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15 Appendix

15.1 Parameter overview

Explanation of symbols

MACHINE	SETUP	SERVICE	INFO	Switch applicator

No.	Icon	Parameter text	ELS standard	ELS 2x1-SC*	ELS 2x1	ELS 500	ELS 620
202		APPLICATOR	OFF 0				
203		OFFSET LONGITUDINAL STROKE	20 mm	-	-		
204		OFFSET TRANSPORT UNIT	40 mm	-	-		
205		EVENTLOG	OFF 0	-	SYSTEM	SYSTEM	SYSTEM
206		NUMBER OF ROWS	2	-	-		
207		EXTERN REWINDING	OFF 0				-
208		NUMBER OF COLUMNS	3	-	-		
210		OFFSET PRINTPOSITION	5 mm	-	-	-	
211		SWITCH OFF DRIVES	OFF 0	-	-		
212		QUANTITY OF LABELS	3			-	-
213		POS. LABELEDGE MAX	99 mm	-	SYSTEM	SYSTEM	-
214		LABELCHECK	OFF 0	-	-		-
215		PRINT LENGTH	30 mm				
216		PRINT DISTANCE	15 mm				
218		HARDWAREVERSION	010_103	-			
219		SHOW ENCODER SPEED	0.0 m/min	SYSTEM	SYSTEM	-	-
220		PROGRAM VERSION		-			
221		DHCP	OFF	-	SYSTEM	SYSTEM	SYSTEM
222		JOBNAME		-			
223		NUMBER OF JOBS	30		SYSTEM	SYSTEM	SYSTEM
225		TCP-PORT	2001	-	SYSTEM	SYSTEM	SYSTEM
226		LANGUAGE	(language)	SYSTEM	SYSTEM	SYSTEM	SYSTEM
227		PASSWORD SERVICE	123	SYSTEM	SYSTEM	SYSTEM	SYSTEM
228		MODE OF OPERATION	1 STANDARD 1				
229		QUANTITY COUNTER RESET					
230		MODE PIECE COUNTER	OFF				
231		QUANTITY COUNTER	0	-			
232		QUANTITY SELECTION	0			-	-
233		EXT. POWER SUPPLY	OFF	-			
234		START SIGNAL LENGTH MIN.	10 ms				
235		DISTANCE PEC DISP. EDGE	40 mm				-

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No.	Icon	Parameter text	ELS standard		ELS 2x1-SC*	ELS 2x1	ELS 500	ELS 620
236		DISPENSE MISSING LABEL	OFF / ON	0				-
237		UPDATE	OFF					
238		LABEL LENGTH	70 mm		-			-
241		ENCODER DIRECTION	OFF	0			-	-
243		OFFSET DIST. PEC DISP.EDGE	0 mm					-
244		OFFSET PEC ADJUSTMENT	5 %					-
245		STARTDELAY	50 ms					
246		POSITION EDGE	0 mm					-
248		TRANSPORT UNIT STBY DELAY	OFF		-	-		-
249		PROCESSING OF EMPTY PACKS	OFF		-	-		-
250		PRINTER	OFF	0				
251		PRINTER START DELAY	5 ms					
252		ERROR EXTERNAL PRINTER	OFF	0				
253		PRINTER PRESS-DOWN TIME	100 ms					-
254		PRINTER RUN-UP TIME	100 ms					-
255		PRINT POSITION	FRONT	0			-	-
256		PRINTER START SIGN. LENGTH	20 ms					
258		PRINTER ON/OFF	OFF	0	PRINTER**	PRINTER**	PRINTER**	PRINTER**
259		PRINTER READY MESSAGE	OFF	0				
260		MONITORING REEL	OFF					-
261		CONTACT 1	READY	1				
262		CONTACT 2	ALARM	5				
263		CONTACT 3	LAMP	0				
264		INPUT 1	OFF					
265		APPLICATOR PRESS-DOWN TIME	200 ms					-
266		APPLICATOR RUN-UP TIME	250 ms					-
267		START EDGE	FALLING	0				
268		PRINTER CLOCK MULTIPL.	3.3x					
269		PREDISPENSE VALUE	50 mm				-	-
270		CROSS SHIFT MAX FREQ	4000					
272		MAX. STARTSIGNALS	8					
276		DISPENSER SPEED	25 m/min					
277		DISPENSER ACCELERATION	25 m/s ²					
278		DISPENSER STEP WIDTH	0.2 mm/S					
279		SPEED OFFSET +/-	0 %					
280		DISPENSER MAX.FREQUENCY	4000 Hz				-	-
281		PRINTER SPEED	25 m/min		-			
282		PRINTER ACCELERATION	25 m/s ²		-			
283		LONGITUDINAL STROKE SPEED	16 m/min		-	-		-

No.	Icon	Parameter text	ELS standard	ELS 2x1-SC*	ELS 2x1	ELS 500	ELS 620
284		LONGITUDINAL STROKE ACCEL.	2 m/s ²	-	-		-
285		TRANSPORT UNIT SPEED	25 m/min	-	-		-
286		TRANSPORT UNIT ACCEL.	25 m/s ²	-	-		-
287		PASSWORD TEMP					
288		CROSS SHIFT SPEED	25 m/s ²	-	-		
289		CROSS SHIFT ACCEL.	5 m/s ²	-	-		
290		LABELS DISTANCE	40 mm			-	-
291		DIE WIDTH	400 mm	-	-		-
293		DIE LENGTH	350 mm	-	-		-
294		SYSTEM SETUP					
297		AUTOSYNCEGE	OFF 0	SYSTEM	SYSTEM	-	-
298		PACKAGING MANAGEMENT	OFF 0	-	-		
299		APPLICATOR STARTDELAY	250 ms			-	-
300		TRANSPORT UNIT ADVANCE	520 mm	-	-		
301		LABELLER STARTFREQUENZ	200 Hz				
302		STEP RESOLUTION SM2	2 mm/S	-			
303		STARTFREQUENZ SM2	200 Hz	-			
304		MAX FREQUENZ SM2	4000 Hz	-			
305		STEP RESOLUTION SM3	0.1 mm/S	-	-		
306		STARTFREQUENZ SM3	200 Hz	-	-		
307		MAX FREQUENZ SM3	4000 Hz	-	-		
308		STEP RESOLUTION SM4	0.2 mm/S	-	-		
309		STARTFREQUENZ SM4	200 Hz	-	-		
310		MAX FREQUENZ SM4	4000 Hz	-	-		
311		DIE LENGTH ASYM	0	-	-		
312		CROSS SHIFT STEP RES.	0.1 mm/S	-	-		-
313		IP-ADDRESS		-	SYSTEM	SYSTEM	SYSTEM
314		SUBNET MASK		-	SYSTEM	SYSTEM	SYSTEM
315		GATEWAY		-	SYSTEM	SYSTEM	SYSTEM
316		SPEED SYNCHRO	SLOW 0			-	-
317		MODE SYNCHRO	OFF 0			-	-
319		MODE SERIAL INTERFACE	OFF	SYSTEM	SYSTEM	SYSTEM	SYSTEM
320		SPEED OFFSET SM2	0				
327		SPEED LABELLER (A)	16 m/min	-			
328		NUMBER OF CYCLES MAX.	0c/min	-			
329		REMOTE	OFF	SYSTEM	SYSTEM	SYSTEM	SYSTEM
330		BOOT LOADER VERSION		-			
331		DATE/TIME	dd.mm.yy hh.mm	-			
332		AUTOMATIC MODE	0 h	-			

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No.	Icon	Parameter text	ELS standard	ELS 2x1-SC*	ELS 2x1	ELS 500	ELS 620
333		LABEL MATERIAL ADVANCE	0 m	-			
334		POSITION ASYM	0	-		-	-
335		APPLICATOR BLOWING TIME	100 ms			-	-
336		SPEED_OFFSET_QH	0 %	-	-	-	
337		SPEED_QH_IST	16 m/min	-	-	-	
338		MAX_LENGTH_QH	800 mm	-	-	-	-
340		NUMBER UNIT X	2	-	-		
341		NUMBER UNIT Y	3	-	-		
342		DISTANCE UNIT Y	350 mm	-	-		
343		DISTANCE UNIT X	350 mm	-	-		
345		OFFSET UNIT Y	40 mm	-	-		
346		NUMBER UNIT X	3	-	-		
347		NUMBER UNIT Y	2	-	-		
348		DISTANCE UNIT Y	350 mm	-	-		
349		DISTANCE UNIT X	350 mm	-	-		
350		OFFSET UNIT Y	40 mm	-	-		
351		OFFSET UNIT X	20 mm	-	-		
355		DETECT ENCODER DIRECTION	PRESTART 0			-	-
356		MAX NO OF MISSING LABELS	3				-
357		PRODUCT LENGTH	0 mm			-	-
358		SWITCH OFF FANS	OFF 0	-	-		-
359		MODE PRINTINGDIR. INKJET	NORMAL 0	-	-	-	
360		PAIRING MODE MACHINES	OFF 0	-	-		-
361		MODE LABELLING	OFF 0	-	-		-
367		OFFSET LABEL DISTANCE	0 0	-	-		-
370		NEUTRAL POINT MASK	OUTFEED FOIL 1	-	-	SYSTEM	SYSTEM
371		COMM. ANSWER	ON 1	-	-	SYSTEM	SYSTEM
372		BYTE ASSIGNMENT	BIG ENDIAN 1	-	-	SYSTEM	SYSTEM
373		BLOW OFF LABELS	OFF 0	-	-		-

Tab. 27: Parameter overview

15.2 Detailed parameter list

Table description

System	System-specific parameters – e.g. date/time, IP address
Machine	Design-specific parameters – e.g. distance between PEC and dispensing edge
Workflow	Process-specific parameters – e.g. press-down times, etc.
saved	Parameter setting is maintained after switching the device off and on
ELS 2x1-SC, 2x1, 500, 620	The checkmarks indicate for which model series the respective parameter is available.

202 APPLICATOR

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1						✓	✓	✓	

An optional applicator can be switched on in manual mode.

203 OFFSET LONGITUDINAL SHIFT

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
20	5	800	mm			✓	✓			✓	

Offset of basic position of the longitudinal stroke from zero position.

204 OFFSET TRANSPORT UNIT

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
40	5	600	mm			✓	✓			✓	

Offset of position of 1st label on transport unit.

205 EVENTLOG

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	5		✓					✓	✓	✓

Only for ELS service purposes. Standard: OFF

206 NUMBER OF ROWS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2	1	9				✓	✓	✓	✓	✓	

Die-specific format setting of the thermoforming machine.

207 EXTERN REWINDING

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓	✓	✓	✓	

A pneumatic backing paper rewinder can be switched on for the dispensing process.

- 0 OFF switched off
- 1 ON switched on

208 NUMBER OF COLUMNS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
3	1	12				✓	✓			✓	

Die-specific format setting of the thermoforming machine.

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211 SWITCH OFF DRIVES

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1			✓					✓	✓

The stepper motor drives can be de-energised for setup purposes.

212 QUANTITY OF LABELS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
3	1	6				✓	✓	✓	✓		

In the "multi-dispense" mode of operation, this value can be used to set the quantity of labels to be dispensed per start signal.

213 POSLABELEDGEMAX

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
99	0	99	mm	✓				✓	✓	✓	

Limitation of the setting value 246 position edge.

214 LABELCHECK

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓			✓	

OFF switched off

ON switched on

Cannot be used with transparent and shaped labels.

Implies optional jam sensor.

215 PRINT LENGTH

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
30	1	199	mm			✓	✓	✓	✓	✓	✓

Print length for inkjet printer.

216 PRINT DISTANCE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
15	0	99	mm			✓	✓	✓	✓	✓	✓

DISTANCE OF PRINTOUTS FOR POSITIONING UNIT ELS620.

218 HARDWAREVERSION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
				✓					✓	✓	✓

Indicates the hardware version, e.g. 010_103

219 SHOW ENCODER SPEED

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1							✓		

Only for ELS service purposes. Standard: OFF

220 PROGRAM VERSION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
				✓					✓	✓	✓

Indicates the version of the installed software, e.g. V10-02-55

221 DHCP

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1		✓			✓		✓	✓	✓

Network: If switched on, the IP address of the control system is assigned by a server.

222 JOBNAME

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	1	99			✓		✓	✓	✓	✓	✓

Name of the currently loaded job. Asterisks in front and behind the name indicate that the active job is based on the specified job, however, the parameters have been changed.

223 NUMBER OF JOBS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
30	1	99		✓			✓	✓	✓	✓	✓

Maximum number of storable jobs.

225 TCP-PORT

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2001	1024	16384		✓			✓			✓	✓

The parameter is required for the communication via Ethernet TCP and sets the port. It has to correspond to the remote station.

226 LANGUAGE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	22			✓		✓		✓	✓	✓

Country-specific language setting.

227 PASSWORD SERVICE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
123	1	9999		✓			✓	✓	✓	✓	✓

The set password can be changed.

Appendix

228 MODE OF OPERATION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	*				✓		✓	✓	✓	✓

Pre-selection of the labelling process depending on the mechanical design of the machine.

* Depends on machine type.

Workflows	ELS 2x1-SC ELS 2x1		ELS5xx		ELS620	
0	PRT	Permanent printing				
1	STD	Dispense	5xx STD	Labelling of single- and multi-row product arrangements Motor-driven positioning in product running direction		
2	STD+O UT/RU	Dispensing with pressure / wrap-around labelling	5xx FIX	Labelling of single-row product arrangements Manual mechanical positioning in product running direction		
3	WS	Corner dispensing edge	5xx OPT	Labelling of single- and multi-row product arrangements Motor-driven positioning in product running direction		
4	PA1	Pneumatic applicator: Pressing on - dispensing	525 +QHIN K	Labelling of single- and multi-row product arrangements Motor-driven positioning in product running direction Additional labelling of products transverse to the running direction by means of inkjet system		
5	PA2	Pneumatic applicator: Dispense - press on	252 +LHIN K	Labelling of single- and multi-row product arrangements Motor-driven positioning in product running direction Additional labelling of products in running direction by means of inkjet system		
6	STD 1- n	Multi-dispensing	510 EF V1	Labelling of single- and multi-row product arrangements Manual mechanical/pneumatic positioning in product running direction		
7	STD + OUT	Dispensing with delayed pressing	510 EF V2	Labelling of single- and multi-row product arrangements Manual mechanical/pneumatic positioning in product running direction		

Workflows	ELS 2x1-SC ELS 2x1		ELS 500		ELS620	
8	PA3	Pneumatic applicator: Blow off - dispense - press on	525 QHINK	Product labelling of single- and multi-row product arrangements Printing transverse to the product running direction		
9	PA4	Pneumatic applicator: Dispense - press on - blow off	525 LHINK	Product labelling of single- and multi-row product arrangements Printing in product running direction		
10	PA5	Pneumatic applicator: Dispense - press on - delayed blow off				
11	STD NO SIG	Dispensing with start signal fade-out			6xx OHPRT	Positioning unit - labelling transverse to product running direction
12						
13					6xx LHPRT	Positioning unit - labelling in product running direction
14						
15			6xx QHPR T FIX	Positioning unit - labelling transverse to product running direction, one row		

229 QUANTITY COUNTER RESET

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS 500	ELS 620
0	0	0						✓	✓	✓	✓

Prematurely reset quantity counter.

230 MODE PIECE COUNTER

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS 500	ELS 620
0	0	2				✓	✓	✓	✓	*	

Mode pre-selection of integrated quantity counter.

0 OFF

1 SUM

The quantity counter is counting upward. It carries out a summation.

2 LIMIT

The quantity counter is counting upward starting from 0 on. If the quantity counter reaches the "232 QUANTITY PRESELECTION" value (SETUP menu), the system stops and indicates note 51.

* for ELS5xx only function SUM or OFF

Appendix

231 QUANTITY COUNTER

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	99999				✓	✓	✓	✓	✓	

Indicates the current value of the quantity counter.

232 QUANTITY SELECTION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	9999		1				✓	✓		

Mode pre-selection of integrated quantity counter.

The desired quantity is entered here, which is to be reached if the quantity counter mode LIMIT is switched on.

233 EXT. POWER SUPPLY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓		✓	✓	✓

By means of the external power supply, a printer can, for example, be supplied with power. This parameter is also set using the green knob switch on the keyboard.

234 START SIGNAL LENGTH MIN.

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
10	1	999	ms			✓	✓	✓	✓	✓	✓

Pre-selection of the minimum start signal length. Its purpose is to avoid any false tripping by, for example, bouncing relay contacts.

235 DISTANCE PEC DISP. EDGE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
40	0	500	mm		✓		✓	✓	✓	✓	

Adjustment setting of the distance from the label PEC to the dispensing edge. This value helps the control system to position the label at the dispensing edge.

236 DISPENSE MISSING LABEL

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓	✓	✓	✓	

0 OFF dispensing function switched off
1 ON dispensing function switched on

Pre-selection of the operating mode in case of missing labels on the label reel.

If a missing label is detected in automatic mode, the dispensing function automatically fills the resulting gap on the label backing strip at the dispensing edge. After the number of missing labels set in parameter 356 has been reached, "error message 92 TOO MANY CONSEC. LABELS MISSING" is displayed.

237 UPDATE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1		✓					✓	✓	✓

ON

OFF

Start automatic search for software update.

238 LABEL LENGTH

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
70	10	500	mm			✓	✓	✓	✓	✓	

Indicates the last read label length.

241 ENCODER DIRECTION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	2				✓	✓	✓	✓		

Setting of the encoder direction. Set parameters 316 and 317 in addition.

- 0 OFF Encoder is not available or switched off.
- 1 ON  Encoder is turning clockwise 
- 2 ON  Encoder is turning counter-clockwise 

243 OFFSET DIST. PEC DISP.EDGE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	600	mm			✓	✓	✓	✓	✓	

If two label PECs are installed, the distance can be set using this parameter.

244 OFFSET PEC ADJUSTMENT

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
5	0	50	%			✓	✓	✓	✓	✓	

During the PEC adjustment, the control system measures the transparency of the backing paper. The measured value is then increased by the offset to always guarantee a safe margin in the measuring of the backing paper.

If, after PEC adjustment has been successfully carried out, the PEC LED flickers when the backing paper is moved within the PEC, this value must be increased.

If, after PEC adjustment has been successfully carried out, the PEC LED flickers in the PEC when the backing paper is moved with label (not in the label gap!) within the PEC, this value must be decreased.

Appendix

245 / STARTDELAY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
5	0	999	mm			✓	✓	✓	✓	✓	✓

ELS 2x1 and ELS2x1-SC: Adjustment of the label position on the product in automatic mode. Relative value depending on start signal.

ELS 500 and ELS 620: Adjustment of the delay time of the start signal in automatic mode.

246 / POSITION EDGE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	-999	999	mm			✓	✓	✓	✓	✓	

Enter position of the label at the dispensing edge in mm.

248 TRANSPORT UNIT STBY DELAY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	10	min		✓		✓			✓	

Adjustment of the time after which the fans of the transport unit are switched off if the packaging machine does not send a start signal.

249 PROCESSING OF EMPTY PACKAGES

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓			✓	

With packaging management activated, the processing of empty packages can be switched on or off.

- 0 OFF
- 1 ON

250 PRINTER

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	5				✓	✓	✓	✓	✓	✓

Pre-selection of an optionally available printer.

- 0 **OFF** No printer available.
- 1 **EXTERN** EXTERNAL printer available.
- 2 **RDW-1** An *integrated rotary printer* with a printing cylinder diameter of 42mm and a *dispensing length* of 142mm (single cam) is available.
- 3 **RDW-2** An *integrated rotary printer* with a printing cylinder diameter of 42mm and a *dispensing length* of 71mm (double cam) is available.
- 4 **ELS190/ELS191** A TT-ELS190/ELS191 printer is available.
- ELS192 A TT-ELS192 printer is available.
- ELS193 A TT-ELS193 printer is available.
- 5 **INKJET** An INKJET printer is available.

251 PRINTER START DELAY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
5	0	1000	ms			✓	✓	✓	✓	✓	✓

Delay of the start signal for optional printer.



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252 ERROR EXTERNAL PRINTER

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	2				✓	✓	✓	✓	✓	✓

Evaluation of an error signal of the available external printer.

- 0 OFF No evaluation of the error signal from the external printer.
- 1 ALARM NC Error signal evaluation is switched on, the signal is evaluated as *closed contact*. The error signal is given via plug connector X4.
- 2 ALARM NO Error signal evaluation is switched on, the signal is evaluated as *open contact*. The error signal is given via plug connector X4.

253 PRINTER PRESS-DOWN TIME

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
100	5	999	ms			✓	✓	✓	✓	✓	

Adjustment of the press-on time of the printer block in the case of a hot foil or stamp printing unit.

254 PRINTER RUN-UP TIME

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
100	5	999	ms			✓	✓	✓	✓	✓	

Adjustment of the run-up time of the printer block in the case of a hot foil or stamp printing unit.

255 PRINT POSITION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	2				✓	✓	✓	✓		

Adjustment of the print position in the case of a hot foil or stamp printing unit.

- 0 **begin** Print on the first part of the label.
- 1 **end** Print on the second part of the label.
- 2 **both** Print on both parts of the label.

256 PRINTER START SIGN. LENGTH

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
20	5	100	ms			✓	✓	✓	✓	✓	✓

Adjustment of the start signal length for an external inkjet printer.

Appendix

258 PRINTER ON/OFF

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓	✓	✓	✓	✓

This parameter is set using the printer key on the keyboard and is used in case of an optional touch panel.

259 PRINTER READY MESSAGE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	2				✓	✓	✓	✓	✓	✓

Adjustment of the printer contact. Ready messages sent by connected printer.

260 MONITORING REEL

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	4				✓	✓	✓	✓	✓	

Activation of the optional reel end monitoring.

OFF

No reel end monitoring.

WARNING

The input signal of the reel end monitoring is evaluated as a warning.

ERROR

The input signal of the reel end monitoring is evaluated as an error. Function strip end

261 CONTACT 1 | 262 CONTACT 2 | 263 CONTACT 3

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC*	ELS 2x1*	ELS500	ELS620
K1 = 1 K2 = 2 K3 = 5	0	7				✓	✓	✓	✓	✓	✓

Potential-free relay contacts for evaluation in downstream/upstream devices.

- 0 OFF No signal output.
- 1 **READY** The contact is opened *during the labelling cycle*.
- 2 **ALARM** The contact is closed *in the event of an error* in the control system.
- 3 **STOCK** The contact is closed *when the minimum reel diameter* is reached.
- 4 **DISPENSING** The contact is closed *during the label dispensing cycle*.
- 5 **LAMP** The contact is closed *in the event of an error*, it flashes periodically every second if there are *information messages*.
- 6 **AUTO** The contact is closed *in automatic operation*.
- 7 **APPLICATOR** The contact is closed parallel to the *press-on[OUT1]* output.

264 INPUT 1

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	4				✓	✓	✓	✓	✓	✓

Potential-free optocoupler input.

OFF No signal evaluation.

ALARM NC The input works as an error input; the error signal is *evaluated as a closed contact*.

ALARM NO The input works as an error input; the error signal is *evaluated as an open contact*.

START NC The input is combined with the start signal; in case of an *active* input, the start signal is evaluated.

START NO The input is combined with the start signal; in case of an *inactive* input, the start signal is evaluated.

265 APLIKATOR PRESS-DOWN TIME

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
200	5	9999	ms			✓	✓	✓	✓	✓	

Adjustment of the press-on time of an applicator that may be available.

266 APLIKATOR RUN-UP TIME

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
200	5	9999	ms			✓	✓	✓	✓	✓	

Adjustment of the run-up time of an applicator that may be available.

267 START EDGE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓	✓	✓	✓	✓

Adjustment of the start trigger for the automatic operation by means of which the labelling cycle is started.

0 FALLING Start with falling edge of trigger signal from active to inactive

1 RISING Start with rising edge of trigger signal from inactive to active

268 PRINTER CLOCK MULTIPL.

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
33	10	80				✓	✓	✓	✓	✓	✓

The readout of the stepper motor increments is given in a resolution of 0.1mm/step. Should the inkjet printer require another stepper resolution, it can be entered.

269 PREDISPENSE VALUE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
50	0	999	mm			✓	✓	✓	✓		

This parameter is only used in the corner dispensing edge (ELS 2x1) workflow and defines the pre-dispensing value of the label at the dispensing edge.

Appendix

270 CROSS SHIFT MAX FREQ

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
4000	200	7500	Hz		✓		✓			✓	✓

276 / DISPENSER SPEED

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
250	50	600	m/min			✓	✓	✓	✓	✓	✓

Pre-selection of the dispensing speed in m/min.

277 DISPENSER ACCELERATION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
25	5	90	m/s ²			✓	✓	✓	✓	✓	✓

Pre-selection of the maximum acceleration of the dispenser stepper motor (depending on motor type and label material).

278 DISPENSER STEP WIDTH

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2	1	4	mm/S		✓		✓	✓	✓	✓	✓

Pre-selection of the resolution of the mechanical transmission of the drive with the labelling head (determined by the manufacturer, must not be changed).

0.1MM One step of the stepper motor corresponds to 0.1 mm of label advance.

0.2MM One step of the stepper motor corresponds to 0.2 mm of label advance.

0.3MM One step of the stepper motor corresponds to 0.3 mm of label advance.

279 SPEED OFFSET +/-

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	-20	20	%			✓	✓	✓	✓	✓	✓

A percentage value can be added to or subtracted from the set speed.

280 DISPENSER MAX. FREQUENCY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
4000	200	7500	Hz		✓		✓	✓	✓	✓	✓

Pre-selection of the maximum dispensing speed (determined by manufacturer, must not be changed).

400 = 4000 Hz **Vmax** SW=0.2mm = 48 m/min;

Vmax SW=0.3mm = 72 m/min.

The lowest possible product distance becomes smaller with a decreasing frequency. The highest possible dispensing speed becomes smaller with a decreasing frequency. For ELS 2x1-SC, the following applies: The frequency is indicated with three digits. 400 = 4000 Hz, 220 = 2200 Hz, etc.

281 PRINTER SPEED

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
250	50	600	m/min			✓	✓		✓	✓	✓

Speed of the optional rotary printer.

282 PRINTER ACCELERATION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
25	5	90	m/s ²			✓	✓		✓	✓	✓

Acceleration of the optional rotary printer.

283 LONGITUDINAL STROKE SPEED

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
160	50	600	m/min			✓	✓			✓	✓

Pre-selection of the speed of the longitudinal stroke in m/min.

284 LONGITUDINAL STROKE ACCEL.

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2	1	5	m/s ²			✓	✓			✓	✓

Pre-selection of the speed of the longitudinal stroke in m/min. Pre-selection of the maximum acceleration of the longitudinal stroke stepper motor (depending on the motor type).

285 TRANSPORT UNIT SPEED

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
250	50	600	m/min			✓	✓			✓	✓

Pre-selection of the transport unit speed in m/min.

286 TRANSPORT UNIT ACCEL.

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
25	5	90	m/s ²			✓	✓			✓	✓

Pre-selection of the maximum acceleration of the transport unit stepper motor (depending on the motor type).

287 PASSWORD TEMP

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
247	1	9999		✓				✓	✓	✓	✓

Request to enter the password to activate the service mode.

Appendix

288 CROSS SHIFT SPEED

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
25	5	60	m/min			✓	✓			✓	✓

289 CROSS SHIFT ACCEL.

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
5	5	90	m/s ²			✓	✓			✓	✓

290 LABELS DISTANCE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
40	0	400	mm			✓	✓	✓	✓		

In the "multi-dispense" machine operation, this value can be used to set the distance between the labels to be dispensed.

291 DIE WIDTH

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
400	5	660	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

293 DIE LENGTH

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
350	5	12x1	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

294 SYSTEM SETUP

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1			✓				✓	✓	✓

Calls SYSTEM page.

297 AUTOSYNCEGE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1		✓			✓	✓	✓		

OFF: synchronisation at the beginning of the label

ON: automatic synchronisation

Automatic detection of suitable label synchronisation.

If a label gap is detected in the area of the label PEC, this function can avoid synchronisation problems.



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298 PACKAGING MANAGEMENT

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	8			✓		✓			✓	

OFF: packaging management switched off

OP: packaging management switched on for upper web labeller

UP: packaging management switched on for lower web labeller

This parameter activates the packaging management for cross-web labelling.

The value is set depending on the device type.

Setting of the device type: 1 = OP, 2 = UP.

In case of upper/lower web devices, both settings are possible; in addition, parameter 360 must be observed.

299 APPLICATOR STARTDELAY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
250	5	9999	ms			✓	✓	✓	✓	✓	

In the "pneumatic applicator" mode of operation ⇒ Dispensing-Delay-Press-on [OUT1], the time between the start signal and OUT1 (Press-on) can be entered with this setting value.

300 TRANSPORT UNIT ADVANCE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
520	10	750	mm			✓	✓			✓	✓

Pre-selection of the maximum transport unit advance of the packaging machine (actual physical width). The sum of parameter



in the MACHINE menu and the parameter 188 must not exceed this value.

301 LABELLER START FREQUENCY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
200	100	500	Hz		✓		✓	✓	✓	✓	✓

Speed at which stepper motor 1 is started, depending on the design.

302 STEP RESOLUTION SM2

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2	1	4	mm/S		✓		✓		✓	✓	✓

Step width of stepper motor 2, depending on the design.

303 STARTFREQUENCY SM2

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
200	100	500	Hz		✓		✓		✓	✓	✓

Speed at which stepper motor 2 is started, depending on the design.

Appendix

304 MAX FREQUENCY SM2

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
4000	200	7500	Hz		✓		✓		✓	✓	✓

Maximum speed of stepper motor 2, depending on the design.

305 STEP RESOLUTION SM3

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
1	1	4	mm/S		✓		✓			✓	✓

Step width of stepper motor 3, depending on the design.

306 STARTFREQUENCY SM3

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
200	100	500	Hz		✓		✓			✓	✓

Speed at which stepper motor 3 is started, depending on the design.

307 MAX FREQUENCY SM3

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
4000	200	7500	Hz		✓		✓			✓	✓

Maximum speed of stepper motor 3, depending on the design.

308 STEP RESOLUTION SM4

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2	1	4	mm/S		✓		✓			✓	✓

Step width of stepper motor 4, depending on the design.

309 STARTFREQUENCY SM4

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
200	100	500	Hz		✓		✓			✓	✓

Speed at which stepper motor 4 is started, depending on the design.

310 MAX FREQUENZ SM4

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
4000	200	7500	Hz		✓		✓			✓	✓

Maximum speed of stepper motor 4, depending on the design.

311 DIE LENGTH ASYM

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1200	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

312 CROSS SHIFT STEP RES.

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
1	1	4	m/s		✓		✓			✓	✓

313 IP-ADDRESS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
000,000,000,000	0	0		✓			✓		✓	✓	✓

IP address of control system. Ask your network administrator.

314 SUBNET MASK

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
255,255,255,000	0	0		✓			✓		✓	✓	✓

Subnet mask. Ask your network administrator.

315 GATEWAY

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
000,000,000,000	0	0		✓			✓		✓	✓	✓

IP address of gateway. Ask your network administrator.

316 SPEED SYNCHRO

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓	✓	✓	✓		

Setting of the encoder speed. **FAST**, **SLOW**. Observe parameters 241 and 317.

317 MODE SYNCHRO

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	2				✓	✓	✓	✓		

Operating mode of the encoder. **OFF**, **DIRECT**, **SCALED**. Observe parameters 241 and 316.

Appendix

319 MODE SERIAL INTERFACE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	3		✓				✓	✓	✓	✓

Settings for serial interface. Setting must only be carried out by ELS!
 0 = OFF, 1 = REMOTE, 2 = FU, 3 = SYSTEM

327 SPEED LABELLER (A)

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
160	5	600	m/min						✓	✓	✓

Actual speed of the labeller.

328 NUMBER OF CYCLES MAX.

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	99	T/min		✓		✓		✓	✓	✓

Maximum possible capacity of the labeller.

329 REMOTE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1		✓			✓		✓	✓	✓

Switched on if only optional touch panel is used as control element.

330 BOOTLOADERVERSION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
				✓			✓		✓	✓	✓

Version of boot loader installed, e.g. B00-02-16.

331 DATE / TIME

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
				✓			✓		✓	✓	✓

Setting and display of date and time, e.g. 23.05.2011 20:01.

332 AUTOMATIC MODE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	99999999	h		✓		✓		✓	✓	✓

Operating hours counter

333 LABEL MATERIAL ADVANCE

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	99999999	m/s		✓		✓		✓	✓	✓

Metre counter

334 POSITION ASYM

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	9				✓	✓			✓	

Die-specific format setting of the thermoforming machine.

340 NUMBER UNIT X

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2	0	9				✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

341 NUMBER UNIT Y

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
3	0	12				✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

342 DISTANCE UNIT Y

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
400	5	660	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

343 DISTANCE UNIT X

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
350	5	1200	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

344 OFFSET UNIT X

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
20	5	800	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

345 OFFSET UNIT Y

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
40	5	600	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

Appendix

346 NUMBER UNIT X

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
3	0	12	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

347 NUMBER UNIT Y

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
2	0	9	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

348 DISTANCE UNIT Y

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
400	5	660	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

349 DISTANCE UNIT X

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
350	5	1200	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

350 OFFSET UNIT Y

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
20	5	800	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

351 OFFSET UNIT X

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
20	5	800	mm			✓	✓			✓	✓

Die-specific format setting of the thermoforming machine.

354 DIE WIDTH ASYM

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	620	mm			✓	✓			✓	✓

Distance between two positions deviating from the symmetric die.



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355 DETECT ENCODER DIRECTION

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	2			✓		✓	✓	✓		

Affects the evaluation of the encoder direction:

0 PRESTART The error message "false encoder direction" is displayed when activating automatic mode.

1 POSTSTART The error message "false encoder direction" is displayed when receiving the start signal in automatic mode.

2 OFF No error message is sent in case of false encoder direction.

356 MAX NO OF MISSING LABELS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
3	1	12		✓			✓	✓	✓	✓	

Maximum number of consecutively missing labels sent after "error message 92 - Too many consec. labels missing".

357 START SIGNAL FADE-OUT

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	999	ms			✓	✓	✓	✓		

A start signal fade-out can be activated for workflow 11.

During this time, the control system does not receive any start signal.

358 SWITCH OFF FANS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	1				✓				✓	

AUS Fan switched off

ON Fan switched on

Fans at the transport unit can be switched off. Required for:

- combined system, if only positioning unit is used
- cleaning mode
- standby

360 PAIRING MODE MACHINES

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	4				✓	✓			✓	

The system condition can be set for combined systems.

Currently, this is required for package management and affects the PACKAGING MANAGEMENT parameter (298).

361 MODE LABELLING

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS500	ELS620
0	0	2				✓	✓			✓	

OFF

EVEN

ODD

All even or odd positions can be labelled in the format.

The empty-package treatment is assigning format information of the data set to products.



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Appendix

367 OFFSET DIST. LABELS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS 500	ELS620
0	-20	+20	%			✓	✓			✓	

The distance between the labels dispensed onto the transporting unit can be adjusted proportionally.

370 ZERO POINT MASK

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS 500	ELS620
1	0	1		✓			✓			✓	✓

Zero point mask of package management. Defines, whether the operating side of the thermoforming machine is arranged in the infeed or outfeed of the plant.

- 0 Infeed foil
- 1 Outfeed foil

371 KOMM. ANSWER

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS 500	ELS620
1	0	1		✓			✓			✓	✓

If the communication of the packaging management with the parent machine requires an answer as handshake, it can be switched on.

- 0 OFF
- 1 ON

372 BYTE ASSIGNMENT

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS 500	ELS620
1	0	1		✓			✓			✓	✓

Setting of the byte assignment in the communication of the packaging management as Little Endian (Intel) or Big Endian (Motorola).

- 0 Little Endian
- 1 Big Endian

373 BLOW OFF LABELS

Default	Min. value	Max. value	Unit	System	Machine	Workflow	saved	ELS 2x1-SC	ELS 2x1	ELS 500	ELS620
0	0	1				✓	✓			✓	

If the optional equipment "blow-off channel" is installed, the function "blow-off label" can be activated with this function.

- 0 OFF
- 1 ON