

**INSTALLERS, SERVICE & LINE MECHANICS: PLEASE READ THIS MANUAL AND FAMILIARIZE YOURSELF THOROUGHLY BEFORE ATTEMPTING TO INSTALL OR SERVICE THE DALEMARK EQUIPMENT DESCRIBED HEREIN. FOR FURTHER ASSISTANCE, CONSULT OUR FACTORY STAFF.**

INSTRUCTION AND PARTS MANUAL

**SERIES 975  
Flat Product Ink Jet Transporter  
MODEL 975-A/TA**

**SERIAL NO. \_\_\_\_\_**

When ordering, always provide the following information:

MODEL NUMBER

SERIAL NUMBER

PART DESCRIPTION & PART NUMBER AS SHOWN IN  
PARTS LIST

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## 1. SPECIFICATIONS:

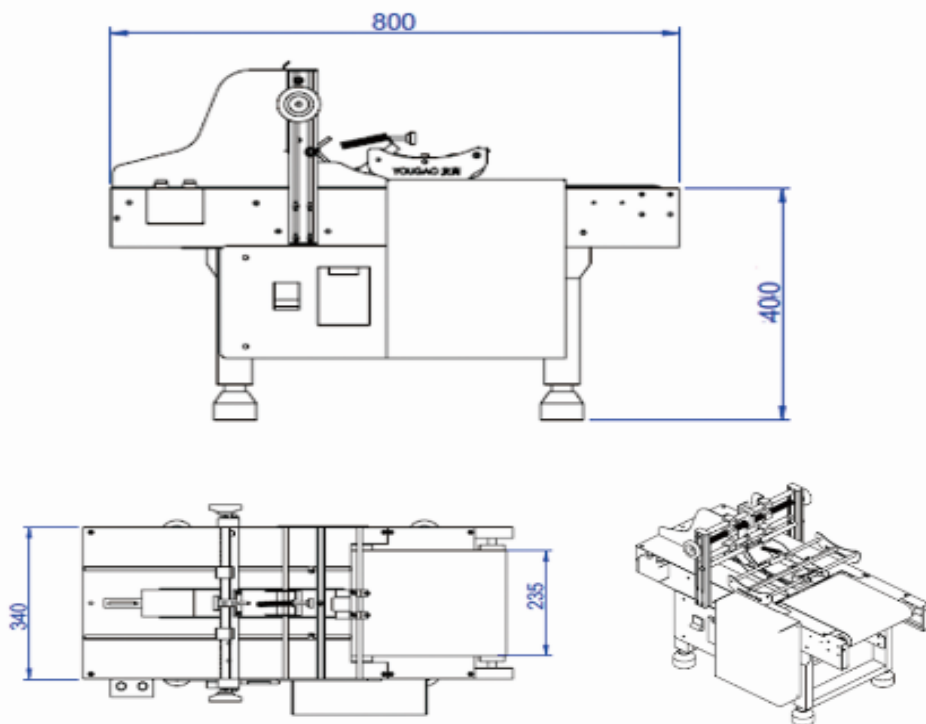
### 1.1 Machine Model & Product Sizes

- 1) MODEL 975-A/TA Standard:1420\*400/300\*725  
Length:60-320 Width:80-350 Thickness:0.02-5

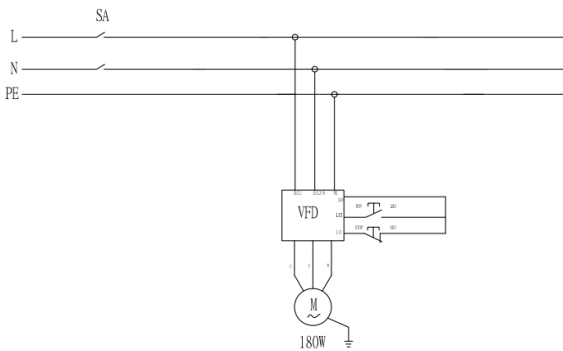
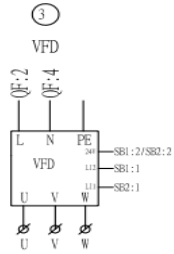
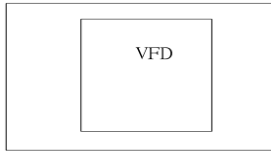
### 1.2 CONSTRUCTION:

- 1) Frame: 316 Stainless Steel
- 2) Feed: Friction Belt
- 3) Voltage: 110 VAC (220 VAC Optional)
- 4) Power: 180 W – 250 W
- 5) Speed Control: Schneider Variable Frequency
- 6) Feed Speed: 30 - 100m/min

## 2.1 MODEL 975-A/TA Layout (w/Optional Floor Base)



### 3.1 MODEL 975-A/TA Controls Layout & Wiring Diagram:



## 2. Machine Set-Up

### 4.1 In-Feed

Adjust of Product Guides and Separator:

1) Place your product between on the Infeed Belt centered between the Side Hopper Plates. Adjust the Hopper Plates so that the product remains centered in the infeed. Leave approximately 1/16" space between the product and each Side Plate.

2) Turn on the Transport with the Speed Control set to Zero. Slowly turn up the speed to determine if the Product Separator pressure needs to be adjusted. For the light/thin products you will need to increase the pressure via clockwise rotation of the Separator Belt Knob to press down on the Separator Belt to achieve proper product separation in the infeed. Likewise, for heavier/thicker products you will need to slightly raise the Separator Belt Knob via a counter-clockwise rotation of the Knob to decrease the pressure.

3) If you are feeding more than one piece per cycle increase the Knob Separator pressure.

4) If no pieces feed during a run cycle decrease the Knob Separator pressure.

5) Once the Separator is set correctly (singulated and consistent product separation and feed) adjust your Variable Speed

Controller for the desired feed speed.

## 4.2 SPEED CONTROL OPERATION

### 4.2.1 Initial Setup -

1) Press “ENT”, go into “rEF” screen, press up and down to shift the model, press down and it will show “rEF”、“NON”、“CONf”.

### 2) Speed Control -

Press “ENT”, go into “rEF” screen, press “ENT” again, it will show 0.0, press “UP” button, the number (conveyor speed) will increase, max number is 100. Press “DOWN” button, the number (conveyor speed) will decrease.

### 3) Parameter set

Press ENT, go into rEF screen, press “DOWN” button, go into “CONf” screen, then press “ENT”:

**ACCELERATION TIME SET:** Enter into “CONf” menu, press up and down to find “ACC”, press “ENT” it will show the numerical value on the screen. Press up and down to set the acceleration time.

**DEACCELERATION TIME SET:** Enter into “CONf” menu, press up and down to find “ACC”, press “ENT” it will show the numerical value on the screen. Press up and down to set the acceleration time.

**LOW SPEED SET:** Enter into “CONf” menu, press up and



down to find "LSP". Press "ENT" it will show numerical value on the screen. Press up and down to set the low speed. Numerical value is 5 Hz

**HIGH SPEED SET:** Enter into "CO nF" menu, then press up and down to find "HSP". Press "ENT" it will show numerical value on the screen. Press up and down to set the high speed. Numerical value is 50 Hz.

4) **MOTOR PARAMETER SET:** Enter menu, then press up and down to find "drC". Press "ENT" and then find the menu and press "ENT" again. Set the numerical value up and down by the button. Press "ENT" again to confirm the new value.

bFr: 50(Hz)

nPr: 0.18(power KW )

UnS: 110 or 220 (V)

nCr: 1.3 (Electric )

FrS: 50 (Hz)

nSP : 900 (r/min)

tFr: 50(Hz)

Ctt: PErF

tUn: Set the motor then enter and choose "YES". Press "ENT". Go to "tUn" menu. It will show "dOnE".

5) **CONTROL MENU SET:** Go into the menu and press up and down to find "Ctl". Press "ENT". Set the parameter by the up and down buttons and then press "ENT" again to confirm the

new value.

Fr1: A1U1

r1n: yes

CHCF: SEP

Cd1: tEr

#### 4.2.2 Restoring Factory Setting:

CONF→FULL (PRESS AND RELEASE) → FCS (PRESS AND RELEASE)

→LNL (PRESS 2 SECONDS AND RELEASE)

POWER OFF AND RESTART.

### 4.3 Transport Belt Adjustment

If the Transport Conveyor Belt is tracking to the left side, then slowly tighten the bolt on left side Pillow Block Assembly at the end of the Conveyor and confirm that the Belt is moving slowly back to a symmetrical position. Once centered observe for several cycles. If the Belt appears to run straight re-tighten the bolt on the Pillow Block. If it is tracking too far to the opposite side, then slightly back-off on the bolt until you have correct tracking. Re-tighten the bolt. Do the same for the right side if you find over time that the Conveyor Belt is tacking off-center and to the right side of the Conveyor.

#### 4.3.3 Maintenance

1) Inspection for any loose components. Tighten as needed. Bearings are sealed but lubricated with light Grease any moving parts, Shafts or Rollers periodically depending upon use. Periodically check belt tracking to avoid Belt damage.

## 4.5 Safety operation

- 1) The Speed Controller range is between 5HZ-60HZ. Avoid extremely low speed operation to avoid any potential long-term damage to the Motor.
- 2) Wipe down the Transport periodically of all dust and oils. Try to avoid operation in areas that are damp, humid or dusty.
  - 3) The machine operates on 110 or 220VAC @ 50HZ Single Phase.
  - 4) The main parameters of Speed Control have been set-up by Dalemark and should not be re-adjusted by the customer to avoid any run issues.

## 5. Operating instructions

- 2) Turn on the Main Power Switch.
- 3) Press the Start button.
  - 4) Adjust the Infeed Hoppers and Product Separator as previously stated.
- 5) Set Run Speed:  $\Delta$  &  $\nabla$  buttons on the Speed Controller – press  $\Delta$  to show speed frequency increases; press the  $\nabla$  show speed frequency decreases.
- 6) Adjustment of the Controller:

The Speed Controller has been presented by Dalemark. Simply adjust the speed you require by pressing the  $\Delta$   $\nabla$  buttons.

“H” shows the running frequency, “F” shows the setting frequency.

7) Begin Running:

After setup is complete press the “RUN” button to begin feeding. At run completion press the “STOP” button to cancel feeding.

10. End of Day Shutdown:

Please turn off the Main Power Switch when operation is complete.

## Model 975-A/TA Spare Parts List

ITEM	PART NAME	SPECIFICATION	
3	TRANSPORT BELT	BLACK TEXTURED	
12	MOTOR	180W/370W	
13	MAIN TIMING BELT	XL	
14	IN-FEED BELT	GREEN RIBBED	
15	SPEED CONTROLLER	110V/60 HZ	
16	SPROCKET AND CHAIN DRIVE	SPROCKET (3 PCS) AND CHAIN	