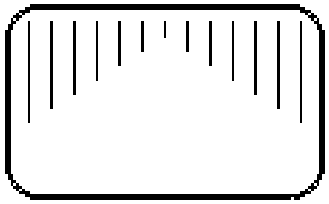
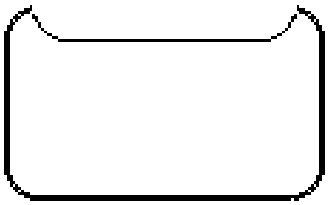
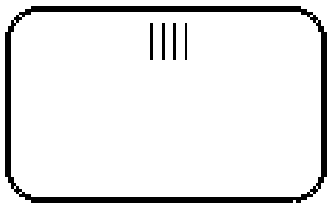
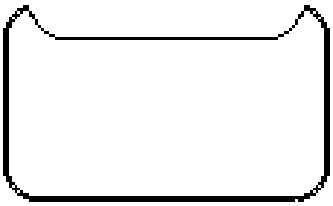
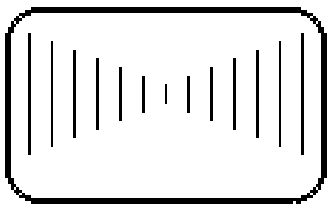
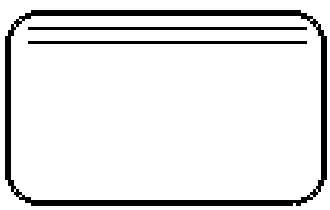
ISHIDA WM-Ai TRAY PROGRAMMING OVERVIEW

These are the basic steps for tray programming. Additional setting changes may be required to achieve a satisfactory wrap.

1. Program menu > Tray.
2. Use the tray number and add a zero. Examples: 7S → 70, 17S → 170, press PLU.
   This allows trays with similar numbers to be grouped together such as 4S (40) and 4D (41).
3. Get an empty tray and soaker pads – ask the customer how many are used in each tray.
4. Follow the Auto Tray Programing screen instructions:
   a. Measure and enter the height of the tray. Use the ruler on the bottom of the printer door.
   b. Place the tray and pad(s) on the scale press the Tray Wt to save the tare.
      If the tare weight is in the PLU File set the tray tare wt as zero (0).
   c. Place something in the tray (wallet, meat, etc.)
   d. Press the PLU key after the tray moves onto the lift to complete the wrap.
   e. Place the wrapped tray on the scale to record the film tare wt.
5. Press the Manual tab.
6. Set Wrap Speed = MIDDLE.
7. Verify Film Select is correct: typically Upper (small film) and Lower (large film).
8. Press the blank space at the top and enter the tray name. Examples: 7S, 17S.
   "Rotate" or "Turn" may be added at the end of the description if the label will be rotated.
9. If there are wrinkles press the Adjust tab.
10. Refer to the table on the next page and adjust the four clamp settings in the upper right as needed.
    In general, do not exceed a +5 setting.
    Unwrap and rewrap the tray until satisfactory.
11. Press LABEL REGIS. (upper right).
12. Set Ordinaly Paste = HORI. (straight) **or** VIRT. (rotate).
13. Set HORI. POS. as 1 or 2, **or** set VIRT. POS. as 5 or 7 depending on the previous selection.
14. Press the Paste Coord tab.
15. Place the tray with contents on the scale.
16. Press the PLU key after the tray moves onto the lift to complete the wrap and apply a label.
17. Adjust the label position up/down, right/left using the arrow keys.
    Unwrap and rewrap and label the tray until satisfactory.
18. If a tray is set for Ordinaly Paste = VIRT. (rotate) change the DEGREE (CW) as needed for the correct orientation.

ISHIDA WM-Ai TRAY PROGRAMMING OVERVIEW

The table below can be used as a general reference when programming trays for the Ishida WM-Ai auto wrappers. The two conditions shown in the images on each line are wrinkles and bent tray edges. The clamps that would address the condition are marked as **+** (stronger) or **–** (weaker).

TRAY CONDITION	STRONGER		TRAY CONDITION	WEAKER	
	FR. CEN. 0	RR. CEN. +		FR. CEN. 0	RR. CEN. –
	FR. SIDE 0	RR. SIDE +		FR. SIDE 0	RR. SIDE –
	FR. CEN. 0	RR. CEN. +		FR. CEN. 0	RR. CEN. –
	FR. SIDE 0	RR. SIDE 0		FR. SIDE 0	RR. SIDE 0
	FR. CEN. 0	RR. CEN. 0		FR. CEN. 0	RR. CEN. 0
	FR. SIDE +	RR. SIDE +		FR. SIDE –	RR. SIDE –
	FR. CEN. 0	RR. CEN. 0		FR. CEN. 0	RR. CEN. 0
	FR. SIDE +	RR. SIDE +		FR. SIDE –	RR. SIDE –
	FR. CEN. 0	RR. CEN. +		FR. CEN. 0	RR. CEN. –
	FR. SIDE 0	RR. SIDE +		FR. SIDE 0	RR. SIDE –

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