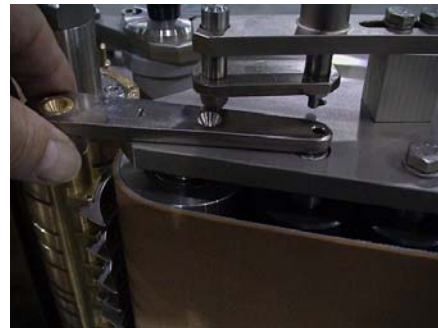


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Install the glue scraper and swing the teeth into the glue roller.



Adjust the distance of the glue scraper to the glue roller surface to a little gap.



Set the label deflector back in place and ensure proper positioning under the pull nob.



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Install label press on roller and start the glue system. Stay at the machine to make immediate glue adjustments when the glue reaches the glue roller. Set up a thin glue film. Grease here before start up.



Move the label magazine back in the operation position.

