



MANUFACTURING INC.

***OWNER'S MANUAL***

***WEB NON-ABSORBENT  
MINI-CODERS  
ALL MODELS***

***INSTALLATION - OPERATION - MAINTENANCE***



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***NPMC-10019***

## **IMPORTANT NOTE**

JMD products are manufactured to exacting standards and every available step has been taken to assure your complete satisfaction. It is most important that the instructions contained in this manual are read and carefully followed for best results. Failure to do so may result in unsatisfactory performance, damage to the equipment and personal injury.

### **TABLE OF CONTENTS**

PREFACE . . . . .	3
SPECIFICATIONS	
WNA-109CM Top Mount Series . . . . .	4
WNA-109RM Side Mount Series . . . . .	5
Reset & Continuous Models . . . . .	6
Mounting Configuration . . . . .	6
Printing Dies . . . . .	7
Ink Rolls . . . . .	8
QUICK START	
Installing the Pre-Inked Roll . . . . .	9
Installing the Printing Dies . . . . .	12
Adjusting the Ink Roll Eccentric . . . . .	13
BASIC PRINCIPALS OF OPERATION	
Inking System . . . . .	14
Using the 4 oz. Reservoir Ink Cartridges . . . . .	14
Selecting an Appropriate Ink . . . . .	15
Ink Drying Time Considerations . . . . .	16
WEB PRINTING	
Mounting Your Coder . . . . .	18
Special Web Printing Applications . . . . .	19
Printing on Narrow Web Materials . . . . .	19
Printing Directly on Master Rolls . . . . .	19
CARTON PRINTING	
Carton Alignment . . . . .	20
Die Positioning for Indexing Applications . . . . .	22
MAINTENANCE	
Pre-Inking a New Roll . . . . .	24
Cleaning the Printing Dies . . . . .	25
Cleaning the Transfer Roll . . . . .	26
Cleaning the Coder . . . . .	26
TRANSFER ROLL / PRINT PRESSURE READJUSTMENT	
Adjusting the Transfer Roll Pressure . . . . .	27
Adjusting Printing Pressure . . . . .	28
PARTS LIST & DIAGRAMS . . . . .	29

#### **- LIMITED WARRANTY -**

JMD Non-absorbent Mini-Coders are guaranteed to be free from defects in materials and workmanship for a period of 90 days from the date of purchase. Components found to be defective during this time will be repaired free of charge if returned to the factory. Damage resulting from use of improper inks, improper installation, or operation is not covered under the scope of this warranty. For warranty service please contact our Customer Service Department.

## **PREFACE**

Printing on non-absorbent materials has always been a major problem in industrial applications. The high degree of maintenance required to keep conventional coders operating with solvent based inks has made many companies opt for manual marking as a cost effective alternative. With JMD Non-absorbent Coders, printing on non-absorbent materials can be accomplished with the same relative ease as printing on absorbent materials. This breakthrough in Non-absorbent coder design opens up in-plant printing opportunities which previously were regarded as too costly to consider.

Inks used to print on absorbent materials dry through absorption into the material being printed. Inks used to print on non-absorbent materials dry through the rapid evaporation of the ink solvents after the print is applied. Since the ink solvents must evaporate very rapidly on the printed material, they also evaporate very rapidly from the ink rolls and ink wells of conventional coders therefore requiring constant maintenance.

The proprietary design of the Non-absorbent Inking System effectively eliminates the rapid evaporation of the ink solvents from the ink roll and additionally provides for convenient automatic re-inking of the roll without interrupting the printing process. After many months of design engineering and field testing, the Non-absorbent Mini-Coder is both simplistic in design and extremely effective in operation. The relatively low cost of this system makes in-plant printing of all types of non-absorbent materials a practical reality. The following pages of this manual explain the installation, operation and maintenance of Non-absorbent Mini-Coder and are the key to trouble free non-absorbent printing.

### **QUICK START** **PAGES 9 THRU 15**

This manual was written with a full understanding that very few people like to read manuals or have the time to do so. To accommodate those who have little time to spare, we have included a Quick Start section which will get your coder operating in just a few minutes.

To keep your coder operating properly, it is important to read and understand the Basic Principles of Operation section which explains the basic operation of the Non-absorbent Inking System.

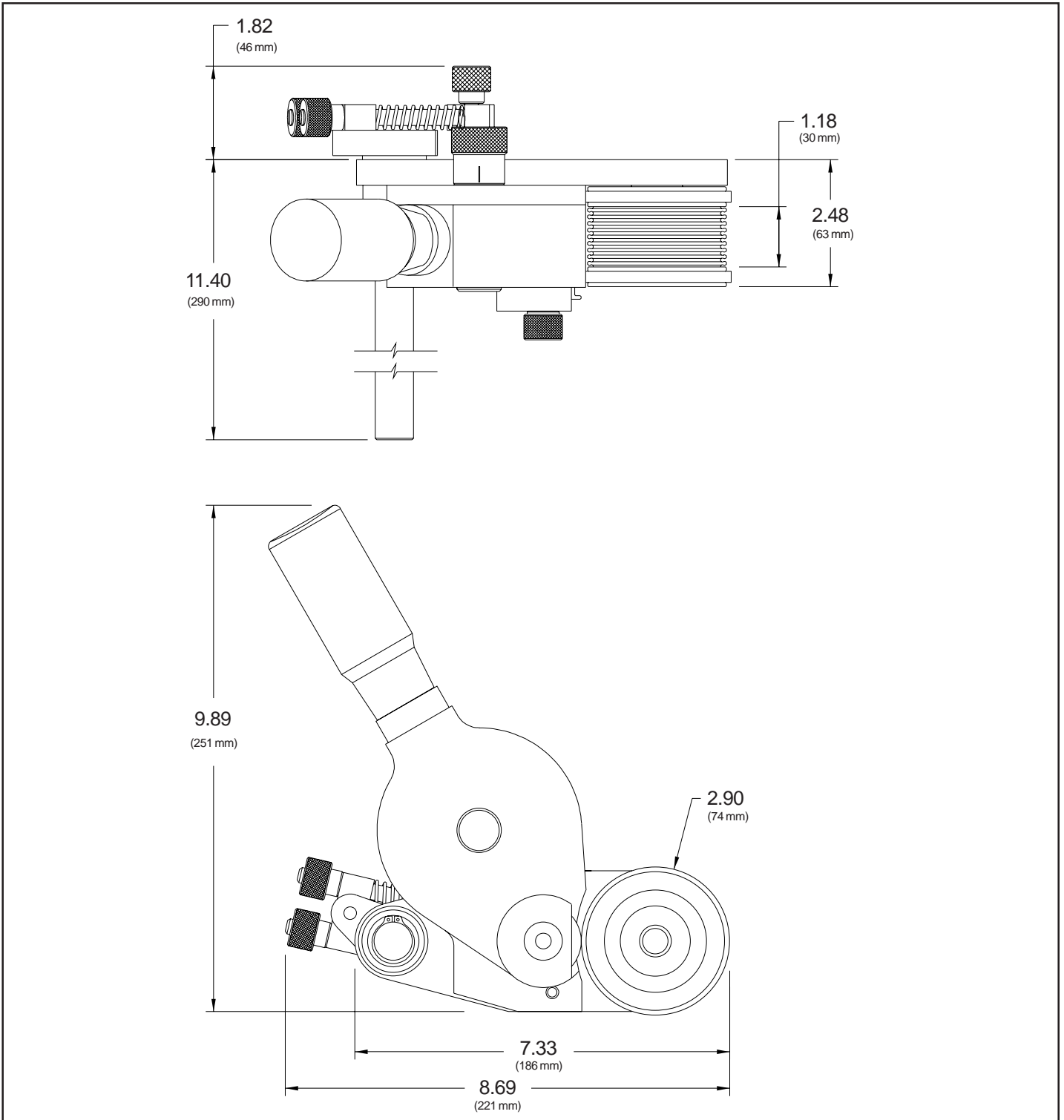
## **CODER SPECIFICATIONS**

The specification section includes drawings with the basic dimensions of the coders, the net weights, maximum die capacities, maximum print width and print drum circumferences. This section also lists the specifications for the printing dies and an explanation of the Reset and Continuous models and the various mounting configurations.

# SPECIFICATIONS

## NON-ABSORBENT MINI-CODER SPECIFICATIONS WNA-109CM TOP MOUNT SERIES

Model Shown: WNA-109CM-RT



NET WEIGHT:

MAXIMUM DIE SIZE - US STANDARD:

MAXIMUM DIE SIZE - METRIC CODERS ONLY:

PRINT DRUM CIRCUMFERENCE:

4 LBS. - 10 OZ. (2.10 KG.)

7/8" (8 RIBS) X 8-3/8" LENGTH

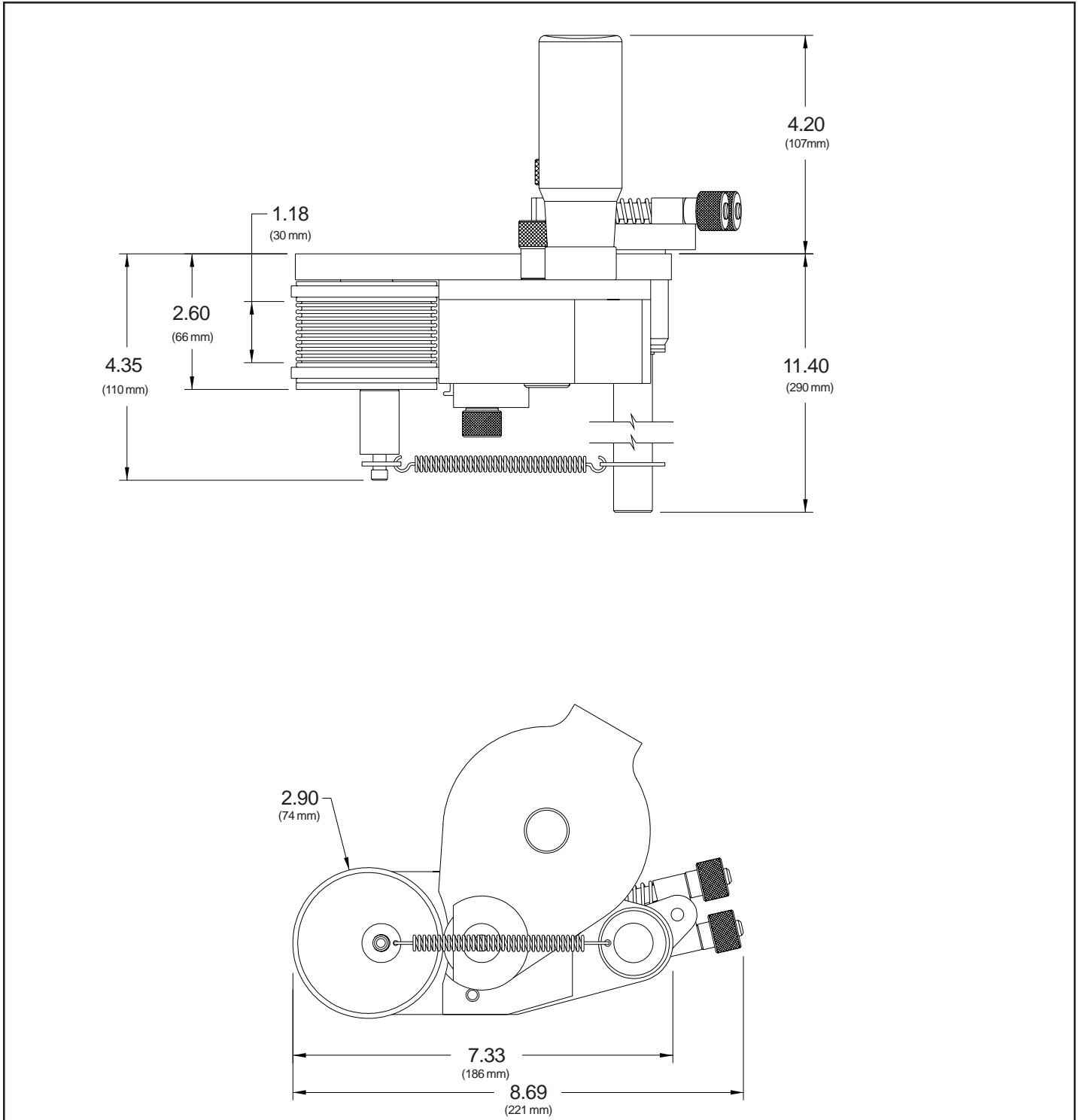
23.8 MM (7 RIBS) X 212.7MM LENGTH

APPROXIMATELY 9.0" (228 MM) MEASURED AT DIE FACE

# SPECIFICATIONS

## NON-ABSORBENT MINI-CODER SPECIFICATIONS WNA-109RM SIDE MOUNT SERIES

Model Shown: WNA-109RM-LW



**NET WEIGHT:**

**MAXIMUM DIE SIZE - US STANDARD:**

**MAXIMUM DIE SIZE - METRIC CODERS ONLY:**

**PRINT DRUM CIRCUMFERENCE:**

**4 LBS. - 5 OZ. (1.96 KG.)**

**7/8" (8 RIBS) X 8-3/8" LENGTH**

**23.8 MM (7 RIBS) X 212.7MM LENGTH**

**APPROXIMATELY 9.0" (228 MM) MEASURED AT DIE FACE**

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# SPECIFICATIONS

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## RESET AND CONTINUOUS MODELS

JMD Non-absorbent Mini-Coders are available in both reset and continuous models.

**Reset coders** contain a print drum spring return mechanism which provides print registration capabilities when carton printing (see Figure 1). As the trailing edge of a carton passes the coder, the print drum automatically rotates back to the same starting or "home" position. There must be adequate space between cartons at any given line speed for this mechanism to work properly. Printing with an reset coder will allow the imprint on each carton to be registered in the same position relative to the leading edge of the carton. The code will repeat every 9.1" down the length of the carton.

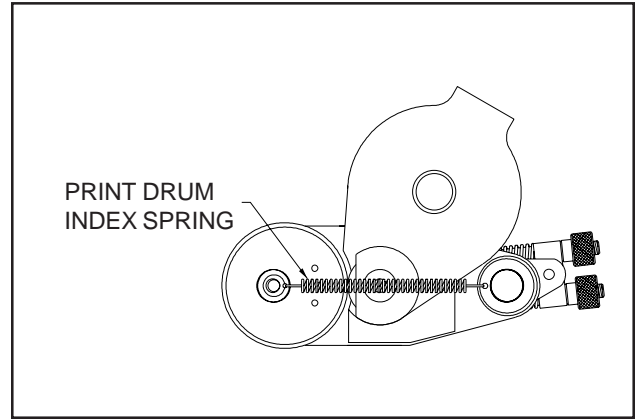


FIGURE 1

**Continuous coders** have print drums which simply rotate on bearings with no spring return mechanism. These coders normally used for web printing applications where the print drum stays in contact with the web at all times. If used in carton printing applications, when the trailing edge of a carton passes the coder, the print drum rotation stops at a random position. When the next carton engages the print drum, the code will begin printing at a random position relative to the leading edge of the carton and repeat the code every 9.1" down the length of the carton.

## MOUNTING CONFIGURATION

The mounting configuration of a coder is determined by how the machine is designed to be mounted in relation to the product and its movement. All references to mounting configuration are made as though you are viewing the production line with the product moving away from you. JMD Mini-Coders are available from the factory in 4 different mounting configurations as shown.

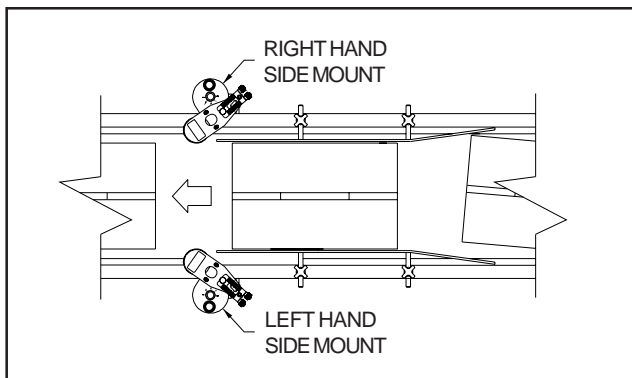


FIGURE 2

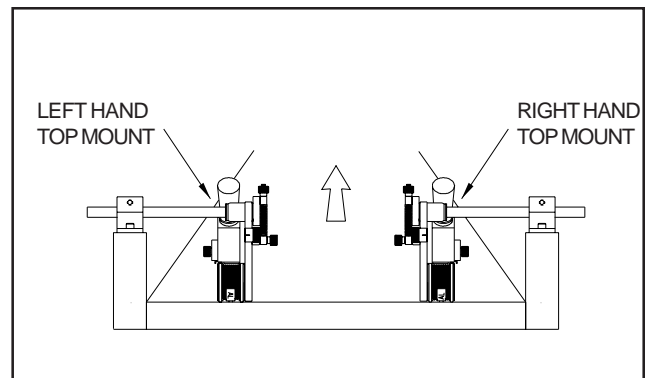


FIGURE 3

**Note:** Due to the asymmetrical design of the Inking System on the Non-absorbent Mini-Coder, the mounting configurations are not field convertible and must be properly specified when ordering.

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## SPECIFICATIONS

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### **RIBtype® PRINTING DIES**

JMD Non-absorbent Coders are designed to use RIBtype® printing dies which have a molded rib backing. The ribs on the back of the die snap into mating ribs in the Drum Cover on the print drum as shown.

The standard printing dies are available in sets with many sizes and character styles. The sets are a combination of individual alphabetic and numeric characters or in sets containing numeric characters only. These character sets or “sorts” can be used to make up text messages and code numbers as necessary.



FIGURE 4

Printing dies are also available in “logo” form in which a complete text message, company logos or trademarks are produced on a single piece of rib backed rubber. These “logo” dies are photographically reproduced from black and white art work. Due to their unitized construction, these dies generally produce better print quality and are much faster to change in the field. For details on ordering custom logo dies, please contact our Customer Service Department.

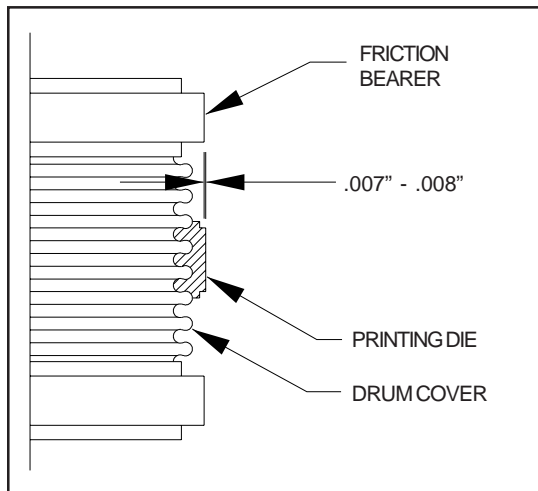


FIGURE 5

The dies are manufactured to precision thickness tolerances which are very critical to the performance of these coders. When installed, the face of the printing die should extend only .007" - .008" beyond the radius of the Friction Bearers as shown. Using dies that do not meet the design specifications will result in poor print quality and possible damage to the transfer roll.

Although there are several competitive rib backed die systems available, it is very important to note that they are not all made to the same rib spacing or thickness specifications and are not interchangeable.

### **CODER MODELS DESIGNED FOR METRIC RIBtype® PRINTING DIES**

JMD also offers Metric RIBtype® die systems for use in countries where metric character sizes are the standard. The Metric dies are thicker and the rib spacing differs slightly from the standard printing dies therefore the two versions are not compatible. To accommodate the differences, the print drums for Metric dies are machined to a slightly different diameter from the U.S. versions.

The coder model numbers on Metric coders will have a “-T” suffix and the Metric Drum Covers have a distinct pink color.

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# SPECIFICATIONS

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## INK ROLLS

JMD offers two ink roll options for the Non-absorbent Mini-Coders - each with unique characteristics which will help determine the suitability for a specific printing application. The coders are designed to accommodate both types of ink rolls without modification. A detailed review of your printing requirements will determine the best choice of ink rolls for your particular application.

### ***XF NEOPRENE INK ROLLS***

JMD's XF Neoprene Ink Rolls are a re-inkable roll which can be used with a variety of alcohol or glycol base inks. These rolls are normally supplied in a dry condition from the factory and require pre-inking prior to mounting on the coder. During production printing, when the ink capacity of the roll is depleted, installing a 4 Oz. Reservoir Ink Cartridge in the coder's reservoir Bottle Port will re-ink the roll automatically as production continues.

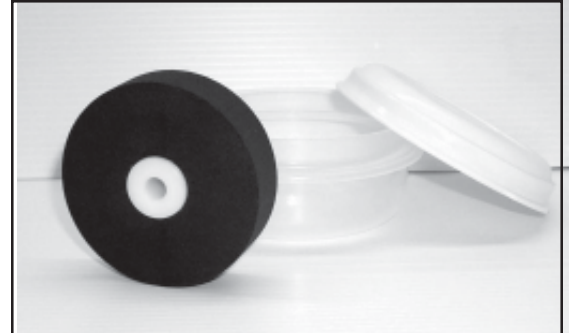


FIGURE 6

In high speed web printing applications, JMD's #100 Inks provide drying times of approximately 2 seconds at 75 Degree F. (24 Deg. C) ambient temperatures. Many other inks, both dye and pigment based, can be used in these ink rolls to meet the specific application requirements. Refer to the Basic Principles of Operation section on Page 15 for more information on selecting an appropriate ink.

### ***TYPE MT INK ROLLS***

Type MT Ink Rolls are disposable pre-inked rolls which are available in a variety of fast drying colors. The MT Ink Rolls provide excellent color density and adhesion on most materials and an average yield of just under 500,000 impressions before replacement is necessary. Since these rolls are not re-inkable, all references in the manual regarding the use of 4 Oz. reservoir Ink Cartridges should be disregarded when using these rolls on your coder. The ability to operate the coder without a Reservoir Ink Cartridge makes the MT Rolls particularly well suited for applications requiring printing on the bottom of web materials.



FIGURE 7

The Type MT Ink Rolls provide drying times between 4 - 7 seconds at 75 Degree F. (24 Deg. C) ambient temperatures. The added convenience and simplicity of using the Type MT Ink Rolls makes them an ideal choice when production operators have little time to monitor the inking system.

JMD Non-absorbent Mini-Coders are shipped from the factory, fully assembled and adjusted for the specific mounting configuration indicated by the coder part number and description. The only additional preparation required before putting the coder into operation is to install a pre-inked ink roller, install the printing dies, and mount the coder on your production equipment.

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## QUICK START

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**Warning:** *Non-absorbent inks contain flammable solvents. Do not smoke or handle these rolls in the presence of sparks or open flames. Inks will also stain clothing, furniture, carpeting and your hands. Rubber gloves should be worn during the following procedures.*

**The ink roll you install on the coder must be properly pre-inked.** If your coder was supplied with a dry XF Neoprene ink roll, refer to the **Maintenance Section** page 26 for inking instructions.

Rollers that have been pre-inked at the factory are normally slightly oversaturated with ink to compensate for potential solvent loss during shipping and storage. If you received a pre-inked ink roll with your coder, it is important to examine the roll prior to installation. **The ink roll should be thoroughly saturated with ink but not dripping wet.** Excess ink can be easily removed by lightly rolling the ink roll across a clean piece of absorbent paper.

### INSTALLING THE PRE-INKED ROLL

- 1 - To install the pre-inked roll, first turn the Ink Roll Eccentric Adjusting Knob “A” to the “MIN” position.**

This moves the Ink roller axle away from the Transfer Roll and enables the ink roll to be installed without interference with the Transfer Roll during reassembly of the inking system.

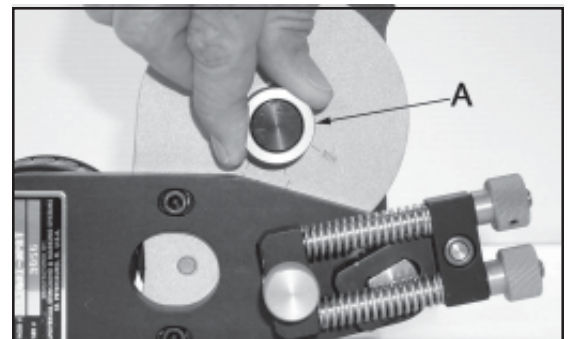


FIGURE 8

- 2 - While holding the Drive Wheel Cover “B” in place, remove the knurled Cover Retaining Knob “C” by turning it counterclockwise.**

The Cover Retaining Knob holds the entire inking system together and other parts may fall free from the coder if not held securely when this knob is removed.

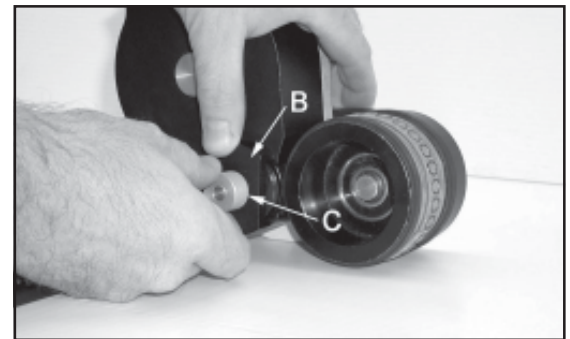


FIGURE 9

- 3 - Hold Inking System Cover “D” in place and remove Knurled Drive Wheel Cover “B”.**

The Knurled Drive Wheel Cover is very loose fitting. Note that the flat on the side of the Drive Wheel Cover is aligned towards the print drum. During reassembly, this must be replaced in the same position.

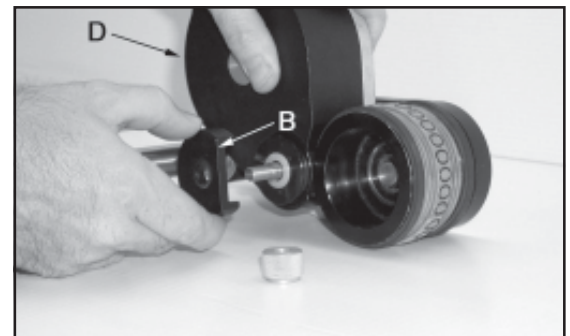


FIGURE 10

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## QUICK START

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### 4 - Remove the Knurled Drive Wheel “E”.

The Knurled Drive Wheel rests on top of the Transfer Roller and is installed over 3 stainless drive pins which protrude through 3 mating holes in the Drive Wheel. This is a close tolerance fit and there will be some resistance from the engagement with the rubber Friction Bearer on the Print Drum when this is removed. A slight rotation or wiggling action will make removal easier.

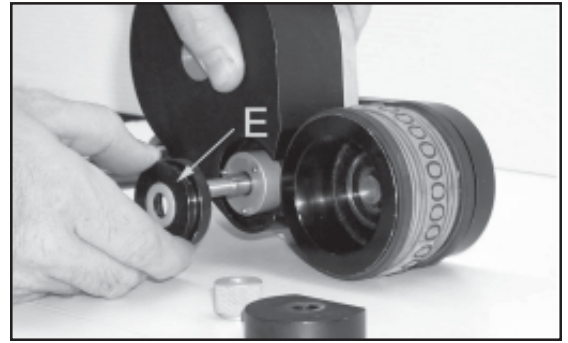


FIGURE 11

### 5 -Carefully pull the Inking System Cover “D” directly away from the Inking System Baseplate “F”. Do not let the cover drag across the surface of the Transfer Roller “G”.

The Transfer Roll Surface is a finely engraved Delrin plastic material which can be easily scratched. When assembled, the Transfer Roll resides in a very close fitting cavity in Inking System Cover. Carefully pulling the Inking System Cover directly away from the Baseplate until it clears the Transfer Roll will prevent damage to the Transfer Roll surface.

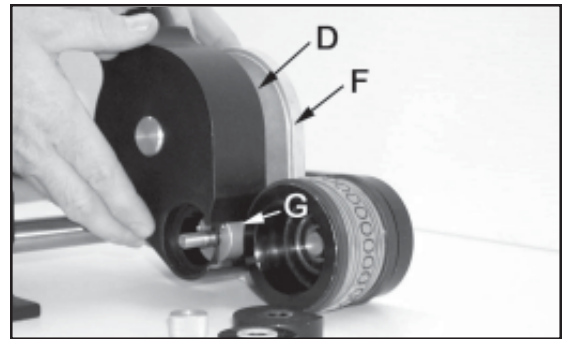


FIGURE 12

### 6 - Put on a pair of rubber gloves and remove the pre-inked ink roller from the storage container by inserting a small rod (a pencil works nicely) in the center of the core.

Keeping ink off your gloves at this stage will prevent contamination of the external parts of the coder during roll installation

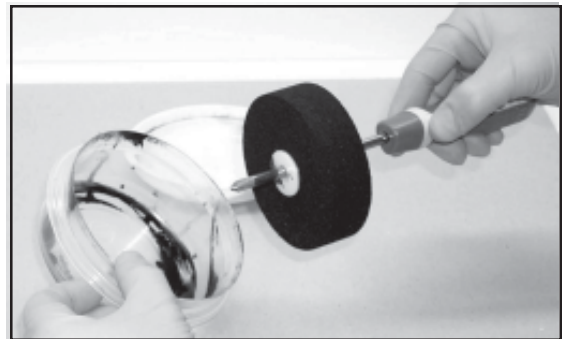


FIGURE 13

### 7 -Inspect the roll for excess surface wetness. Remove any excess ink by rolling the roll lightly over a piece of absorbent paper.

Rolls which have been pre-inked at the factory are typically over saturated with ink to compensate for potential solvent loss during shipping and storage. Installing an over saturated roll on the coder will result in ink leakage from the Inking System and in extreme cases may damage the ball bearings in the Transfer Roll. When the roller is installed, it must be thoroughly saturated with ink but you should not be able to see any liquid ink on the surface of the roll. If necessary, blot excess ink from the sides of the roll with a dry paper towel before installation.

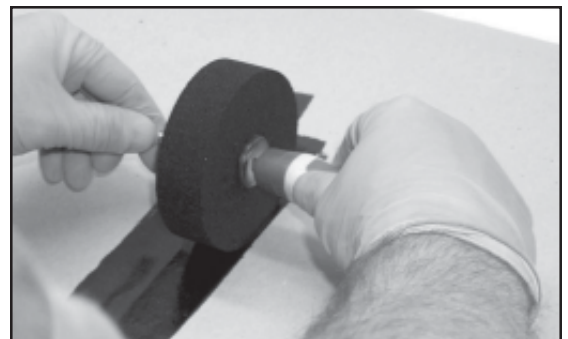


FIGURE 14

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## QUICK START

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**8 - Install the ink roll on the Ink Roll Axle “H” by aligning the end of the rod or pencil with the end of the axle and pushing the roll onto the axle.**

When this step is complete, remove the rubber gloves to prevent ink contamination with the external parts of the coder.

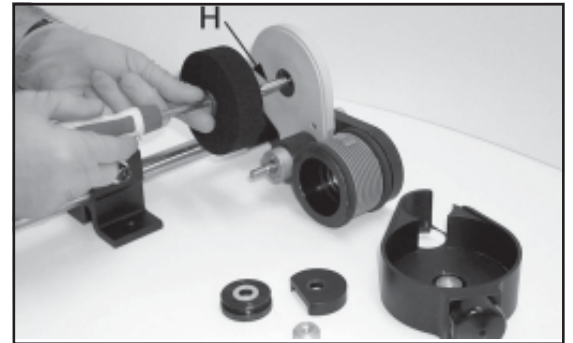


FIGURE 15

**9 - Immediately replace the Inking System Cover “D” by carefully guiding the cover over the Transfer Roll “G”. Try not to let the cover contact the surface of the Transfer Roll to prevent scratching. Make sure the Cover is seated properly against Baseplate “F”.**

While handling the ink rolls, solvents will evaporate from the rolls very rapidly at normal room temperatures. The Inking System Cover must be replaced quickly to prevent solvent loss.

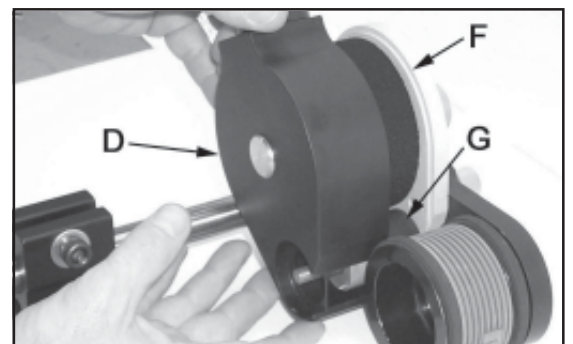


FIGURE 16

**10 - Replace the Knurled Drive Wheel “E” by aligning the 3 small holes with the 3 stainless drive pins on the top of the Transfer Roll “G” and pressing the Drive Wheel onto the Transfer Roll.**

A slight wiggling action or rotation of the Drive Wheel will help overcome the resistance caused by contact with the rubber Friction Bearer on the Print Drum. The tops of the stainless pins will be flush with the top of the Drive Wheel when seated properly.

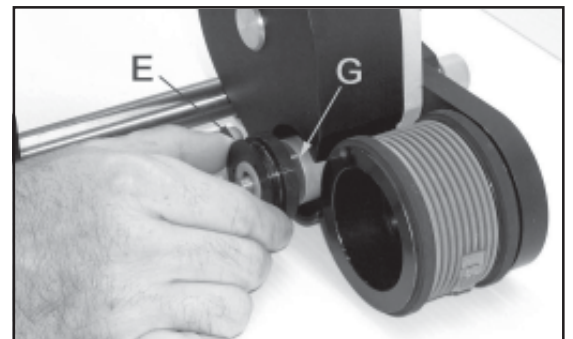


FIGURE 17

**11 - Replace the Drive Wheel Cover “B” and rotate it into position with the flat edge directly facing the Print Drum.**

Hold the Drive Wheel Cover and Inking System Cover in place.

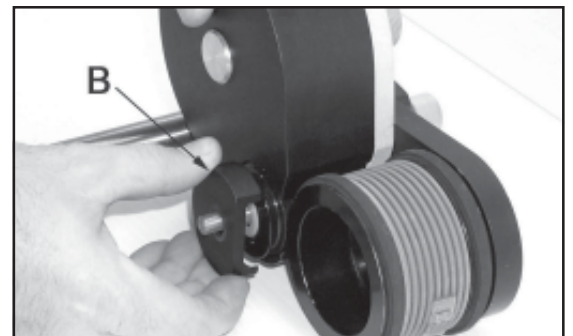


FIGURE 18

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## QUICK START

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- 12 - Replace the Cover Retaining Knob “C” and lightly tighten. Do not over tighten this knob or you may bend the top of the Drive Wheel Cover “B” and cause it to bind against the Knurled Drive Wheel.**

The Cover Retaining Knob should be just tight enough to keep the Inking System Assembly together and prevent the Drive Wheel Cover from rotating out of position.

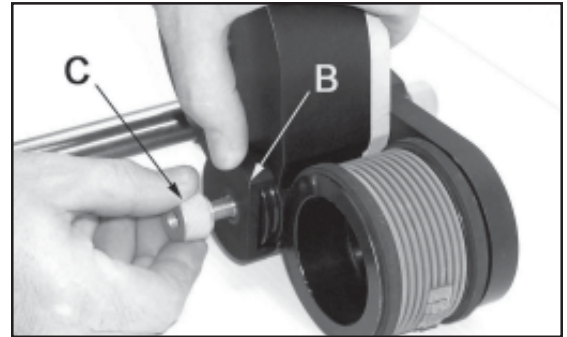


FIGURE 19

### INSTALLING THE PRINTING DIES

- 1 - Install the Printing Dies “I” on the Print Drum “J” by aligning the ribbed backing on the dies with the matting covering on the Print Drum and pressing firmly until they are completely engaged. It is best to install the dies as close to the middle of the print area on the Print Drum as possible.**

Individual character codes or text messages are installed in a mirror image of normal written text. In other words install in a right to left direction as shown. When printed, codes or text installed in this orientation will print in normal left to right order.

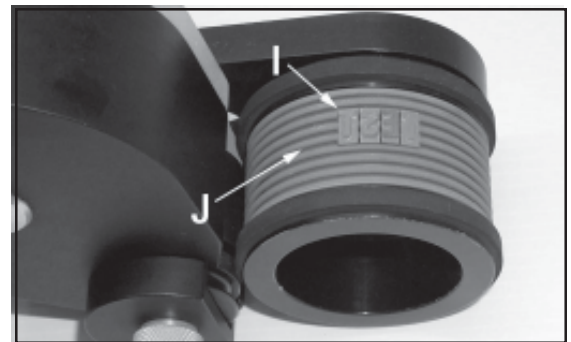


FIGURE 20

**Tip: To make die installation easier, moisten a sponge with water containing a small amount of liquid detergent. Lightly moisten the back of the printing die and then immediately press the die into the drum cover. Do not apply too much liquid or the dies will slip during printing. Note: Do not apply silicone, oil or any other lubricating agent to the rib backing or the dies will not hold properly during printing.**

- 2 - When using small individual characters to make up a code message, use the Type Blocking Kit “K” included with your coder to support the leading and trailing ends of the type as shown.**

Characters which have only a 2 or 3 rib backing do not have the stability of the larger sizes when snapped into the drum cover. Adding the rib backed type blocks on either side of the code will provide added stability. The Type Blocks are not as thick as the Type and will not pick up ink from the Transfer Roll.



FIGURE 21

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## QUICK START

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### ADJUSTING THE INK ROLL ECCENTRIC

With the printing dies installed on the print drum, manually rotate the print drum continuously in one direction while slowly rotating the Ink Roll Eccentric Adjusting Knob “A” from the “MIN” towards the “MAX” position. Turn the Eccentric Knob in small increments and observe the face of the printing dies “I” for signs of ink between each adjustment.

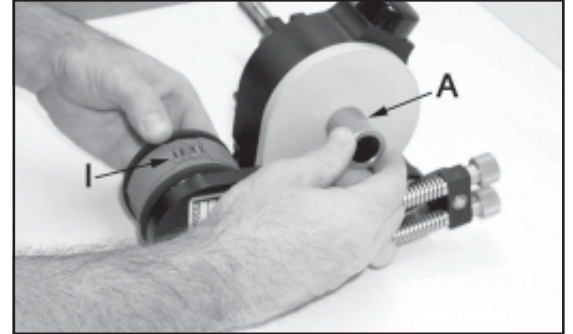


FIGURE 22

As soon as you can see complete ink coverage on the die faces, stop rotating the eccentric. Proper adjustment will normally be reached when the reference line on the Eccentric is somewhere between the 2 and 3 dial position.

This adjustment procedure brings the Ink Roller into contact with the surface of the Transfer Roller which in turn applies the ink to the face of the printing dies. Do not rotate the Ink Roll Eccentric Knob further than necessary towards the “MAX” position or the excess contact pressure will squeeze ink out of the ink roll and may cause dripping inside the cover.

**FOR MOUNTING INSTRUCTIONS  
REFER TO THE APPROPRIATE SECTION  
FOR YOUR APPLICATION**

**WEB PRINTING - PAGE 17  
CARTON PRINTING - PAGE 20**

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## BASIC PRINCIPLES OF OPERATION

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### THE NON-ABSORBENT INKING SYSTEM

Inks designed for printing on non-absorbent surfaces contain very fast drying alcohol solvents, a component to impart color which can be either a liquid “dye” or a finely ground solid or “pigment”, and a resin material which binds the color medium to the material surface. When the printed marks are applied by the coder, the solvents rapidly evaporate from the surface of the material leaving only the dried resin and color.

Preventing rapid solvent loss from the inking system, which would cause the coder to stop printing, has traditionally been a very difficult task. The patented Non-absorbent Inking System design has overcome this problem by enclosing all of the inking system components in a tightly sealed housing. This unique design offers the capabilities of a flexographic printer without the limitations associated with having an open well of ink. The advantages of this design include minimal maintenance requirements, unrestricted mounting configurations and the ability to rapidly change ink colors.

The inking system is comprised of two main components as shown in Figure 23. The ink roll serves as a reservoir for the ink, and a transfer or “anilox” roll transfers the ink from the ink roll to the face of the printing dies. To prevent the loss of ink solvent through evaporation, these rolls are mounted in separate precision machined cavities in a sealed aluminum housing. The integrity of the housing is such that the system can be left idle for days without risk of the ink roll drying out.

The ink roll is installed on an eccentric mounted axle which enables the roll to be adjusted into contact with the transfer roll. The surface of the transfer or “anilox” roll is finely engraved with thousands of microscopic cavities which picks up ink from the ink roll and transfers it to the surface of the printing dies. Since the transfer roll applies a very thin film of ink to the die face, the printed marks dry very rapidly.

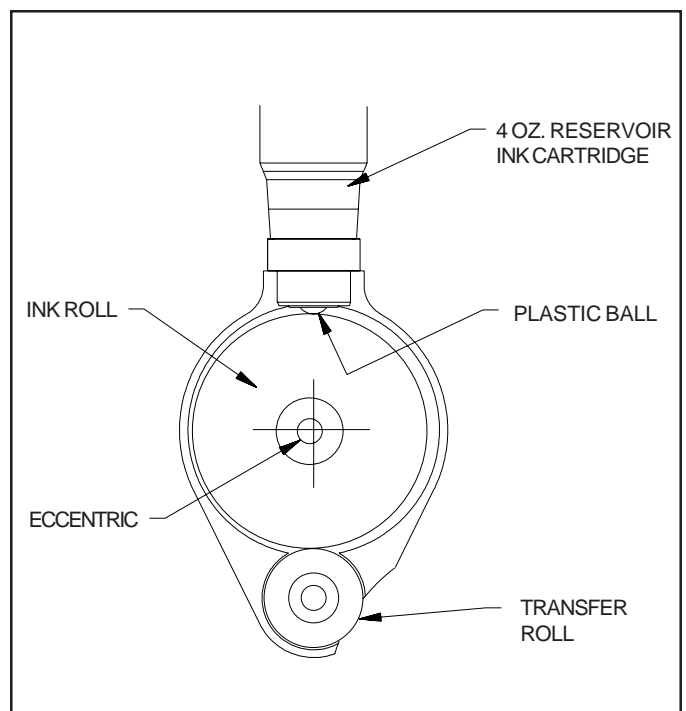


FIGURE 23

### USING THE 4 OZ. RESERVOIR INK CARTRIDGES

**Note:** The MT Ink Roll is disposable by design and is not to be used with the 4 oz. ink cartridge. When the ink is depleted from the MT Ink rolls they are to be discarded.

It is important to note that the Reservoir Ink Cartridge shown in Figure 23 is not considered to be an integral part of the inking system but is used only to re-ink the XF neoprene ink roll when needed. **The 4 Oz. Reservoir Ink Cartridges should be installed only after the ink supply in the XF neoprene ink roll has been depleted and the printed marks indicate a need for more ink.** Depending on the amount and size of the text being printed and number of imprints being applied per hour, the ink capacity of the XF neoprene ink roll may last anywhere from 1 hour to several days of continuous operation. Installing a 4 ounce Reservoir Ink Cartridge prematurely may result in over saturation of the XF neoprene ink roll and flooding of the inking system.

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## **BASIC PRINCIPLES OF OPERATION**

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When a Reservoir Ink Cartridge is threaded into the bottle port, the plastic ball in the cartridge comes into contact with the surface of the neoprene ink roll. When the ink roll rotates during the printing operation, a thin film of ink is transferred from the reservoir cartridge onto the surface of the ink roll. The printed impressions will improve within a few seconds after installation of the cartridge. When the printing operation is stopped, the Reservoir Ink Cartridge automatically stops feeding ink to the roller to prevent over saturation during idle periods.

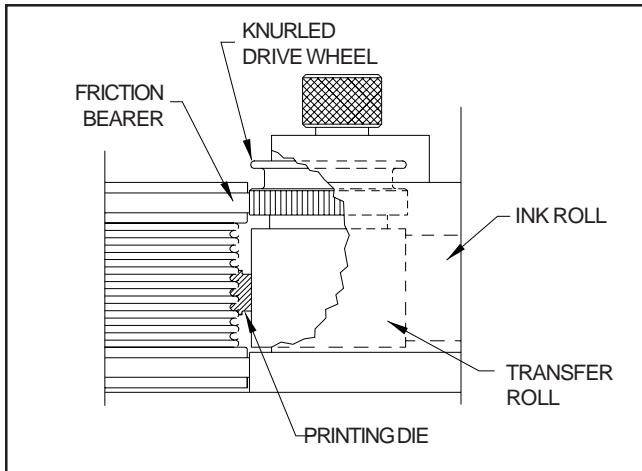


FIGURE 24

The knurled drive wheel shown in Figure 24 sits on top of the transfer roll and is engaged by three stainless steel drive pins. The knurled face of the drive wheel runs in contact with a friction bearer on the print drum. When the print drum starts to turn, the knurled drive wheel rotates the transfer roll at the exact surface speed of the die face. Keeping these two surfaces running at a synchronous speed ensures a uniform coating of ink on the die face and extends die life.

### **SELECTING AN APPROPRIATE INK**

JMD's Non-absorbent Inking System is compatible with a wide range of alcohol base marking inks. Although we offer a variety of inks for specific applications, you are not restricted to using only JMD brand inks. When selecting inks from other manufacturers however, it is your responsibility to make sure the inks are compatible with the coder.

Dye base inks contain liquid color which is translucent and will provide good color contrast only on light colored materials. These inks are generally faster drying than pigmented inks and normally produce less residue buildup on the transfer roll and printing dies, thus requiring less frequent cleaning of the coder. Although dye base inks are normally the easiest to use, they will fade more rapidly than pigmented inks when exposed to direct sunlight.

Pigmented inks contain finely ground solids which are opaque, providing much greater color contrast when marking on dark colored surfaces. These inks also resist fading when exposed to direct sunlight. Pigmented inks have a tendency to build up on the surface of the transfer roll and the die face more rapidly than dye base inks and will generally require more frequent cleaning of these parts.

The first step in selecting an appropriate ink, is to determine if the ink will bond to the surface of the material being printed and provide acceptable color contrast. It is normally recommended that inks be test printed on the material being marked with a rubber stamp to determine if the resulting marks are acceptable. Please note that when testing inks with a rubber stamp, the drying times will generally be much slower than when the inks are applied with the Non-absorbent Mini-Coder.

***It is also extremely important to test the affect of other manufacturer's ink on the XF Neoprene ink roll.*** Since the ink roll must fit into a precision machined cavity in the inking system housing with little clearance, swelling of the roll, in reaction to non-compatible solvents in the ink, could cause serious problems with the performance of your coder. The dry XF neoprene ink roll measures 3.425" (86.99 mm) OD. After thoroughly saturating the ink roll with ink, the roll should not exceed 3.500" (88.90 mm) OD.

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## BASIC PRINCIPLES OF OPERATION

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### INK DRYING TIME CONSIDERATIONS

Depending on the specific characteristics of the printing application, some consideration needs to be given to the drying time of the ink and its suitability for the application. Printing on a plastic film in an intermittent motion Form and Fill Machine may require a slower drying ink formulation than that recommended for high speed continuous web printing applications. Although extremely fast drying inks are normally specified by customers in all applications, the ink must be suitable for the specific application or it will not perform properly in the coder.

JMD #100 ink is an extremely fast drying formulation and is normally recommended for continuous motion web printing applications. In these applications, the ink must dry very rapidly on the material to prevent downstream transfer to idler rolls. When the print drum is rotating at high speeds, the dies rotate past the Transfer Roll where ink is applied and within milliseconds the die face contacts the surface of the material being printed and the impression is transferred. (Refer to Figure 25)

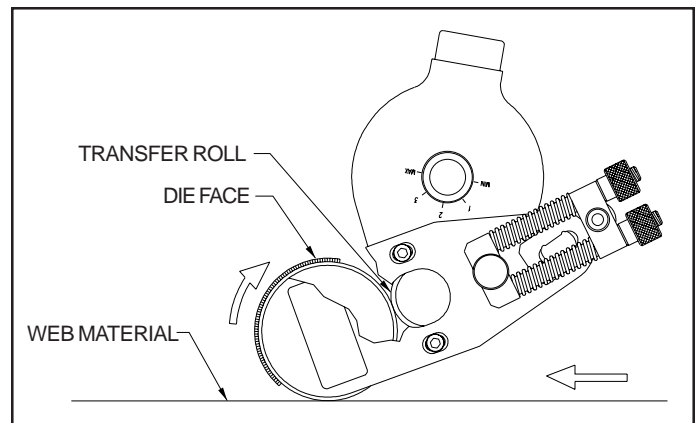


FIGURE 25

When printing on very slow moving web materials, the print drum rotates at much slower speeds. As a result, when the dies rotate past the Transfer Roll and the ink is applied, it may take several seconds for the dies to contact the web. Since the solvents in the #100 Inks evaporate very rapidly at normal room temperatures (even from the die faces), the die faces may be dry before contact with the web material. In these applications, a slightly slower drying ink formulation would be necessary to ensure that the ink remains wet on the die faces until they contact the web material.

When the coder is installed on a Form and Fill machine, the plastic film may move at fairly high speed when pulled from the supply roll but it stops for a period of time during the product fill cycle. In these applications, if the die face has already rotated past the Transfer Roll and picked up ink and the web motion stops for several seconds, a very fast drying ink like the #100 will flash off the die face before the web motion resumes. It is therefore necessary to take into consideration the cycle rate of the particular machine when selecting an ink.

## WEB PRINTING

This section applies to the installation of the Non-absorbent Mini-Coders for printing on continuous web materials such as plastic films, rubber sheeting, metals and other extruded materials.

Careful consideration should be given to selecting an appropriate area in the production line for installation of the coder. Since the coders are friction driven by the moving web of material, a primary factor is to select an area where the position of the web material is accurately controlled and preferably supported by an idler or guide roller on the underneath side as shown in Figure 26.

The only real consideration with respect to the attitude of the coder frame is that the 4 oz. reservoir ink cartridge (when installed) should be kept as near as possible to a vertical position with the plastic ball pointing down. This will ensure proper ink feed from the 4 oz. cartridge to the ink roll. When disposable Type MT Ink Rolls are used on the coder, 4 oz. Reservoir Ink Cartridges are not used and therefore the coder can be mounted in any convenient attitude. When installing the coder, the print drum axle of the coder should be in parallel alignment with the idler roll and the print drum should contact the web at the point where the web is tangent to the idler roll and solidly supported.

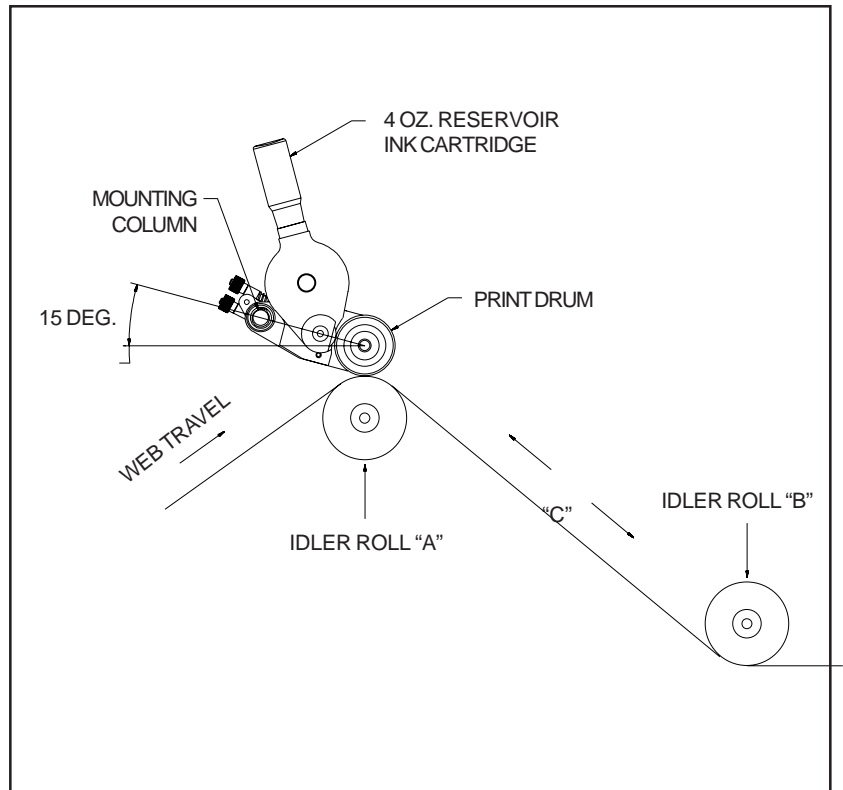


FIGURE 26

It is also important to note that the distance "C" between idler roller "A" and idler roller "B" should be adequate so that at the maximum web speed, the ink will dry before the printed marks contact idler roller "B". If distance "C" is not adequate for the drying time of the ink used, a ghost image transfer of the marks may be overprinted on the web by idler roller "B".

To eliminate this problem, if idler roller positions are not adjustable, a slight undercut in the face of idler roller "B" where the printed marks pass under the roll, will prevent the wet marks from touching the face of the idler. Generally the undercut in the idler roller needs to be only .020" - .030" deep and slightly wider than the printed marks as shown in Figure 27

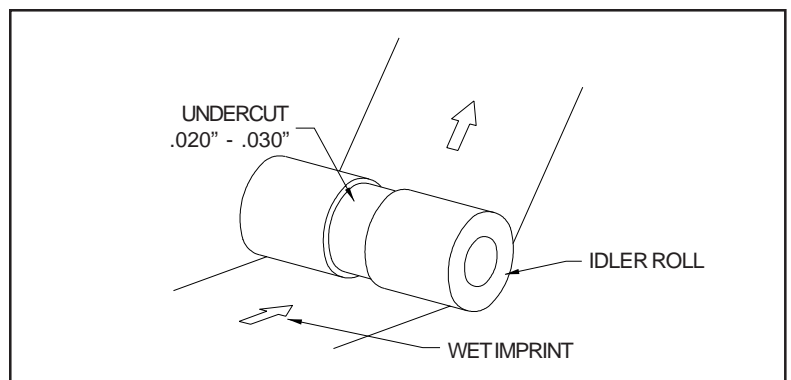


FIGURE 27

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## WEB PRINTING

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In high speed web applications, the distance the web travels at a given speed in 2-3 seconds can be substantial. It is important to note that when the printed web is tightly rewound, the additional pressure applied to the printed marks can increase the possibility of a ghost image transfer of the ink to the back of the web.

If this situation occurs and the web speed cannot be slowed down to allow more drying time, air blowers can be used to direct heated air on the printed marks to accelerate drying. Preheating the web material slightly with hot air before printing can also be an effective method to decrease the drying time. If either of these techniques are used, it is recommended that the hot air blowers be electrically tied into the web feed motor energizing circuit. This will ensure that the blowers are turned off automatically if the web is stopped.

### MOUNTING THE CODER

**1 - After determining the best location to mount the coder, install the supplied mounting bracket (Figure 28) on a rigid surface using two 3/8" diameter bolts, nuts, washers and lock washers (not supplied). Be sure that mounting column of the coder is parallel to the idler roll.**

**2 - Insert the mounting column into the mounting bracket and allow the print drum to pivot into contact with the idler roll. Do not tighten the bracket clamping screw at this time.**

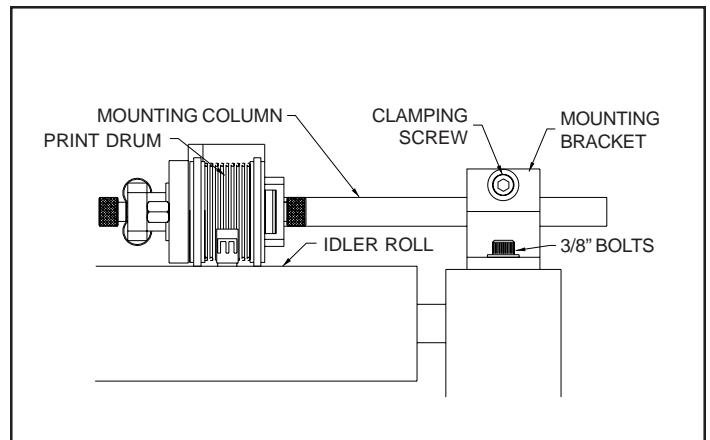


FIGURE 28

**3 - Using an adjustable wrench, grip the Cam Block (Figure 29) and rotate it approximately 10-15 degrees to compress the Tension Springs. While holding the Cam Block in this position, tighten the Mounting Bracket Clamping Screw.**

This procedure is used to adjust the contact pressure which the print drum exerts against the web. Only enough pressure should be applied to ensure positive friction drive of the print drum. Excessive contact pressure will impose unnecessary drag on the web and may result in poor print quality.

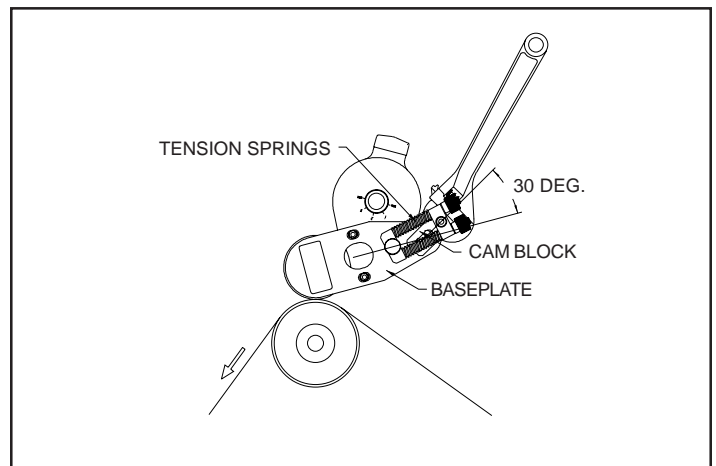


FIGURE 29

**DO NOT INSTALL A 4 oz. RESERVOIR INK CARTRIDGE AT THIS TIME.** The coder is designed to print using the ink contained in the pre-inked ink roll. Since a freshly saturated Ink Roll was just installed on the coder, the system will have plenty of ink. **Installing a 4 oz. Reservoir Ink Cartridge immediately will result in over saturation of the ink roll and flooding of the Inking System.** The 4 oz. Reservoir Ink Cartridge should not be installed until most of the ink is consumed from the ink roll and the print quality shows signs that more ink is needed.

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# WEB PRINTING

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## SPECIAL WEB PRINTING APPLICATIONS

In applications where the web material is too narrow for both friction drive bearers to contact the surface of the web, contact with one friction bearer is acceptable. When the web is too narrow for even one friction bearer to contact the web and still position the print as necessary, a custom made guide roller can often be utilized.

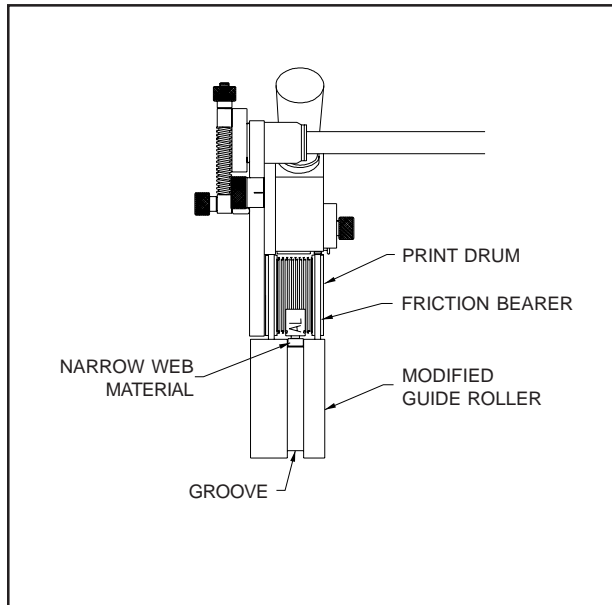


FIGURE 30

### PRINTING ON NARROW WEB MATERIALS

Using this approach, the guide roll must be machined with a groove which will not only accurately guide the web material and drive the guide roll but it must also keep the surface of the web material flush with the surface of the guide roll where the friction bearers make contact. (See Figure 30.)

This method of mounting is generally more appropriate when the web material is extruded rubber or some similar material which has a high coefficient of friction since it must drive both the guide roll and the print drum. Using a custom guide roller which is driven by an external power source is certainly acceptable but it is generally rather costly since the surface speed of the guide roller must precisely match the speed of the web or smeared prints will result.

### PRINTING DIRECTLY ON MASTER ROLLS

JMD Non-absorbent Mini-Coders can also be mounted on custom designed extension arms which will enable them to print directly on the surface of a master roll of web material as it is unwound. This technique is frequently used when conveniently positioned idler rolls are not available. In these applications, as the master roll of web material decreases in size, the mounting arm pivots and keeps the print drum in constant contact with the surface of the roll as shown.

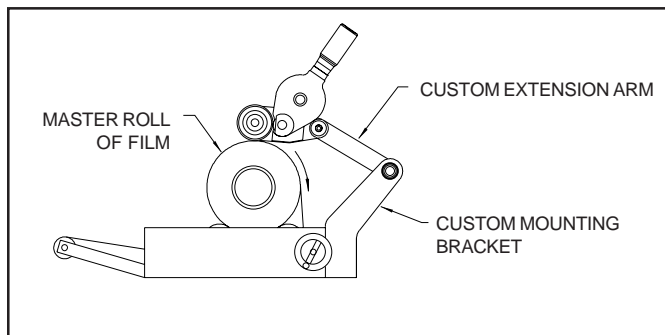


FIGURE 31

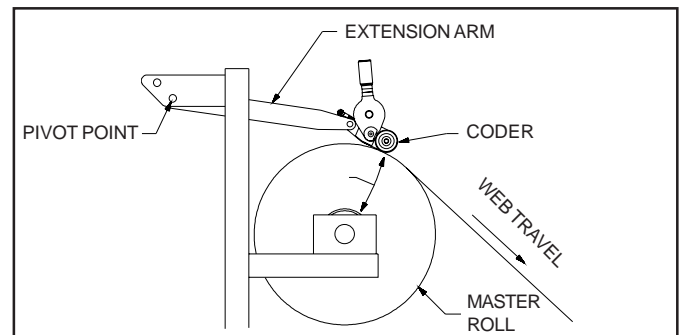


FIGURE 32

You will note in Figure 31 that the coder is mounted in an orientation which will rotate the print drum in the reverse direction of a normal web printing installation. This is an acceptable method of mounting the coder if it is more convenient for installation on the parent equipment. In these installations, the weight of the coder is used to supply printing pressure and typically the standard spring tension mechanism and mounting column are removed. Custom mounting brackets and extension arms should be carefully designed to keep the coder in an acceptable attitude when printing on a full roll of film all the way down to the smaller diameter of the core. For more details on custom mounting systems, contact our engineering department.

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## CARTON PRINTING

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Printing on non-absorbent surfaces, such as waxed or varnished cartons, can be accomplished easily with JMD Non-absorbent Mini-Coders. The selection of an appropriate place for installation on your conveyor line or other packaging equipment is a very important consideration in the performance of your coder. The most important factor to consider is carton alignment. To ensure print reliability and prevent damage to your coders, the cartons must be accurately guided through the printing station by guide rails. If your conveyor is not equipped with guide rails - they must be installed before proceeding with coder installation.

### CARTON ALIGNMENT

Proper alignment of the cartons as they pass the printing station is imperative as shown in Figure 33. Improper alignment will produce poor print quality, poor print registration, and in extreme cases, could damage the machine.

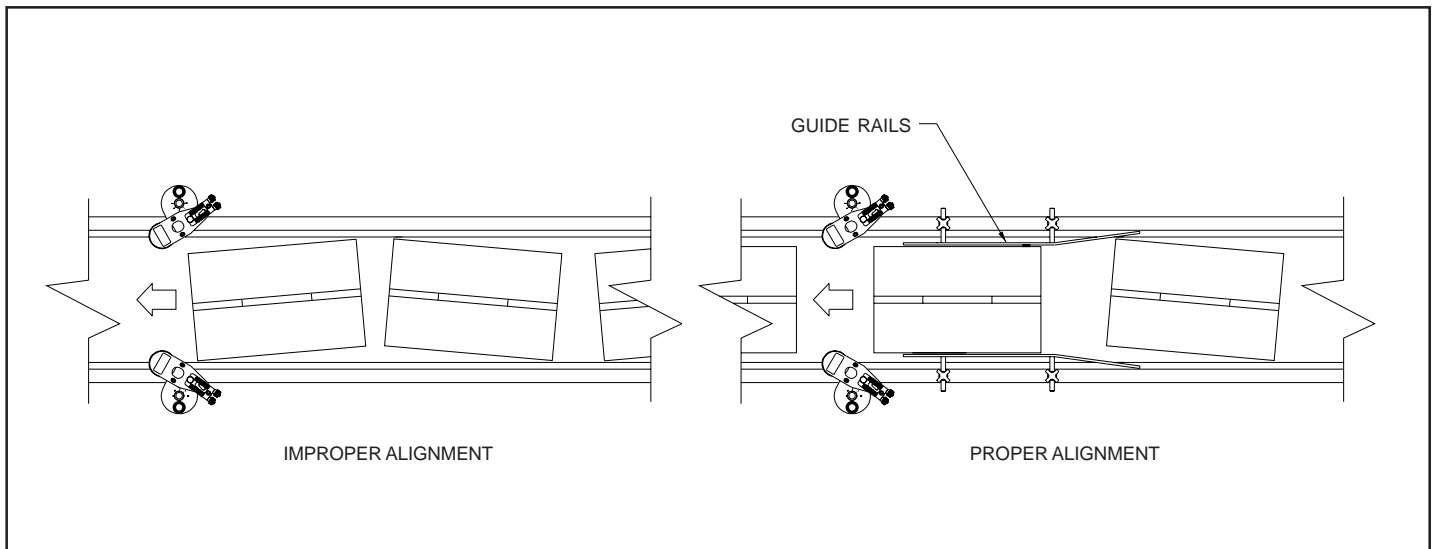


FIGURE 33

JMD Non-absorbent Mini-Coders are spring loaded so that the print drums will press against the carton surface on contact. This pressure is necessary to accomplish the friction drive rotation of the print drum and ensure enough printing pressure to give you a sharp impression. The spring tension mechanism on the coder will also compensate for slight variations in the width of the cartons without jamming the conveyor line. Excessive pressure, caused by improperly guided cartons, will result in smudged impressions and could cause damage to the spring tension mechanism.

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## CARTON PRINTING

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JMD Non-absorbent Mini-Coders are designed so the frame of the machine will pivot on the mounting column. This allows the print drum to deflect, or swing, on contact with the leading edge of the carton a maximum of 2". It is recommended that cartons be aligned between guide rails with no more than 1/4" clearance on each side as shown in Figure 34. This should allow ample clearance for cartons and protect your printer from damage.

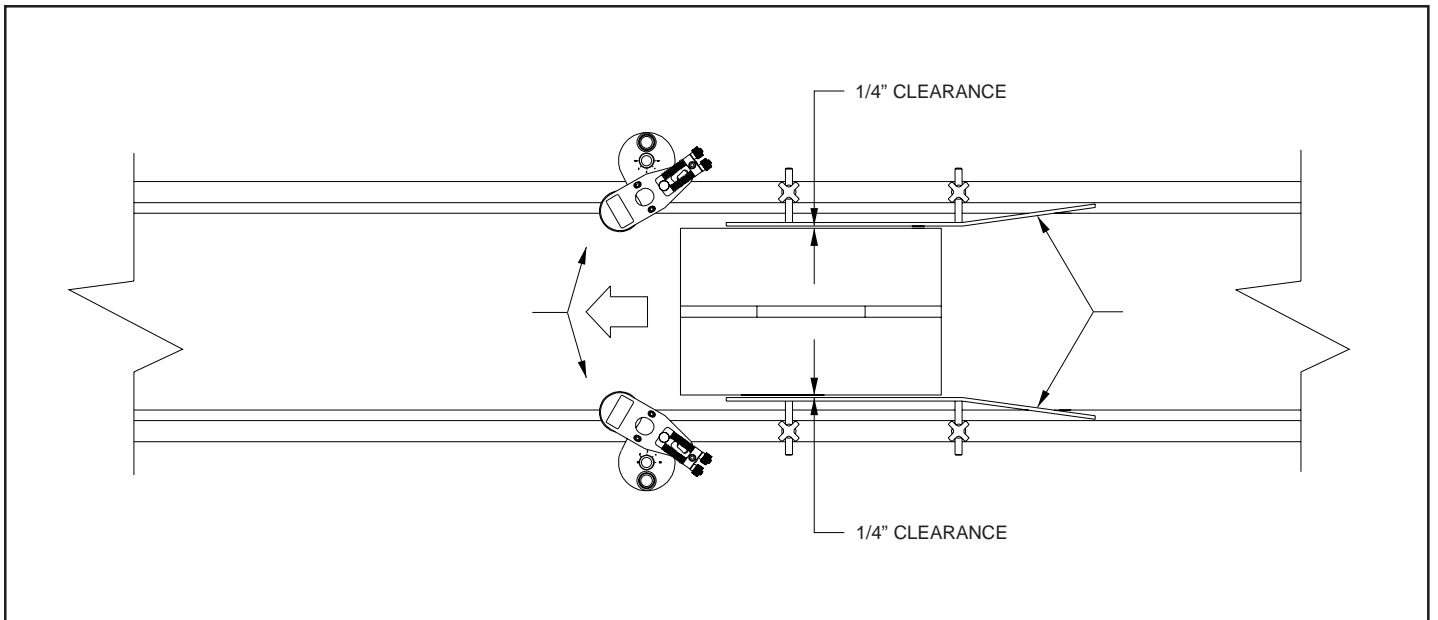


FIGURE 34

In most applications, installation of the printer can be accomplished by attaching the mounting bracket to the side rails of the powered conveyor using two 3/8" machine bolts. The printers should be mounted as close as possible to the end of the guide rails to ensure that proper carton alignment is maintained at the printing station.

Before tightening the mounting bolts, check alignment of the print drum. It is very important for proper tracking that the top of the print drum is parallel to the top of the conveyor (see Figure 35) and the side of the print drum is parallel to the side of the carton (see Figure 36). Once this alignment has been achieved, tighten the mounting bolts.

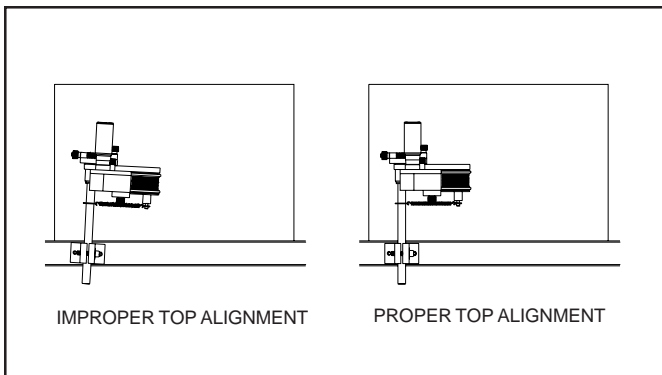


FIGURE 35

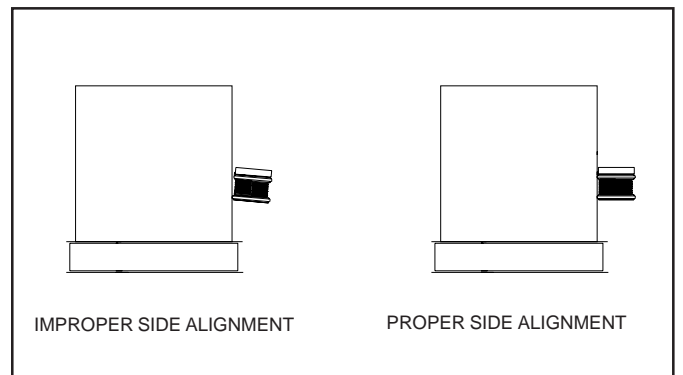


FIGURE 36

## CARTON PRINTING

Loosen the mounting column clamping bolt (Figure 37) and position the printer to the required height for printing. Swing the printer into position so that the print drum will lightly contact the side of the cartons as they emerge from between the guide rails. Check the print drum contact with the cartons while the conveyor is under power and adjust the print drum position to obtain approximately 1/4" - 3/8" deflection (see Figure 38).

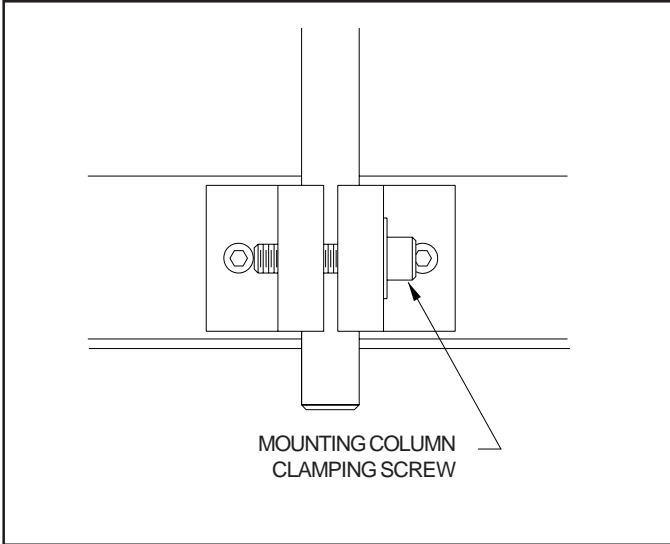


FIGURE 37

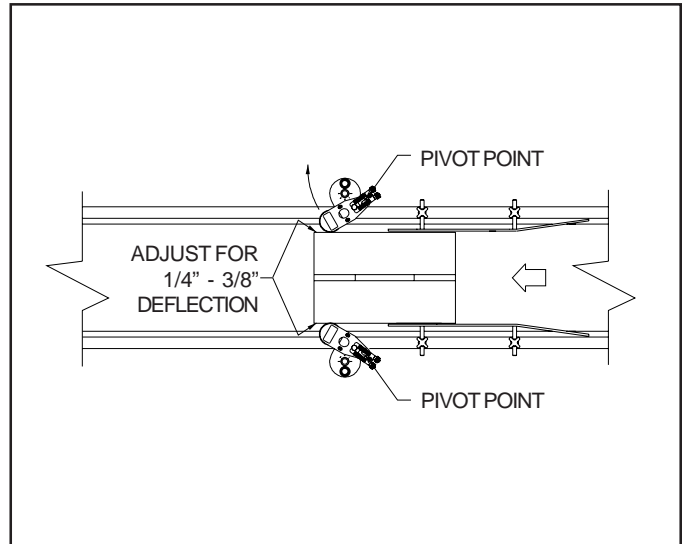


FIGURE 38

### ***DIE POSITIONING FOR RESET APPLICATIONS***

Continuous models of the coder do not offer print registration capabilities, therefore mounting the printing dies at a specific location on the print drum is not important. On Reset machines, however, the position of the die on the print drum determines the registration of the print on the carton. Since non-absorbent marking inks are normally extremely fast drying, die positioning will also have an affect on the ability of the coder to reliably transfer ink to the carton surface. Production cycle rates, ambient temperature and ink selection are also factors which have to be considered to ensure proper performance of the system.

Figure 39 illustrates the best die position for carton printing when using extremely fast drying inks. Note that the leading edge of the printing die should be positioned rotationally upstream of the transfer roll. When the leading edge of the carton contacts the print drum, the drum begins to rotate in a clockwise direction. The die travels a short distance and then contacts the transfer roll where ink is applied to the die face. When the die contacts the carton the mark is applied. The print drum will continue to rotate until the trailing edge of the carton passes the coder, then the print drum will automatically return to the same starting position.

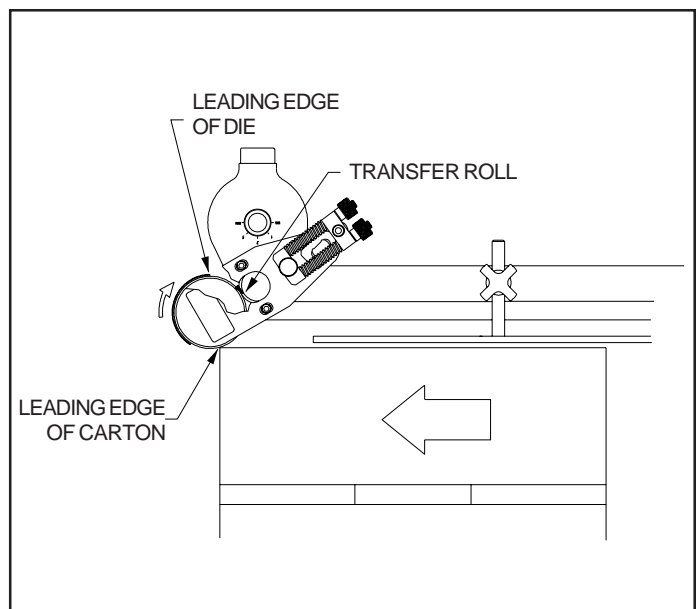


FIGURE 39

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## ***CARTON PRINTING***

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Although installing the printing dies in this position restricts how close to the leading edge of the carton you can register the print, it is one of the only ways to ensure a good imprint on every carton. Since the fastest drying non-absorbent inks will dry in approximately 2 seconds at 75 Degree F. ambient temperature, the ink will also dry on the die face within 2 seconds after it is applied by the transfer roll. If the dies have not contacted the carton surface before then, no imprint will be transferred to the carton.

If the cycle rate of the production line is very fast and the ambient temperature is relatively low, the printing dies could be positioned rotationally downstream of the transfer roll so they print much closer to the leading edge of the carton. When the coder completes one printing cycle, a portion of the die or all of the die may have already passed the transfer roll and picked up ink in preparation for printing the next carton. The machine can remain idle like this for only a second or so before the next carton must contact the print drum or the ink will dry on the die face and not be transferred to the carton.

If your production cycle rate is not fast enough but you still need to print close to the leading edge of the carton, the only alternative is to use a slower drying non-absorbent ink. When making the ink selection, be sure to consider ambient temperature, it can have a dramatic affect on ink drying times. Hot temperatures make inks dry faster, cold temperatures retard drying.

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## MAINTENANCE

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### PRE-INKING A NEW INK ROLL

When you are ready to begin printing, you must first install an ink roll which has been properly pre-inked with the appropriate non-absorbent ink. Unless you ordered a pre-inked roll with your machine, you will find a dry roll in a plastic container with your coder.

Note: Dry rolls cannot be inked automatically using the 4 Oz. Reservoir Ink Cartridges.

**Warning: Non-absorbent Inks contain flammable solvents. Do not smoke or handle these rolls in the presence of sparks or open flames. Inks will also stain clothing, furniture, carpeting and your hands. Rubber gloves should be worn during the following procedures.**

A dry XF Neoprene ink roll has the same characteristics as a sponge with the capacity to absorb approximately 3-4 fluid ounces of ink. Please follow the guidelines below to properly pre-ink your roll:

**1 - Remove the dry roll from the storage container. Pour 3 to 4 oz. of ink into the container.**

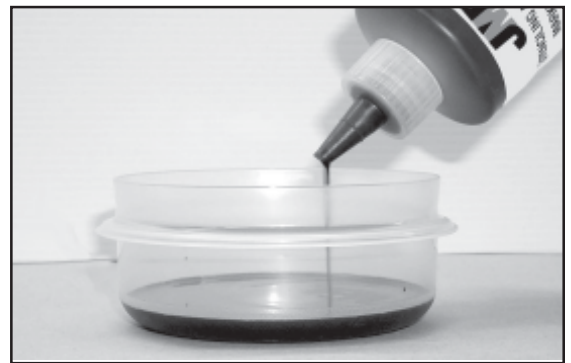


FIGURE 40

**2 - Carefully place the roll into the container of ink. Using your finger tips, firmly press down on the foam side of the ink roll and then release the pressure. Repeat this process several times while rotating the roll in the container and pressing on different areas. This will force the air out of the roll and the voids will be filled with ink.**



FIGURE 41

Remove the roll from the storage container and turn it over, placing the un-inked side down in the container. Repeat the process above until all the ink in the container has been absorbed into the roll.

**3 - Inspect the roll to ensure it is completely saturated with ink but not dripping wet. If the surface of the roll seems excessively wet after inking, remove the excess ink by inserting a rod through the core and while pressing down lightly, roll the roller across a clean piece of paper.**

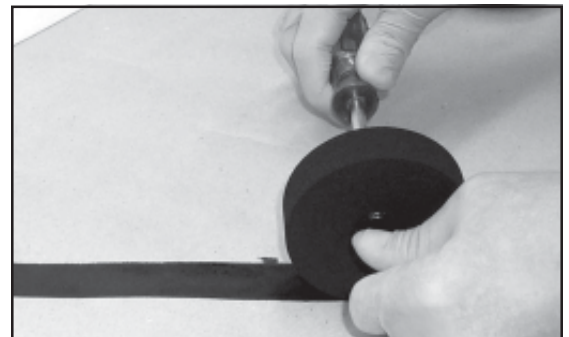


FIGURE 42

After this process is completed, the roll should immediately be installed on the coder or it should be placed back in the storage container and the lid tightly sealed to prevent solvent evaporation.

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## MAINTENANCE

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### CLEANING THE PRINTING DIES

All inks which are formulated for printing on non-absorbent surfaces contain a resin binder which bonds the dye or pigment in the ink to the surface of the material being printed. As the ink begins to dry, this binder becomes “tacky” or “sticky”. While in this stage of the drying process, the tack on the dies will tend to pick up both airborne dust and any dust or dirt on the surface of the material being printed. When this happens, the dies should be cleaned or replaced. The easiest method of cleaning the dies requires the appropriate solvent for the ink being used, a pair of rubber gloves, safety glasses, an apron to protect your clothing is recommended, a toothbrush, some clean paper towels and a plastic bag to protect your workbench from staining. (Naturally, the toothbrush will never be suitable for oral hygiene use after this process.)

After some period of use, the accumulation of contaminants on the dies will cause degradation of the print quality; cleaning the printing dies, excluding excessive wear to the die face, will restore the print quality of the coder.

**1 - Place the contaminated printing die on top of several layers of paper towels to absorb the excess solvent.**

**2 - Pour just enough solvent on the face of the printing die to cover the die face.**

**3 - Using the toothbrush, carefully scrub the face of the die to remove the contamination and old ink. Add more solvent as necessary and repeat the process until the die is clean. Do not submerge or soak the dies in solvent as this may cause swelling of the rubber compound.**

**4 - Blot the surface of the die with a clean paper towel to dry and reinstall the clean dies on the coder.**



FIGURE 43



FIGURE 44

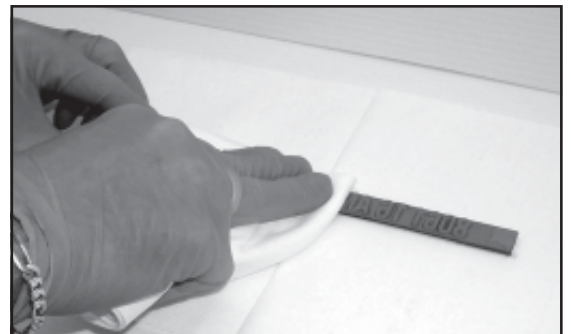


FIGURE 45

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## MAINTENANCE

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### CLEANING THE TRANSFER ROLL

The surface of the transfer roll is made from DuPont Delrin material and the O.D. of the roll is finely engraved which enables it to hold a uniform film of ink. This surface material is very fragile and under no circumstances should you attempt to clean it with anything abrasive.

To clean dust and ink residue from the surface of the transfer roll, first remove it from the coder. Lightly saturate a soft cotton cloth with the appropriate ink solvent and gently rub the surface of the roll until it is clean. **DO NOT SUBMERGE THE TRANSFER ROLL IN SOLVENT!** If the transfer roll is submerged in solvent, the bearings will be permanently damaged.



FIGURE 46

### CLEANING THE CODER

Periodically, the inking system should be disassembled and inspected for ink residue and dust contamination. To remove ink contamination from the surface of the machine, moisten a soft cotton cloth with the appropriate ink solvent and rub it across the contaminated area.

The frequency of required cleaning can be greatly reduced if the inking system is kept in proper adjustment during normal operation and if the ink roll does not become over saturated with ink.



FIGURE 47

**Note:** *Non-absorbent ink solvents can be extremely flammable and should be handled accordingly. Refer to the appropriate MSDS sheet for precautionary information.*

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# TRANSFER ROLL / PRINT PRESSURE READJUSTMENT

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## ADJUSTING TRANSFER ROLL PRESSURE

*The contact pressure that the transfer roll exerts on the face of the printing die has been adjusted at the factory and should not require further adjustment.*

If the coder has been completely disassembled for any reason, the Transfer Roll contact pressure will need to be readjusted. To make this adjustment, remove the Drive Wheel Cover Retaining Knob, the Drive Wheel Cover, the Knurled Drive Wheel and the Inking System Cover. (See Figures 8-12 on pages 11 & 12).

**1 - Install a few new RIBtype® Die characters on the print drum and make sure they are fully engaged in the Drum Covering. For best results, use 1/4" to 1/2" characters.**

**2 - Loosen the 2 inking system mounting screws approximately 1/2 turn each so the inking system can be moved on the baseplate.**

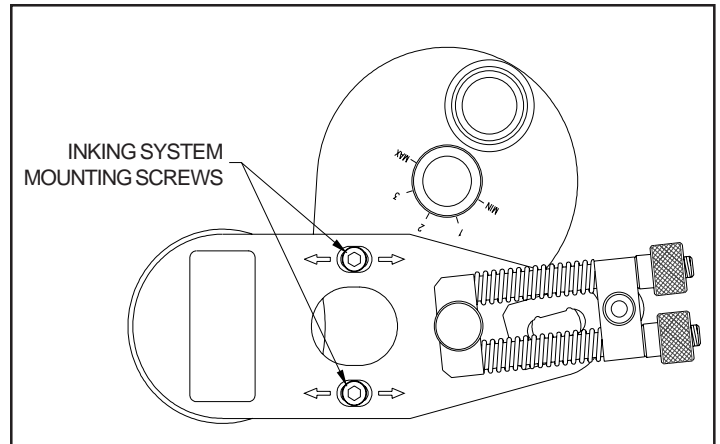


FIGURE 48

**3 - Rotate the print drum until one of the characters "A" is centered against the transfer roll "B" as shown in Figure 49. Gently slide the inking system towards the print drum, applying a minimal amount of force. While holding the inking system in position, lightly tighten the 2 Inking System Mounting Screws.**

**4 - To check for proper adjustment, rotate the print drum until the characters pass the transfer roll. The transfer roll should turn when the dies make contact and a slight resistance or bump will be felt.**

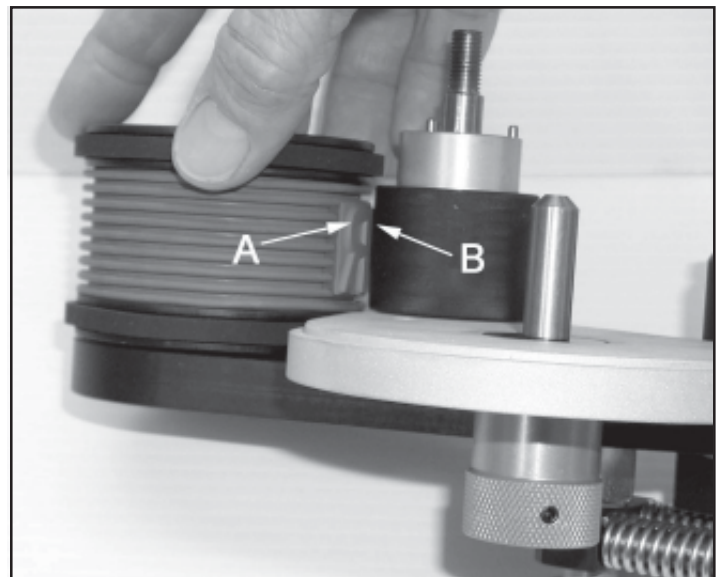


FIGURE 49

Too much contact pressure will compress the face of the printing dies and cause significant resistance when rotating the print drum. Excessive pressure will result in smudged impressions, particularly with small character dies. Too little contact pressure will result in poor ink transfer to the die face which can be easily detected in the print quality.

# TRANSFER ROLL / PRINT PRESSURE READJUSTMENT

## ADJUSTING PRINTING PRESSURE

The spring tension assembly shown in Figure 50 is designed to maintain print drum pressure against the surface of the material being printed and is adjusted at the factory for normal applications. The design of this assembly enables it to be set for either Right Hand or Left Hand Coder models. In carton printing applications it automatically compensates for slight positioning variations of the cartons as they pass the printing station. It also gives the user the option of fine tuning the initial print drum contact pressure exerted on a carton when carton printing.

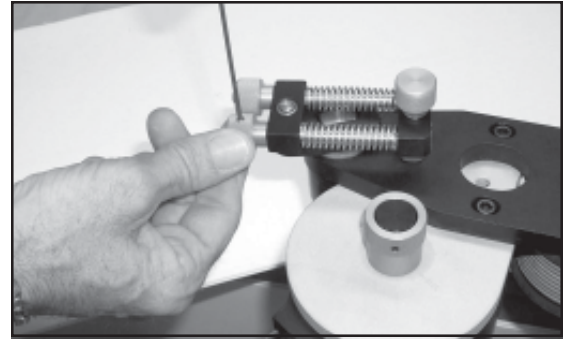


FIGURE 50

A normal factory setting for a Right Hand Mounting Configuration is shown on the right diagram of Figure 51. The Tension Adjusting Knobs are adjusted to hold the Cam Block at an approximate 15 Degree angle to the center line of the Base Plate. In this position, the coder Base Plate will pivot only in the clockwise direction. A Left Hand Coder Model would function just the opposite of this.

If greater print drum contact pressure is needed, the 2 Tension Adjusting Knobs can be readjusted to compress the springs more in the resting state. To make this adjustment, loosen the nylon tip set screw in each of the knobs as shown in Figure 50 and push the Base Plate to make it pivot in a clockwise direction (on a Right Hand Coder). This action takes the spring pressure off the rear pivot block and makes the adjusting the knobs easier. While holding the Base Plate in this position, thread both of the Tension Adjusting Knobs in a few turns onto the guide shafts. Retighten the nylon tip set screws to prevent the knobs from loosening.

It is important to understand that although making this adjustment to increase initial spring tension can be beneficial in some printing applications, it also reduces the pivoting range of the coder. To prevent possible damage to the coder, it is very important to ensure that the guide rails on the conveyor line will prevent the cartons from compressing the springs to their full limits.

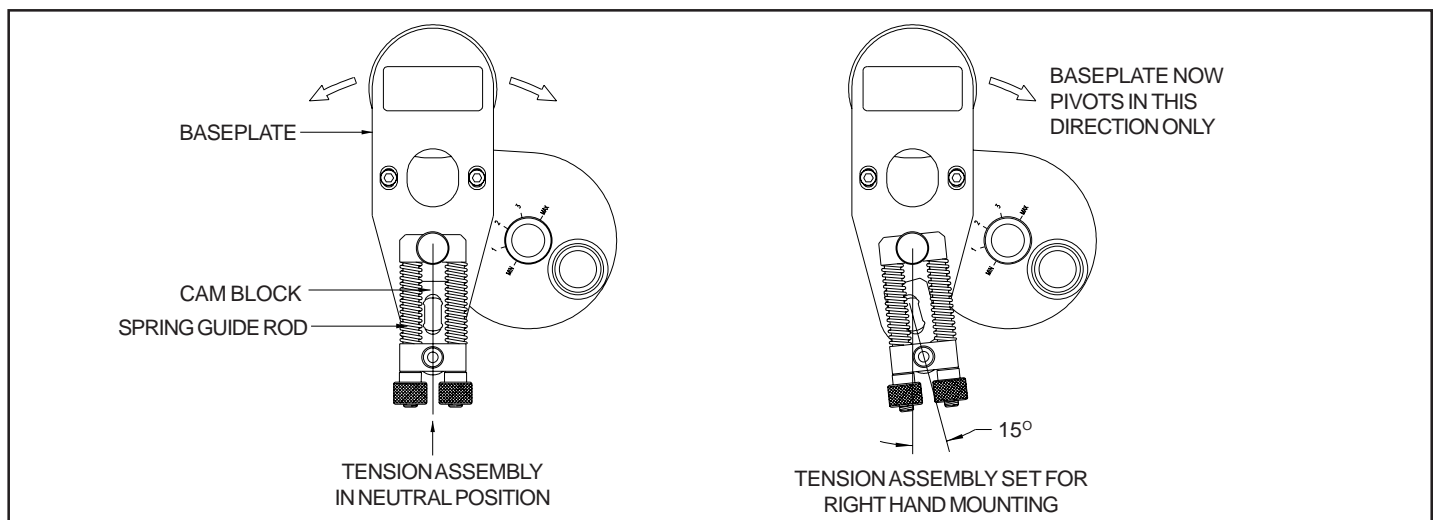
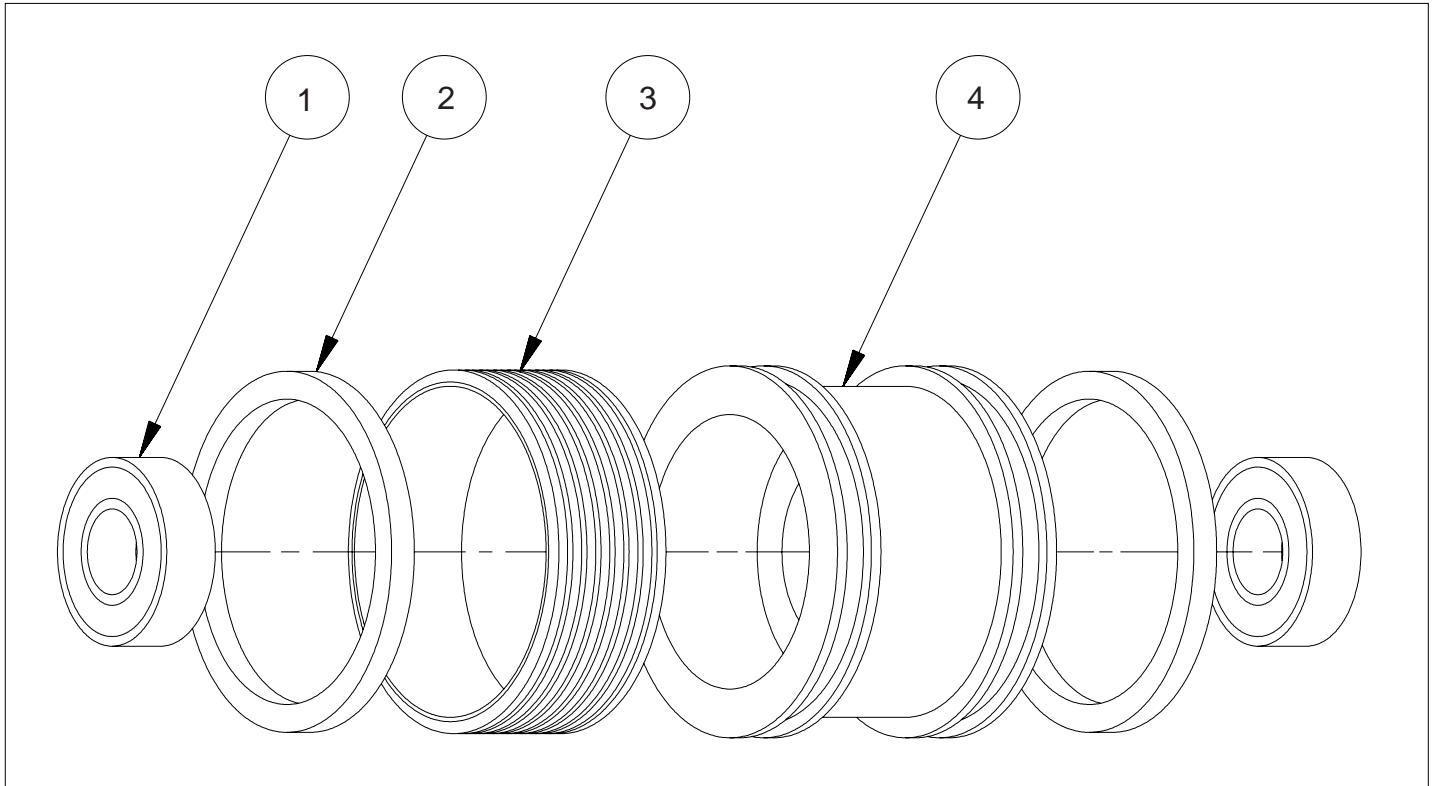


FIGURE 51

If proper installation procedures are followed, the maintenance of your new coder will be limited to periodic cleaning to remove dust and any ink residue which may accumulate during operation. The frequency of this maintenance procedure is dependent upon the environmental conditions and proper inking of the machine. Dust accumulation on the printing dies or transfer roll will cause a noticeable degradation in print quality.

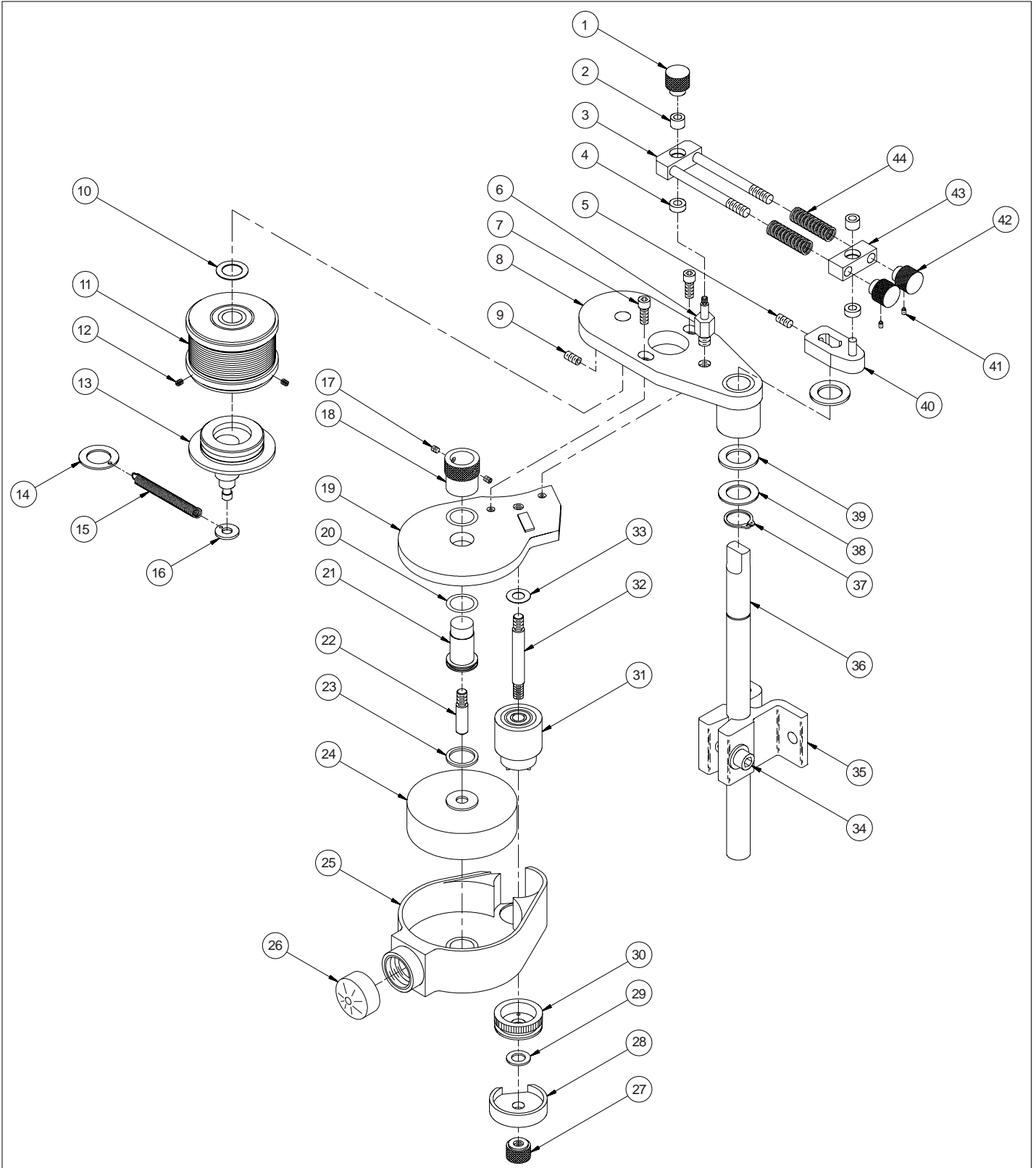
**WEB NON-ABSORBENT MINI-CODER PRINT DRUM ASSEMBLY  
WNA-109RM & WNA-109CM SERIES**



**PRINT DRUM ASSEMBLY PARTS LIST**

KEY NO.	PART NUMBER	QTY. REQD.	DESCRIPTION
1	CB-04	2	PRINT DRUM BEARING
2	MC-01S	2	PRINT DRUM SQUARE BEARER RING
3	MC-43	1	1-1/8" MINI-CODER RIBtype® RING
	MC-43T		1-1/8" MINI-CODER RIBtype® RING - METRIC
4	MC-26NP	1	1" PRINT DRUM - CONTINOUS
	MC-26NP-I		1" PRINT DRUM - RESET
	MC-26NP-T		1" PRINT DRUM - METRIC - CONTINOUS
	MC-26NP-I-T		1" PRINT DRUM - METRIC - RESET

**WEB NON-ABSORBENT MINI-CODER PRINT ASSEMBLY**  
**WNA-109RM & WNA-109CM SERIES**



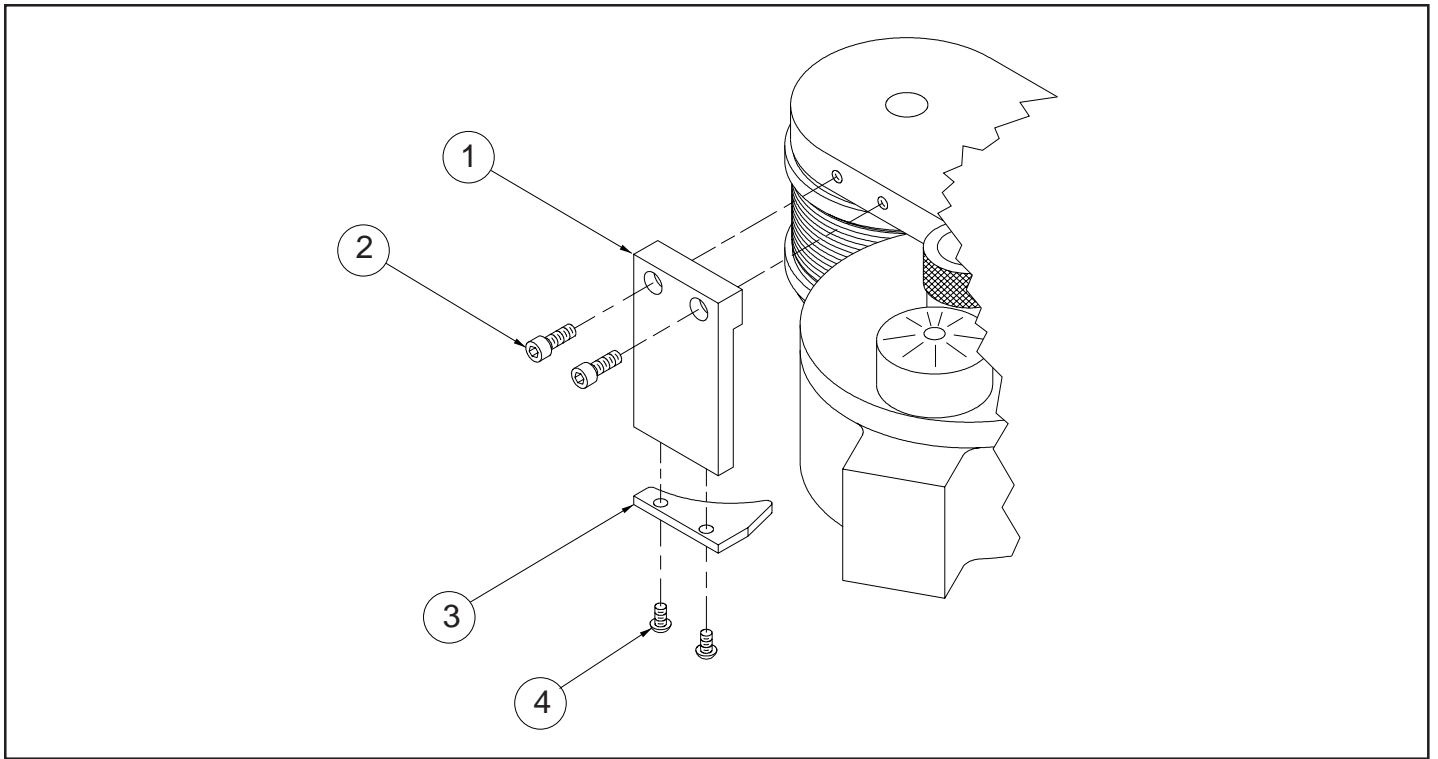
**WEB NON-ABSORBENT MINI-CODER PARTS LIST**  
**WNA-109RM & WNA-109CM SERIES**

KEY NO.	PART NUMBER	QTY. REQD.	DESCRIPTION
1	MC-15	1	TENSION BLOCK RETAINING KNOB
2	CB-05	2	NEEDLE BEARING
3	MC-103	1	PIVOT BLOCK ASSEMBLY "A"
4	MC-19	2	DELTRIN BUSHING
5	MC-17	1	SET SCREW, 1/4-20 X 1/2" CPS
6	MC-06	1	HEX PIVOT POST
7	MC-02	2	SCREW, 1/4-20 X 5/8" SHC
8	MC-100	1	BASE PLATE ASSEMBLY
9	MC-55	1	SPRING PLUNGER
10	CW-04	1	BRASS WASHER
11	MC-10NI-PDA-NP	1	1" CONTINOUS PRINT DRUM ASSEMBLY - COMPLETE
	MC-10-PDA-NP		1" RESET PRINT DRUM ASSEMBLY - COMPLETE
	MC-10NI-PDA-NP-T		1" CONTINOUS PRINT DRUM ASSEMBLY - COMPLETE - METRIC
	MC-10-PDA-NP-T		1" RESET PRINT DRUM ASSEMBLY - COMPLETE - METRIC
12	HP-06	3	SET SCREW, 8-32 X 3/16" CPS
13	MC-ICA-NP	1	INDEX CAP ASSEMBLY - NON-ABSORBENT
14	CW-01M	1	SPRING ATTACHMENT RING - LARGE
15	MC-25	1	PRINT DRUM INDEX SPRING
16	MC-56	1	SPRING ATTACHMENT RING - SMALL
17	HP-06	2	SET SCREW, 8-32 X 3/16" CPS
18	NP-19	1	ECCENTRIC KNURLED KNOB
19	NP-04-LS	1	MC INKING SYSTEM BASEPLATE - LEFT HAND SIDE MOUNT ASSEMBLY
	NP-04-RS		MC INKING SYSTEM BASEPLATE - RIGHT HAND SIDE MOUNT ASSEMBLY
	NP-04-LT		MC INKING SYSTEM BASEPLATE - LEFT HAND TOP MOUNT ASSEMBLY
	NP-04-RT		MC INKING SYSTEM BASEPLATE - RIGHT HAND TOP MOUNT ASSEMBLY
20	HP-42	2	DELTRIN WASHER
21	NP-20M	1	INK ROLL ECCENTRIC
22	NP-07	1	INK ROLL AXLE
23	NP-21	1	ECCENTRIC O-RING
24	NP-XC1	1	1" MC/CLP XF NEOPRENE INK ROLL - DRY

**WEB NON-ABSORBENT MINI-CODER PARTS LIST**  
**WNA-109RM & WNA-109CM SERIES**

KEY NO.	PART NUMBER	QTY. REQD.	DESCRIPTION
25	NP-01-MLS	1	MC INKING SYSTEM COVER - LEFT HAND SIDE MOUNT ASSEMBLY
	NP-01-MRS		MC INKING SYSTEM COVER - RIGHT HAND SIDE MOUNT ASSEMBLY
	NP-01-MLT		MC INKING SYSTEM COVER - LEFT HAND TOP MOUNT ASSEMBLY
	NP-01-MRT		MC INKING SYSTEM COVER - RIGHT HAND TOP MOUNT ASSEMBLY
26	NP-29	1	BLACK VINYL CAP
27	NP-17	1	COVER RETAINING KNOB
28	NP-16	1	DRIVE WHEEL COVER
29	NP-15	1	DRIVE WHEEL DELRIN WASHER
30	NP-14	1	KNURLED DRIVE WHEEL - WITH DELRIN WASHER
31	NP-TRA-1	1	1" TRANSFER ROLL ASSEMBLY
32	NP-05	1	1" TRANSFER ROLL AXLE
33	HP-04	1	3/8" BRASS FLAT WASHER
34	CF-09	1	SCREW, 3/8-16 X 1-1/2" SHC
	CW-02		3/8" STEEL FLAT WASHER
35	CM-17	1	MOUNTING BRACKET
36	MC-39	1	MOUNTING COLUMN
37	CF-13	1	SNAP RING FOR 3/4" SHAFT
38	CW-01	1	3/4" STEEL FLAT WASHER
39	CW-05	2	3/4" NYLON FLAT WASHER
40	MC-104	1	CAM BLOCK ASSEMBLY
41	CF-05	2	SET SCREW, 8-32-3/16" S.S. NTS
42	MC-14	2	TENSION ADJUSTING KNOB
43	CM-33	1	SPRING BLOCK "C"
44	MC-36	2	TENSION SPRING

**WEB NON-ABSORBENT MINI-CODER CE GUARD ASSEMBLY  
WNA-109RM & WNA-109CM SERIES**



**WEB NON-ABSORBENT MINI-CODER CE GUARD ASSEMBLY PARTS LIST  
WNA-109RM & WNA-109CM SERIES**

KEY NO.	PART NUMBER	QTY. REQD.	DESCRIPTION
1	NP-64	1	CE GUARD PLATE #1
2	MS-36	2	SCREW, 8-32 X 1/2" SHC
3	NP-65	1	CE GUARD PLATE #2
4	NP-66	2	SCREW, 6-32 X 1/4" SOC BHC

