

CWL – LABELLING MACHINE OPERATING MANUAL



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Cross – Web Labelling system



CWL – 100 & 200

User Manual

EFFECTIVE SERIAL #: / /

User Manual V-10

Revision Date:04/05/2026

Baumann Engineering Pty.Ltd.

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CWL – LABELLING MACHINE OPERATING MANUAL

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Declaration of Conformity

Product description: CWL bottom – up Labelling station

Serial Number: No. / /

The manufacturer declares that the above product meets all the requirements of the machinery Directive.

The above product fulfils the following requirements:

- Cross Web Labeller in special construction

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Acceptance certificate for machine transfer

Machine Type:			
Machine No.:			
The installation was carried out in accordance with the project specification:			
Functional test and test run without any deficiencies:			
The personnel were trained:			
Names of participants:			
• • •			
The operating manual was handed over.			Yes / No
There were not found any safety defects arising from the machine, the operation, the settings, or adjustment of the machine.			Yes / No
Safety defects were found:			Yes / No
Comment:			
<u>Customer's Address:</u>		<u>Address of appointed Dealer:</u>	
Date / Customer's Signature		Date / Signature of service engineer	
.....			

1. General

1.1 Information on this Manual

This Manual provides important information on how to work with the device safely and efficiently. The Manual is part of the device, must always be kept in the device's direct proximity and should be available for the personnel at any time.

Compliance with all specified safety notes and instructions is a basic requirement for safety at work.

Moreover, the accident prevention guidelines and general safety regulations applicable at the site of implementation of the device must also be complied with.

For better representation of circumstances, the illustrations used are not necessarily to scale and may vary from the actual design of the device.

2. Preface

We would like to thank you for choosing our product. We can assure you that you have chosen a product which offers the latest motion control technology and expectational reliability, which derives from computer aided design and the high-quality materials used in this construction.

The CWL – 100 / 200 Cross – Web package labelling machine has been designed to meet your specific needs both in terms of yield and versatility.

Please read this manual carefully. It will help you to maintain the machine in prime operating condition and will enable you to maximise its usage. The Baumann Engineer service department is always at your disposal to help you take full advantages of the quality and production capacity of our product.

3. Introduction

The information in this manual has been prepared by Baumann Engineering Department to familiarise operators and maintenance personnel with the CWL Cross – web package labelling machine. The machine incorporates some proprietary items for which operating, and maintenance instructions are supplied separately from this manual on a USB flash drive. These will be contained in the documentation package supplied with each machine.

The CWL – 100 / 200 Cross – web package labelling machines has been designed to operate using simple, easily understood principles and will operate safely, at high speed, under computer control for long periods.

This manual gives operators and maintenance engineers a general understanding of the machine.

A full and complete understanding of this machine can only be gained by experience, supported by a study of this manual and the associated publications and training provided by Baumann Engineers. Personnel using or repairing this machine should have received the appropriate training to ensure that they are familiar with possible dangers. All safety interlock equipment must be maintained and regularly checked for satisfactory operation.

Baumann Engineering Pty.Ltd. has a policy of continual research and development, and we reserve the right to make such modifications and design changes as are considered necessary. For this reason, illustrations, and, given in this manual may differ in detail from machines in current production.

No part or software program of this document may be produced or copied in any way without prior written permission from Baumann.

CWL – LABELLING MACHINE OPERATING MANUAL

4. ID / CWL – Cross-Web package labeller

Product:	Model:	Machine. No.:	Year /Manuf.
CWL – 100 Cross-Web package labellers	CWL 100 X	465	2026
CWL – 100 Labelling Head / without Motor	CWL 100 X	465/1	2026
CWL – 200 Cross-Web package labellers	CWL 200 X	466	2026

Construction: Aluminium, Stainless Steel Delrin, PET - P construction.

Note: Specifications are subject to change any time.

For Sales, Call:

e-mail: sales@baumann-industries.com

For Technical Support, Call + 61 2 423544686

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5. OWNERS RESPONSIBILITY

Chapter 1 Owner's duties:

The device is used commercially. Thus, the owner of the device is subject to legal industrial safety and obligations.

The warning and safety instructions in this Manual, the safety, accident prevention guidelines and environment protection regulations, applicable at the site of operation must be completed with the following,

- The owner must inform himself of applicable health and safety regulations.
- The owner must determine additional potential hazards that arise due to the specific working conditions prevailing at the site where the device is implemented.
- The owner must implement the necessary rules of conduct for the operation of the device at the site of implementation by means of the instructions.
- The owner must check regularly throughout the entire implementation period the device, whether the work instructions created by him comply with the current legislation.
- If necessary, the owner must adapt the instructions to new regulations, standards and operating conditions to new regulation standards and operating conditions.
- The owner must clarify regulate and specify the responsibilities for the installation, operation, maintenance, and cleaning of the device.
- The owner must ensure that all employees dealing with the device have read and understood this Manual. In addition, the owner must train personnel in handling the device at regular intervals and inform personnel of possible danger.
- The owner must provide personnel carrying out work on the device with required and recommended protective equipment and check for continuous compliance of the compulsory wearing of protective equipment.
- The owner must provide the required clearances and enough lighting for safe operation and ensure continuous order and cleanliness at the installation site of the device and its surroundings.

In addition, the owner is responsible for ensuring that the device is always in a technically perfect condition. Therefore, the following applies.

- The owner must ensure that the maintenance intervals described in this Manual are complied with.
- The owner must have all safety devices inspected regularly for completeness and function.

OWNERS RESPONSIBILITY

Chapter 2 Responsibilities of the personnel:

The device is used commercially. Thus, the personnel are subject to legal industrial safety obligations.

In additions to the warnings and safety notes in this manual, the safety, accident prevention guidelines and environmental protection regulations, applicable at the site of implementation must be complied with.

In particular:

- The personnel must inform itself of applicable health and safety regulations.
- The personnel must comply with the rules of conduct for the operation of the device at the site of implementation specified in the operating instructions.
- The personal must properly fulfil the specified requirements in terms of operation, maintenance, and cleaning of the device.
- The personnel must have read and understood the Manual before starting any work.
- The personal must use the specified and recommended protective equipment.

In addition, any employee working on the device is responsible for ensuring in its field of responsibility that the device is always in a technically perfect condition.

Therefore, the following applies:

- The personnel must ensure that the maintenance intervals described in this Manual are complied with.
- The personnel must have all safety devices inspected regularly for completeness and function.

OWNERS RESPONSIBILITY

Chapter 3 Personnel requirements:

The different tasks described in this Manual lay down various requirements regarding the qualification of persons entrusted with these tasks.

Insufficiently qualified personal may not assess risks related to the operation of the device and put themselves and others in danger.

Any tasks at the device may only be carried out by persons able to carry out their tasks properly and reliably and who comply with the requirements specified for their task.

- Persons whose reaction capability is impaired. e.g., through drugs, alcohol or medication are not allowed to carry out at work.
- When selecting the personnel, stipulations regarding age and occupation applicable at the site of implementation must be observed.
- Insufficiently qualified personnel must be kept away from the work area.

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OWNERS RESPONSIBILITY

Chapter 4 Instruction:

The personnel must be instructed in the tasks assigned to it by the owner as well as in the possible dangers related to the work before starting any work. The personnel must have read the Manual and participated in an instruction.

Knowledge of the contents must be confirmed by the participants by signature.

Instructions must be repeated at regular intervals (however, at least once a year).

For better tracking, an instruction protocol must be created containing at least the following information:

- Date of the instruction
- Name of the person instructed
- Content of the instruction
- Name of the person having carried out the instruction
- Signatures of the person instructed, and the person having carried out the instruction

Date	Name	Content of the instruction	Instructed by	Signature of the person instructed

OWNERS RESPONSIBILITY

Chapter 5 Unauthorised persons:

No access for unauthorised persons. Unauthorised persons do not know the dangers in the work area and may cause serious injury to themselves and others.

The following persons are deemed unauthorised persons:

- Any person who has not or not completely read the Manual or who has not properly understood it.
- Any person not complying with the personnel requirements (minimum qualification). See page 8.
- Any person who has not been instructed by the owner or its representative for the activity and/or who has not been commissioned.

Unauthorised persons are not allowed to access the work and danger area of the machine.

- In doubt, address the respective persons and direct them to leave the work and danger area of the machine.
- Interrupt work on the machine if unauthorised persons are present in the work and danger area.

6. SAFETY

a. Dangers due to untrained personnel:

Untrained and unqualified personnel pose a risk to itself and other persons.

- Work may only be carried out by personnel experienced in the performance of the commissioned tasks and informed about the dangers.
- Responsibilities of the personnel must be clearly specified for the respective live phases.
- Only employ sufficiently trained and authorised personnel having the qualifications specified in the personnel requirements.
- Personnel to be trained may only carry out work under permanent supervision by an experienced expert.

b. Dangers due to electrical power:

Touching conductive parts causes a danger to live, this may result in severe injuries or death. In addition, electrical components which are switched on may carry out uncontrolled movements.

- Work on electrical systems and equipment must only be carried out by a skilled electrician and in accordance with electro-technical regulations. Before starting work on the electrical system:
 - De-energise the device.
 - Secure it against being switched on again.
 - Make sure that motors/drives and moving parts are standing still.
 - Cordon off the work area and mark it with a warning sign.
 - Check for de-energisation.
 - Earth and short circuit.
 - Cover neighbouring parts.
- Only use voltage isolated tools.
- Regularly check electrical equipment for damage. Danger due to loosen cable connections and burnt cables. Remedy defects immediately and have repairs carried out.
- Do not bridge fuses or render them ineffective.
- When replacing defective fuses make sure you use the correct amperage.
- Keep moisture away from conductive parts.
- Always keep control cabinets locked. Access is only permitted to authorised personnel.

SAFETY

c. Dangers due to electrostatic residual potentials:

Friction caused by paper, film, conveyor belts and other non-conductive materials may build electrostatic potentials and result in a danger to persons. Discharge may result in an electrical shock or in secondary accidents due shock reaction as a result of discharge. In case of fear of repeated shocks, uncertainty may lead to mistakes. Furthermore, the health of persons is generally impaired in cases of permanent charging.

- Ensure potential equalisation prior to touching parts.
- Wear conductive clothing and shoes.

d. Dangers due to moving components:

Freely accessible moving device components can create hazard zones which may cause severe injuries or death. There is a danger of being caught, pulled in or entrained by moving parts.

If the hazard zone cannot be spatially separated from the work area, the following safety measures must be observed.

- Keep a safety distance to hazard zones.
- Wear tight fitting clothing.
- Do not wear rings, chains, neckless, and other jewellery.
- Wear a hair net in case of long hair.
- Do not remove protective covers.
- Do not put safety devices and/or functions out of operation and do not render them inoperative or bypass them.
- Never reach in to running equipment.
- Before starting any work in hazard zones, always wait for the standstill of lagging components and for the autonomous discharge of residual energies.
- Secure the device from being switched on again to avoid unintentional movements of components. Cordon off the work area and mark it with a warning sign.

SAFETY

e. Dangers due to falling material rolls and other items:

During operation and especially in case of replacement, material rolls may fall and causes injuries.

- Always hold material rolls tight with both hands when handling them and secure them as specified after insertion.
- Always wear personal protective equipment when setting up and carrying out maintenance or repair work.

f. Dangers due to sharp edges:

Sharp edges, sharp corners and sharp paper edges may result in abrasion, scratches, and cuts.

- Always pay attention and caution when carrying out work.
- Wear personal protective equipment.

g. Dangers due to pressurised media:

Pressurised pipes and hoses (for example compressed-air supply, media supply) may move uncontrollably and cause severe injuries in case of improper handling. Media may leak from pressurised components under high pressure in case of improper handling or a defect and cause severe injuries.

Before start working on these components:

- Establish an unpressurised condition.
- Discharge residual energies.
- Check the system for a depressurised condition.
- Make sure that the medium is not unintentionally leaking.
- Defective components which are pressurised during operation must be immediately replaced.
- In general, work on pressurised components may only be carried out by appropriately qualified experts (pneumatic experts)

SAFETY

Read and understand owner's manual before using this machine. Failure to follow operating instructions could result in personal injury or damage to equipment.

DANGER

h. Hazardous voltage.

Disconnect and lockout power before servicing machine or cleaning. Do not remove panels unless power has been disconnected and locked out at risk of electric shock hazard.

WARNING

i. Moving parts. Pinch point hazard.

Do not put hands in to machine while running. Ensure that the conveyor is not operating prior to freeing product or handling conveyor. Conveyor creates pinch point and draws in prior to freeing product or handling conveyor. Conveyor creates pinch point and draws in hazards.

CAUTION

j. Hot surfaces. Do not touch.

To avoid skin burns, disconnect and lockout power. Allow surfaces to cool before servicing or cleaning.

k. Cleaning agents.

Do not get the cleaning agents in eyes, or skin, or clothing. Always wear rubber gloves, goggles, and protective clothing when contact is likely. Consult product manufacturer for specific details.

Signal words used in classification of potential hazards are defined as follows:

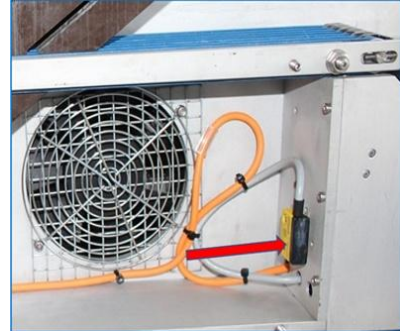
1. **DANGER:** Indicates an imminently hazardous situation, which, if not avoided, may result in death or serious injury.
2. **WARNING:** Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury.
3. **CAUTION:** Indicates a potentially hazardous situation, which, if not avoided, may result in minor or moderate injury. Caution also indicates that may cause property damage

SAFETY

I. Installed safety devices:

Non-functioning bridged or disabled safety devices are not protecting against dangers and may cause severe injury or death.

- Before switching on the system, always make sure that all safety devices are properly installed and working.
- Never disable safety devices.
- Always keep safety devices freely accessible.



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7. TECHNICAL DATA

I. Model CWL – 100 / 200

The following data are applicable to all models of the series CWL -100 /200

Note:

The data on dimensions of the automatic cross-web labelling machine are included in the dimension sheet in the annex to this operating manual.

Parameter	Value
Electrical supply	
Voltage and number of phases	240 – VAC, 50/60 Hertz, single phase
Max. power consumption	1500 VA
Normal current	4 A
Circuit breaker: Tipping current	10 A.
Tripping current characteristic	Characteristic C
Pneumatic supply	
Pressure	6 bars
Quality	Compressed air, oil free, clean
Air consumption CWL-100	3.7 NL

Work area:

Specification	Value
Temperature range	5 – 30 ° C
Relative humidity, non- condensing	25 – 80 %
Conditions	Protect devices components and media containers from sun and heat. Avoid direct moisture, dust load and frost.
Noise emission	≤ 70 Db (A)

Operating time:

Specification	Value
Uninterrupted operation, max.	Suitable for continuous operation
Maintenance intervals, min.	3 months

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TECHNICAL DATA

II. Model CWL – 100 / 200

Labelling Station

Specification	Value CWL - 100	Value CWL - 200
Passage width	100 mm	200 mm
Label reel (max. outer diameter)	380 mm	380 mm
Label reel weight	12 Kg	12 Kg
Label reel (core diameter)	76 (40) mm	76 (40) mm
Backing paper reel max	100 mm	200 mm
Maximum dispensing speed	40 m/min (Depend. label size)	40 m/min (Depend. label size)
Drive	Step motor	Step motor
Increment	0.1 mm	0.1 mm

Transporting unit

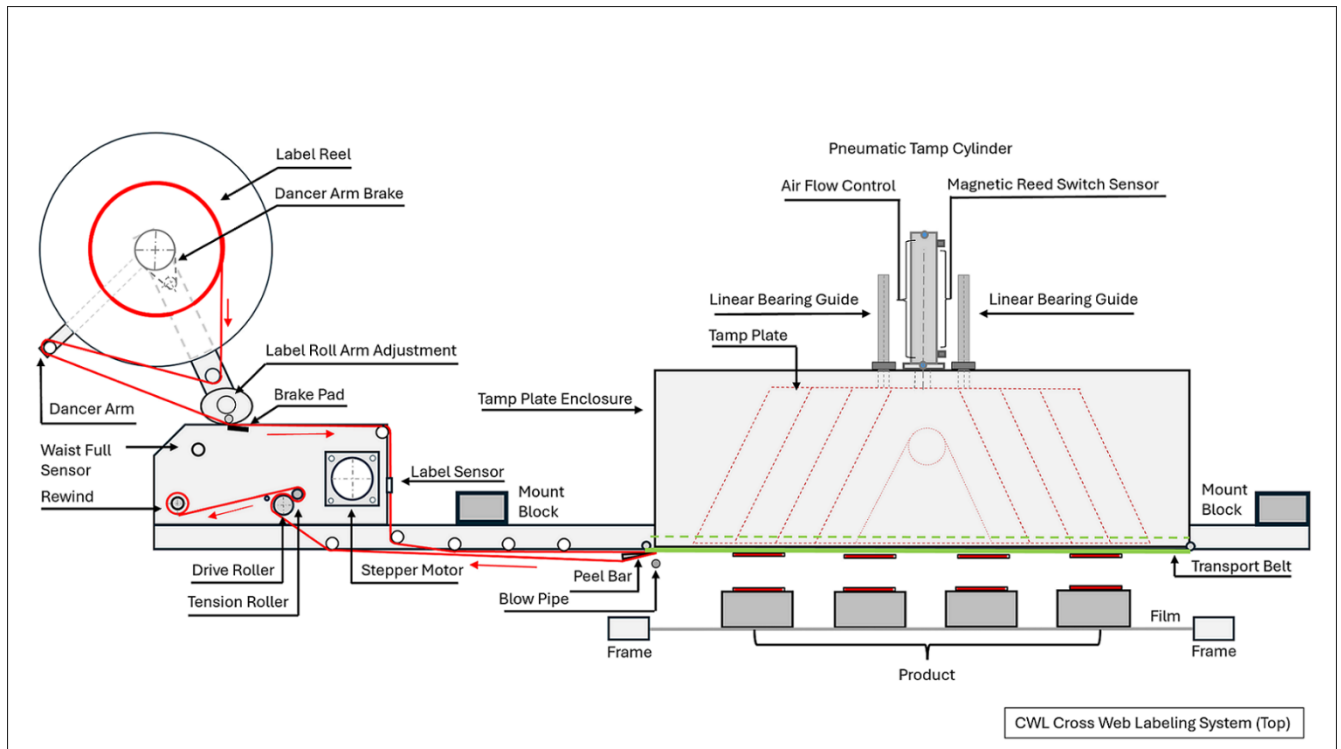
Specification	Value
Film width	720 mm
Transport width	650 mm
Label size (min. diameter)	30 mm
Max. speed transport unit	40 m/ min (Depend. label size)
Drive	Step motor
Increment	0.1 mm

Longitudinal stroke unit (option)

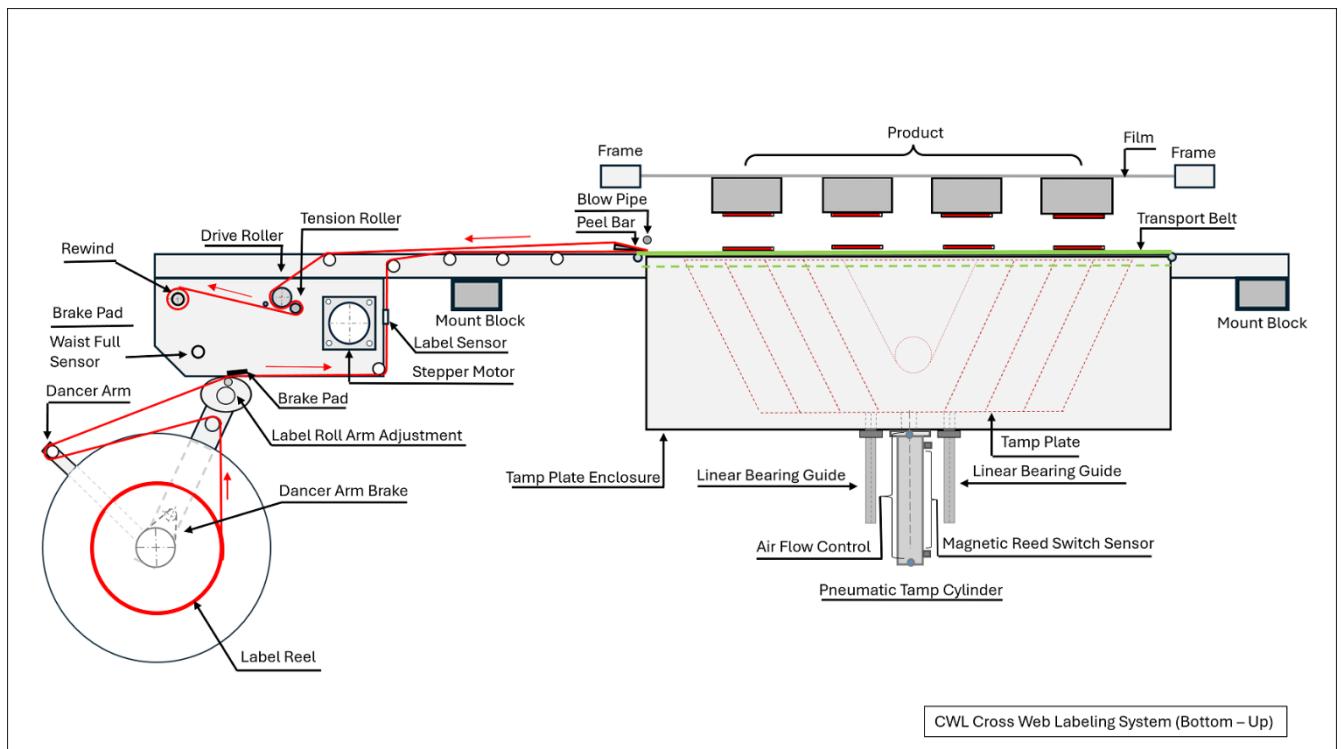
Specification	Value	Value CWL – 200
Maximum amount of pull	800 mm	800 mm
Travel distance max.	400 mm	400 mm

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8.STRUCTURE AND FUNCTION



The labels are dispensing onto a transporting belt, are separated, and are transported crosswise to the direction of movement of the packaging machine conveyor over the finished packages. The labels are positioned and pressed on to the packages during the stand still of the packing machine conveyor.



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It is possible to label more than one package row during one packaging machine. Cycle by way of using the optional longitudinal stroke unit transporting the complete cross-web labeller by an adjustable distance.

STRUCTURE AND FUNCTION

1. Unwinder:



The unwinder receives the label tape. The flanged disks are secured with quick release buckles.

The flanged disks have two functions:

- They prevent the label reel from slipping sideways.
- They fix the label reel so that the swing arm can release or engage to the brake band

The labelling station is responsible for the transport of the backing strip. After the labels have been detached from the backing strip, the backing strip is wound on to a coiler.



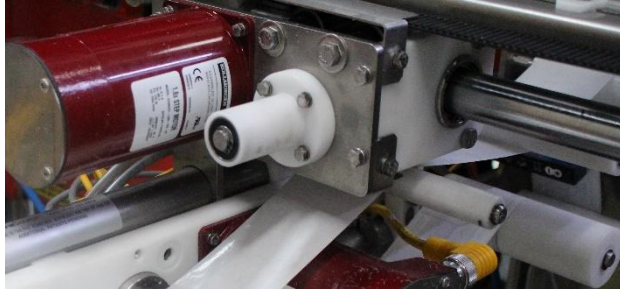
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STRUCTURE FUNCTION

2. Longitudinal adjustment:

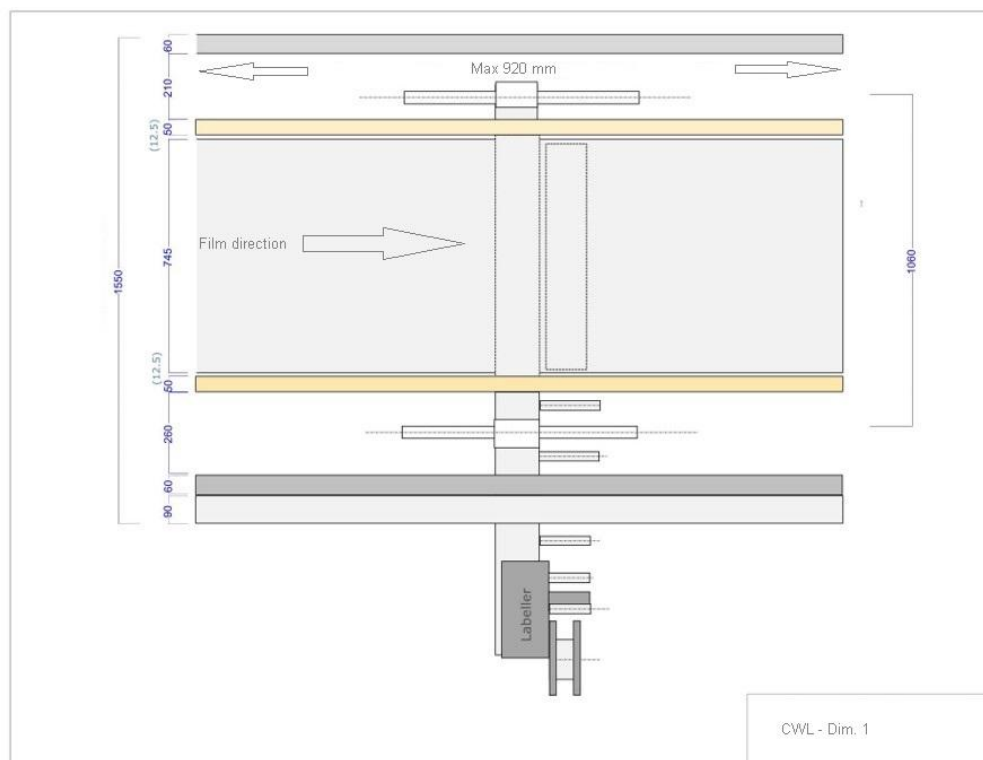
OPTION

The longitudinal set position of the labels to the pack can be manually adjusted.



Option:

For multiple package rows during one packaging machine cycle using the longitudinal transport unit for shifting the cross-web labeller by automatic adjustable distance.



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STRUCTURE AND FUNCTION

3. Label transport unit:



The label transporting unit will hold off the labels by vacuum released from the backing strip and will transport the labels to the defined position.

An integrated pusher will transfer the labels on to the product.

4. Blow pipe:



Air blow system to keep the label down during label transfer (low pressure)

9.INSTALLATION

1. Installation:

The installation of the CWL Cross-web Package Labeller should be performed by a Baumann Service technician or qualified Packaging Machine OEM technician. If you are installing the CWL Cross-web Package Labeller, contact Baumann Services at + 61 2 423544686 for telephone assistance.

NOTE: 240 VAC POWER MUST BE MAINTAINED CONTINUOUSLY TO THE LABELLER IN HARSH ENVIRNMENTS.

Model Identification

Baumann Engineering Pty. Ltd.

8 Powys CCT.

Castle Hill NSW 2154 Australia

Phone No. + 61 (2) 4235 44686

e-mail: sales@baumann-industries.com

Model No. _____

Serial No. _____

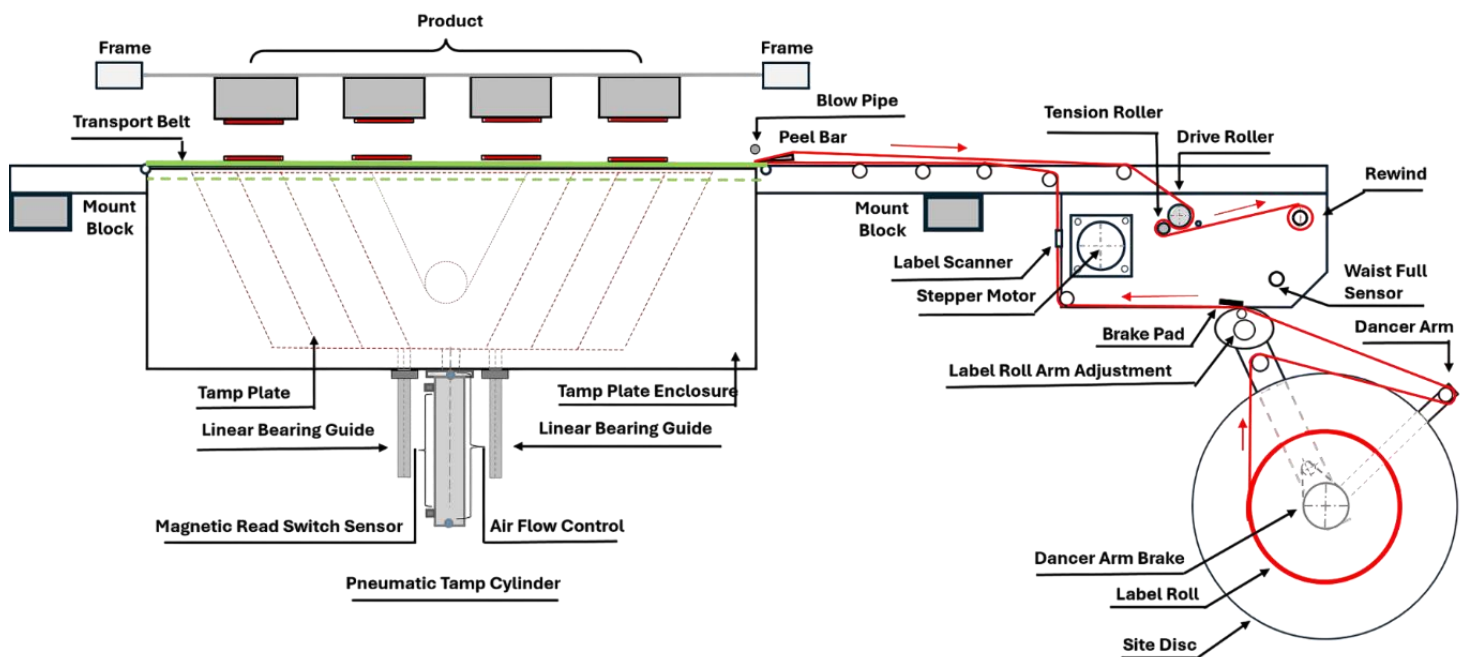
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CWL – LABELLING MACHINE OPERATING MANUAL

10. Operating Instruction

I. Pre-Run Check List:

- ✓ Verify tension roller.
- ✓ Verify label brake arms are down.
- ✓ Verify sure label reel is tightened against label roll.
- ✓ Verify sure dancer operation stops label roll from unwinding.
- ✓ Verify threading, particularly in peel bar area and label sensor area.
- ✓ Check pressure regulator.



Operation Instruction

II. Labelling System:

The system controller holds up to 10 product recipes which may be changed when the labeller is stopped. When a recipe is selected for download, labellers are updated simultaneously.

1. Upon power up, the touch screen will show the start screen.
2. The CWL Cross-web Labeller is programmed without changing Tools.

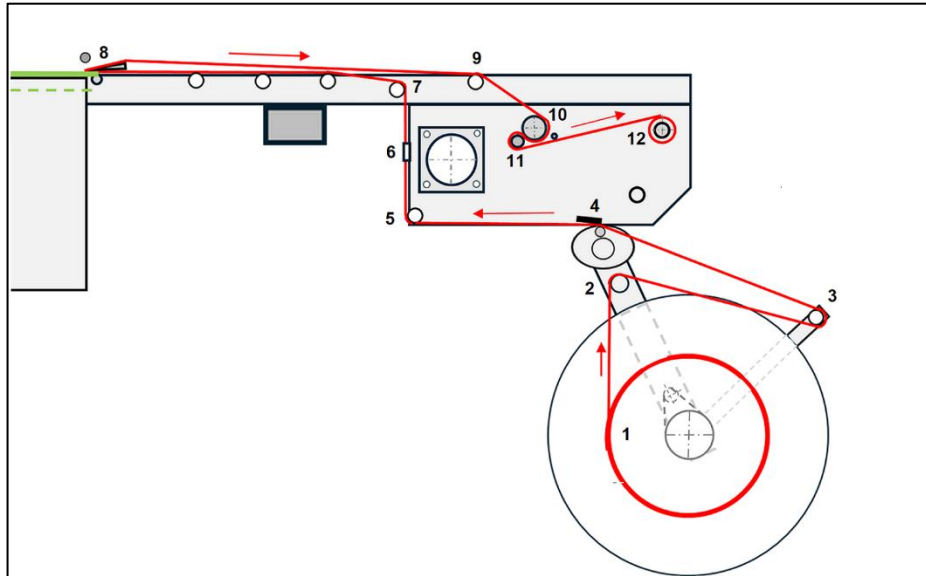
- **Thread the label roll into the labeller. Ensure tension roller is engaged.**
- **Perform a label sensor sensitivity adjustment.**

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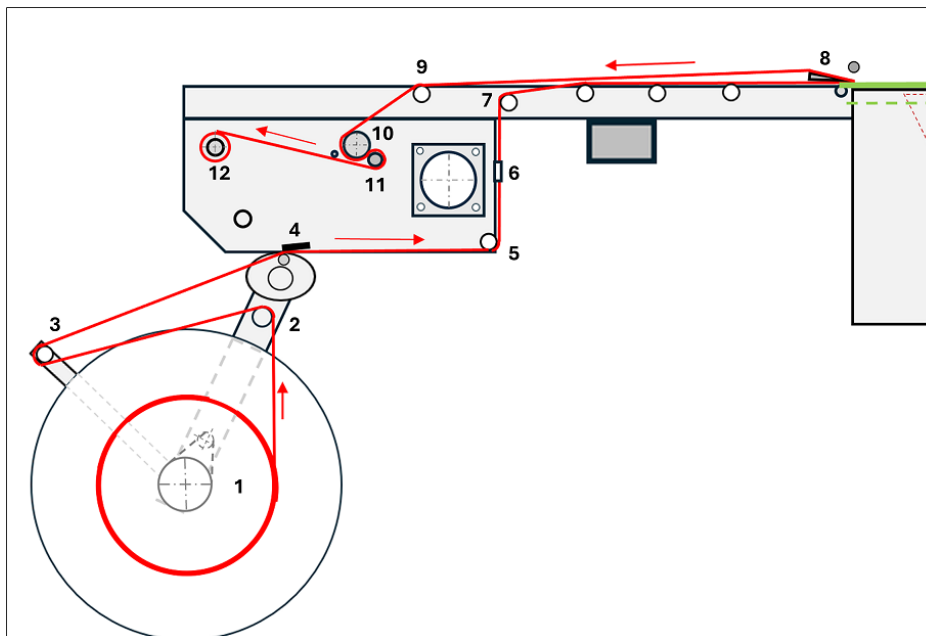
Operation Instruction

III. Threading Diagrams bottom labeller:

Bottom Left



Bottom Right



Label reel can be adjusted to different positions to provide the optimal ergonomic loading position.

(Depending on installation)

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12. Operating Steps



Power – up the labeller

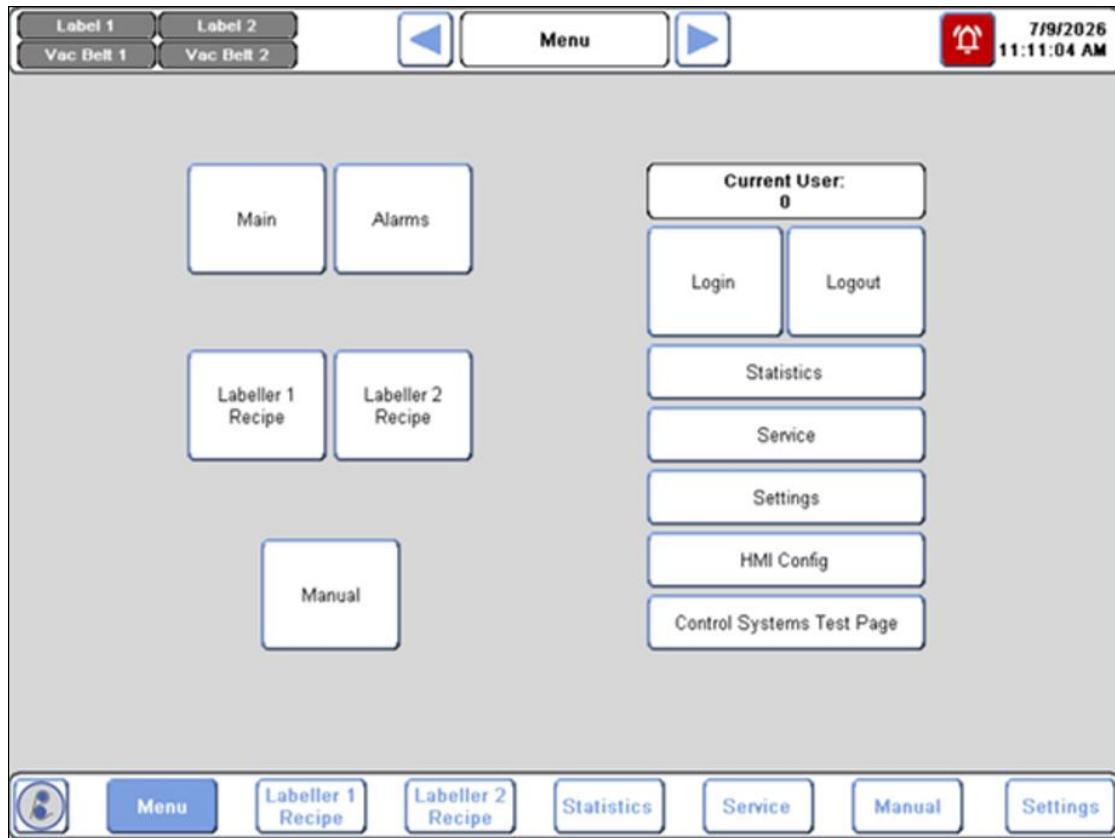
Welcome Page



This page is displayed when the labeller system is turned on.

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Menu



This is the main menu of the system. From all pages can be accessed.

General Navigation

Additional to the “Menu” page, the navigation bar at the bottom of the page will allow the user to navigate through various pages.

The  and  buttons will take the user forward and backward through previously accessed pages.

The  button / indicator will take the user to the Alarm page.

The  button will take the user to the “Main” page.

Access Levels

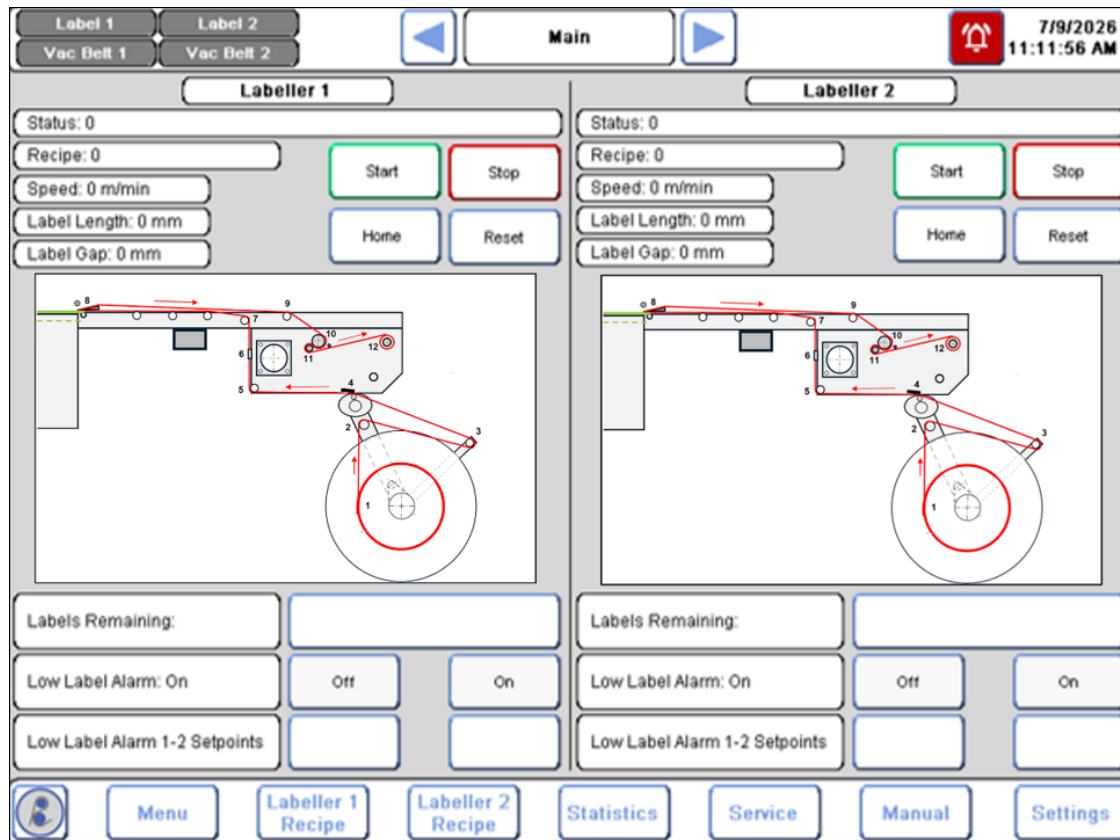
Different access levels grant access to different pages. Access levels are granted by

Using the  Log in button.

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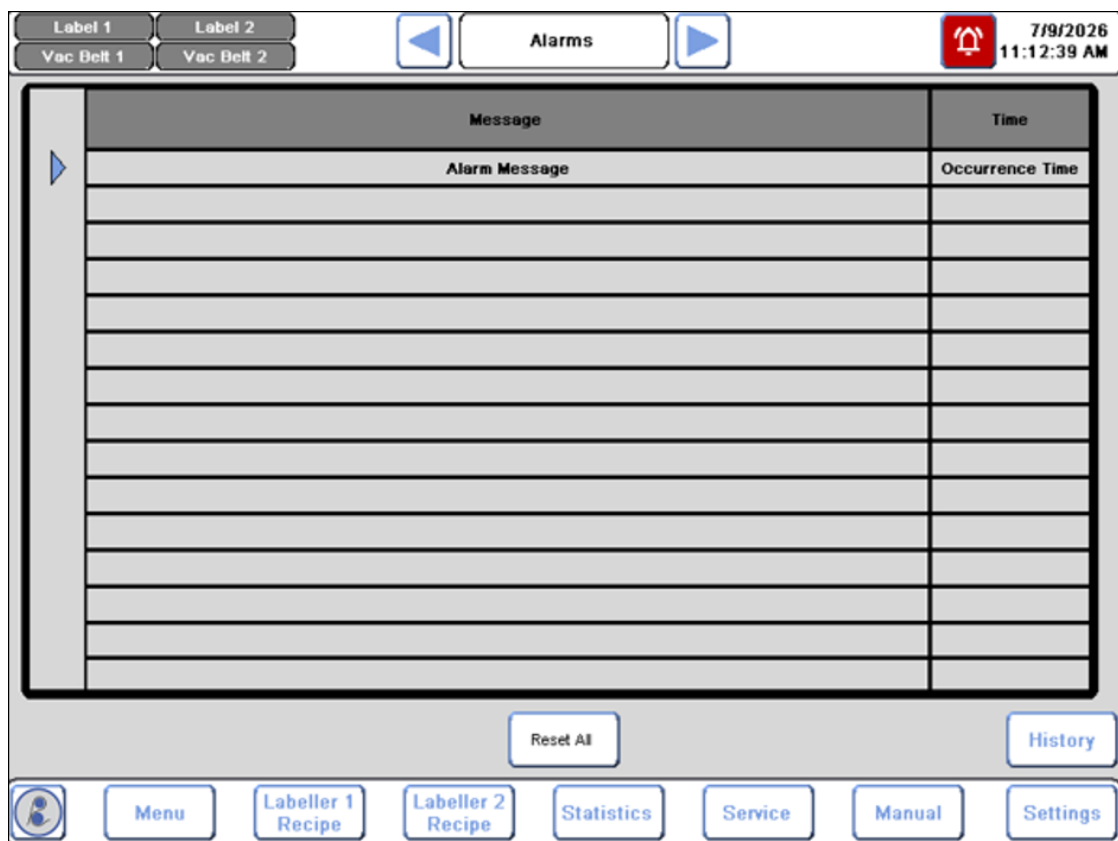
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Main



This is the main page of the system where the operator will likely spend most of their time. The path of the threaded label can be seen here to assist the operator in threading a new label. Each labeller can be started and stopped, homed and reset. Low label alarms can also be set here.

Alarms



The alarms page will display the active alarms only. To switch to the alarm history, press **History** button.

To reset all alarms, press the reset **Reset All** button.

Manual Mode. this page allows to test the displayed functions.
Labeller must be in stop position.

Admin Service: Displays when next service is due. New service date can be edited.

Labeller Recipe (1 and 2)

The screenshot displays the 'Labeller 1 Recipe' interface. At the top, there are tabs for 'Label 1', 'Label 2', 'Vac Belt 1', and 'Vac Belt 2'. The main title is 'Labeller 1 Recipe'. On the right, a red alarm icon and the date/time '7/9/2026 11:13:17 AM' are shown. The interface is divided into two main sections: a left section for label layout and a right section for recipe parameters.

Left Section (Label Layout):

- Film Width (mm):** Input field.
- Label Distance (mm):** Input field.
- Dispense Edge Offset (mm):** Input field.
- Number Of Labels:** Input field.
- First Label Position (mm):** Input field.

Right Section (Recipe Parameters):

- Running Recipe:** 0
- Recipe Name:** Input field.
- Labeller Speed (m/min):** Input field.
- Vac Belt Speed (m/min):** Input field.
- Label Start Delay (ms):** Input field.
- Vac Belt Start Delay (ms):** Input field.
- Tamp Wait Time (ms):** Input field.
- Tamp Up Time (ms):** Input field.
- Blow Air Pulse Start (ms):** Input field.
- Blow Air Pulse Stop (ms):** Input field.

At the bottom, there are navigation buttons: 'Menu', 'Labeller 1 Recipe' (highlighted), 'Labeller 2 Recipe', 'Statistics', 'Service', 'Manual', and 'Settings'. There are also left and right arrow buttons and a 'Download' button.

The labeller recipe page allows the user to edit; view and download recopy.

- **Recipe Running:** The name of the currently downloaded running recipe.
- **Labeller Speed:** Speed of the labeller.
- **Vac Belt Speed:** Speed of the vacuum belt.
- **Label Start Delay:** The delay for the labeller to print after the last set of labels was applied by the tamper.
- **Vac-Belt Start Delay:** N/A
- **Tamp Wait Time:** The delay the tamper will wait after receiving the label apply trigger.
- **Tamper Up Time:** The time the tamper will stay in the up position:
- **Blow Air Pulse Start:** The time the air tube will stay on.
- **Film Width:** The width of the plastic film.
- **Dispense Edge Offset:** The distance the first label will sit from the next label index.
- **First Label Position:** The distance the first label will sit from the next label index.
- **Number Of Labels:** The number of labels in the recipe.

CWL – LABELLING MACHINE OPERATING MANUAL

Manual

Label 1		Label 2		Manual		7/9/2026 11:13:56 AM	
Vac Belt 1		Vac Belt 2					
Labeller 1 I/O				Labeller 2 I/O			
Home		Dispense		Home		Dispense	
Label Axis				Label Axis			
Manual Speed		Jog	.00 m/min	Manual Speed		Jog	.00 m/min
Move Distance		Move		Move Distance		Move	
Vac Belt Axis				Vac Belt Axis			
Manual Speed		Jog	.00 m/min	Manual Speed		Jog	.00 m/min
Move Distance		Move		Move Distance		Move	
Air Pulse	Off	On		Air Pulse	Off	On	
Tamper	Down	Up	Up Dn	Tamper	Down	Up	Up Dn
Label Sensor				Label Sensor			
Waste Full Sensor				Waste Full Sensor			
Label Position Error: .00 mm				Label Position Error: .00 mm			
E-Stop Health				E-Stop Health			
Menu		Labeller 1 Recipe		Statistics		Service	
		Labeller 2 Recipe		Manual		Settings	

This page allows the user to monitor various inputs and outputs as well as manually operate various functions.

Settings

The screenshot displays the 'Settings' screen of the CWL Labelling Machine. The interface is organized into two main sections for 'Labeller 1' and 'Labeller 2'. Each section contains a list of adjustable parameters with corresponding input fields:

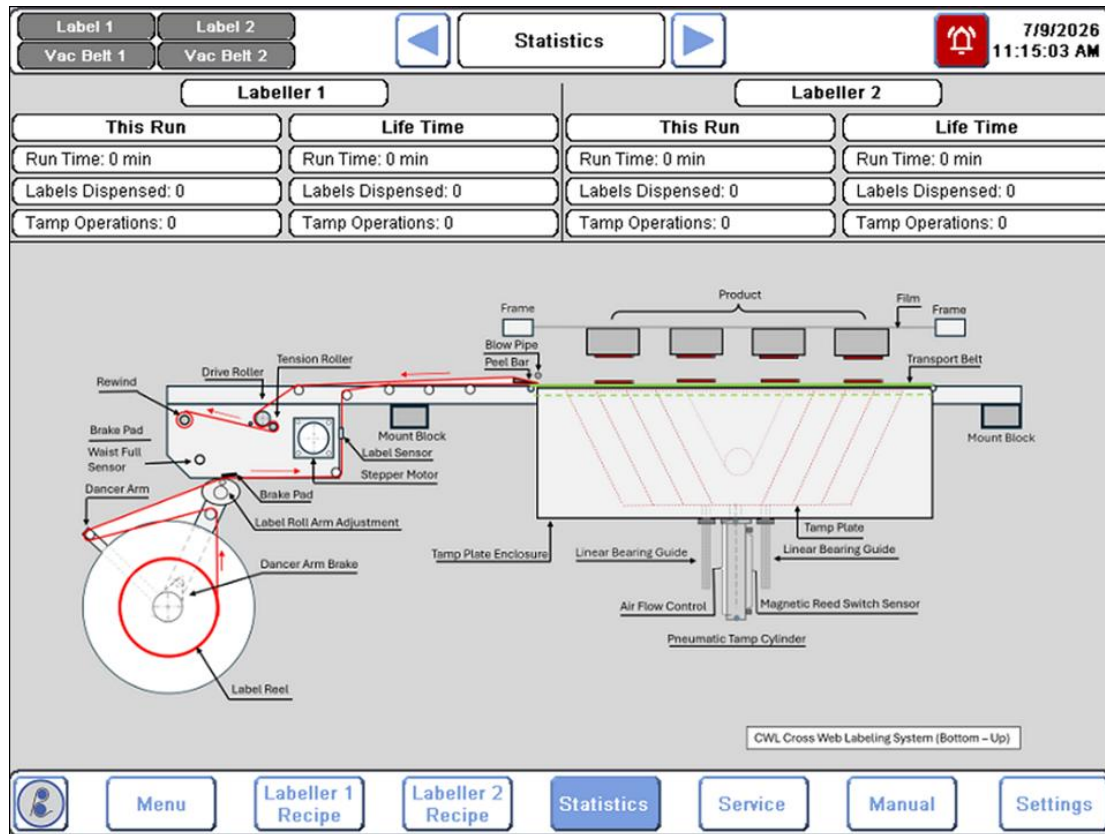
- Labeller 1 Settings:**
 - Dispensing Edge Compensation
 - Acceleration (%)
 - Deceleration (%)
 - Jerk (%)
 - Homing Speed (m/min)
 - Blow Tube Compensation
 - Idle Time Turn System Off (ms)
- Labeller 2 Settings:**
 - Dispensing Edge Compensation
 - Acceleration (%)
 - Deceleration (%)
 - Jerk (%)
 - Homing Speed (m/min)
 - Blow Tube Compensation
 - Idle Time Turn System Off (ms)

Below each list of settings is a 'Factory Defaults' button. The top of the screen features a header with 'Label 1', 'Label 2', 'Vac Belt 1', 'Vac Belt 2', a 'Settings' button, a red alarm icon, and the date/time '7/9/2026 11:14:35 AM'. The bottom of the screen has a navigation bar with buttons: Menu, Labeller 1 Recipe, Labeller 2 Recipe, Statistics, Service, Manual, and Settings.

Allows the user to set various settings for the labelling system.

CWL – LABELLING MACHINE OPERATING MANUAL

Statistics



Shows the user an overview of the system and various components to allow them to familiarise with the system. Also includes various statistics.

CWL – LABELLING MACHINE OPERATING MANUAL

Service



Quick reference contact information.

Baumann Engineering Pty.Ltd.

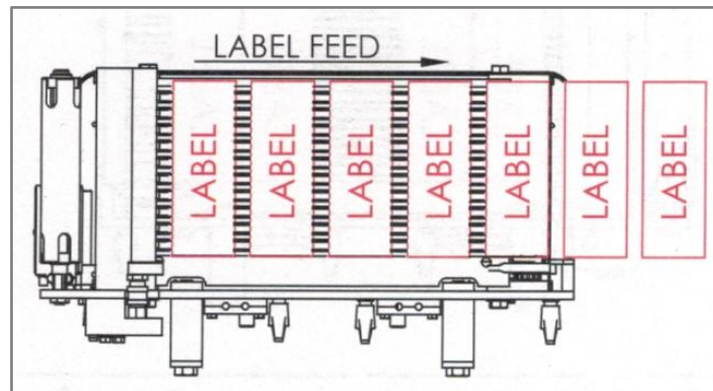
13. TROUBLE SHOOT

1. Trouble shooting quick guide

Label feed does not switch off; labels continue to run	• Label material was inserted in a wrong way • Wrong PEC adjustment • PEC is dirty • Labels run out of the PEC
Labels are misaligned on the product	• Feed unit not closed • Paper brake not applied • Deflection rollers are pull-out with glue • Label glue on dispenser edge • Torsion spring in the feed unit is broken • Label material is inserted in a wrong way
Control cannot be switched on	• No supply voltage • Circuit Breaker tripped • Power plug loosened
Backing paper is not wound up	• Toothed belt is torn • Friction disks are worn
Control is switched on, but Stepper motor has no holding torque	• Fuse for motor voltage is damaged • Stepper motor step is in fault condition (LED motor drive shines red) • Cable rupture
Stepper motor is bucking	• Dispenser acceleration too high • Rewind reel for backing paper is full • Glue residues on the deflection rollers • Dispenser edge worn
No start signal	• Automatic operation not switched on • Packing machine does not provide any start signal
Tamp blade not moving up	• No air pressure for pneumatic cylinder • Label stuck between tamp blade • Read switch on air cylinder faulty

TROUBLE SHOOT

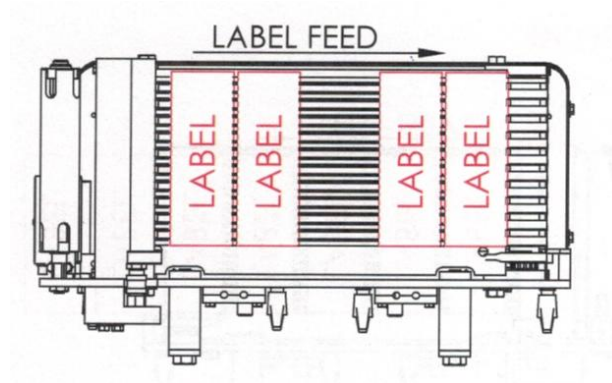
2. Sensing and dispense



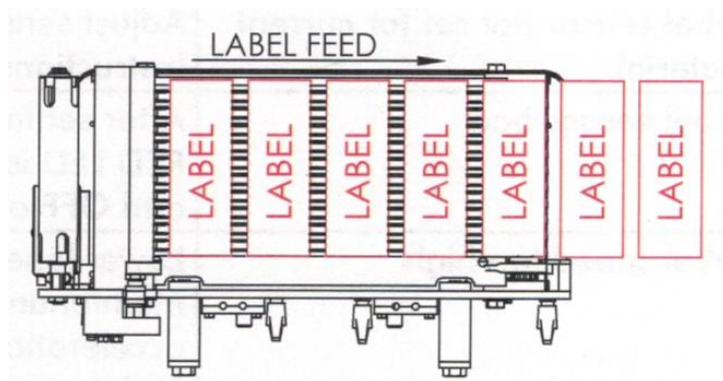
Problem	Indications	Remedy
Labels run out quickly without stopping.	Labels mis thread.	Confirm labels are running in forked gap of sensor and not threaded around blow – on tube.
	Label sensor not set for current material.	Adjust sensor sensitivity per instructions.
	Label speed to high.	Lower label speed (or have maintenance increase acceleration rate in maintenance screen).
	Label peel over parameter is too low.	Increase peel parameter.

TROUBLESHOOT

3. Sensing and dispense



Problem	Indications	Remedy
Labels dispense two at the time, consistently in pairs.	Label peel over distance sensor / label position is set to high.	Adjust distance

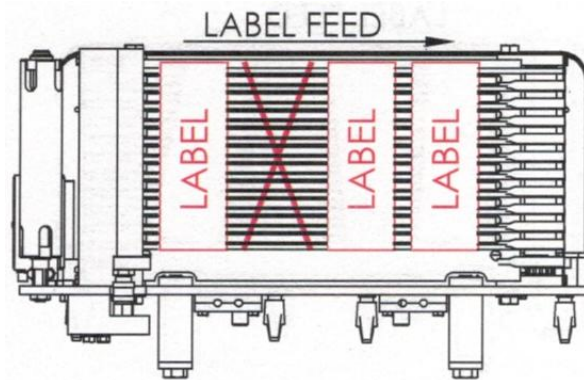


Problem	Indications	Remedy
Labels dispense two at the time, occasionally.	Label sensor sensitivity not set.	Adjust sensor sensitivity per instructions,

CWL – LABELLING MACHINE OPERATING MANUAL

TROUBLE SHOOT

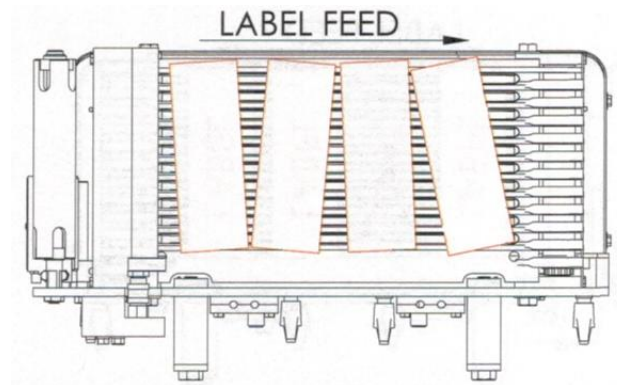
4. Sensing and dispense



Problem	Indications	Remedy
Labels missing.	Label sticking to blow tube.	1. Adjust blow tube direction and / or flow control. 2. Check for missing labels on label roll. 3. Make sure knurled tension roller is locked down. 4. Make sure label reel is tightened against label roll to assure proper dancer operation.
Label backing paper tearing.	Check peel bar edge for nicks or cuts.	1. Replace peel bar if necessary. 2. Replace label roll if cut marks are easily visible. 3. Make sure, knurled tension roller is locked down. 4. Make sure label brake arms are in position.

TROUBLE SHOOT

5. Transport across the web

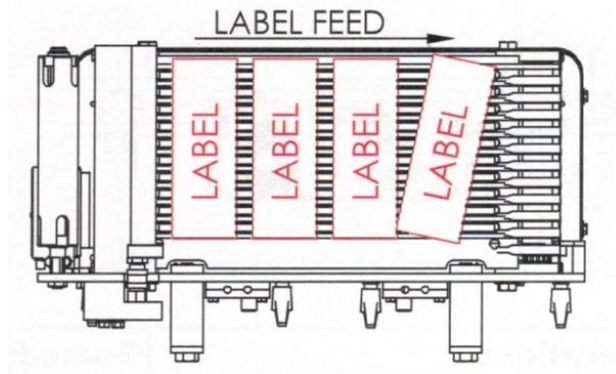


Problem	Indications	Remedy
All labels misaligned after transport, before tamping.	Vacuum fans blocked or failed.	Check for clear operation of all fans.
	Blow-on tube directed out toward transporter and / or air pressure adjusted to high.	1. Rotate blow on tube where hole faces directly down toward transports or slightly back toward peel bar. 2. Adjust flow on blow – on valve on the pneumatic valve.
	Peel over setting.	3. Make sure at least 1 mm of label edge is visible on peel bar, and not more than 5 mm.
	Label material stuck to tamp blades or transport belts.	4. Clean and remove any material.
	Label brake adjusted loosely.	5. Increase tension on labeller
	Label material die cut in to backing paper.	6. Check liner for cut marks. If present, talk to the label supplier about correcting.
	Blue transport belts loose.	7. Tighten belts using adjustment bolts. (Do not overtighten belts) 8. If labels are round or non-rectangular, be sure labels and photo sensor are positioned consistently and reading the same position on the label.

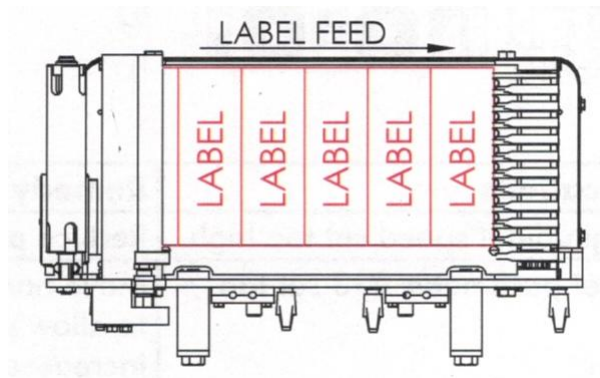
CWL – LABELLING MACHINE OPERATING MANUAL

TROUBLE SHOOT

6. Transport across web



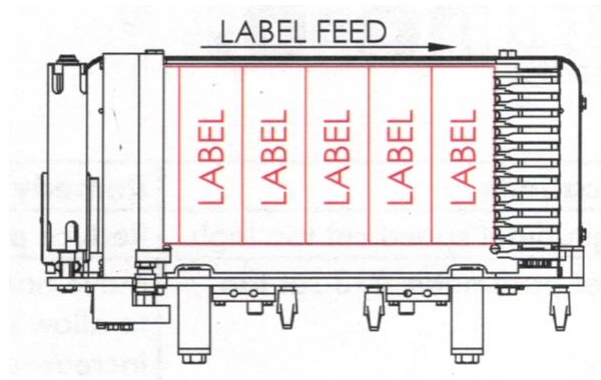
Problem	Indications	Remedy
First label out misaligned after transport, before tamping.	Tamp retract time too short, resulting in first label dispensed contacting the retracting tamp blades.	1. Increase tamp wait time 2. Speed up tamp cylinder retract by opening the flow control screw.



Problem	Indications	Remedy
Labels aligned but coming up short in position.	Transporter stalling or belts slipping.	Tighten transporter belts.

TROUBLE SHOOT

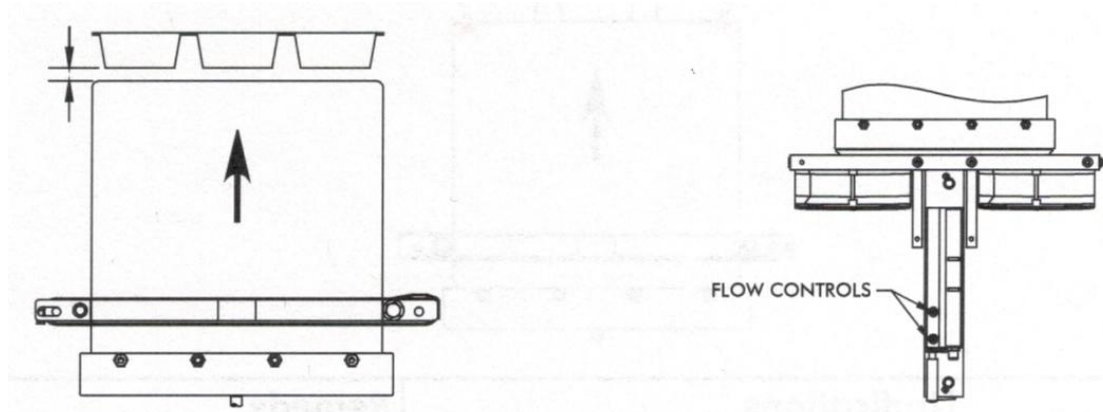
7. Transport across Web



Problem	Indications	Remedy
Labels aligned but coming up short in position	Transporter stalling or belts slipping	Tighten transporter belts

TROUBLE SHOOT

8. Label Tamp not reaching surface



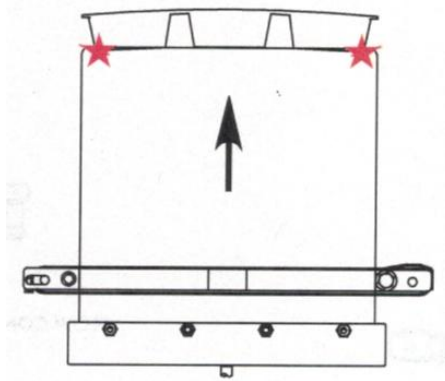
Problem	Indications	Remedy
Label Tamp not reaching surface.	Not enough air pressure.	Check regulator to confirm pressure is at 90 p. s. i. (6 bar).
	Tamp time is not set high enough.	Increase tamp time.
	Tamp cylinder flow control is not adjusted.	Open flow control adjustment as shown.
	Cylinder worn or shaft bent.	
	Linear guides not moving freely.	Grease or oil linear guide's shaft.

Note:

For higher speed applications, the flow control adjustment should be left completely open and tamp setting should be adjusted primarily tamp time.

TROUBLE SHOOT

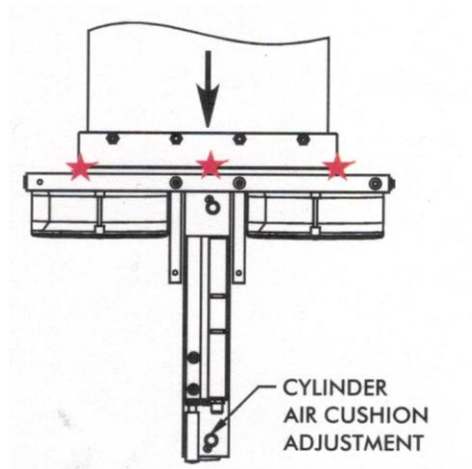
9. Label tamp stroke varying



Problem	Indications	Remedy
Label tamp not reaching surface.	Too much air pressure.	Check regulator to confirm pressure is at 90 p. s. i. (6 bar).
	Tamp time is set too high for flow control adjustment.	Degrease tamp time by 5mS increments or close off flow control adjustments one half turn until desired tamp is reached.
Label tamp varying throughout the day.	Supply air pressure varying and / or not high enough pressure source.	Change or improve the air source to provide a minimum of 90 p.s.i. (6 bar) To the labeller regulator.
	Water in the tamp valve or regulator.	Open drain on regulator and clear the water present.
	Tamp valve or cylinder worn.	Replace components.

TROUBLE SHOOT

10. Label tamp banging on return stroke



Problem	Indications	Remedy
Label tamp banging on return stroke.	Cylinder air cushion is out of adjustment.	Tighten air cushion until desired return stroke is achieved. Do not tighten cushion too much, Or tamp blades will retract too slowly and impede the label dispense.

14.LABELLER SPEED

Labeller speed and acceleration is a function of motors speeds, die configuration, and tamp times. The labeller speed is entered in m/min, and the acceleration rate is entered in m/sec². Two motor options available: standard-torque and high torque.

The motor speeds listed below are average speeds for these motors. Some factors, such as temperature and label size, may reduce the actual speed that the labeller can achieve. In general, the labeller speeds should be set as low as possible while still maintaining packaging machine speed.

Standard – Torque		
Motor		Max.
Label speed	Depend on label size	40 m/min
Transporter speed	Depend on label size	40 m/min
Label Acceleration Rate		1m/s ²

TROUBLE SHOOT

11. Blow – On

Location	Problem	Indications	Remedy
Blow - On	Blow – on does not activate with valve and relay LED (on PWB) indicators “ON.”	• Loss of air pressure. • Pressure regulator not set or faulty. • Flow control out of adjustment. • Valve coil damaged	Restore line pressure. Set or repair pressure regulator to 90 p.s.i. (6 Bar). Open flow controls to obtain proper operation. Replace Valve.
Blow - On	Blow – On does not activate with valve LED indicator OFF and relay LED (On PWB) indicators:” ON.”	• Relay damaged or not seated properly. • Connection between relay output and valve faulty. • 5 Amp fuse on PWB board blown.	Replace or re-install relay. Check connections. Replace fuse and check isolation.
Blow - On	Blow – On does not activate relay LED indicators (On PWB) “OFF.”	• Drive I/O not reaching relay input.	Check connections.

TROUBLE SHOOT

12. Display

Location	Problem	Indications	Remedy
Display	Labeller does not display anything on screen.	• 240 VAC disconnected • Main control power Circuit Breaker off. • 24 VDC power supply failed. • 24 VDC power supply connection loose. • 24 VDC time delay failed. • Touchscreen failed.	Check 240 VAC input Reset Circuit Breaker. Replace power supply. Check connections on power supply pins and PWB. Replace time delay relay. Replace touch screen.

CWL – LABELLING MACHINE OPERATING MANUAL

TROUBLE SHOOT

13. Label Sensor

Location	Problem	Indications	Remedy
Label stopping.	Label gaps missed or runaway labels.	Label sensor out of adjustment. Label speed set to high.	Set label sensor Degrease label speed parameter or increase acceleration parameter.

14. Motor Torque

Location	Problem	Indication	Remedy
Motor torque	There is little or no holding torque; the power LED is "ON" and the motor fault RED LED is "OFF."	- Current selects AMPS DIP is set improperly. - Motor internally shorted. - Low AC line voltage. - Drive failure.	Confirm proper drive switch settings. (See electrical diagram) Check motor impedance and replace if necessary. Verify incoming line Voltage is minimum 208VAC and maximum 240VAC. Replace drive.
Motor operation	Motor does not move with Drive Power LED (green) "ON"	Motor circuit or motor has short or open circuit.	Disconnect power from the labeller and motor wiring from the drive. Check continuity across A phase and B phase (maximum of 1.0 ohms for large motor and 5.0 ohms for small motor. Check for isolation between phases and to ground.
Motor operation	Motor jerking	Bad motor windings	Verify A and B loop. Replace motor if necessary.

TROUBLE SHOOT

15. Power

Location	Problem	Indications	Remedy
Power.	Stepper drives power GREEN LED is "OFF", and the power supply GREEN LED is "OFF."	• No 240 VAC power. • Power supply has had a thermal shut down. • Power supply damaged.	Verify AC power, 210VAC minimum. 240VAC maximum). Measure temperature at heat sink (60°C maximum) Replace power supply.
Power.	Stepper drives power GREEN LED is "OFF", and the power supply GREEN LED is "ON."	• Short or open circuit in drive cabling or motor.	Check drive cabling and then cycle AC power.
Power.	Touch screen comes on, but 24VDC output does not.	• 24VDC time delay relay failed.	Replace time delay relay.

TROUBLE SHOOT

16. Tamp

Locations	Problem	Indications	Remedy
Tamp.	Tamp cylinder does not activate with valve and relay LED (on PWB) indicators "ON"	- Loss of air pressure. - Pressure regulator not set or faulty. - Flow controls out of adjustment. - Valve coil damaged. - Valve(s) damaged. - Tamp time set to low.	Restore line pressure. Set or repair pressure regulator to 90 p.s.i. (6 Bar) Open flow controls to obtain proper operation. Replace coil. Replace valve(s) Increase tamp time.
Tamp.	Tamp cylinder does not activate with valve LED indicator OFF and relay LED (on PWB) indicators "ON"	- Relay damaged or not seated properly. - Connection between relay output and valve faulty.	Replace or reinstall relay. Check connections.
Tamp.	Tamp cylinder does not activate. Relay LED indicators (On PCB) "OFF"	- Drive I/O not reaching relay input. - Drive I/O damaged.	Check connections reseal / replace PWB ribbon cables. Replace drive.

14.MAINTENANCE

Maintenance Log (Printed form only)

A maintenance log is a journal of all maintenance performed. Each entry includes a date, maintenance performed (details about the type of work done), and technician (who performed the maintenance). The maintenance log is also a place where a schedule is kept for further maintenance.

A maintenance log will clearly show daily inspections, tamp blade replacement, and so on.

Please create a copy of the “Maintenance Log” page and store in the back of this owner’s manual.

15.SERVICE

Service Log

A service log is a journal of all service work performed. Each entry includes a date, service provided (details about the type of service), and technician (who performed the service).

A service log will clearly show training provided, frequent wear items, and so on.

Please create a copy of the “Maintenance Log” page and store in the back of this owner’s manual.

CWL – LABELLING MACHINE OPERATING MANUAL

17.Maintenance Log

[illegible]

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[illegible]

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14.PM PREVENTIVE MAINTENANCE

1. PM Weekly Check:

PM – PREVENTIVE MAINTENANCE CWL – 100 CROSS WEB LABELLER			
WORK ORDER NO.		SCHEDULE DATE:	
Customer Name:			
Address:			
City:	State:	ZIP Code:	
Status: PM – WEEKLY CHECK	Contact: _____		
	Tel: _____		
WEEKLY CHECK TIME LIMIT: MAX. 50 MINUTES			
Problem Reported:			
System Down: Yes / No (please cycle)		Equipment Type:	
Make:		Cause:	
Call Reported by:	Date:	Time:	
Location of Installation:			
SERVICE DETAILS			
Defects found on inspection:			
Events Time:	Start of Service:	End of Service:	
PLEASE RATE THIS CALL BY TICKING AN OPTION			
Extremely Satisfied	Satisfied	Dissatisfied	Annoyed

CWL – LABELLING MACHINE OPERATING MANUAL

PREVENTIVE MAINTENANCE

2. PM Weekly Check:

AGENDA – WORK- PROCEDURE / CHECK THE FOLLOWING

1	Labelling Head	X	Comment
	Check condition and clean machine		
	Check pneumatic system and drain water		
	Check electrical connection and label sensor		
	Check rewinding unit		
	Check paper brake		
	Check and clean all rollers		
	Make measuring run		
	Make manual test of labelling head		
2	Vacuum Unit		
	Check condition of all belts on vacuum unit		
	If dirty, clean belts with alcohol-based solvent		
	Check drive motor and timing belt		
	Open vacuum box and check pusher plates		
	If labels stuck in vacuum box, remove		
3	Dispensing Edge		
	Check condition of dispensing edge		
	Check condition of blow pipe		
4	Control Unit		
	Check and clean control unit		
5	Test Run		
	Run the machine in manual at 4 cycles		
	Confirm test run completed		

Spare Parts Request:

	Part No.	Description	Quantity
1			
2			
3			
4			
5			

CWL – LABELLING MACHINE OPERATING MANUAL

PREVENTIVE MAINTENANCE

3. PM Monthly Check:

PM – PREVENTIVE MAINTENANCE CWL – 200 CROSS WEB LABELLER			
WORK ORDER NO.		SCHEDULE DATE:	
Customer Name:			
Address:			
City:		State:	ZIP Code:
Status: PM – MONTHLY CHECK		Contact: _____ Tel: _____	
MONTHLY CHECK TIME LIMIT: MAX 2 HRS.			
Problem Reported:			
System Down: Yes / No (please cycle)		Equipment Type:	
Make:			
Call Reported by:		Date:	Time:
Location of Installation:			
SERVICE DETAILS			
Defects found on inspection:			
Events Time:	Start of Service:		End of Service:
PLEASE RATE THIS CALL BY TICKING AN OPTION			
Extremely Satisfied	Satisfied	Dissatisfied	Annoyed

CWL – LABELLING MACHINE OPERATING MANUAL

PREVENTIVE MAINTENANCE

4. PM Monthly Check:

AGENDA – WORK- PROCEDURE / CHECK THE FOLLOWING

1	Labelling Head		
	Check condition and clean machine		
	Check pneumatic system and drain water		
	Check electrical connection and label sensor		
	Check rewinding unit		
	Check paper brake		
	Check and clean all rollers		
	Open cover and check timing belt		
	Check condition of clutch		
	Make measuring run		
	Make manual test of labelling head		
2	Vacuum Unit		
	Check condition of all belts on vacuum unit		
	If dirty, clean belts with alcohol-based solvent		
	Check drive motor and timing belt		
	Open vacuum box and check pusher plates		
	If labels stuck in vacuum box, remove		
	Check condition of fan		
	Check linear guide for pusher cylinder		
3	Dispensing Edge		
	Check condition of dispensing edge		
	Check condition of blow pipe		
4	Control Unit		
	Check and clean control unit		
5	Test Run		
	Run the machine in manual at 4 cycles		
	Confirm test run completed		

Spare Parts request:

	Part No.	Description	Quantity
1			
2			
3			
4			
5			
6			

PROGRAM - PARAMETERS

Program Parameters

The program parameters are a journal of the program's individual setting for up to 20 individual product lines. Each program has unique parameters that can be documented in these charts.

Program Name or No. Labeller 1	
1	
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20	

PROGRAM – PARAMETERS

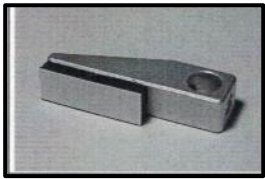
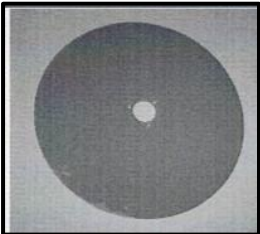
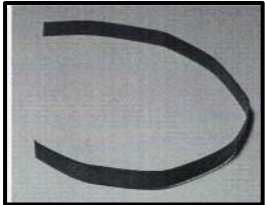
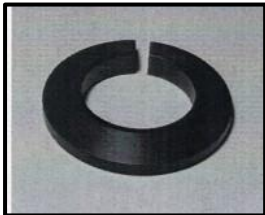
Program Parameters

The program parameters are a journal of the program's individual setting for up to 20 individual product lines. Each program has unique parameters that can be documented in these charts.

Program Name or No. Labeller 1	
1	
2	
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SPARE PART LIST

Image	Item No.		
	853	Paper brake complete	
	391	Flanged disc complete Ø 380 mm	
	392	Flanged disc Ø 360 mm	
	865	Label brake band	
	197	Guide ring Ø 32 mm	
	860	Brake shaft	

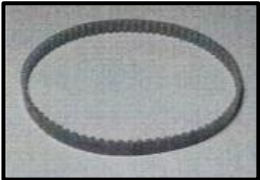
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SPARE PART LIST

	314	Knurled deflection roller Ø 32 mm	
	315	Deflection roller	
	90	Press on roll complete	
	618	Label driver roll	
	137	FC-4100 Series Capacitive Label Sensor	

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SPARE PART LIST

	813	Backing paper unwind clutch	
	870	Ball bearing for roller	
	866	Timing belt drive motor	
	269	Timing belt unwind clutch	
	270	Timing belt motor drive vacuum box	

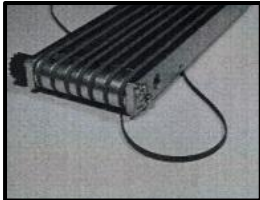
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SPARE PART LIST

	867	Tension spring	
	129	Stepper motor main drive labeller 6.6 NM / 5.8A	
	130	Stepper motor vacuum belt drive 3NM / 4A	
	98	Air nozzle / Blow pipe	
	66	Dispensing edge 100 mm / 200 mm	

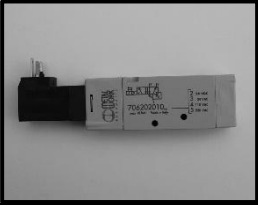
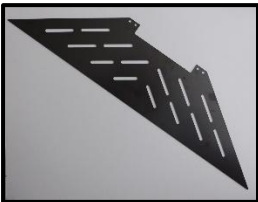
CWL – LABELLING MACHINE OPERATING MANUAL

SPARE PART LIST

	879	Pneumatic cylinder / Pusher plates Vacuum box DSNU 25 – 100 PPV DSNU 25 – 150 PPV DSNU 25 – 200 PPV	
	23	Drive roller shaft (set) for vacuum belt 200 mm	
	231	Drive roller shaft (set) for vacuum belt 100 mm	
	24	Flat belt 420 mm	
	340	Vacuum Fan 24VDC 17W / 0.71A	

CWL – LABELLING MACHINE OPERATING MANUAL

SPARE PART LIST

	130	Pneumatic Valve Festo MFH 5 – 1/4	
	131	Flow Control	
	132	Read sensor, Festo	
	133	Take - up Unit assembly 100 RH Take - up Unit assembly 200 RH	
	134	Tamp Plate 420 mm	

CWL – LABELLING MACHINE OPERATING MANUAL

SPARE PART LIST

	235	Label Unwind Roller Shaft	
	236	Brake band	
	238	Power Supply SDR – 240 24 Input AC / 100 – 240 V. 2.6 A-1 phase Output 24 V / DC 10 / A	
	239	Power Supply SDR – 960 – 48 Input AC / 200 – 240 V. 6.0 A- 1 phase Output 48 V / DC 20 / A	
	240	FESTO Service Unit FRC/FRC S – D Series	

CWL – LABELLING MACHINE OPERATING MANUAL

SPARE PART LIST

**Closed- loop
Stepper Motor Drive
with Encoder**



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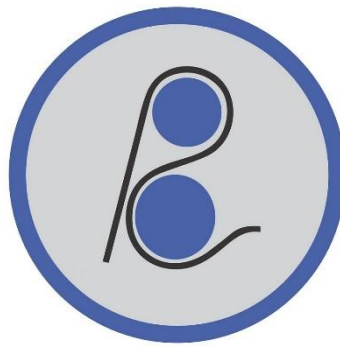
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SPARE PART LIST



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Remote control log & AB technical assistance:

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SCHEMATICS

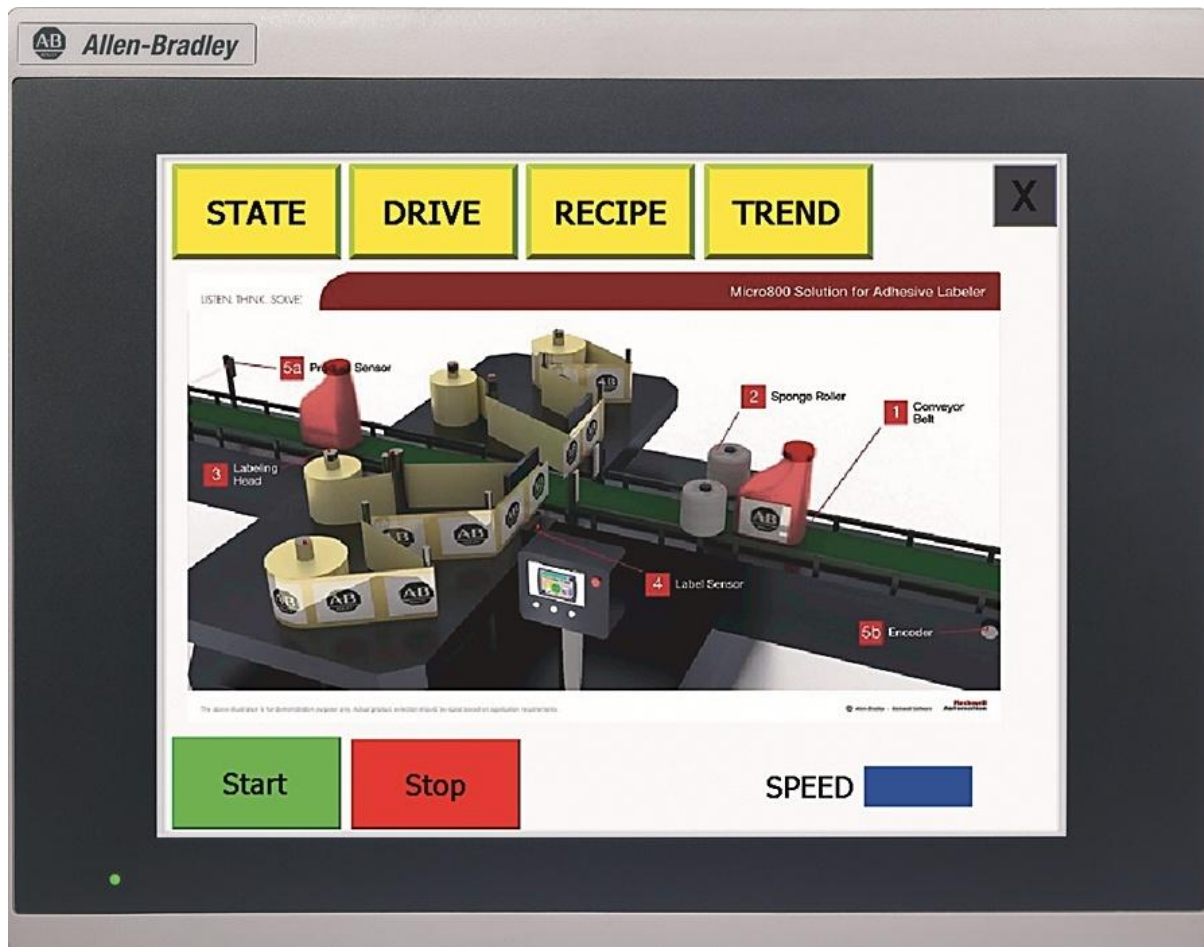
PLC Controller



Allen Bradley 2080 – L 50 E -240 VB

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CWL – LABELLING MACHINE OPERATING MANUAL



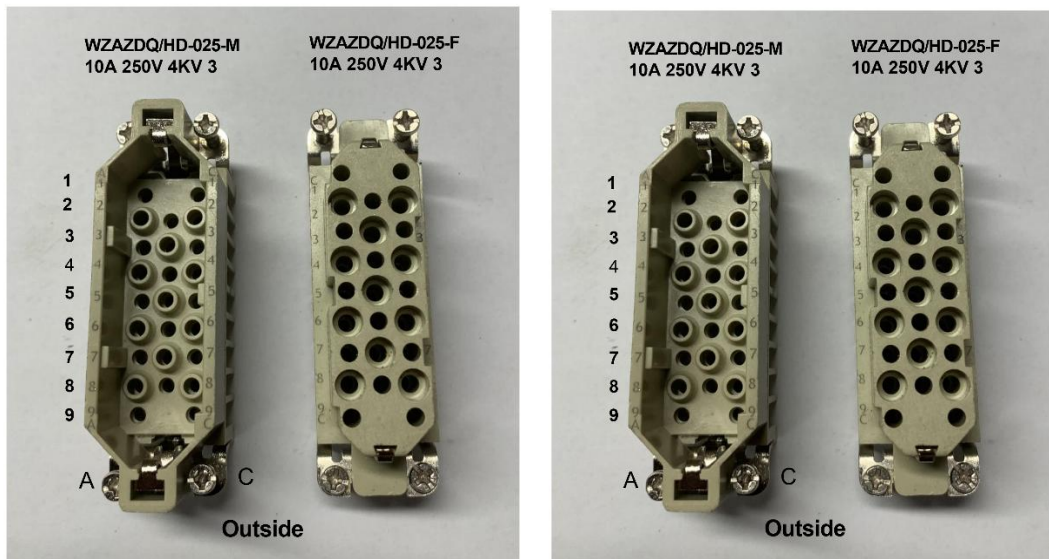
PanelView 800, 10.4 in HMI Terminal Touch Screen TFT, Serial and Ethernet port

Enclosure Rating: The front side features IP65 and NEMA Type 4X environmental protection, making it water-resistant and dust-tight for harsh industrial settings.

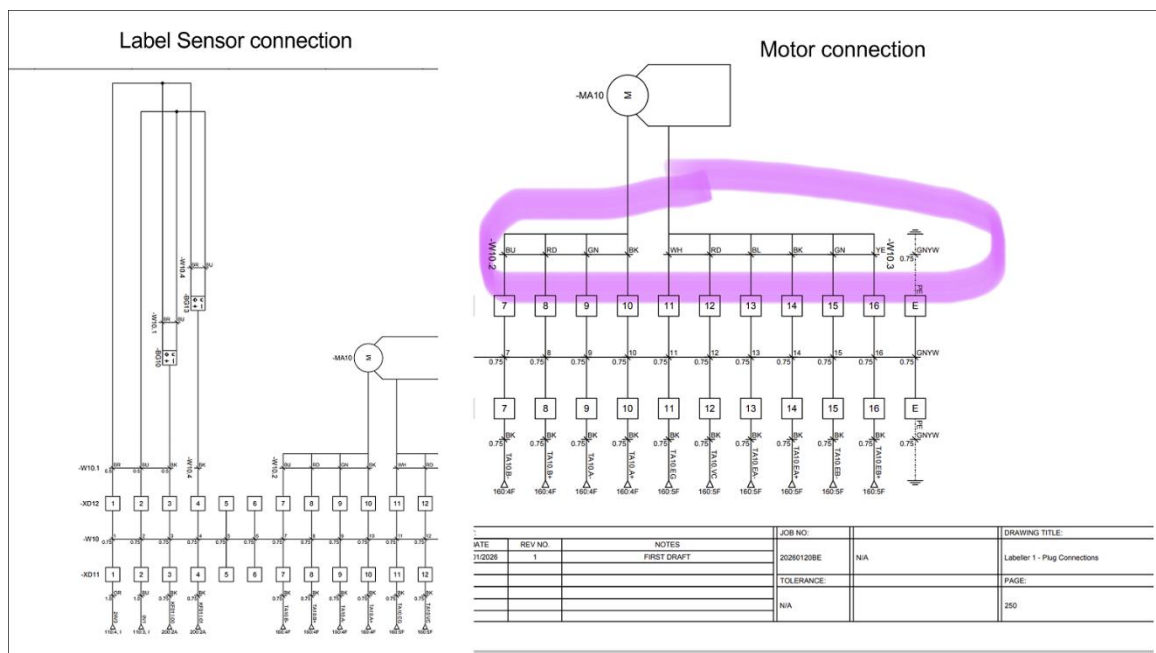
Configuration Software: Programmed using Rockwell's Connected Components Workbench (CCW) software (version 8 or later)

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CWL – LABELLING MACHINE OPERATING MANUAL

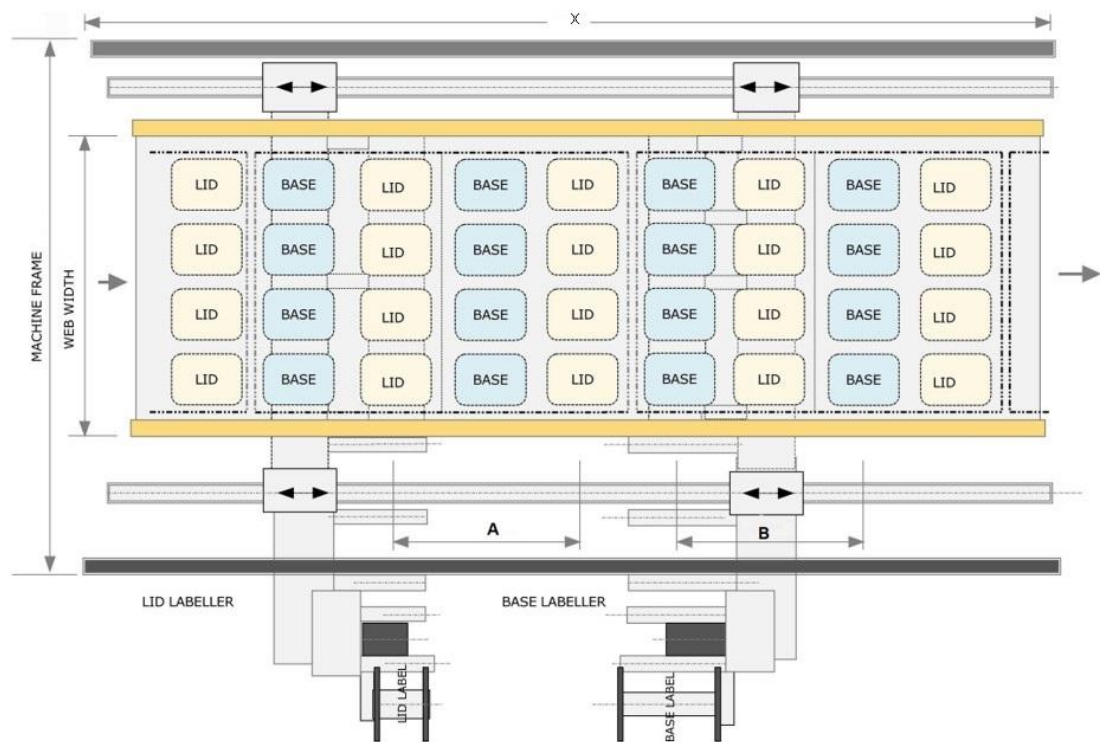


Labeller 24 Pin Plug Configuration

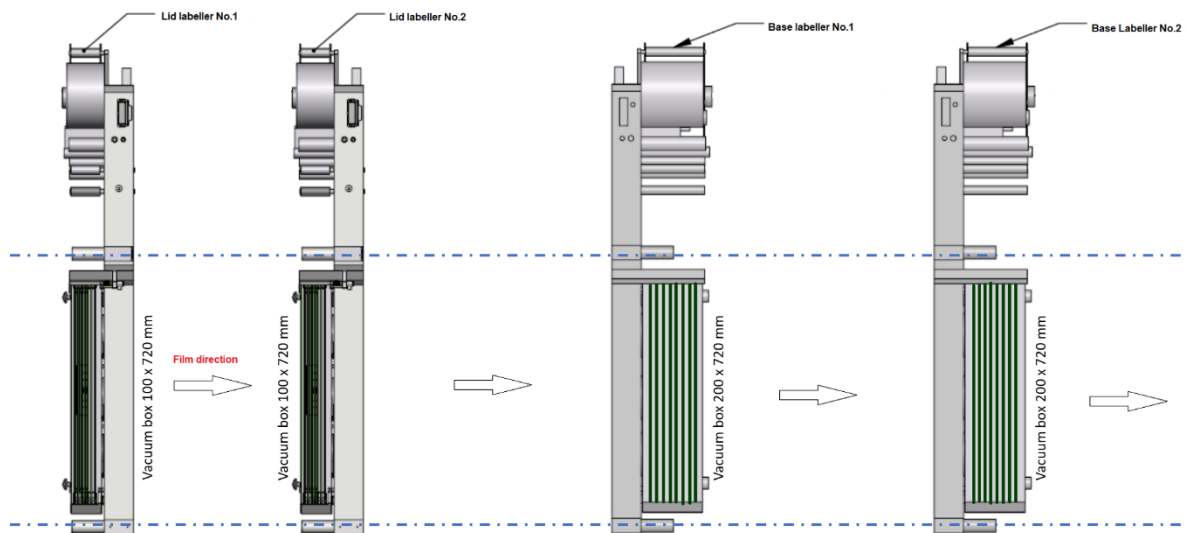


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CWL – LABELLING MACHINE OPERATING MANUAL



Flexible for Installation



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PNEUMATICS



Festo air maintenance unit (often called an FRL) prepares compressed air for pneumatic tools and machinery.

Cleans the air, sets the correct operating pressure, and adds lubricating oil.

The integrated shut-off valve allows you to safely turn off and depressurize the system for maintenance.

The main components and their functions include:

1. Air Filter Purpose: Removes contaminants, including solid dirt particles, rust from air lines, and moisture (condensate).

2.How it works:

Compressed air is forced through a filter element (usually 5 to 40 microns) which catches debris. Moisture collects at the bottom of the bowl, which can be drained manually or automatically.

3.Pressure Regulator Purpose:

Ensures steady, safe air pressure and prevents your pneumatic tools from being damaged by sudden pressure spikes from the compressor.

4.How it works: You manually adjust the rotary knob while monitoring the pressure gauge. Even if the line pressure fluctuates upstream, the regulator maintains a constant downstream working pressure.
3. Lubricator (Oiler)Purpose: Introduces a fine oil mist into the compressed air stream. **How it works:** This protects moving internal parts in air cylinders, motors, and valves by ensuring they are constantly lubricated, which reduces friction and prevents rust. You can use a regulating screw to control the exact drip rate...

5.Shut off (On/Off) Valve



FC-4200/D Label Sensor Instruction Manual

1 Product Appearance



Thank you very much for choosing F&C products. Please read this instruction manual carefully and completely to use this product correctly and reasonably. Please keep this manual handy for quick access



- Do not use this product as a detection device for human protection.
- For human body protection, please use products suitable for human body protection in various countries such as OSHA, ANS and IEC.

Warning

Product accessories list

1. FC-4200/D sensor body
2. Only 1 M12 connection (2 meters)
3. Manual

Capacitive label sensor for reliable detection of bright and opaque labels

NPN and PNP normally open or normally closed transistor output modes can be selected at the same time

Metal shell and cover plate with bevelled edges and rounded corners to protect drag labels

2 Specifications Table

Model	Capacitive Label Sensor
Specification Table	FC-4200/D G02M
Operating Voltage	12-24VDC±10% pulsation (P-P) below 10%
Current consumption	35mA
Leakage current	<0.01mA
Residual voltage	<2.0VDC (load current 100mA, wire 2 meters)
Slot width	0.8mm
Groove depth	85mm
Detectable object	Transparent or non-transparent labels
Frequency	5KHZ
Response time	0.5ms
Power reverse polarity protection	YES
Short circuit protection	YES
Action characteristics	Direction reversible
Load current	100mAmax
Sensitivity	Button intelligent adjustment
Balance base value	Button intelligent adjustment
Red light H	Balance Reference Indicator
Red light G	Sensitivity level indicator
Green light F	Signal output indicator
Output mode	NPN.NO.OR.NC + PNP.NO.OR.NC
Ambient temperature	0~60°C
Protection class	IP64
Impact pressure	1000VAC50-60HZ1min (between the charging part and the shell)
Insulation resistance	>20MQ (between the charging part and the shell)
Shell material	Alumina (Black)
Connection method	M12 connector, 4PIN
Net weight	205g

Note: The maximum label speed is 10m/s, and the minimum label spacing is 2mm

Notes :

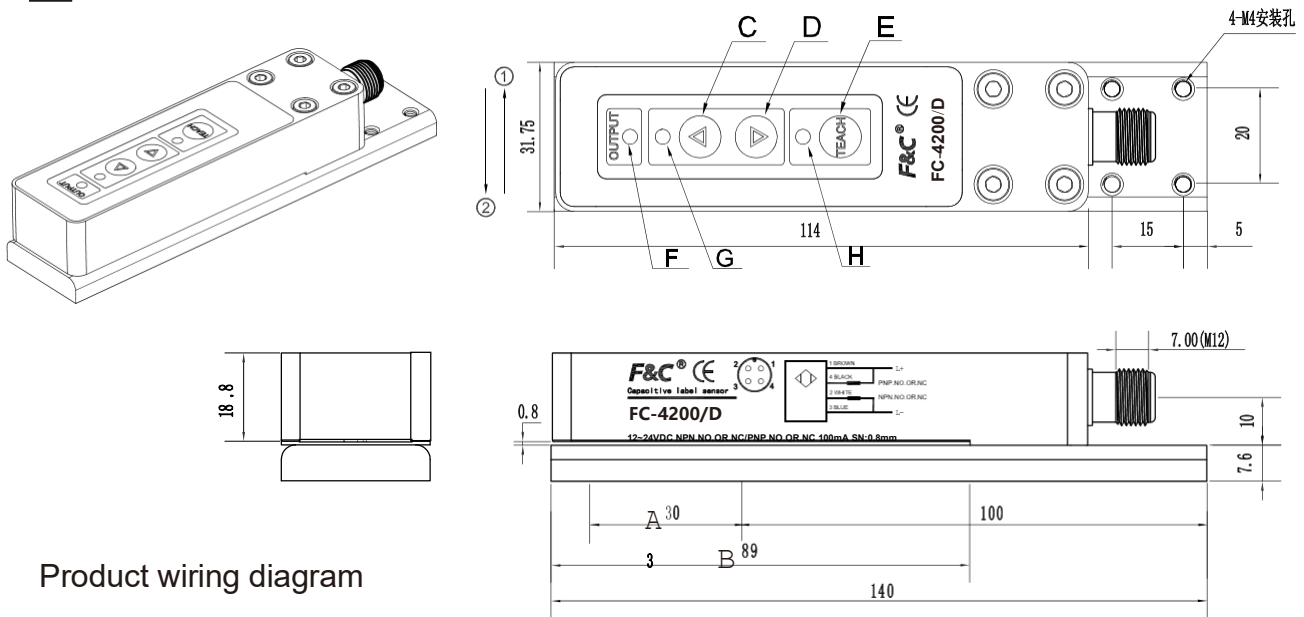
The sensing position of the sensor on the label is related to the direction in which the label enters the sensor slot laterally. The output switching is shown in the table below

Moving direction	Switch output black and white	
	NO	NC
①	signal on gap	signal on the label
②	signal on the label	signal on gap

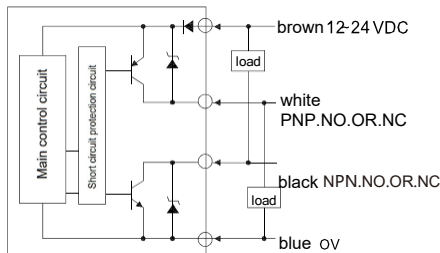
Product usage tips:

1. The brighter the balance reference indicator, the higher the balance of the sensor and the more ideal the working state.

3 Product Size Chart



Product wiring diagram



- A: Detection area
- B: Groove depth
- C: Sensitivity increase key
- D: Sensitivity decrease key
- E: Reference adjustment TEACH key
- F: Output indicator green light
- G: Sensitivity indicator red light
- H: Reference balance indicator red light
- ①+② Label movement direction

Instructions

1. Intelligent setting of the balance reference value:

Put the label into the detection slot, press and hold the TEACH button for 5 seconds, until the reference indicator light **flashes twice** and then release the button, then the reference indicator light is always on (if it is not on, repeat step 1 operation until the reference indicator light is always on), the setting is completed.

2. Sensitivity intelligent setting: **Insert the label into the detection slot, press the sensitivity increase button and decrease button at the same time for 5 seconds**, until the sensitivity indicator and output indicator blink at the same time, then release the button and enter the setting state for 10 seconds. At this point, drag the label back and forth (*it is best to keep the label gap parallel to the detection slot, and drag it smoothly and slowly to pass through at least 5 label gaps*). Until the sensitivity indicator is always on, the setting is completed. Note: When entering the setting state, you must ensure that the label is in the detection slot, and the detection slot cannot be pulled out.

3. Sensitivity fine-tuning: (if it is set through steps 1 and 2, this step can be omitted if it meets the work requirements)

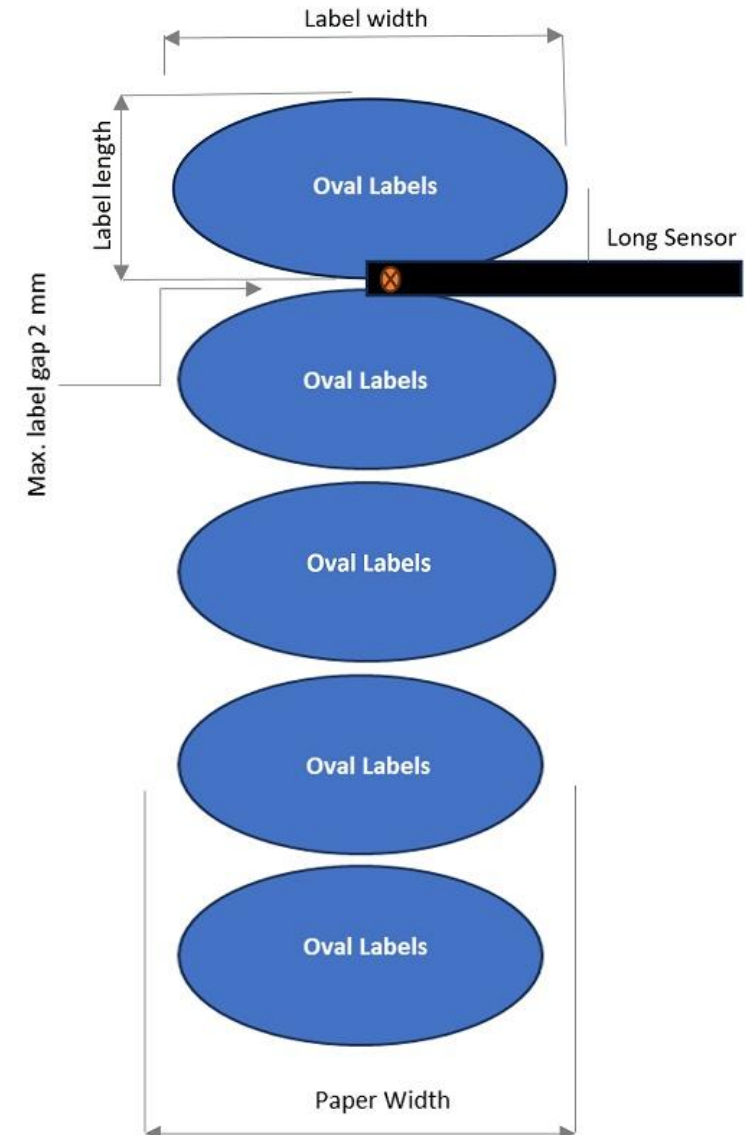
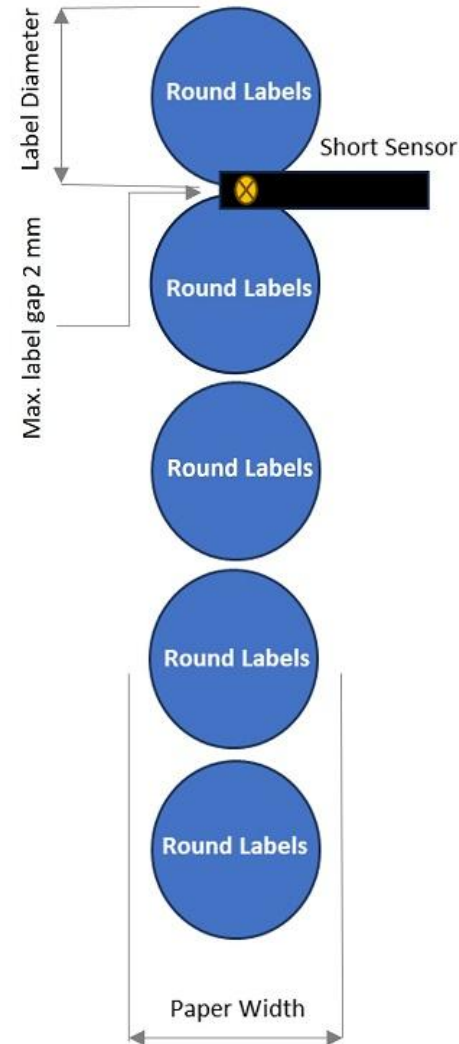
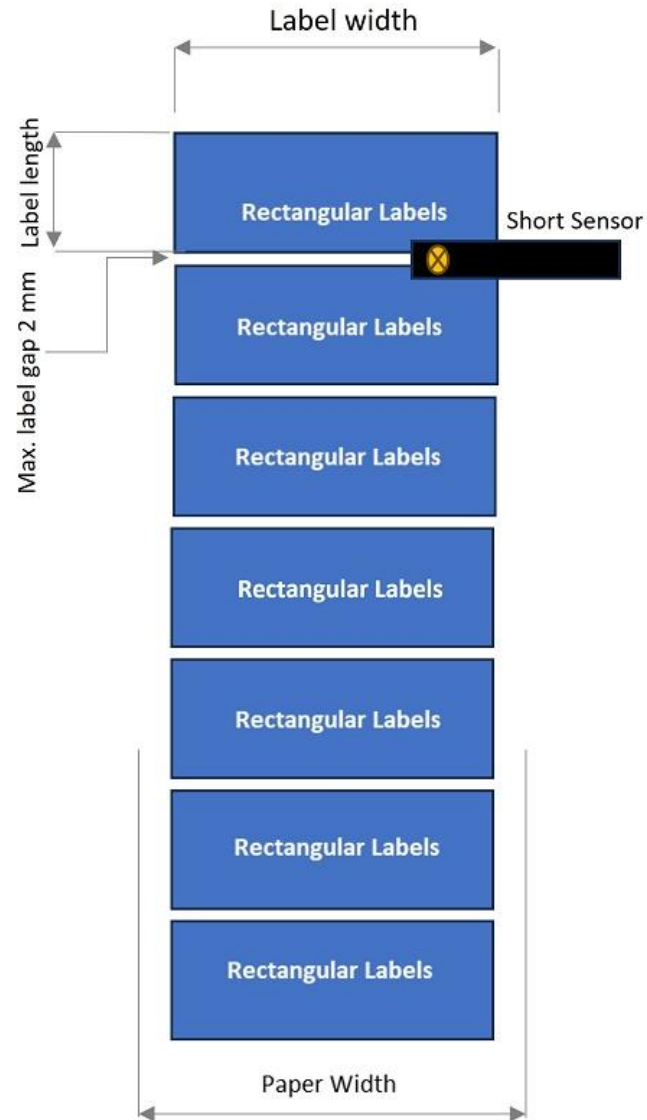
Increase sensitivity: long press the sensitivity increase button for 2 seconds, until the sensitivity indicator flashes twice, then release the button

Decrease sensitivity: press and hold the sensitivity decrease button for 2 seconds, until the sensitivity indicator flashes twice, then release the button

If you press and hold for 2 seconds, the sensitivity indicator will not flash, indicating that the sensitivity is the highest or the lowest.



Label Sensor configuration for paper labels



0

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A

B

C

D

E

F

G

H

I

J

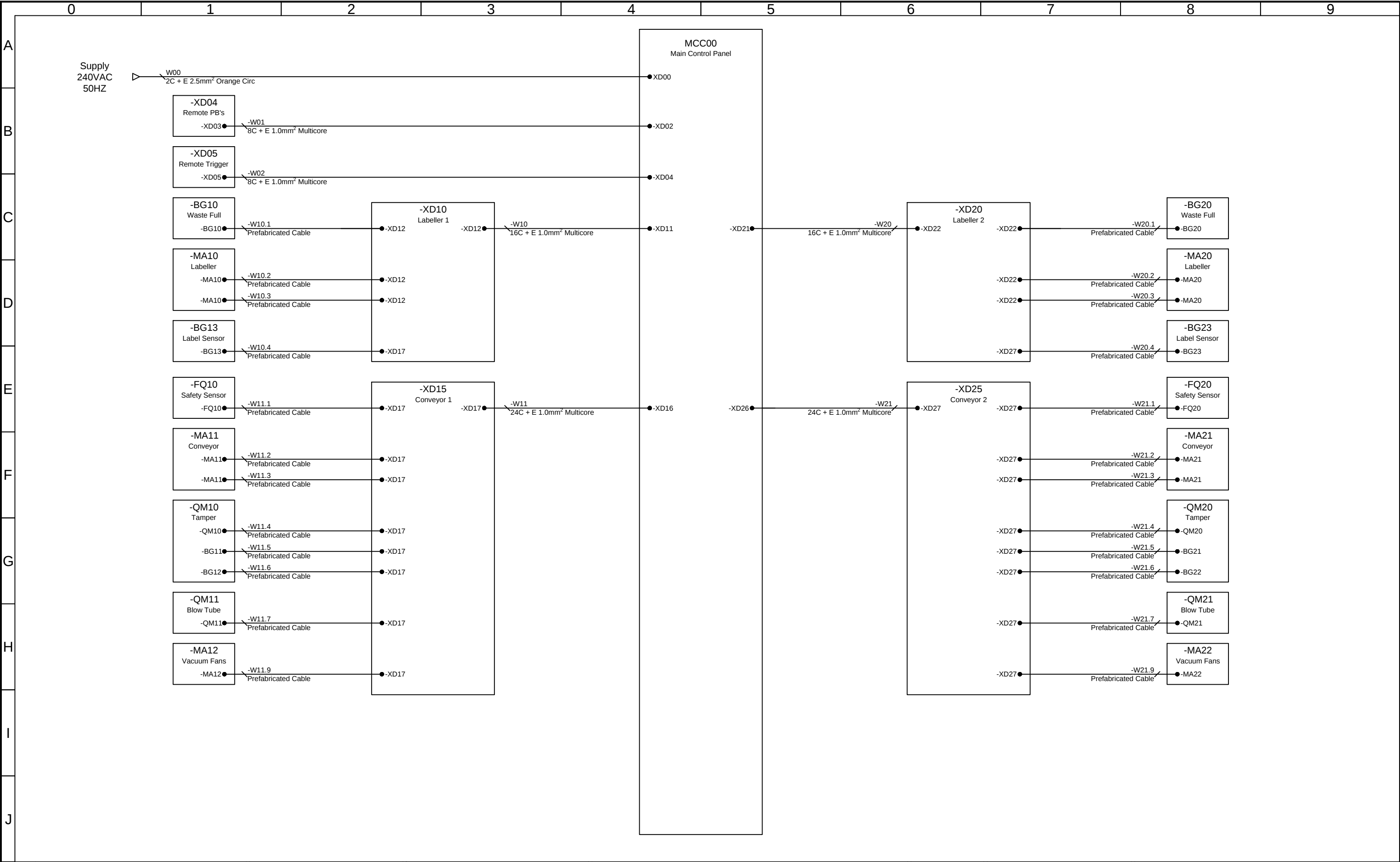
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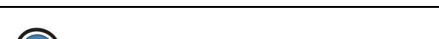


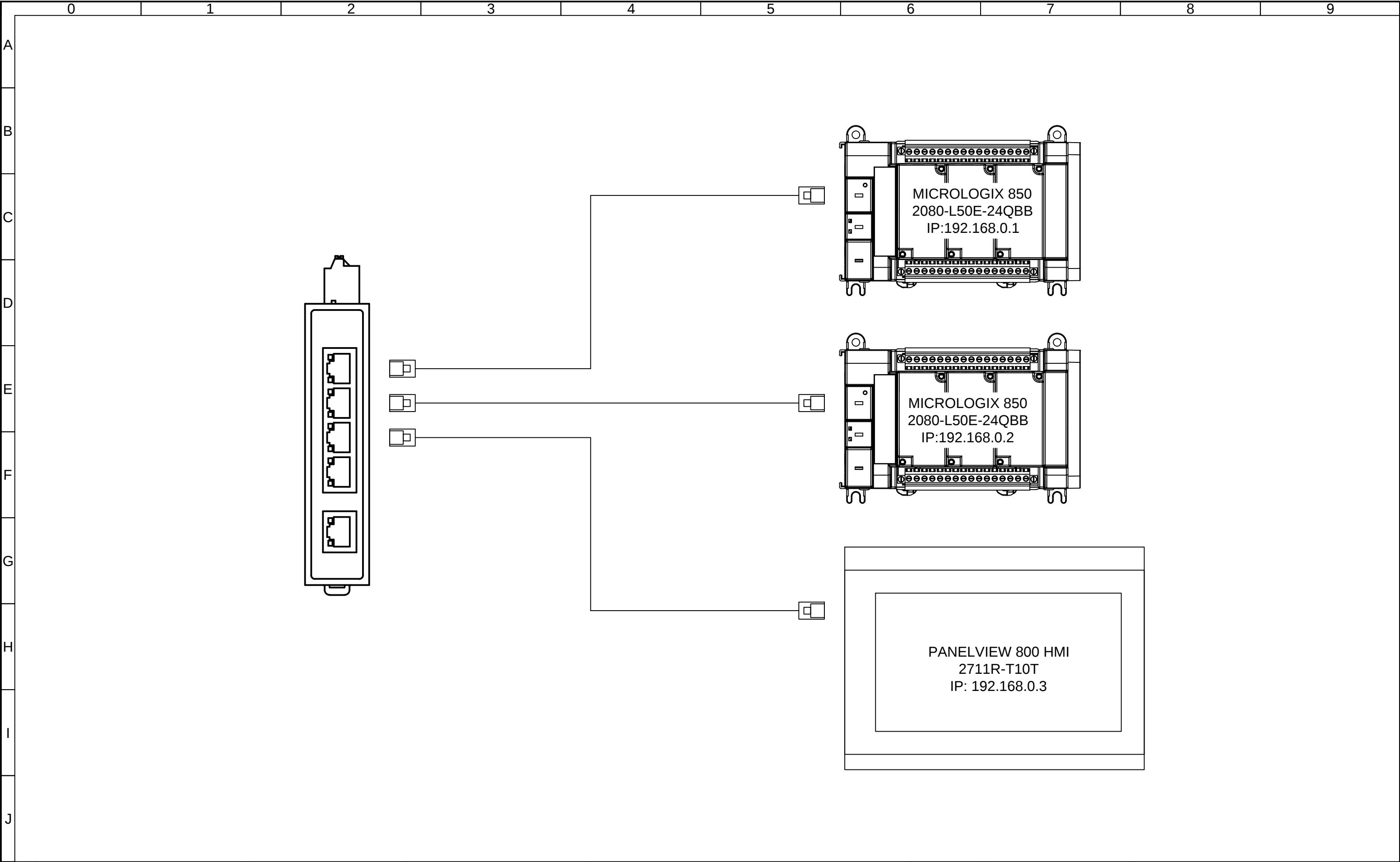
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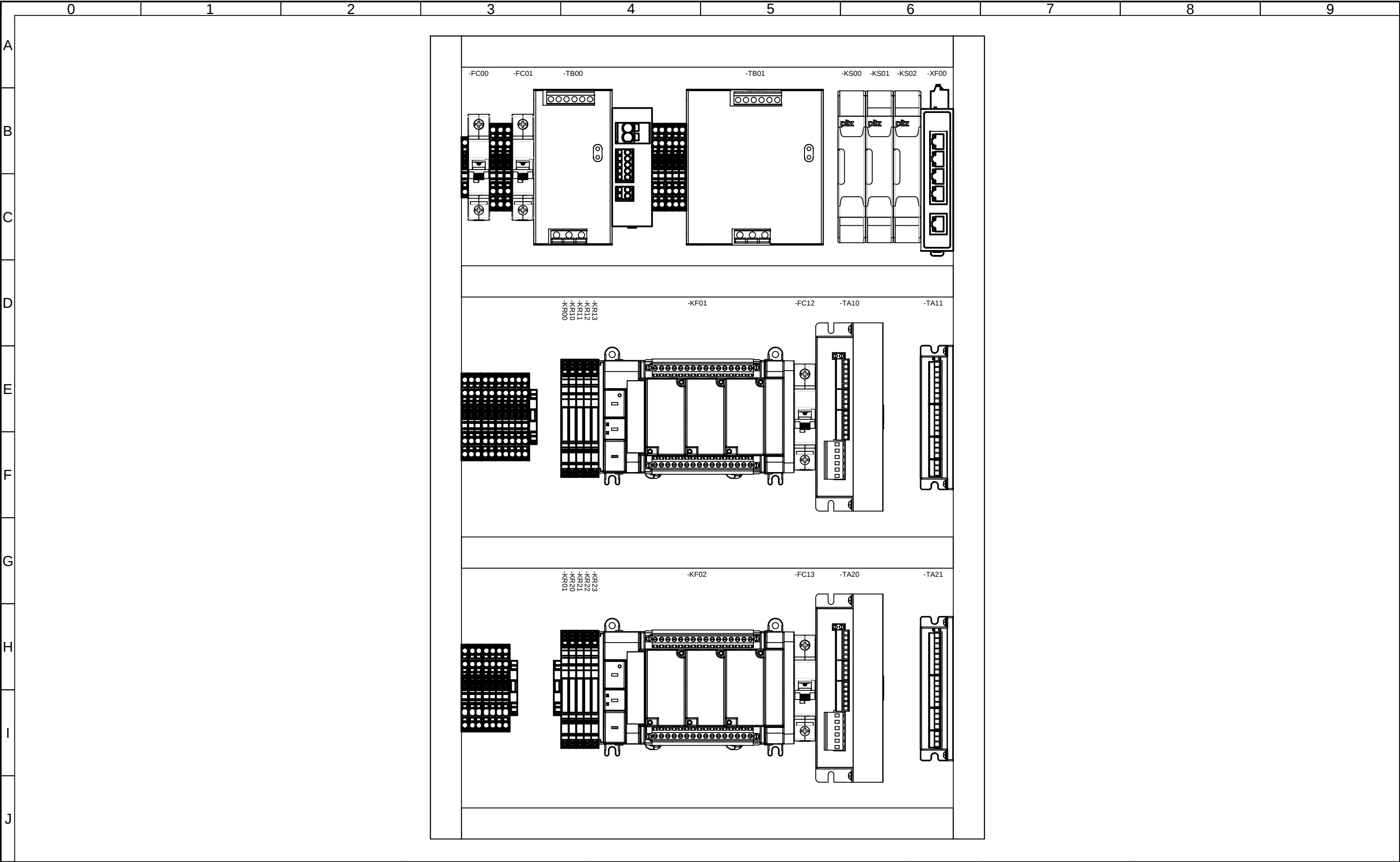
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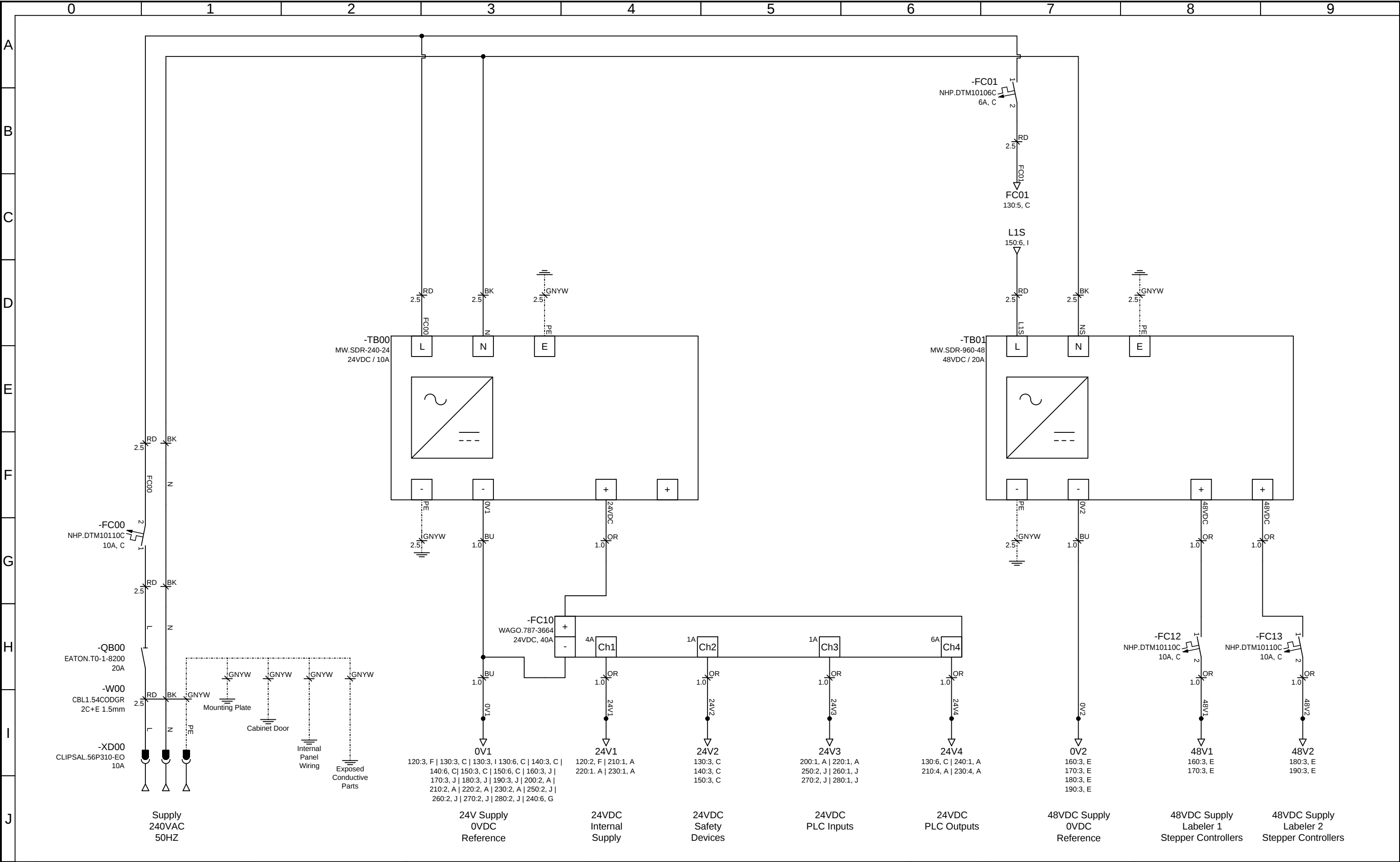
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	02	Table Of Contents								
C	03	Cable Layout								
	04	Network Diagram								
D	05	Panel External								
	06	Panel Internal								
	07	Power Distribution								
	08	General 24VDC								
E	09	Safety Relay - Emergency Stop								
	10	Safety Relay - CWL 1 Switch								
	11	Safety Relay - CWL 2 Switch								
	12	Labeller 1 - Controller								
	13	Vacuum Belt 1 - Controller								
F	14	Labeller 2 - Controller								
	15	Vacuum Belt 2 - Controller								
	16	CWL 1 - PLC Inputs								
	17	CWL 1 - PLC Outputs								
G	18	CWL 2 - PLC Inputs								
	19	CWL 2 - PLC Outputs								
	20	Relay Control								
	21	Labeller 1 - Plug Connections								
H	22	Vacuum Belt 1 - Plug Connections								
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	24	Vacuum Belt 2 - Plug Connections								
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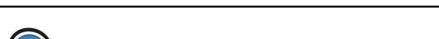


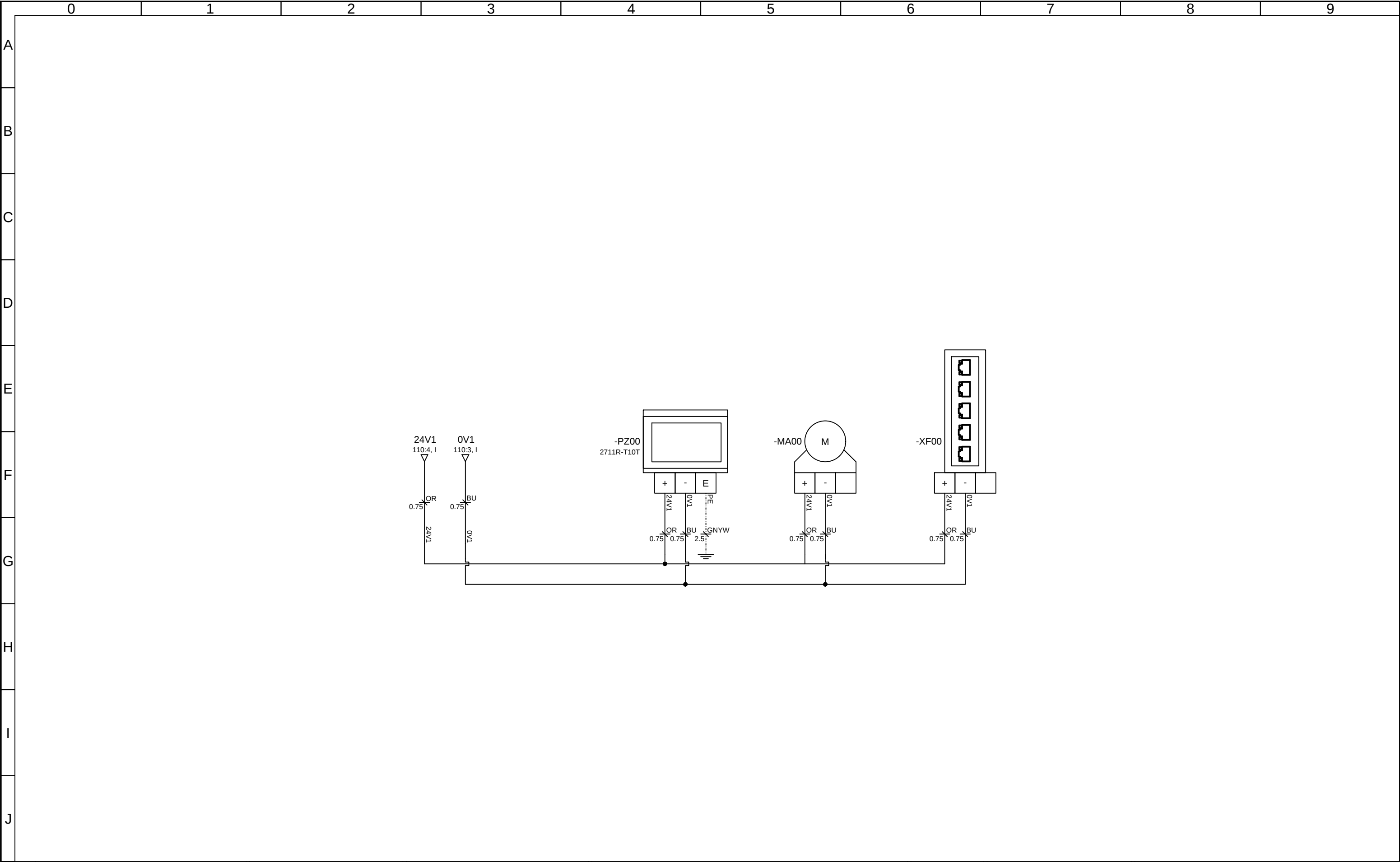
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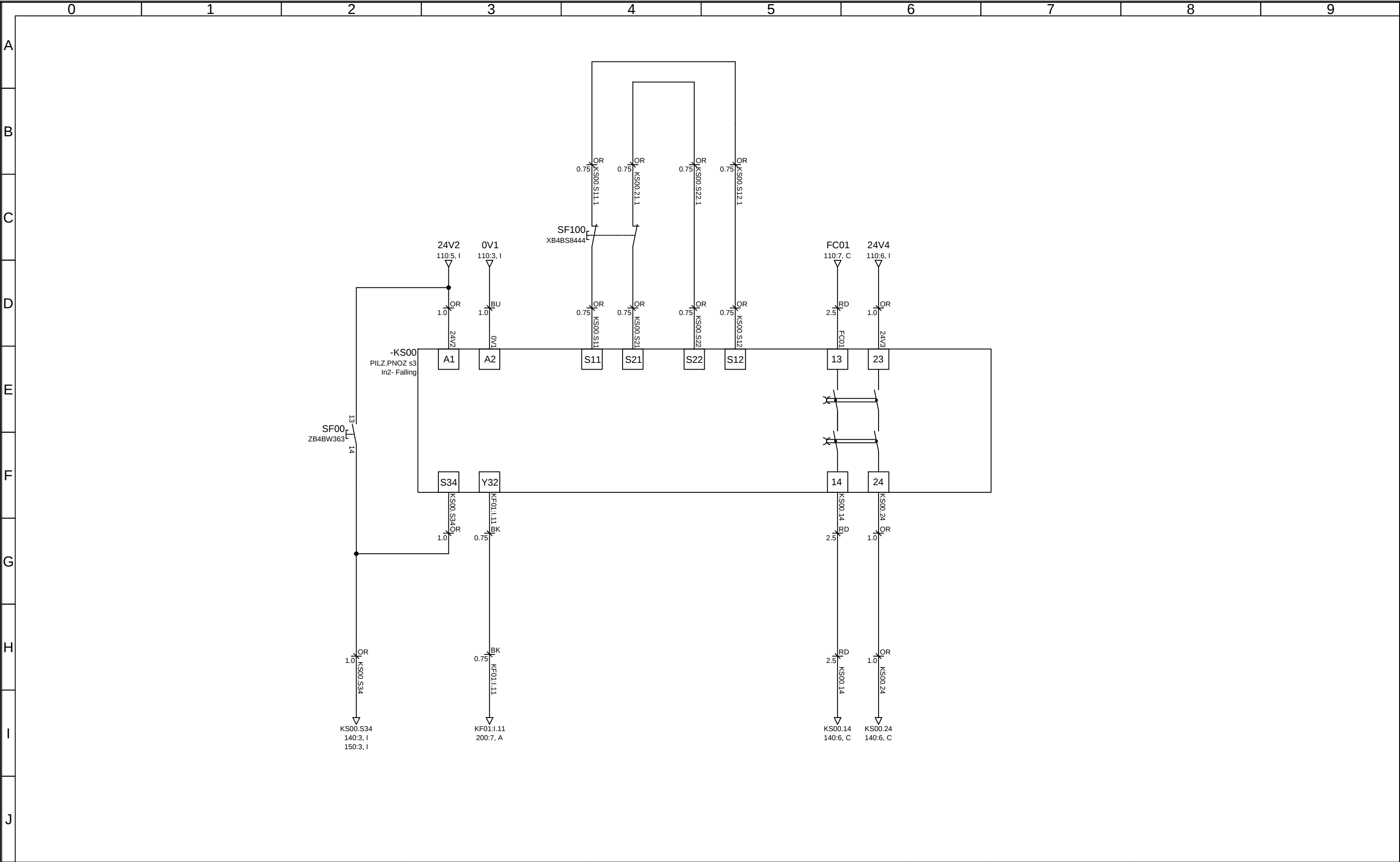


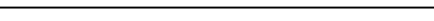
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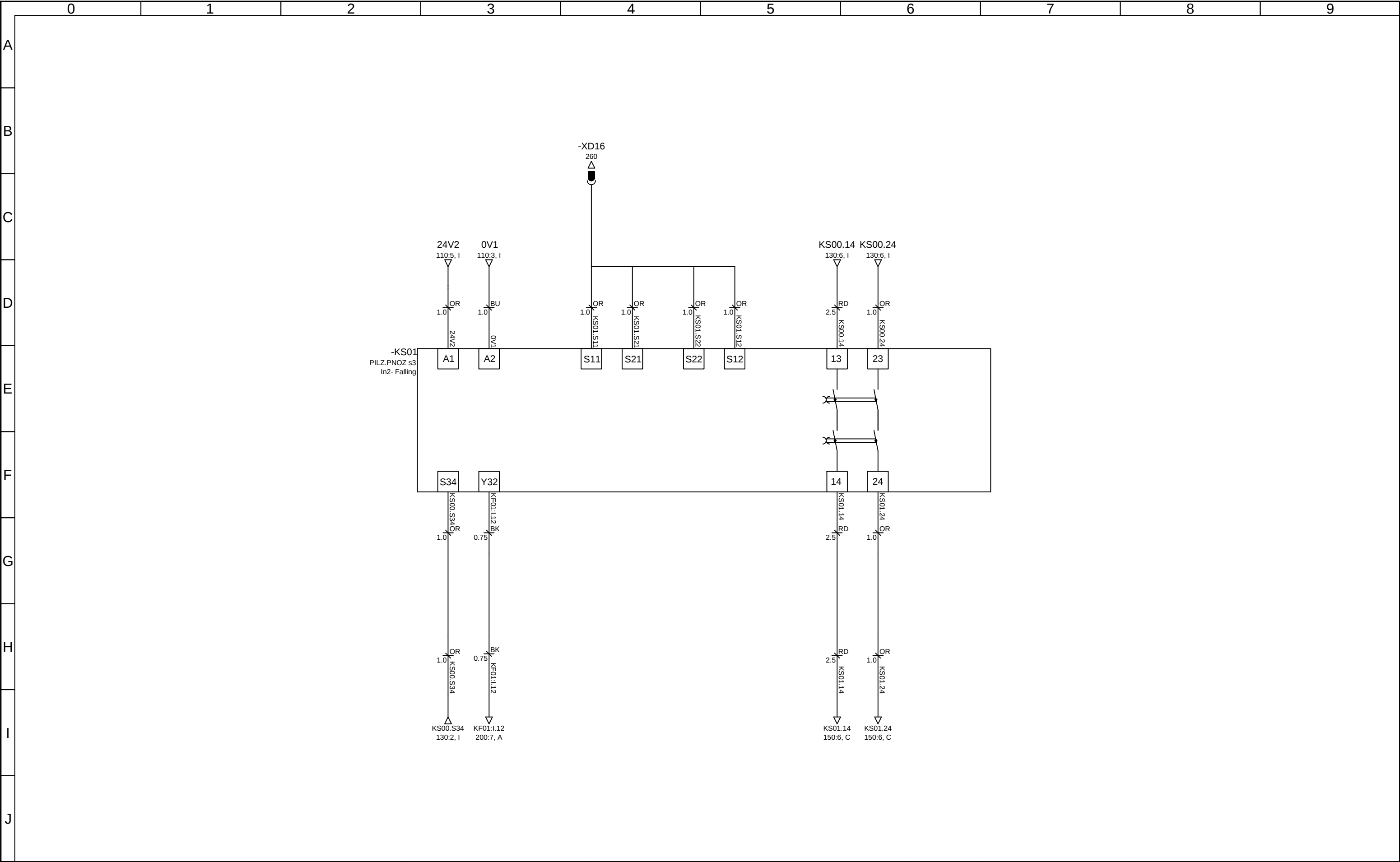


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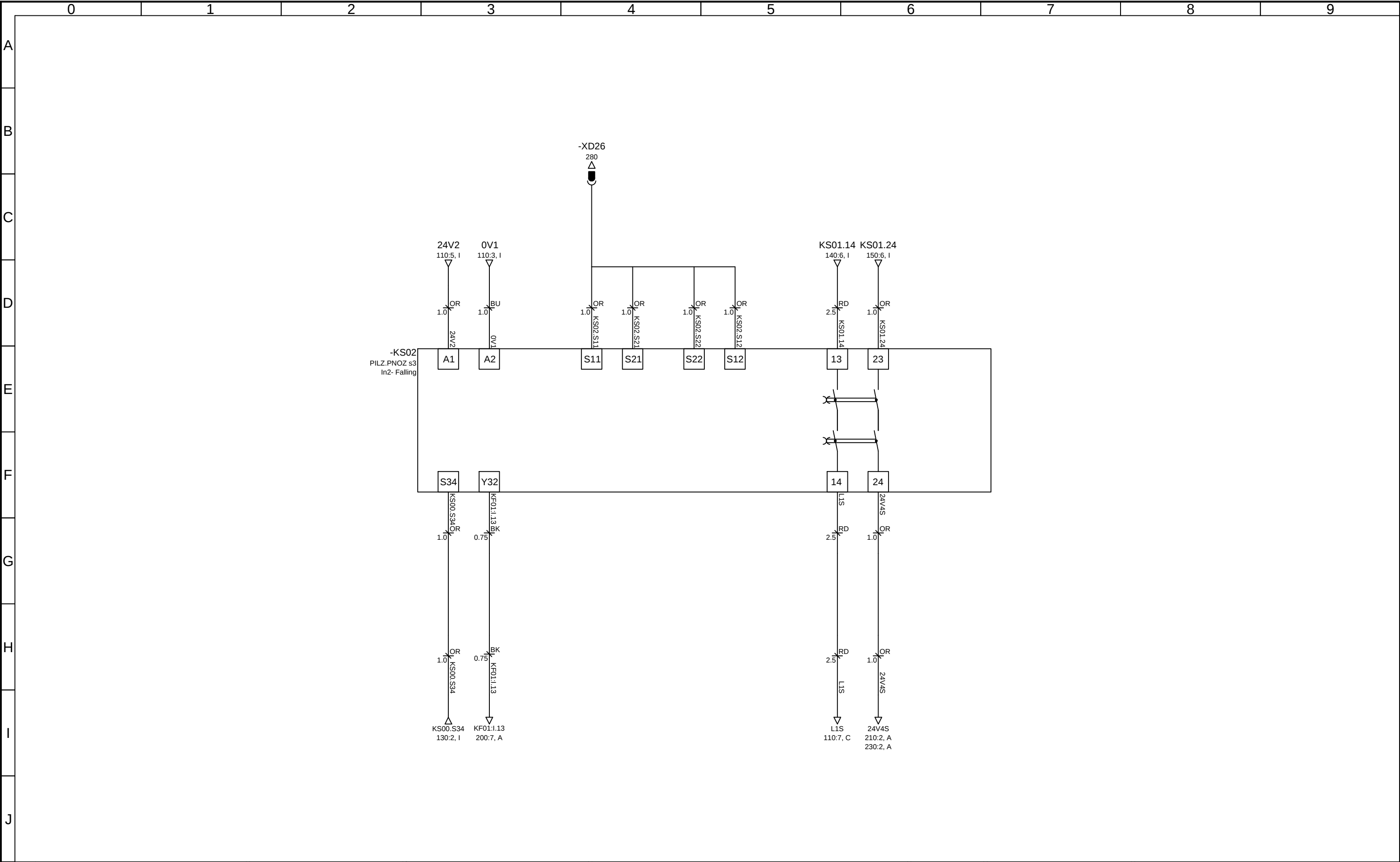


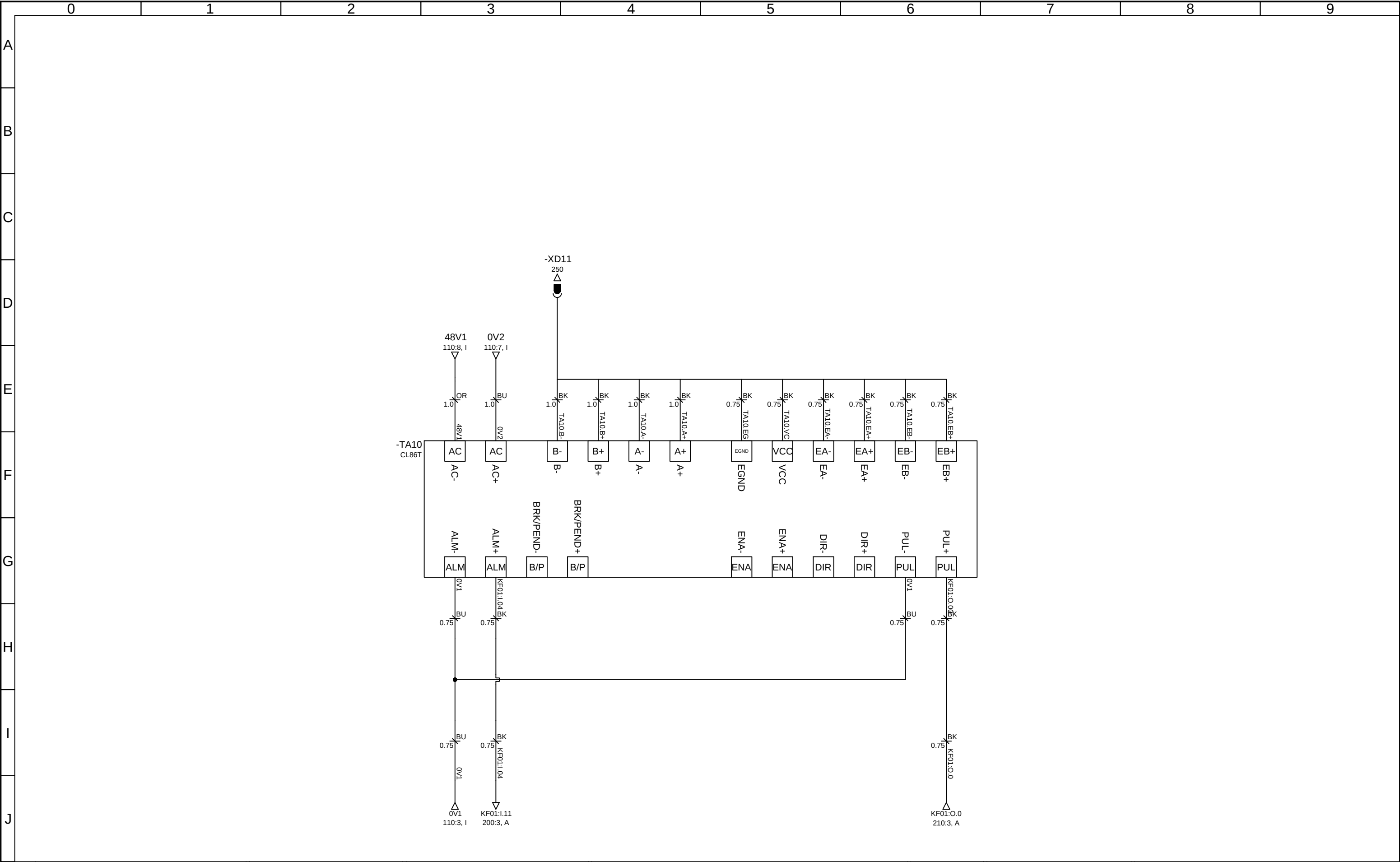


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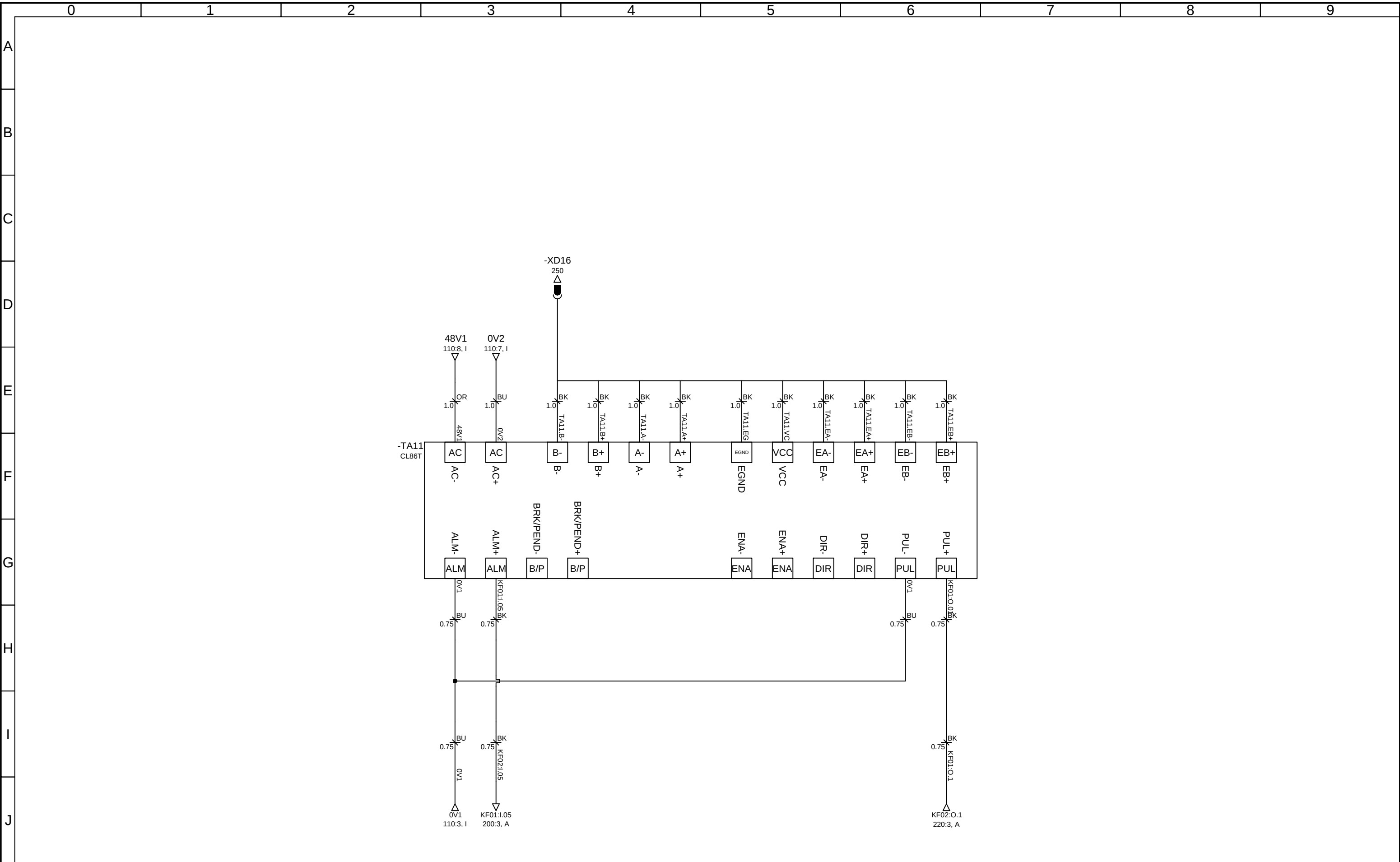


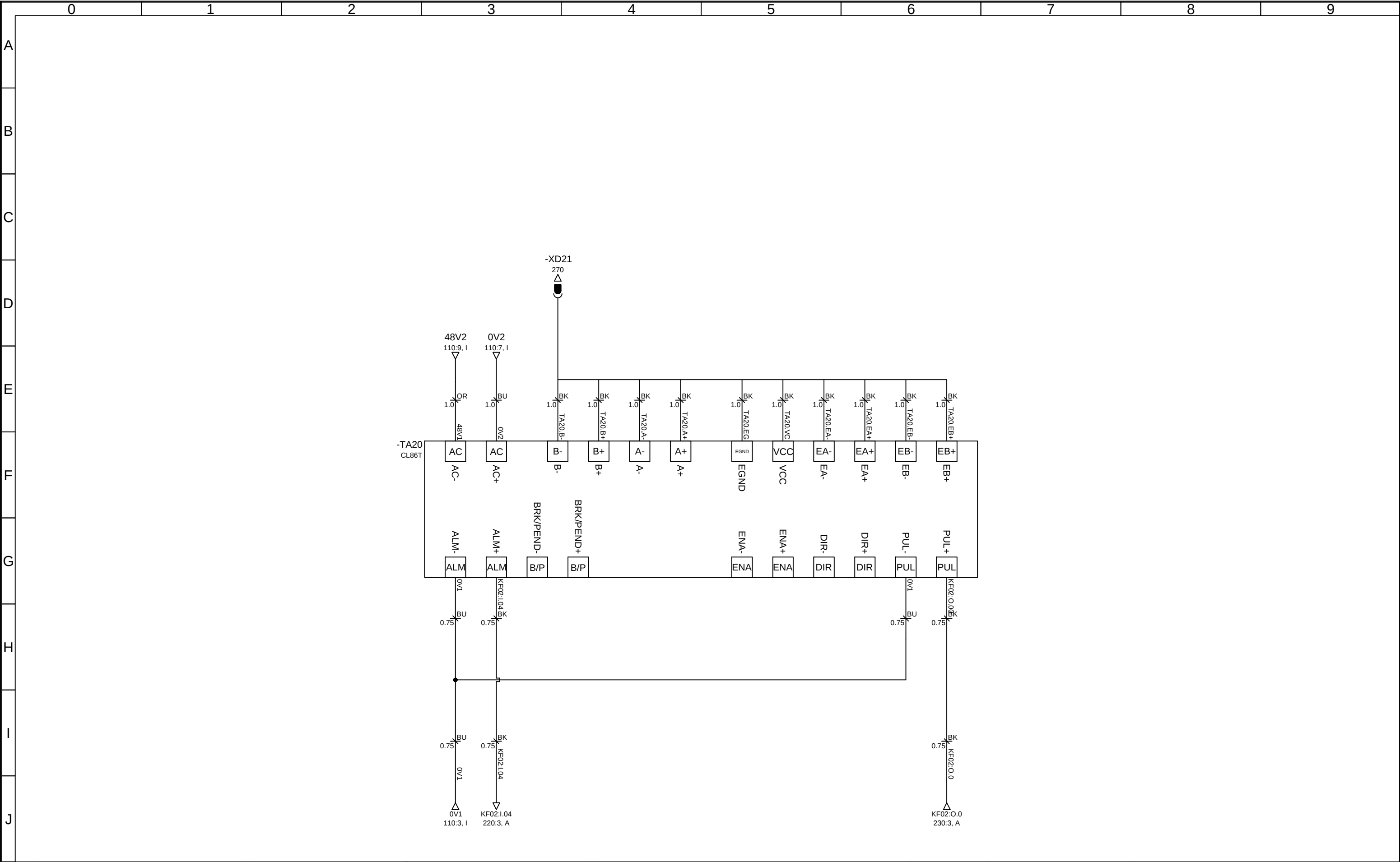
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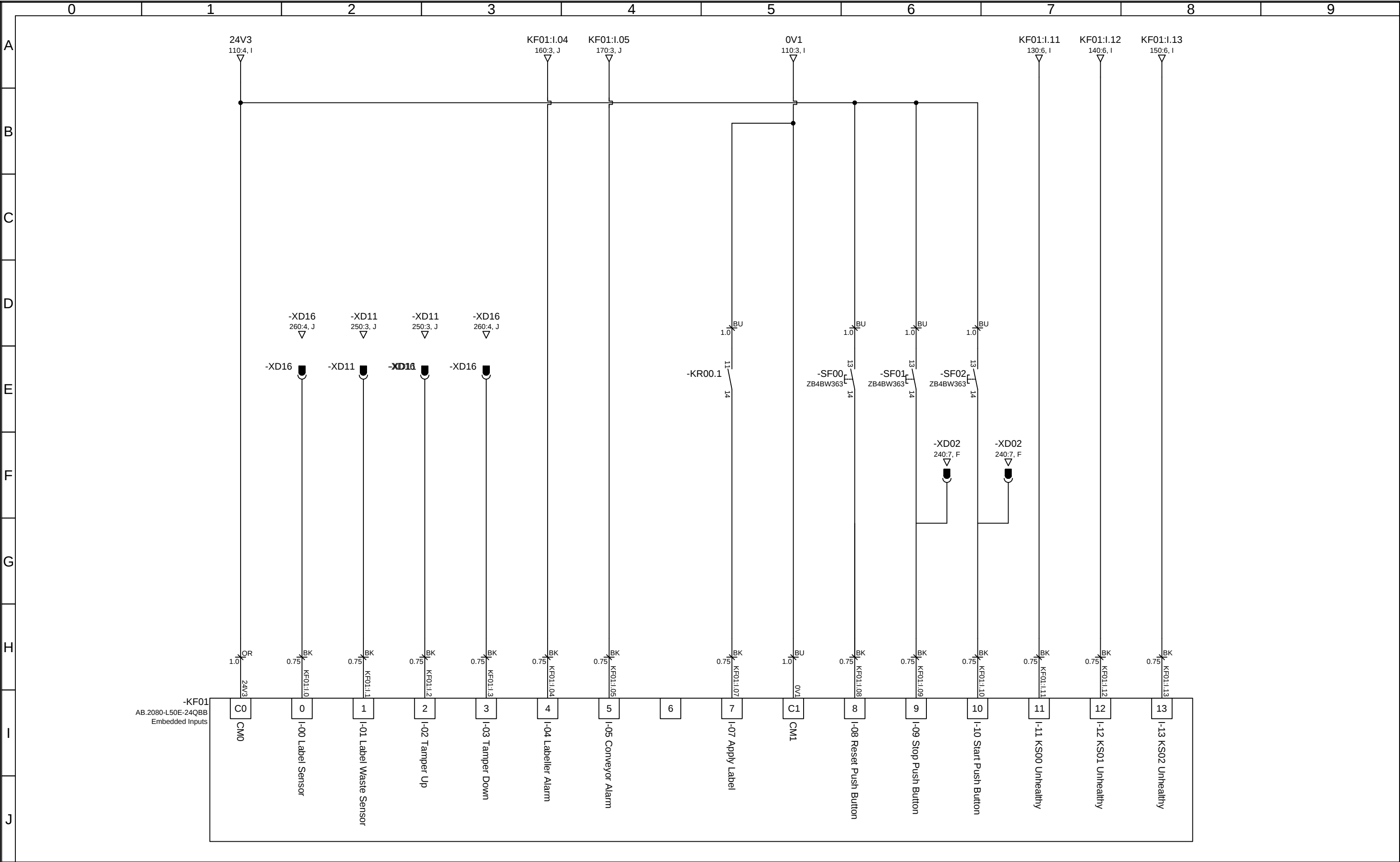


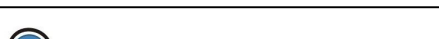


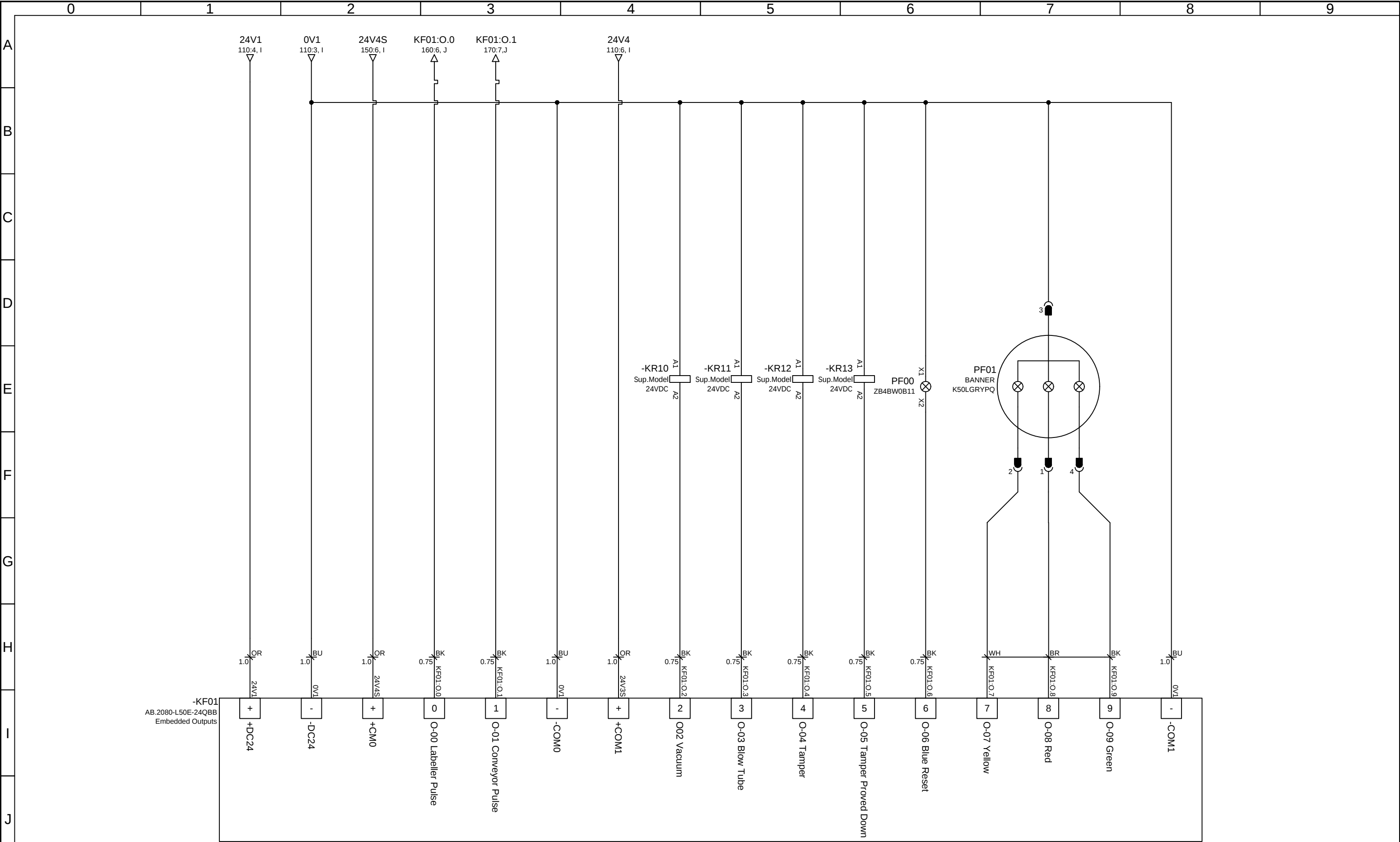
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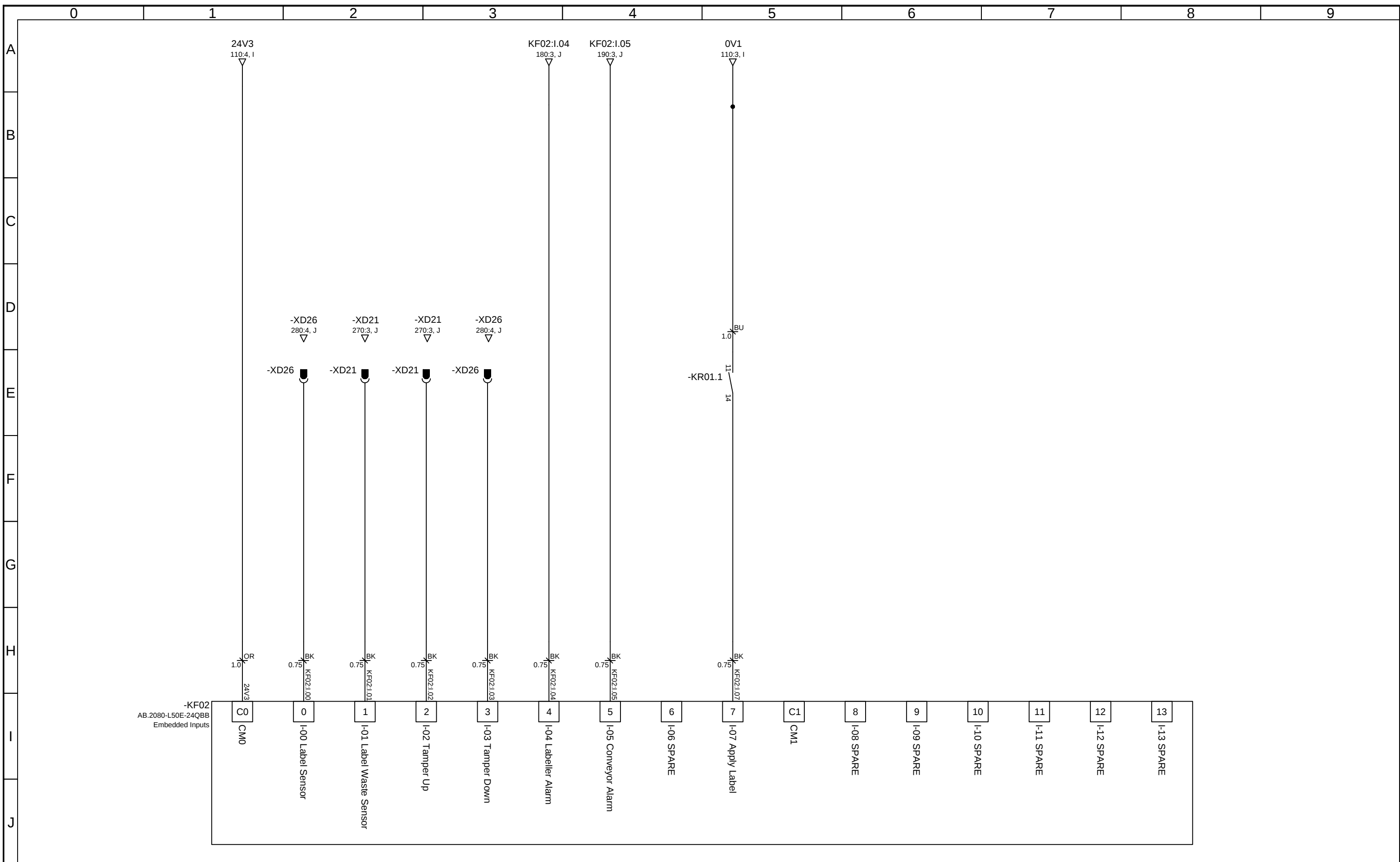


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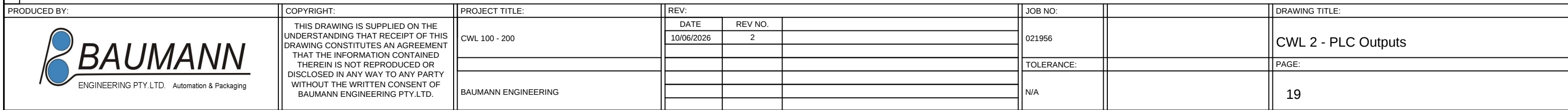
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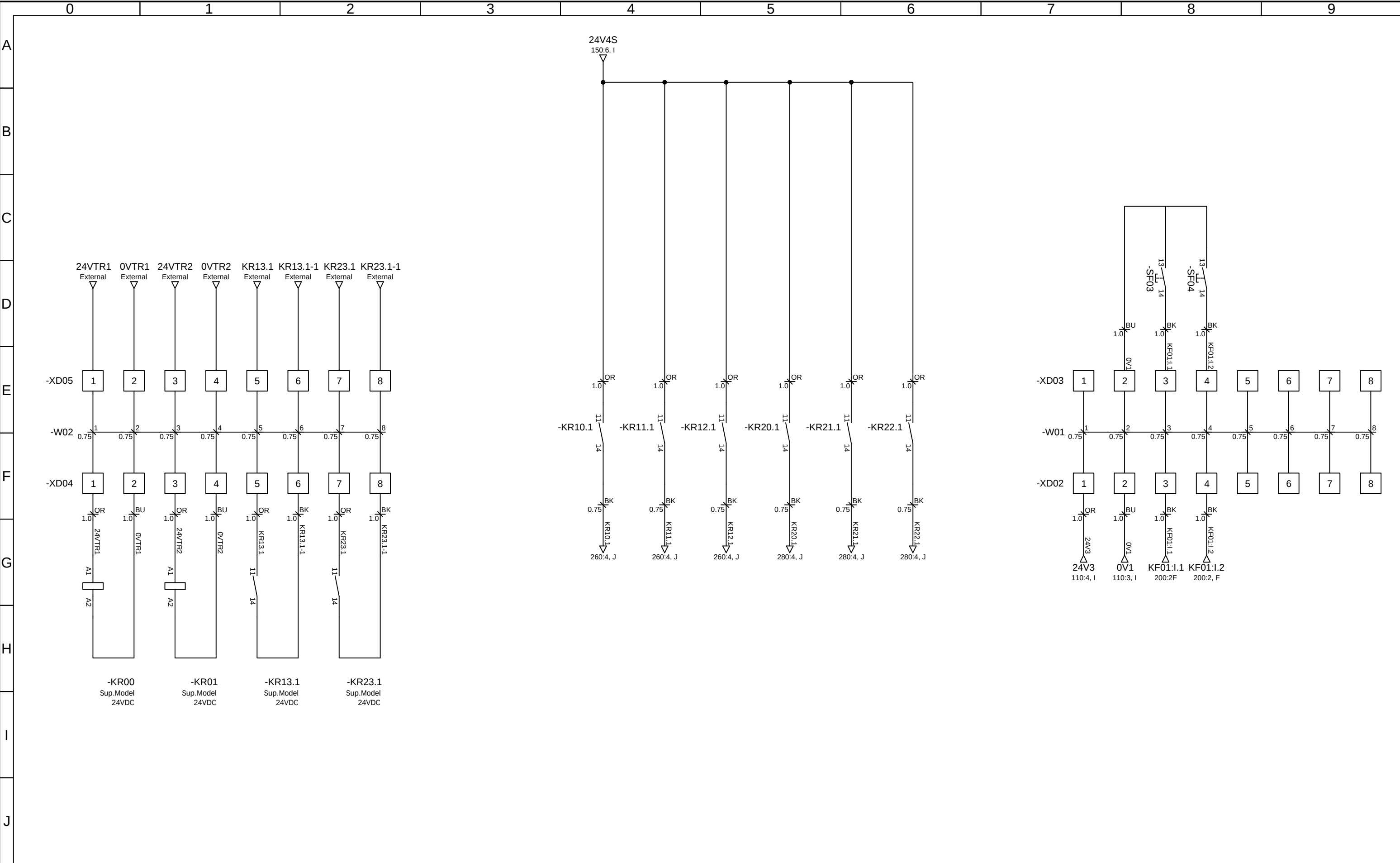
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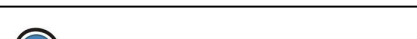
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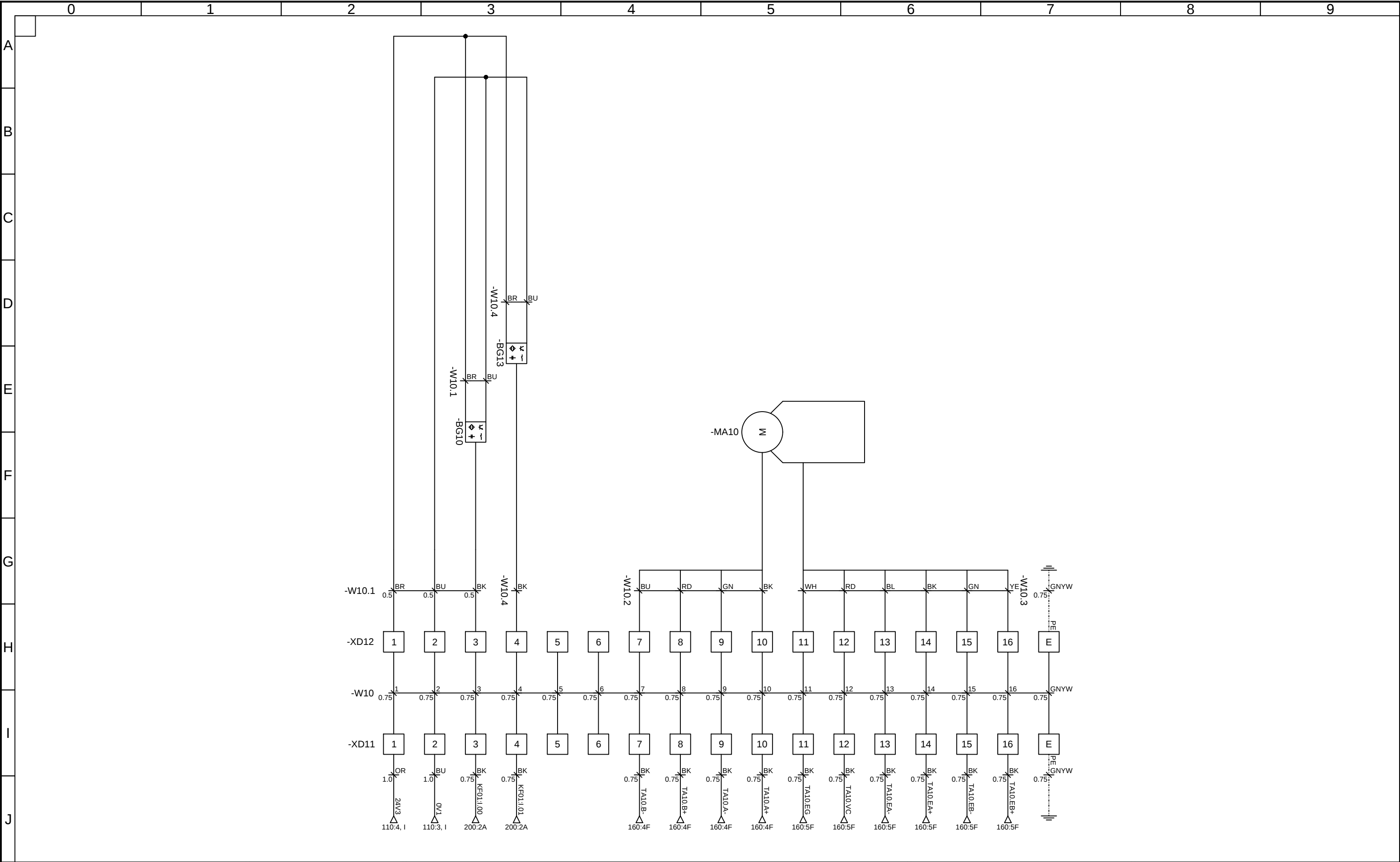


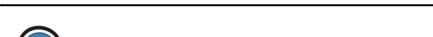
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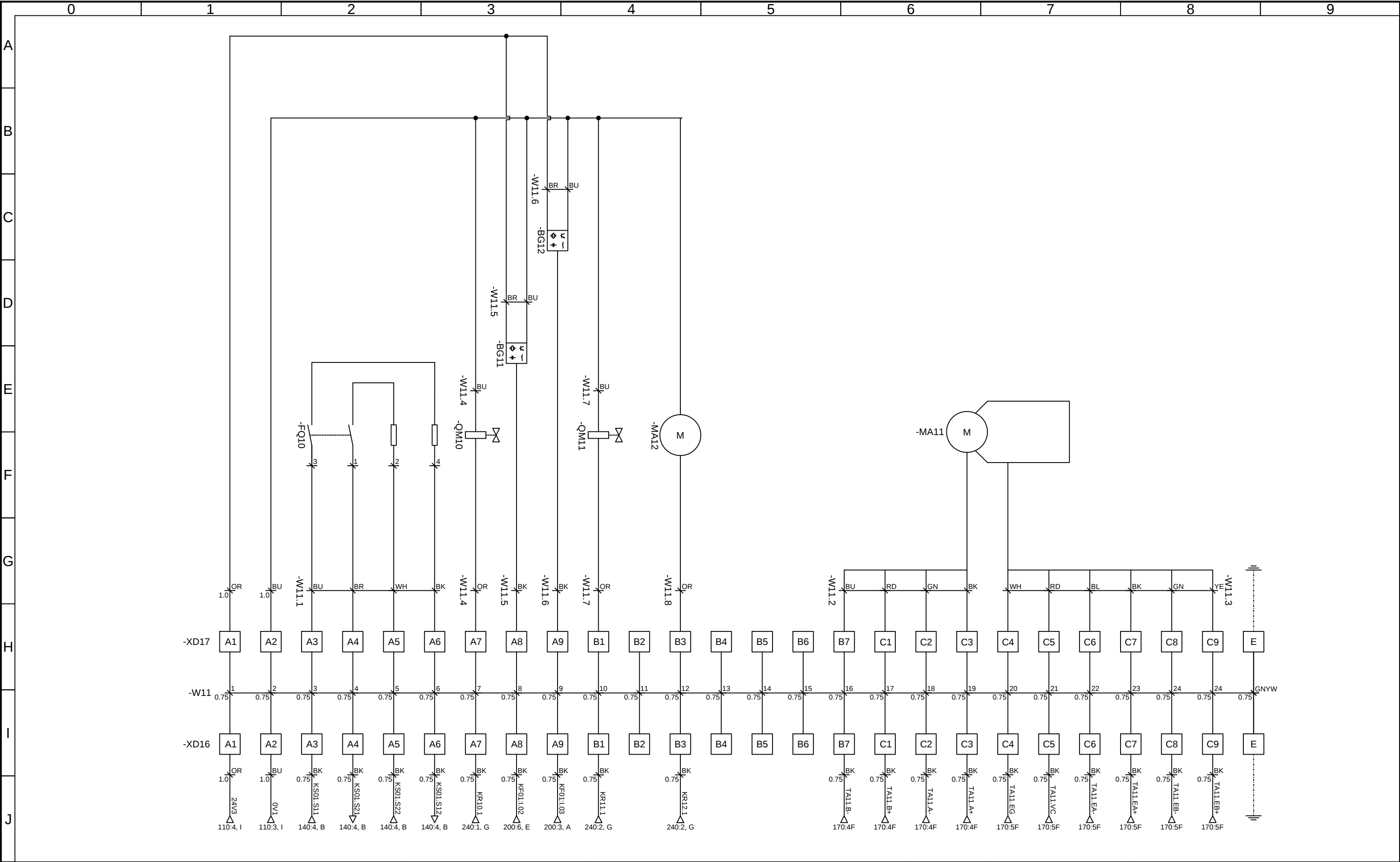




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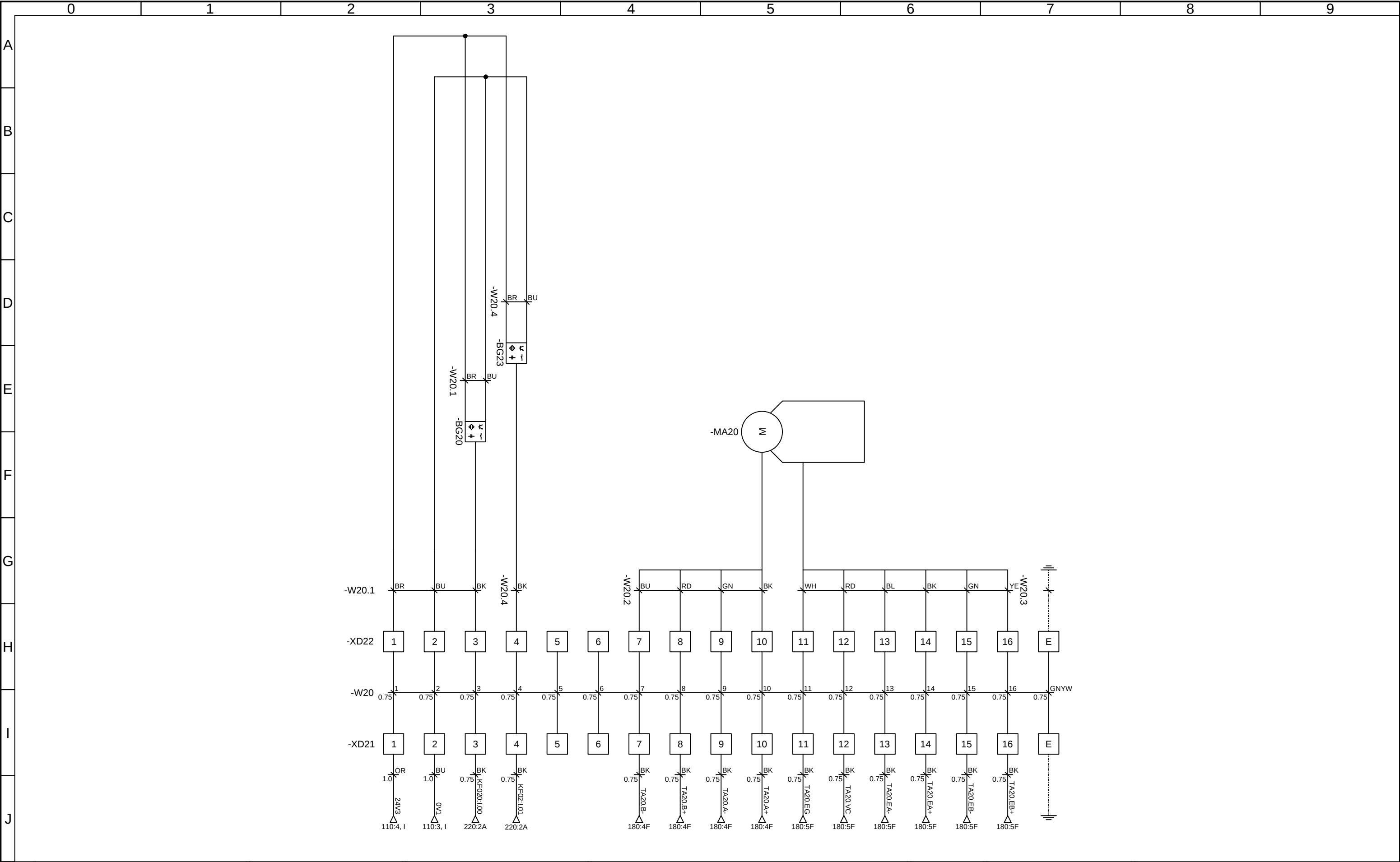
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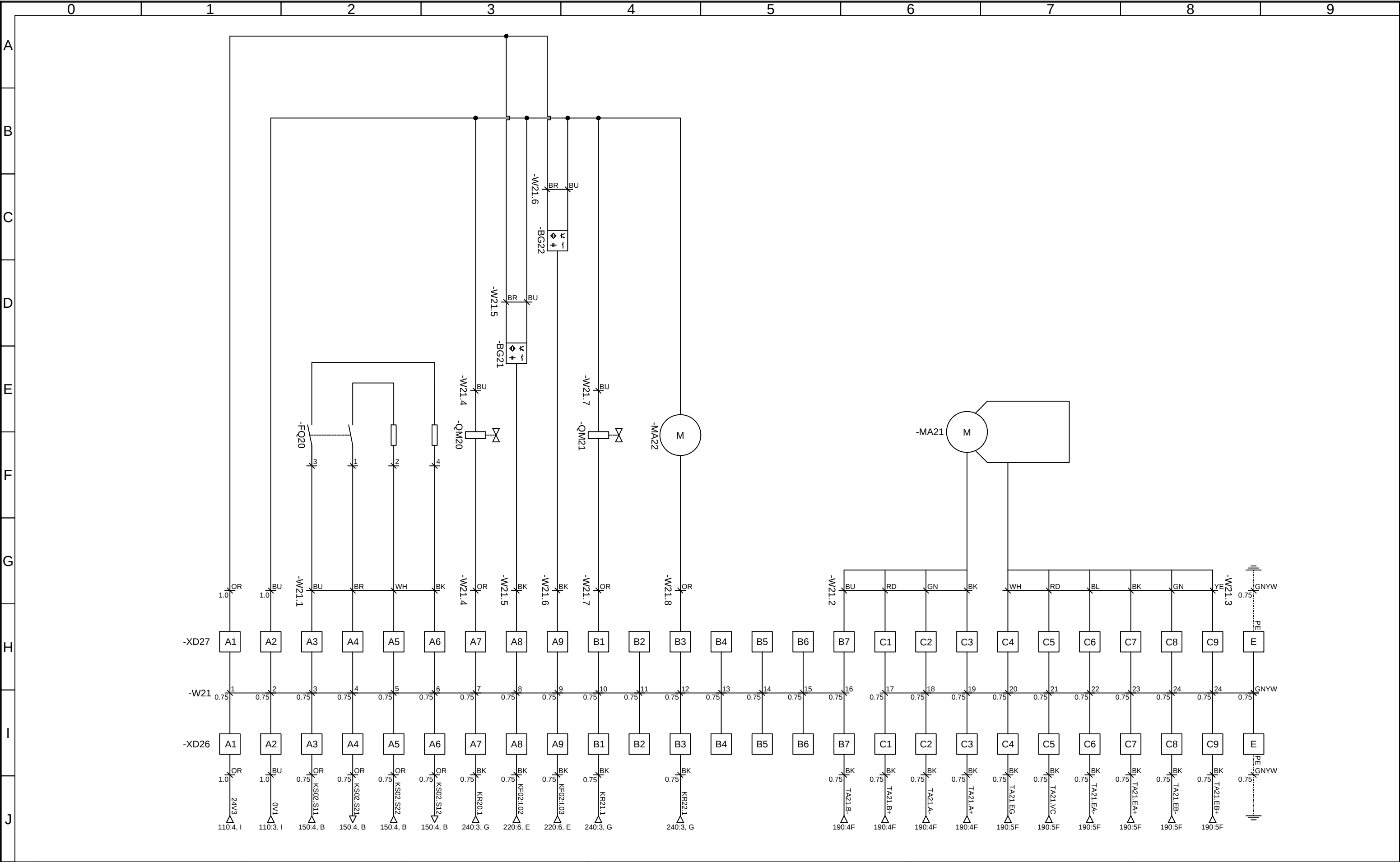
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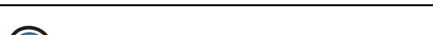
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