

# **AP-CODE**

## **DATE CODER**

### User's Manual

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For the most recent version of this manual please visit  
<http://www.primera.com/ap-codesupport>

110824

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## Revision History

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**FCC Compliance Statement:** This device complies with part 15 of the FCC rules. Operation is subject to the following two conditions: (1) this device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

**For Users in the United States:** This product is intended to be supplied by a UL listed Direct Plug-In Power Supply marked "Class 2" or a UL listed ITE Power Supply marked "LPS" with output rated 12VDC, 3A or higher. This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of the FCC Rules. In a domestic environment, this product may cause radio interference, in which case the user may be required to take adequate measures. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Re-orient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

Use of shielded cables is required to comply with the Class A limits of Part 15 of the FCC Rules. You are cautioned that any changes or modifications not expressly approved in this manual could void your authority to operate and/or obtain warranty service for this equipment.

**For Users in Canada:** This digital apparatus does not exceed the Class A limits for radio noise for digital apparatus set out on the Radio Interference Regulations of the Canadian Department of Communications. Le present appareil numerique n'emet pas de bruits radioelectriques depassant les limites applicables aux appareils numeriques de la class A prescrites dans le Reglement sur le brouillage radioelectrique edicte par le ministere des Communications du Canada.

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## Section 1: Getting Started

Thank you for purchasing the Primera AP-CODE Date Coder. The AP-CODE allows you to add printed information to your labeled containers immediately after applying the label. The AP-CODE can be installed on any Primera AP-360, AP-362 or AP380 Applicator regardless of manufacture date.

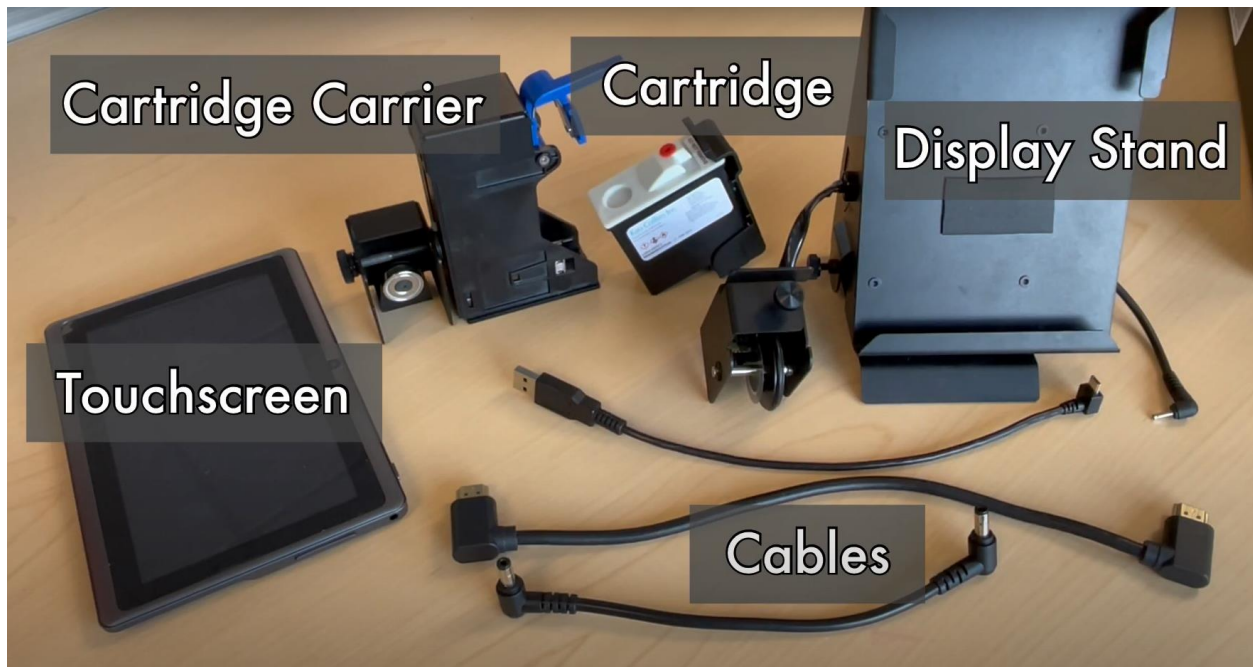
### 1A Choosing a Good Location

- Place the AP-CODE in a location with adequate air circulation to prevent internal heat buildup.
- Do not place the AP-CODE near heat sources such as radiators or air ducts or in a place subject to direct sunlight, excessive dust, mechanical vibration, or shock.
- Allow for adequate clearance above the AP-CODE to accommodate the print head as you move the container arm up to its maximum height.
- Allow for 2" of addition clear on the right side of the AP360/362/380 to allow for the touchscreen display and cable attachment.

## 1B Unpacking and Inspection

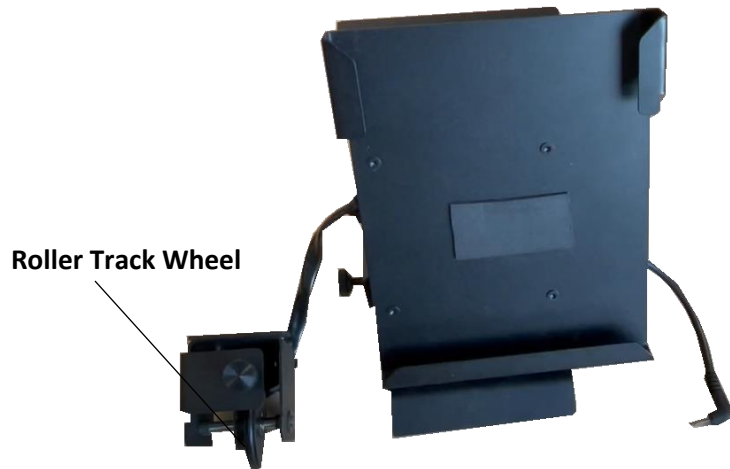
While unpacking your AP-CODE, inspect the carton to ensure no damage has occurred during shipping. Make sure that all supplied accessories are included with your unit. The following items are included in the box:

1. Cartridge Carrier (Print Head)
2. 1x Solvent Ink Cartridge (53580)
3. Display Stand with attached drive roller sensor
4. Touch Screen
5. Micro USB Cable
6. HDMI Cable
7. Power jumper cable (5mm barrel)

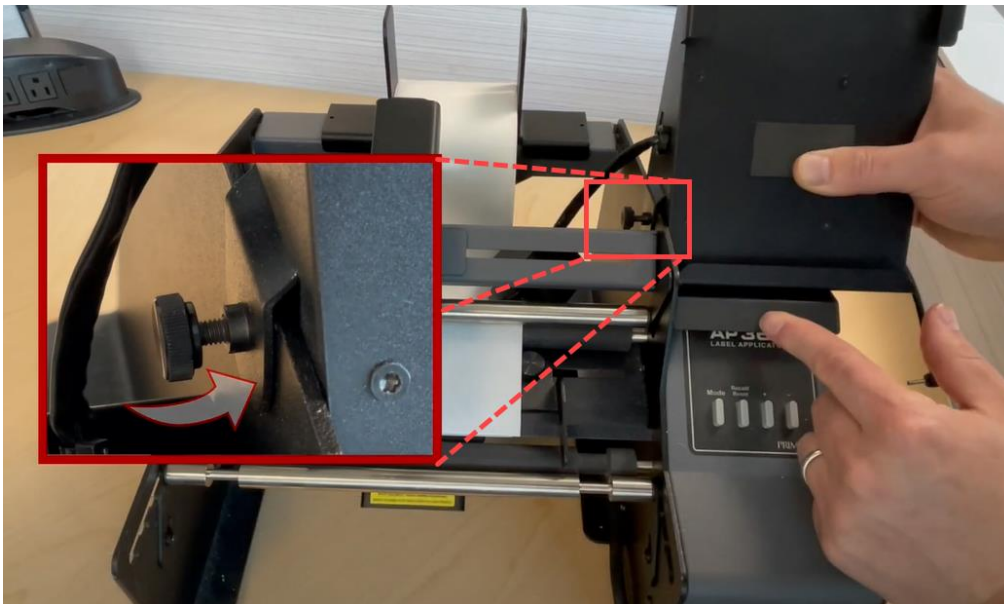


## 1C Assemble your Date Coder

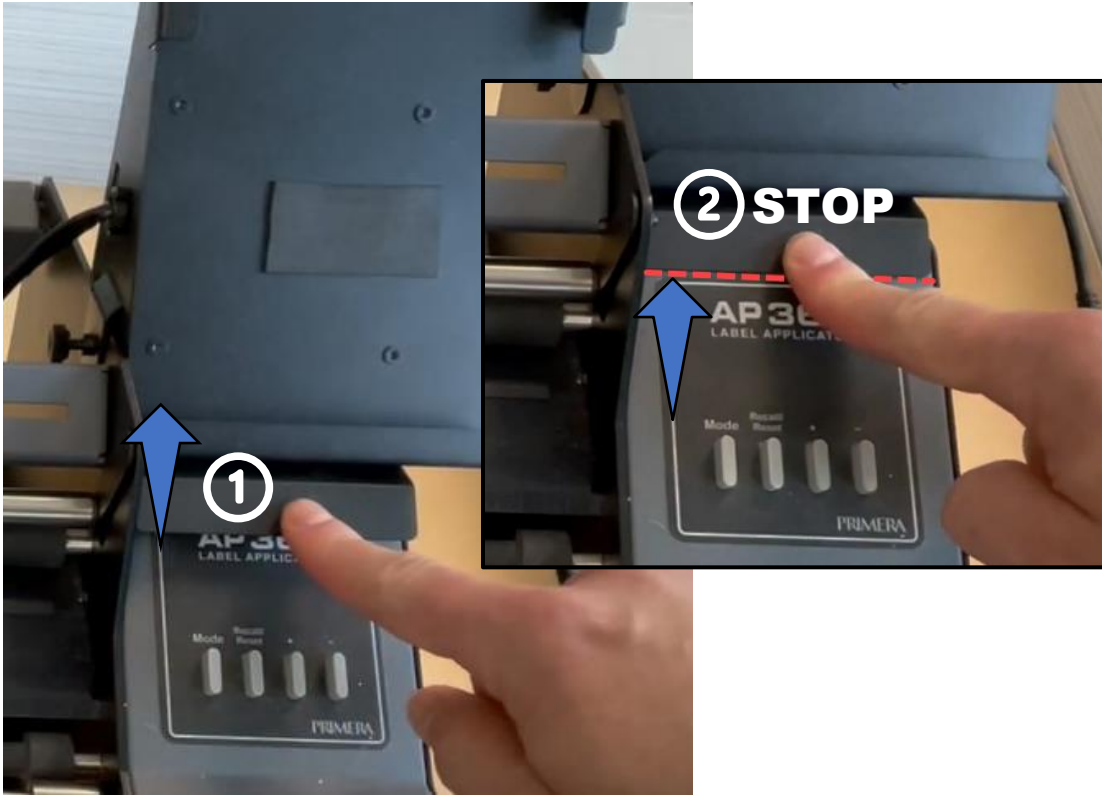
1. Locate the Display Stand.



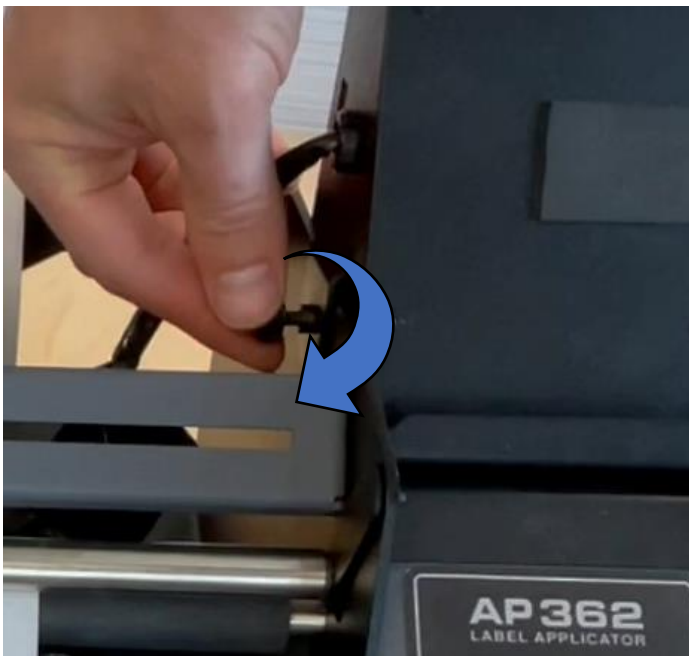
2. Place the display stand on the right side of the Applicator just above the AP360/AP362 Logo Label. The magnets on the underside will attach it to the top of the cover. Make sure the thumbscrew tab on the left side of the display stand fits over the applicator frame.



3. Push the stand so the bottom aligns with the top of the logo label.



4. Tighten the Thumb Screw

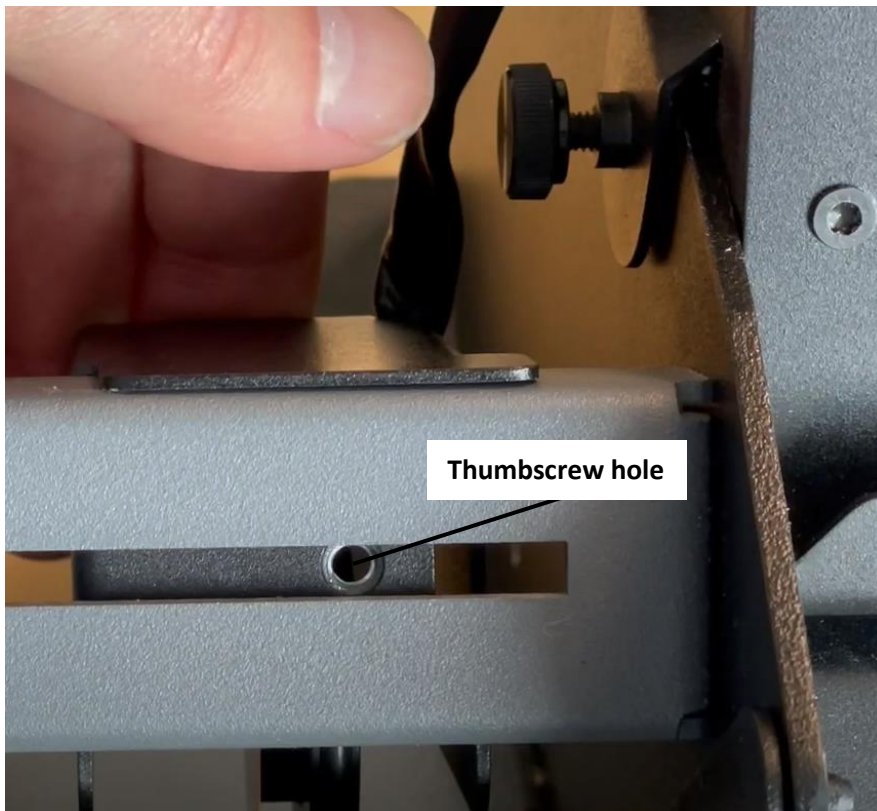




5. Locate the Roller Track Wheel attached to the display stand and remove the thumbscrew.

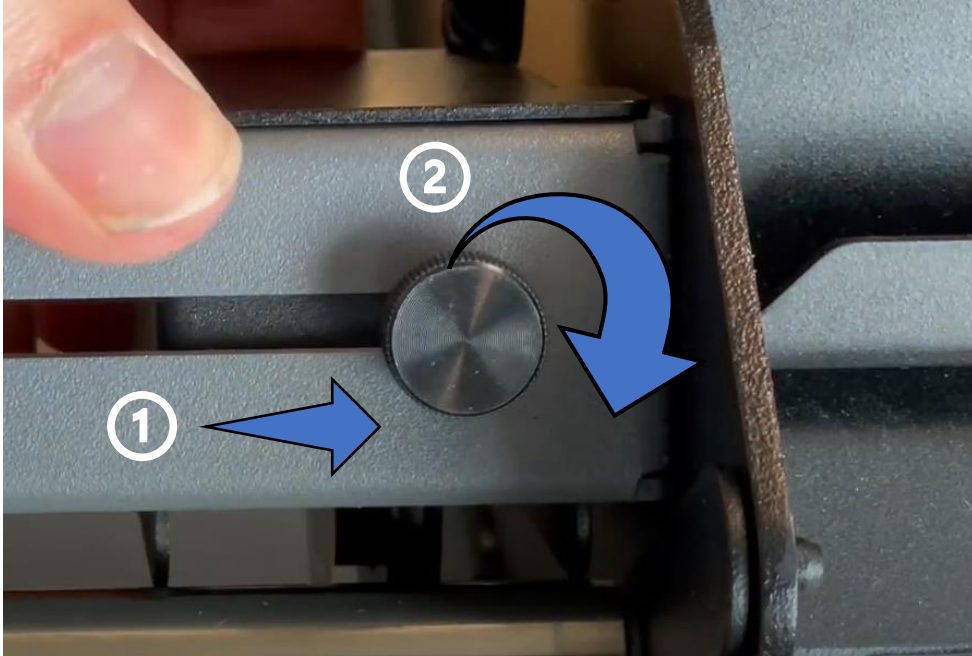


6. Position the track wheel to the pressure arm bar, so the thumbscrew hole is visible.

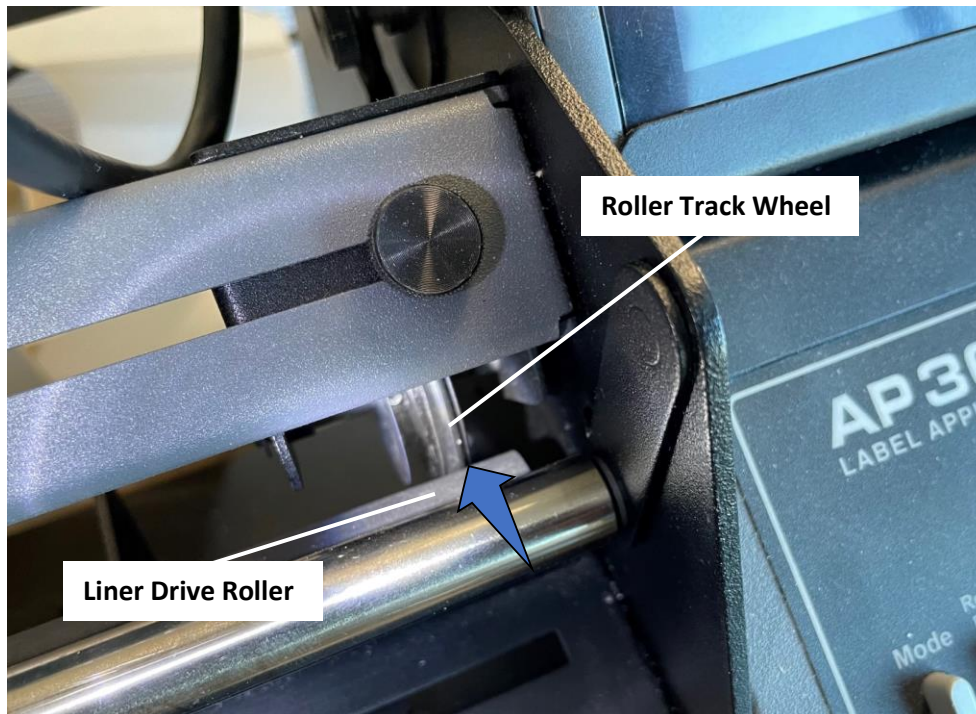




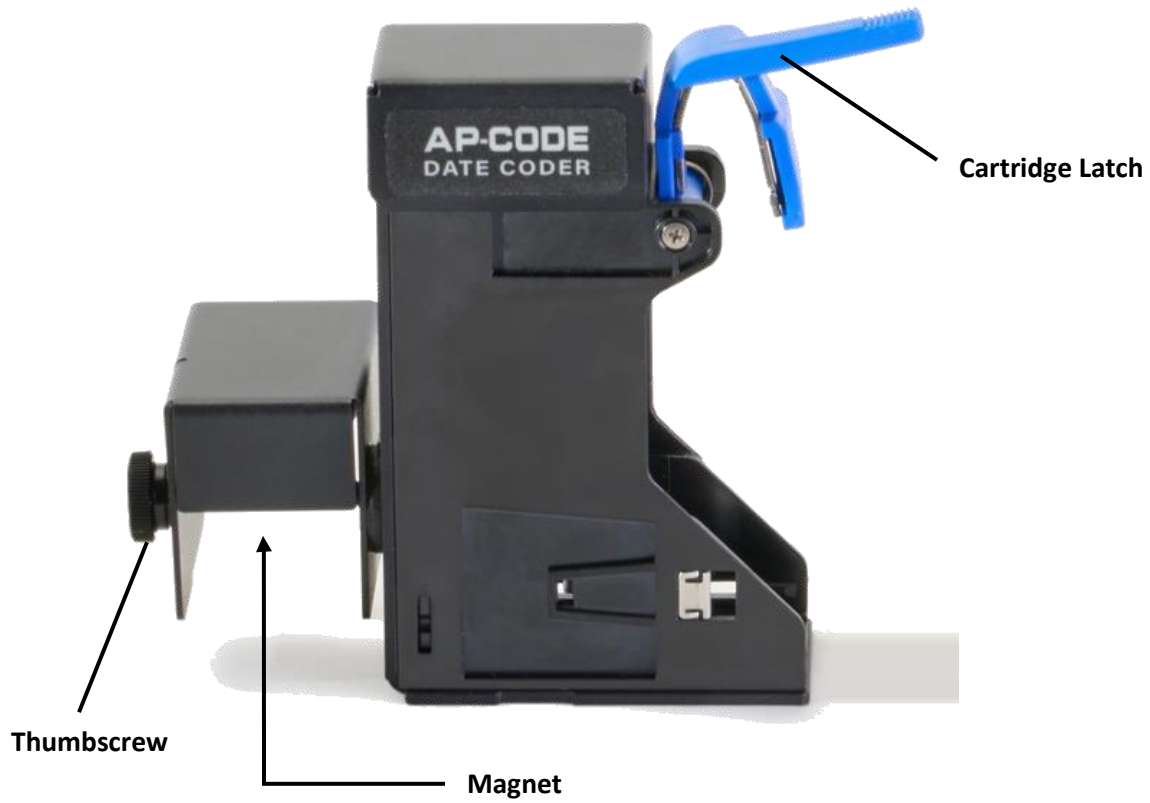
7. Push the track wheel to the right, insert the thumbscrew and tighten it.



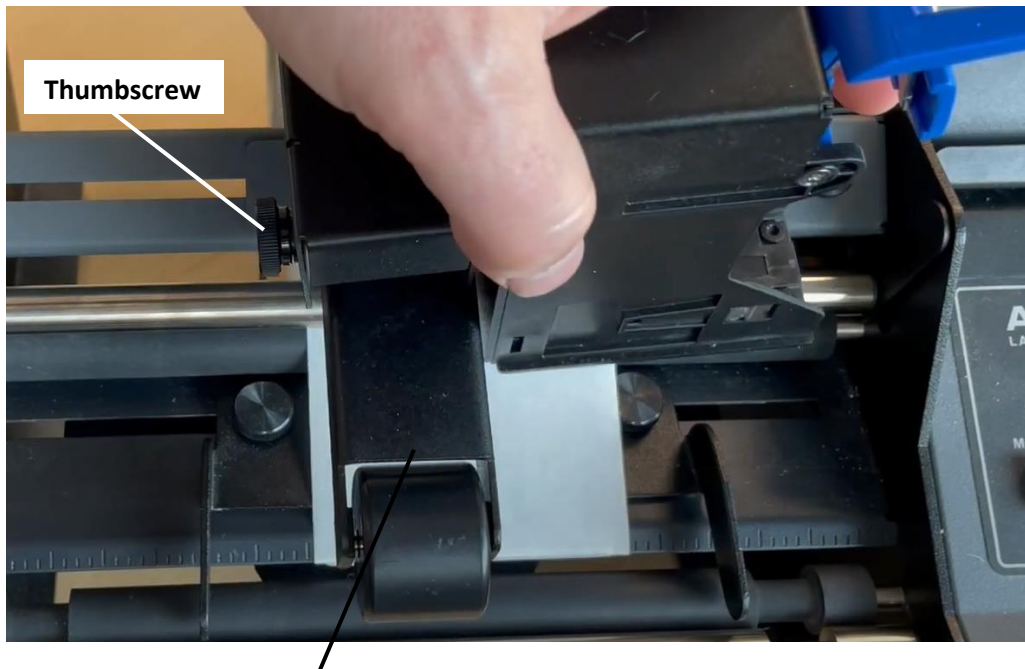
8. The roller track wheel **should be touching** the Liner Drive Roller. Watch [this video](#) to ensure it is installed properly!



9. Locate the Cartridge Carrier.

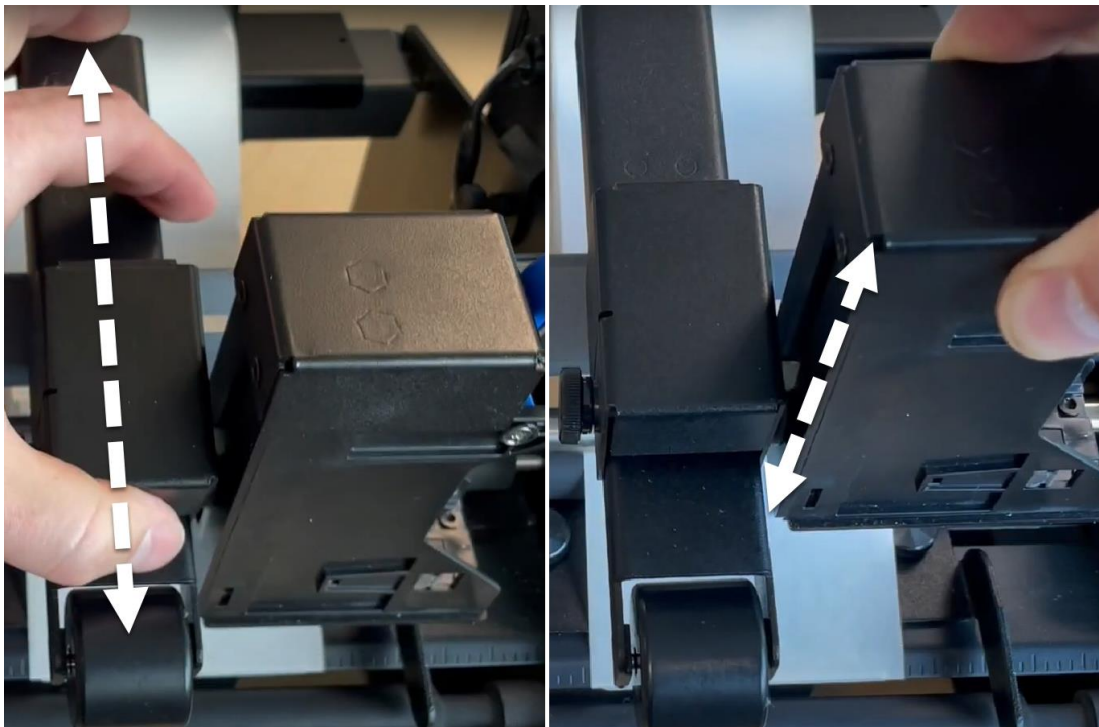


10. Place the Cartridge Carrier on the Roll Pressure Arm. Turn the magnet so it faces the arm. The magnet is all you need to attach the cartridge carrier.

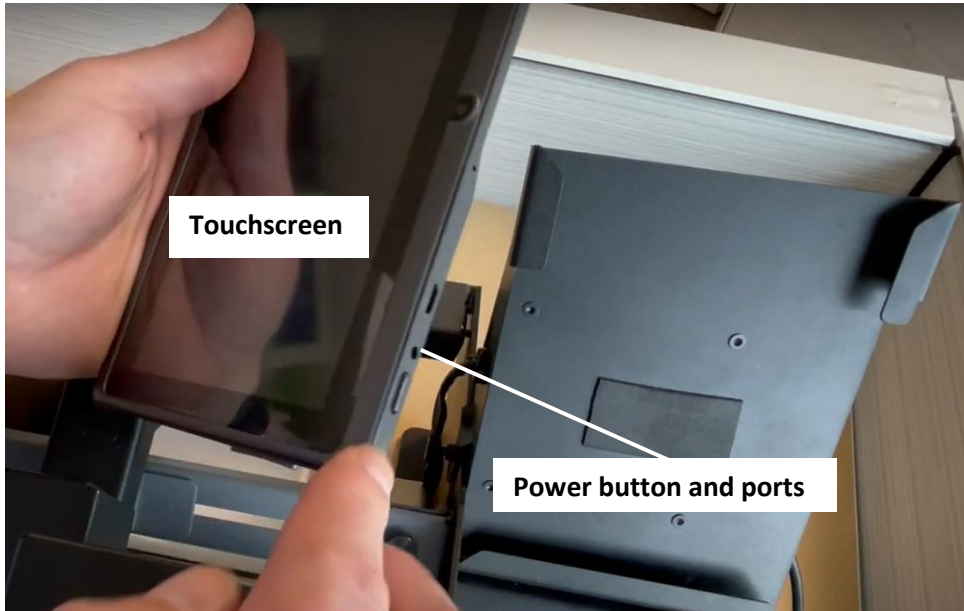


**Roll Pressure Arm**

11. The thumbscrew allows you to adjust the height and position of the print head along the Roll Pressure Arm. Once you have it where you want, tighten the thumbscrew.



12. Install the touchscreen display tablet. Orient the screen, so the power button and ports are on the right side.

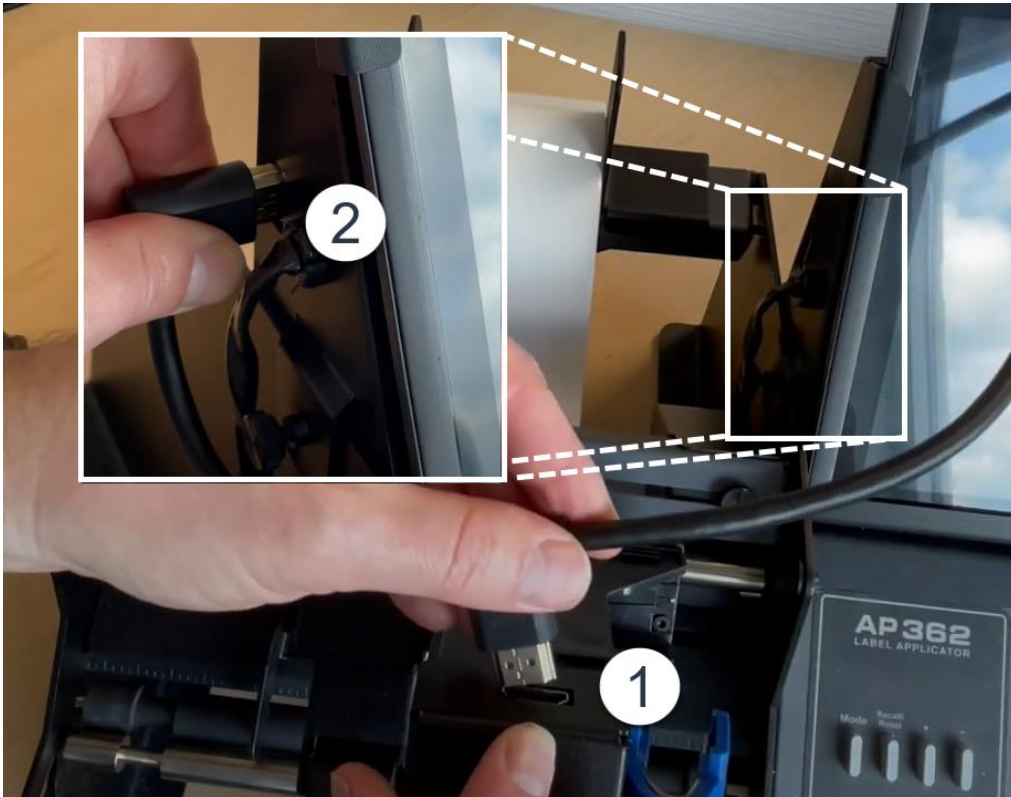


13. Slide the Touchscreen into place on the display stand.

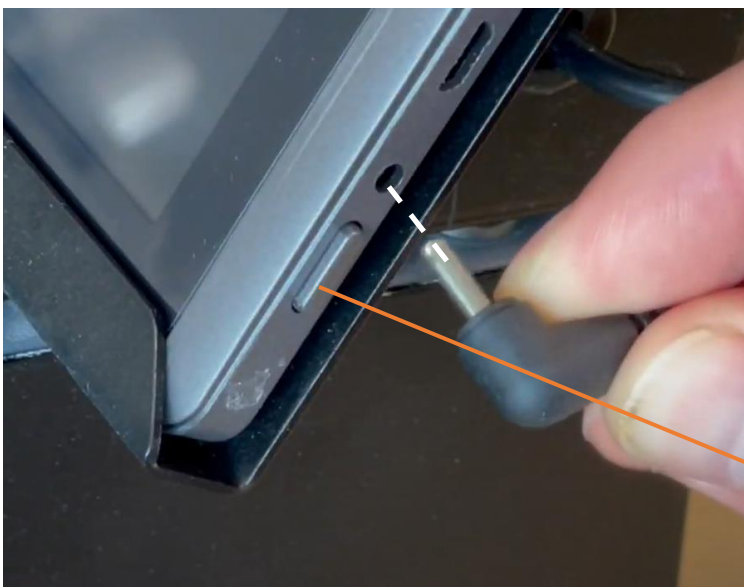




14. Connect the HDMI cable to the cartridge carrier (1) and the left side of the display stand (2).



15. Connect the power from the display stand to the Touchscreen



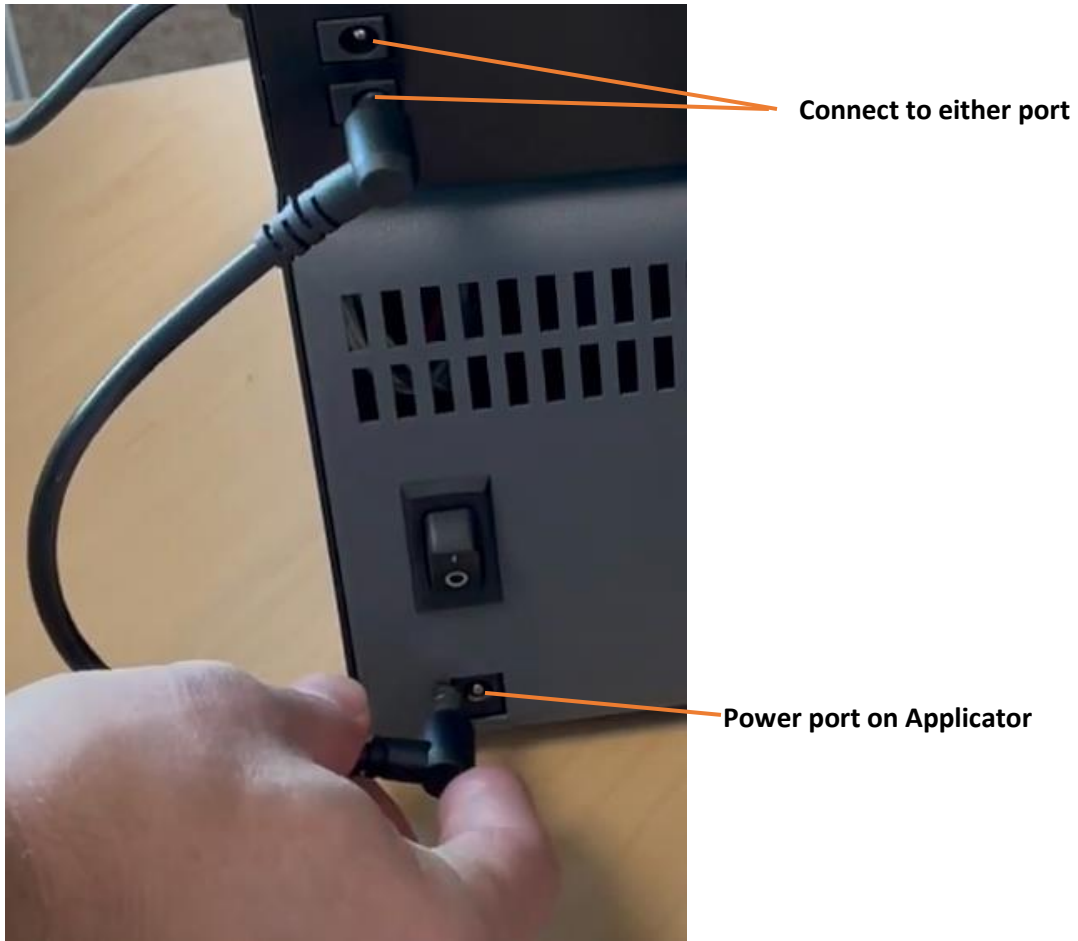
**Power Button (Hold to  
Power off display)**

16. Connect the micro-USB cable to the Touchscreen and the back of the display stand.





17. Connect the Power jumper cable to either of the ports on the back of the display stand. Connect the other side to the Applicator.



18. Use the power supply that came with your Applicator. Plug it into the remaining open port on the back of the Display Stand.



19. Connect the power supply to a power outlet and toggle the power switch.



## 1D Install/Remove the ink Cartridge

The AP-CODE comes with one solvent-based ink cartridge, which will last for thousands of prints. When you remove the cartridge for replacement or storage between uses, follow this procedure.

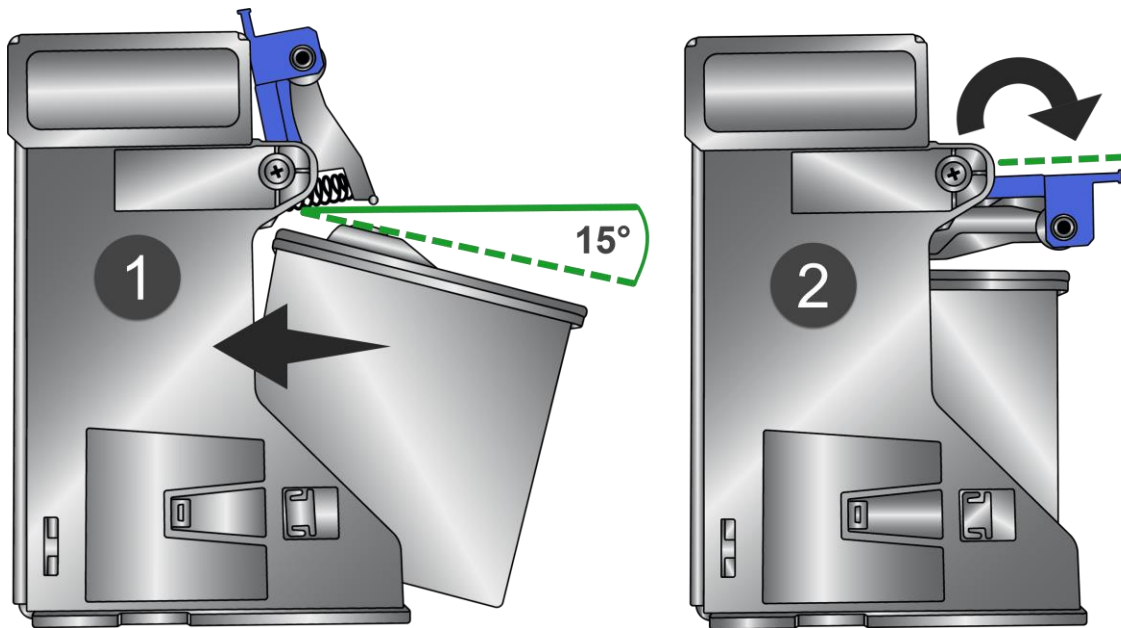
1. Remove the cartridge (SKU 074384) from its packaging.
2. Separate the cartridge from the cartridge cap.



3. **Keep the Cap And the bag to Store the Cartridge!**



4. Angle the cartridge slightly (15 degrees) as you insert it into or remove it from the carrier.



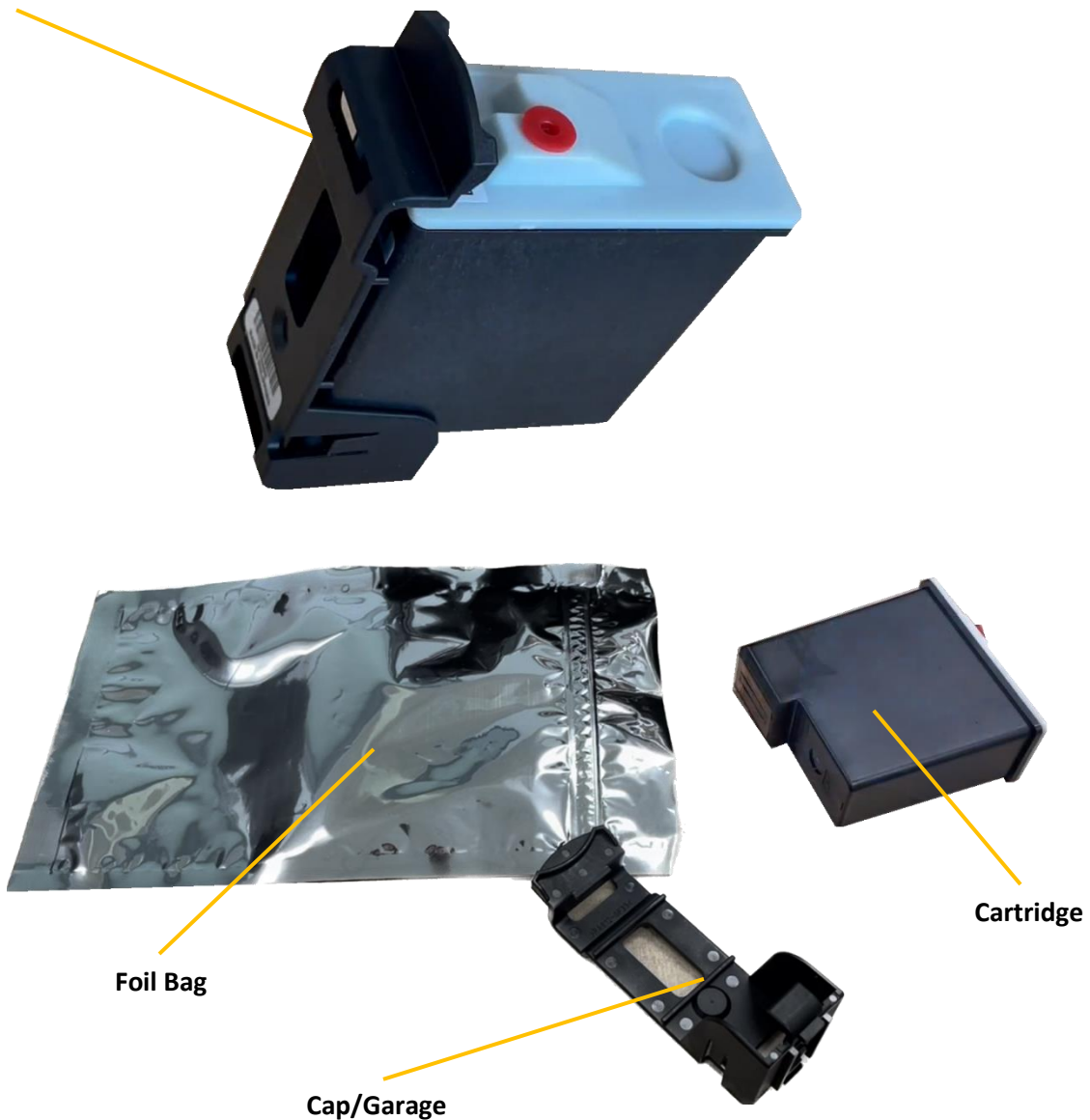
5. When the cartridge is fully seated, lower the blue lever to lock it into place.

## 1E. IMPORTANT: Cartridge Storage

If the cartridge will not be used for several weeks, to prevent ink evaporation, when the cartridges is not being used, you should remove it from the printer, cap it using the included cartridge garage and store it in the bag that it came with.

Follow the instructions in this [Article/Video](#).

**Cartridge Garage**

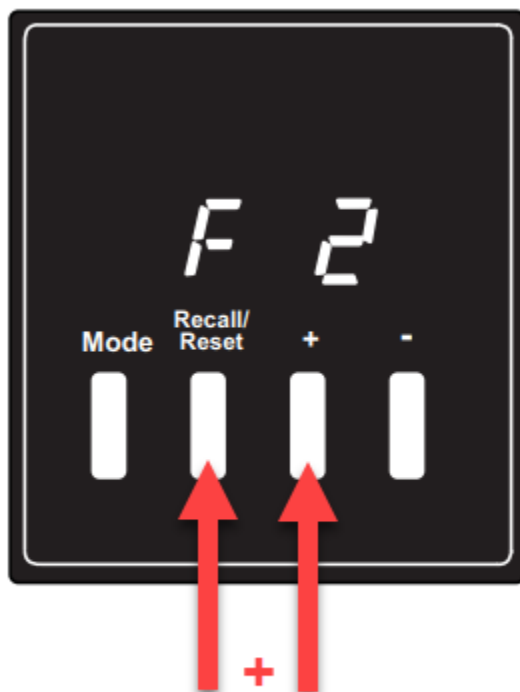


## 1F. Set your applicator to Run After Apply Mode

This mode causes the container rollers to continue to spin after every application, allowing the print to complete successfully, especially if you have set up a text offset/time delay on your AP-Code. This is the default mode of the AP362/AP380 applicator and should automatically be enabled if you just purchased it. If you have the AP360, the applicator can only be set to Run After Apply Mode.

### Instructions for AP362:

1. Turn off the applicator.
2. Press and hold the **Recall** button with the '+' key and turn on the applicator.



**Press and hold these  
buttons at power up**

**Note:** The applicator can be in stop after apply mode if the **text offset is zero** and the label length is longer than the width of the code printed. Since the container will continue to spin while the label is being applied, a label longer than the printed code will ensure the code printing is not interrupted.



### Instructions for AP380:

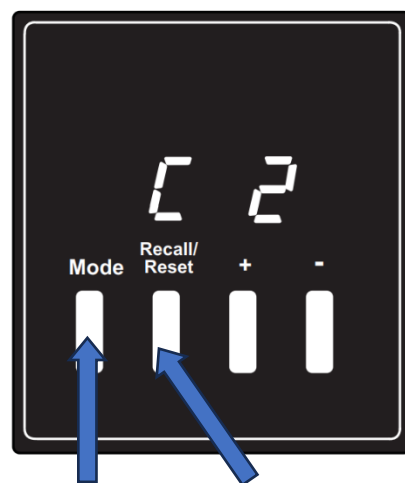
If you have the AP380 you can adjust the distance the containers rollers will continue spinning after an application.

Press the “Mode” button twice to display the current container roller mode (designated by C on the display). Use the “Recall/Reset” button to select a number (0-9). After selecting the desired container folder mode and waiting 8 seconds, the unit will store the mode and setting, and the display will revert back to Label Counter Mode.

**Immediate Stop Mode:** C 0 displayed. This mode stops the container immediately after the label application.

**Delayed Stop Mode:** C 1–8 displayed. Use this mode to print on the label or container using the AP-Code. Rotation after application is usually required to locate printing where desired.

The number displayed indicates the rotation distance after label application (after the second label in Double-Label Mode). Each unit equals 4.3 inches [10.9 cm]. For example: After the entire label is applied, C 2 rotates the container roller 8.6 in. [21.8 cm] before stopping.



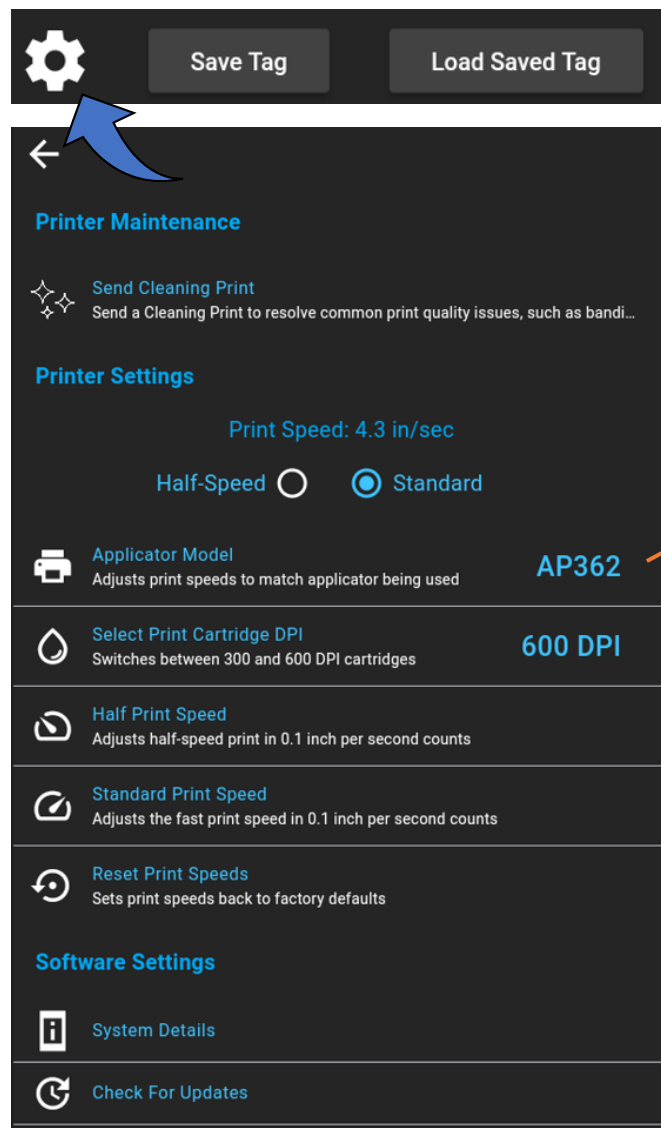
Press 2x to  
Enter this mode

Press to add  
rotation distance  
after application

## 1G. Choose your Applicator Model in Settings

Depending on your applicator model, the motors run at slightly different speeds. This will affect the length of the print. If you choose the wrong model, the print will appear stretched or squished.

Touch the gear icon to access system settings.



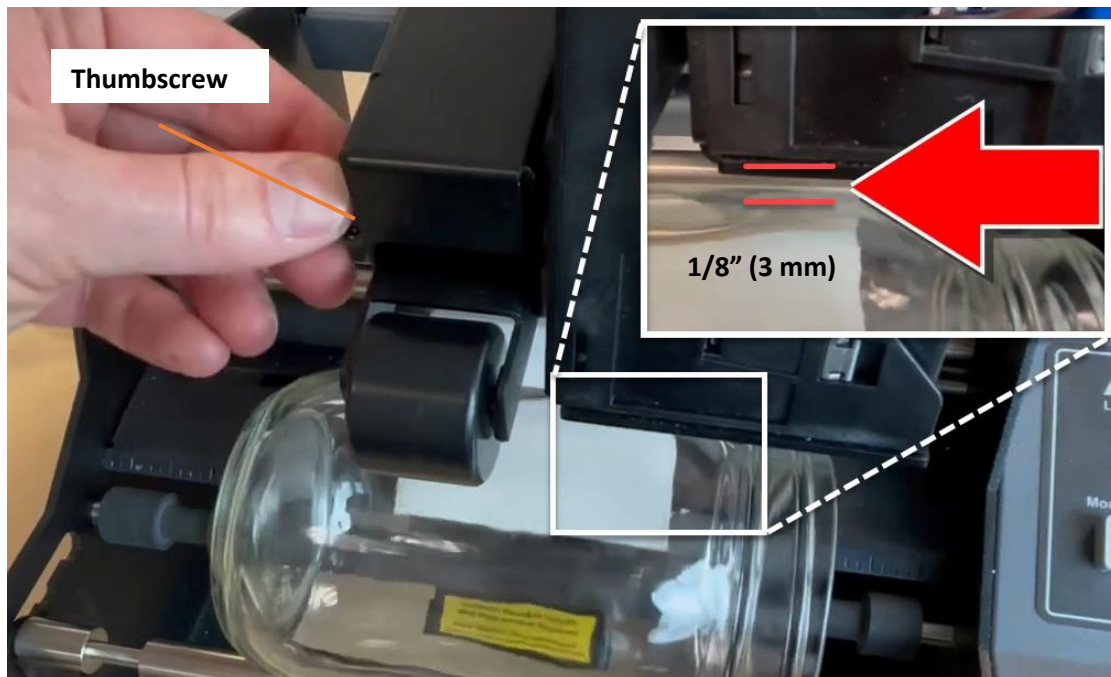
### Set Applicator Model.

**Note:** Choose AP362 for older models of AP360s. Choose AP380 for newer models of AP360. Or try both to determine which looks better. AP360s changed speeds in models after mid-2024.

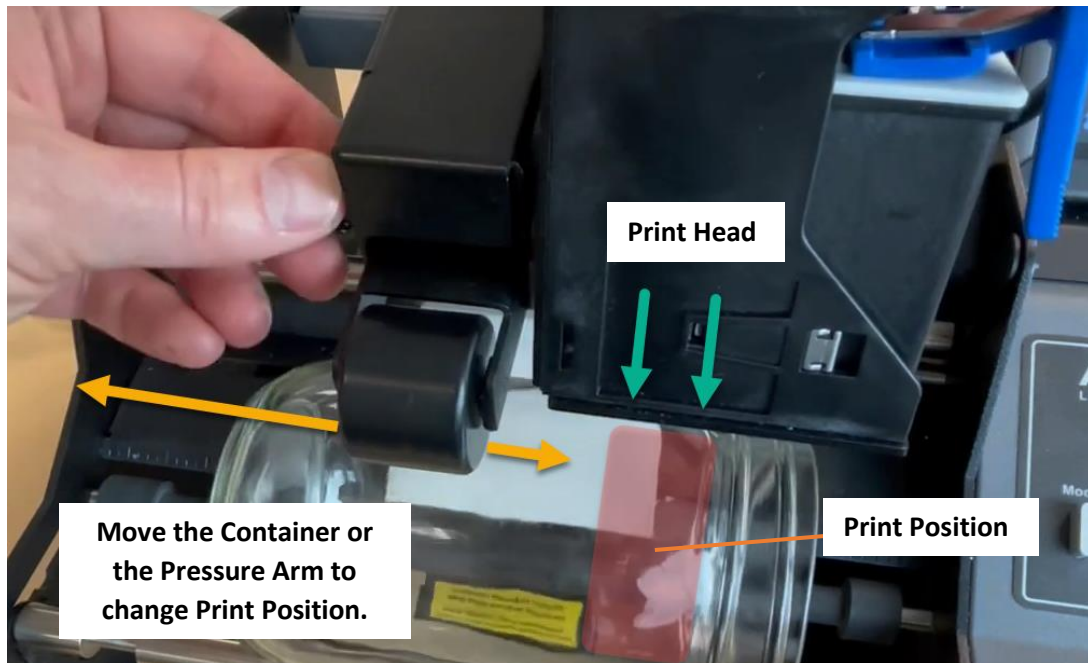
## Section 2 How to use AP-CODE

### 2A Tutorial: Create a Tag

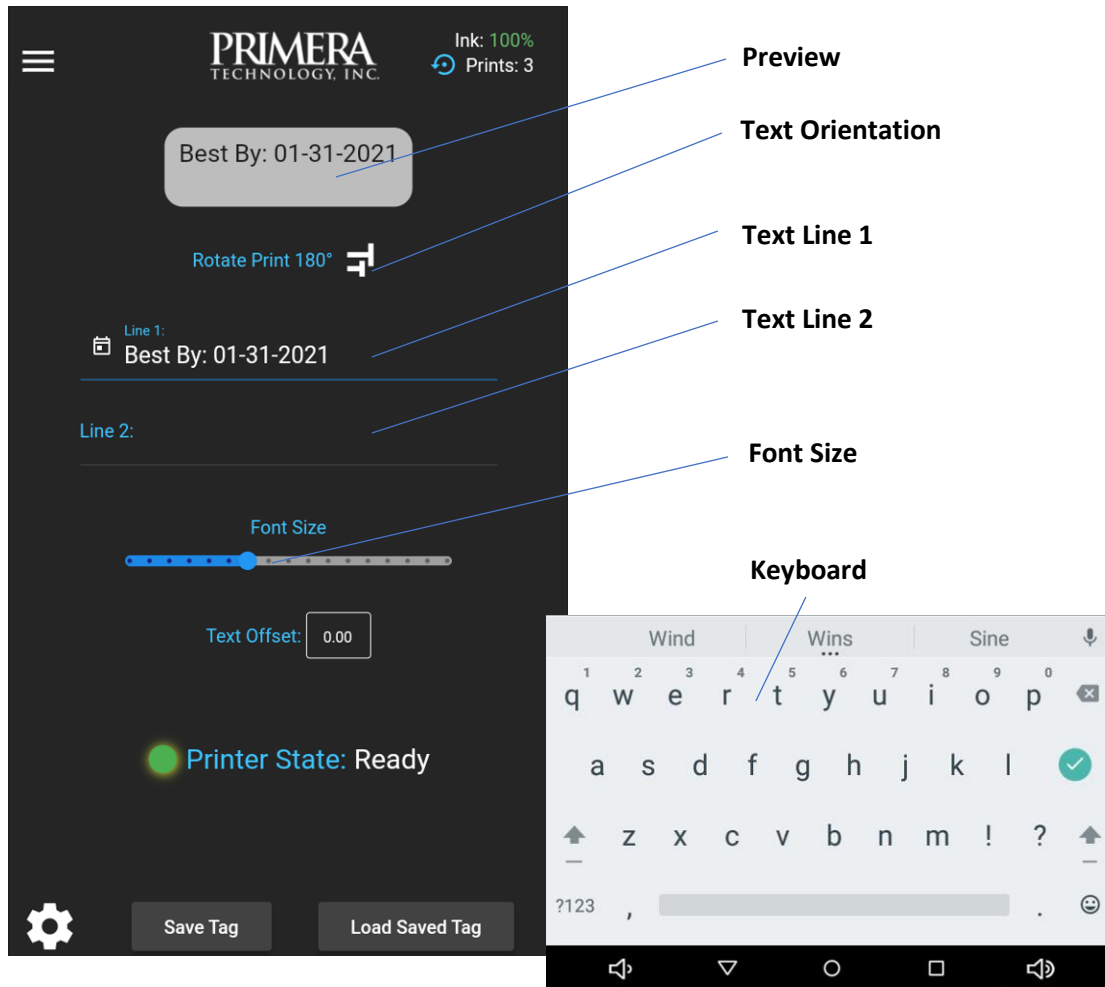
1. Install your label roll and thread it through the Applicator as you normally would. Refer to the applicator [setup video](#).
2. Ensure the container pressure arm is contacting the container with pressure. Usually, you will need to remove the container first, lower the container pressure arm  $\frac{1}{2}$ " and press the container in place. The pressure arm is spring-loaded. This allows the spring pressure to engage your container.
3. Once your container has been installed, use the thumbscrew to adjust the print head's position. There should be approximately  $\frac{1}{8}$ " (3mm) between the container and the printhead.



4. Move the container left to right, or the Pressure Arm left to right to adjust the print position. You may need to change the orientation of your container to achieve some print positions. In the example above, to print on the bottom of the container, we would need to flip the container so the top of the container is on the left.

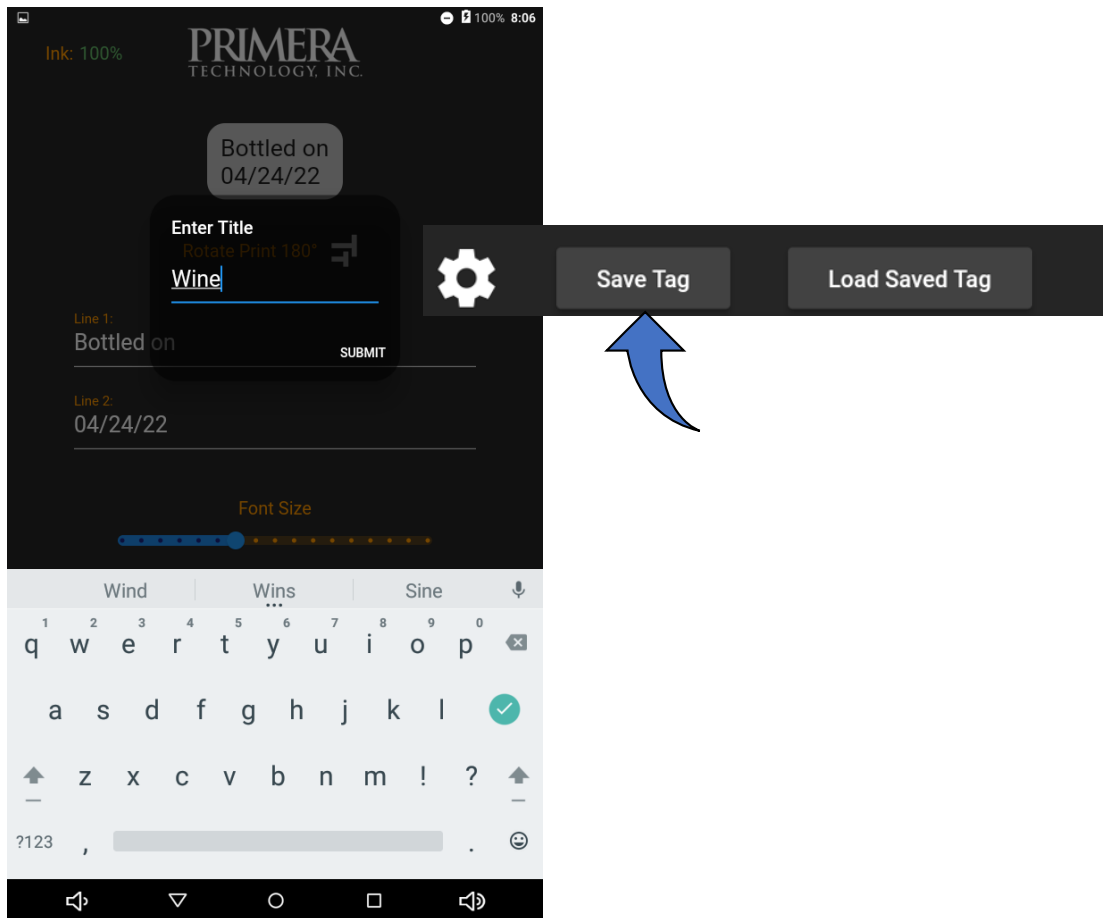


- Once the container is in the correct position, you are ready to create the tag. Touch Line 1 on the display. When you touch the screen, a keyboard will appear. Type the contents of your tag. In this case, type "Best By". Repeat the process for Line 2. Type the Best by date "12/03/23". Line 2 is optional.



- You may also adjust text orientation by touching the Tt icon or adjust font size by grabbing the slider and dragging. If the font is too large, you can only print one line of text.

7. Touch Save Tag to save the text and attributes for future use.

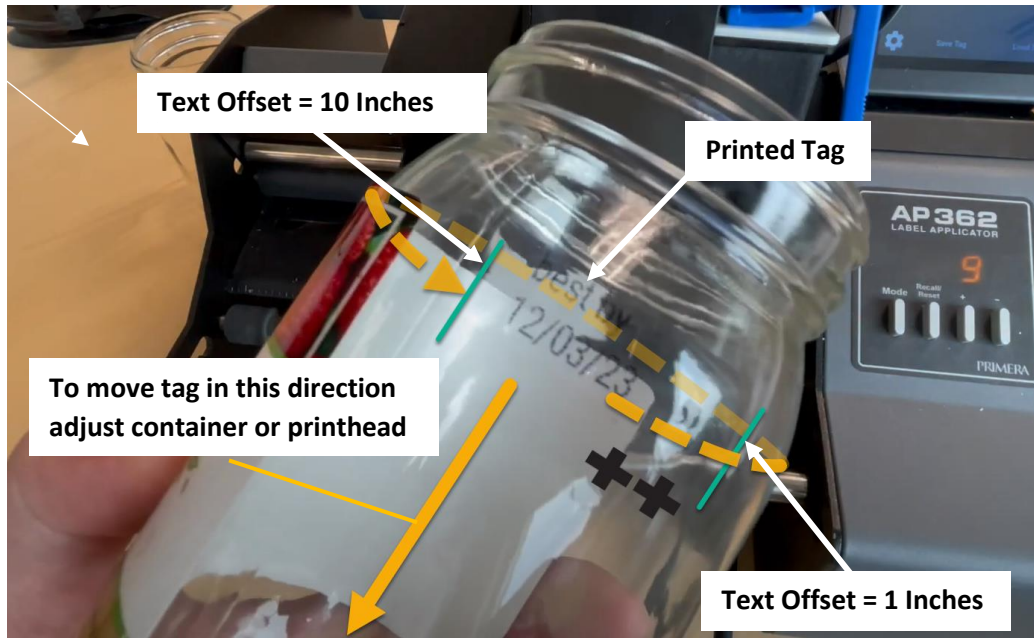


8. We are now ready to apply a label and print our tag. Load a container and press the foot pedal.





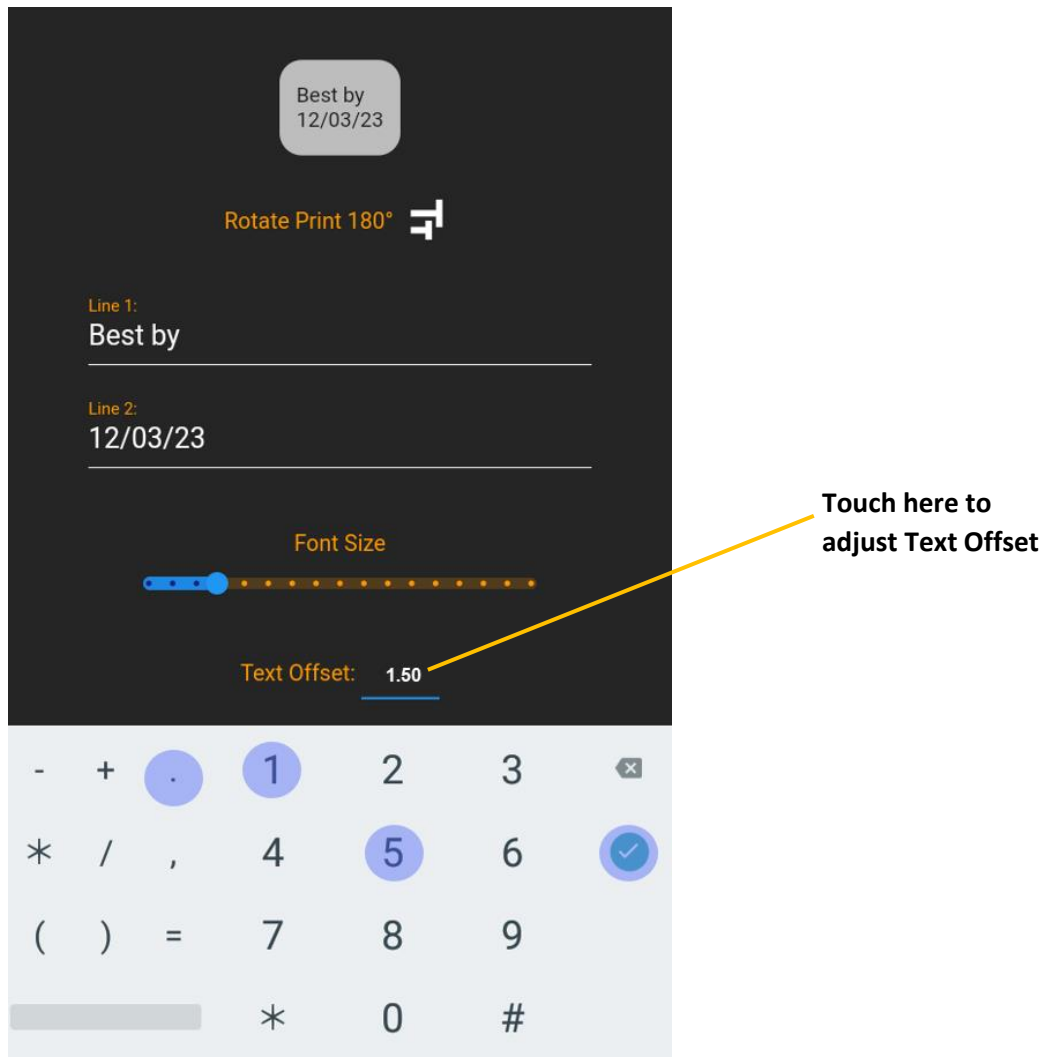
9. The first time you apply a label and print, you will probably need to adjust the position text offset. Text offset adjusts the tag position around the circumference of the container. You can only move the tag in one direction. For example, to move the tag slightly to the right, you increase the text offset just a little. If you want to move it to the left, you would increase the offset by a lot so that the text would move almost all the way around the container!



10. In this case, we would like to move the tag to the right, so it is directly on the back of the container relative to the position of the label. Use a paper roller or flexible tailor ruler to measure how far to move the tag.



11. Press "Text Offset" on the touch screen to enter the amount you want to move the tag. The maximum offset is 17".



12. Now, apply the label and print again. It's perfect!



## 2B Print Quality Tips / Acceptable Print Surfaces

For best print quality results follow these guidelines:

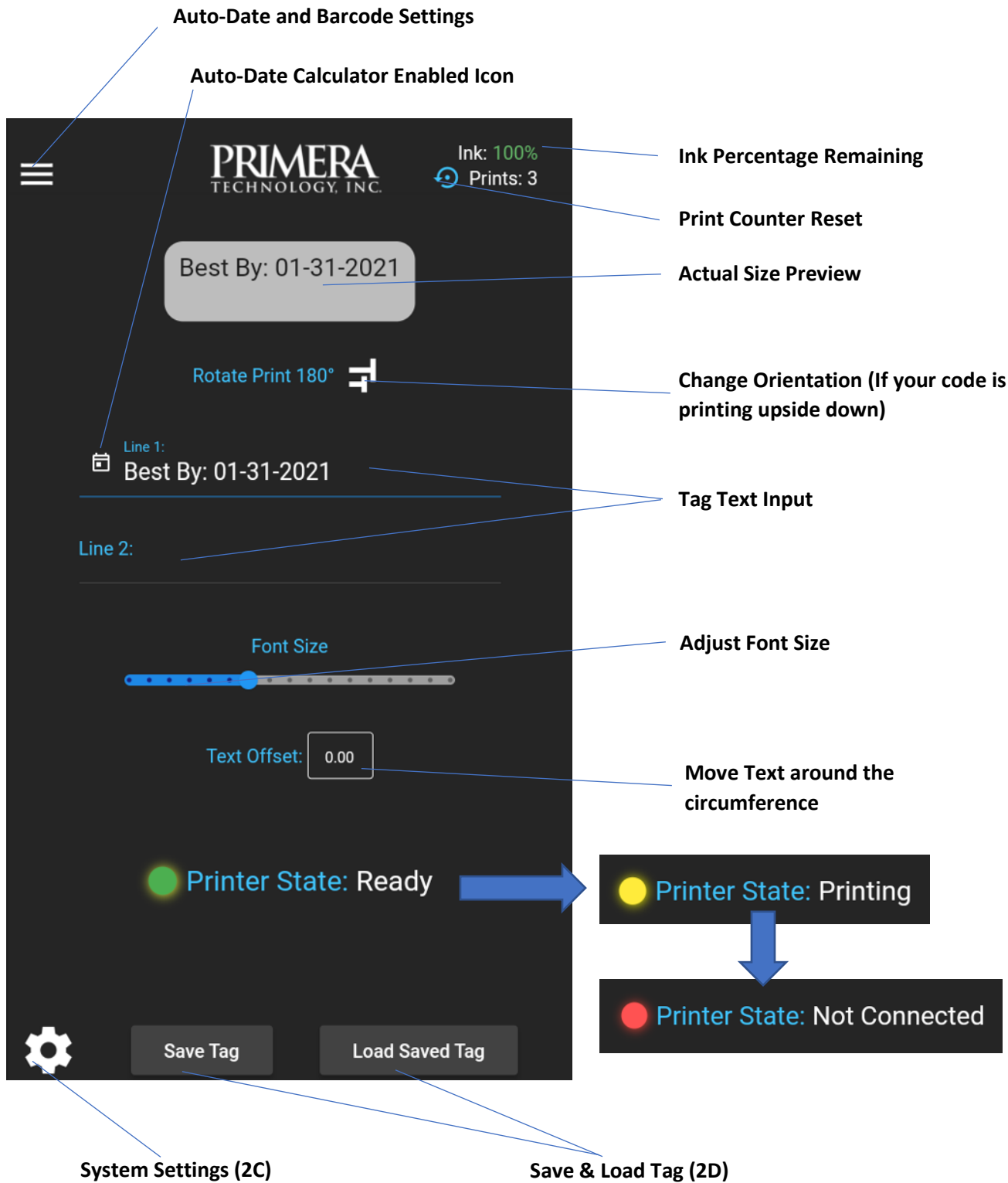
1. **Containers should be completely dry and at room temperature.** If you print on cold containers, they may condense, creating a thin layer of water on the surface. While it is possible to print on this, the quality will not be as good, and it will take longer to dry. The ink will be susceptible to smearing until the container is completely dry.
2. **Wait at least 30 seconds** after printing to touch the printed information. The ink will cure in this time.
3. **Minimize container rotation** after printing is complete. If the container continues to spin after printing, the rollers can contact the still-wet ink and cause it to smear. See section 2F to adjust the container roller behavior.
4. **Clean your cartridge before use.** If you see lines through your print you may need to lightly clean your cartridge to clear any clogged nozzles. See section 3A.
5. **Print on the label when possible.** The ink will usually dry faster and look better if it is printed on the label instead of the container.

### Acceptable Print Surfaces

You may print on the following surfaces.

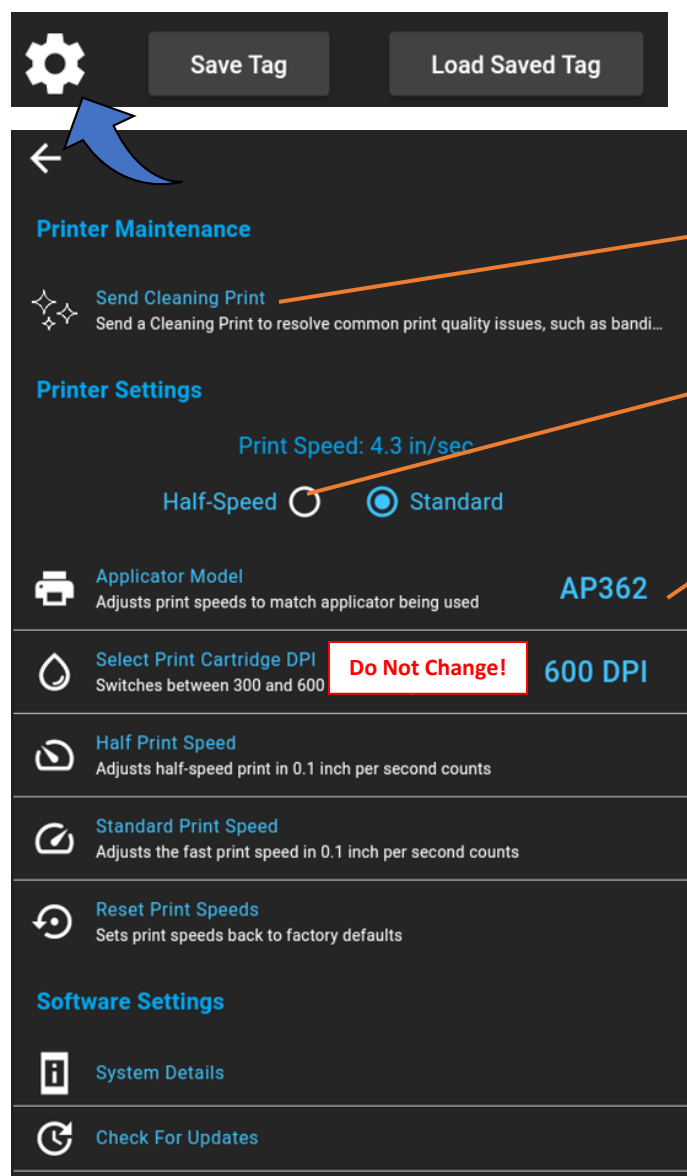
- Polyester, BOPP, Vinyl or Paper Labels
- Glass
- Plastic
- Metal

2C Touch Screen Overview



## 2D System Settings

Touch the gear icon to access system settings.



Send a Cleaning Print to fix printing problems or as a test print.

If you use half-speed/high-torque mode on your applicator enable this setting.

**Print Speed:** Match the Print Speed to the container speed setting set on the Applicator. The AP360/362 includes a half-speed mode that generates more power from the motors for wider label stock. To activate this mode, hold down the Foot Switch while switching on the unit. The AP362 will remain in this mode until it is deactivated.

To deactivate this mode, hold down the Foot Switch again while switching on the unit.

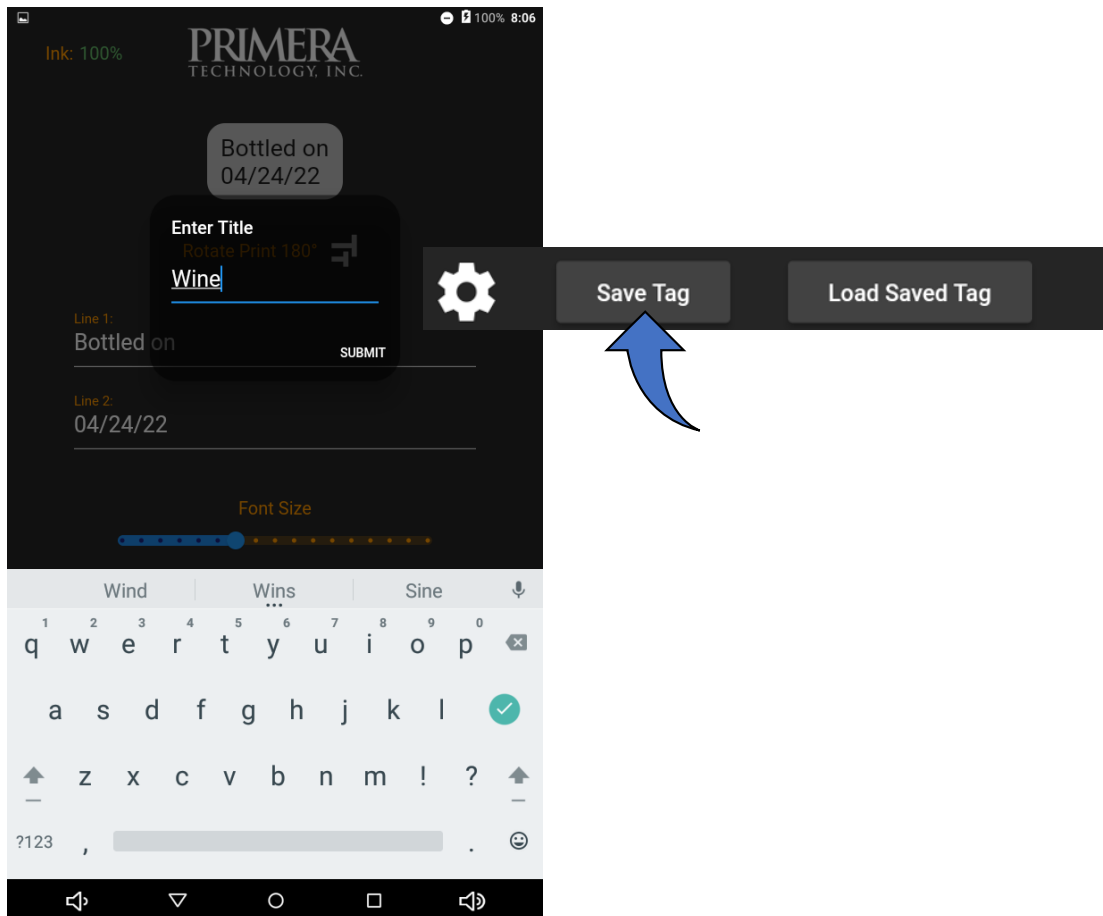
Fine tune the default print speed in Half-Speed and Standard mode. Adjust this if letters look squished or stretched horizontally.

**Note on Clean Test Print:** Send this prints with a container in place and rolling. Prints are sent to the printhead immediately, but they are only intelligible if the container is in place and rolling.

## 2E Save and Load Tags

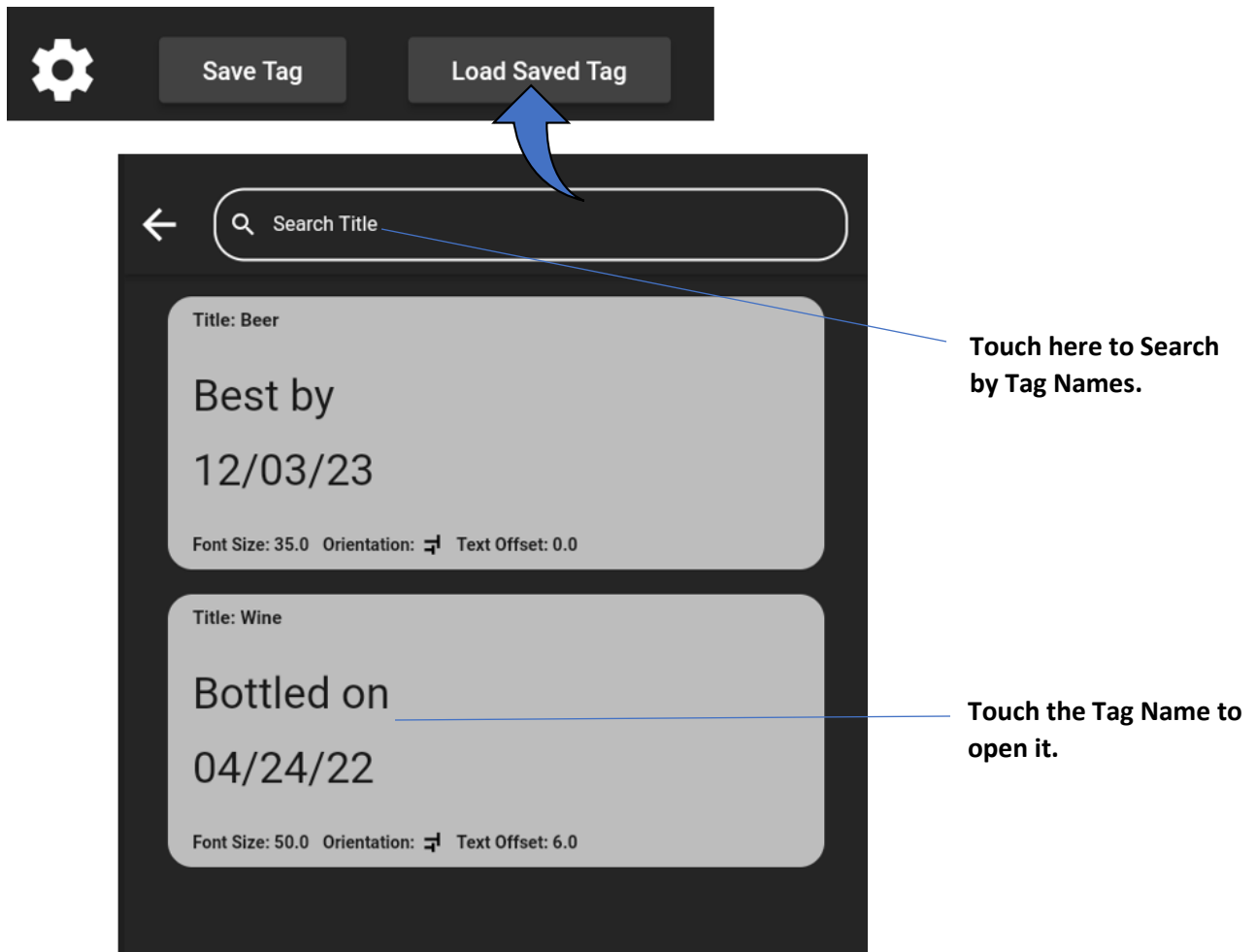
If you have several different containers with unique text and setting configurations, you can Save tags and load them again for future use. The text, font size, Orientation, and Text Offset will be saved along with the name you choose for the tag.

1. Touch Save Tag to save the text and attributes for future use.





2. To load the tag, press the Load Saved Tag button on the main screen.



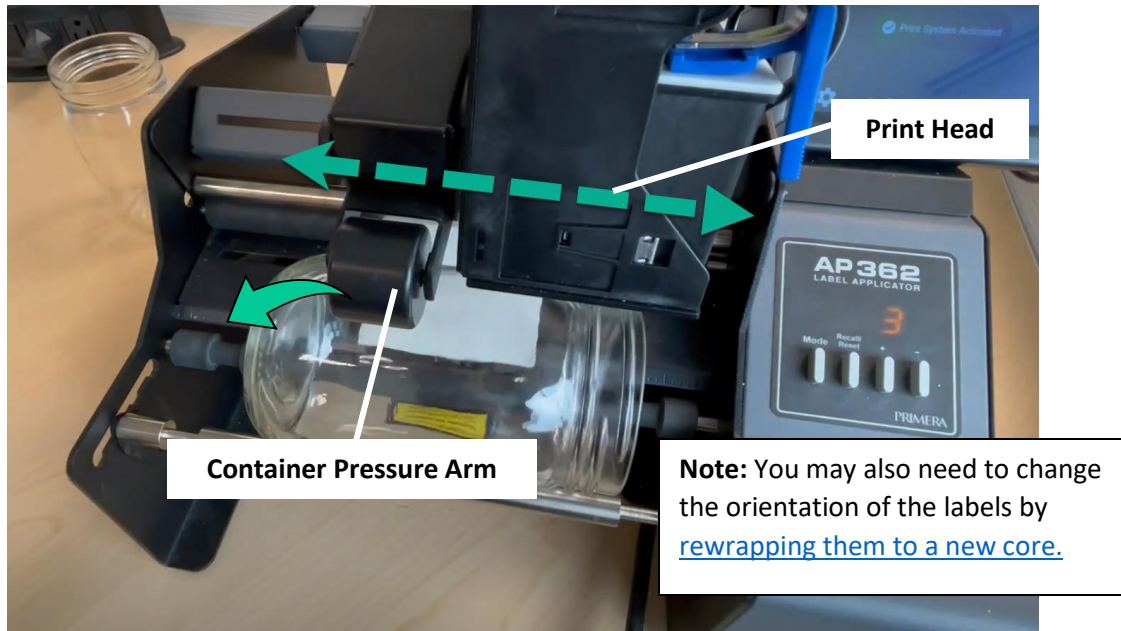
## 2F Adjusting Print Position

There are three ways to adjust print position of the tag.

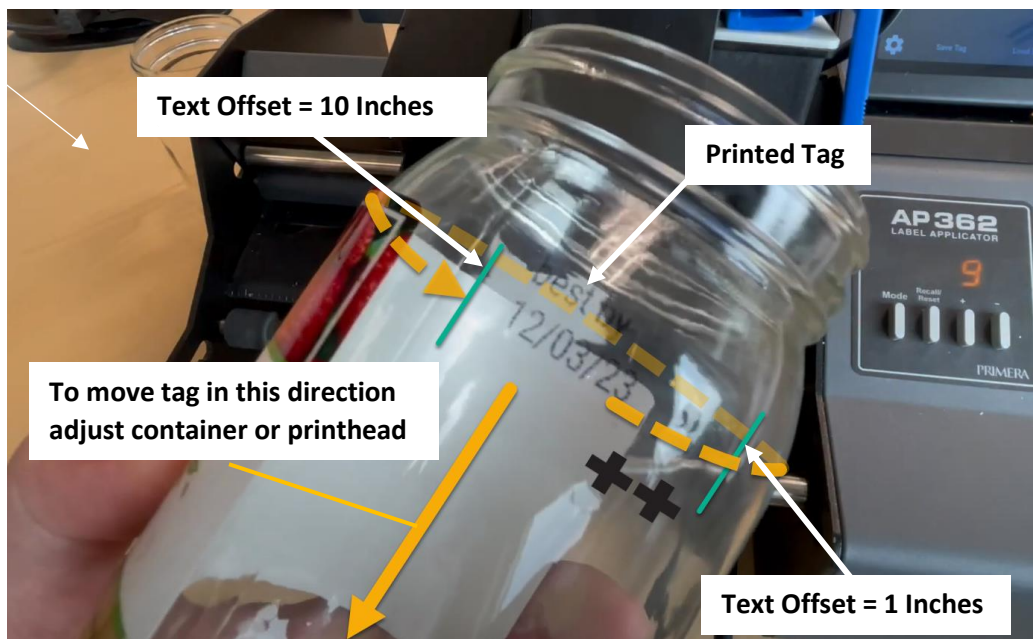
1. **Adjust the Container Position.** You can move the container left or right on the container rollers. You can also flip the orientation of the container. In the example below, in order to print on the bottom, the container would need to be in the opposite orientation.



2. **Adjust the Print Head Position.** You can adjust the print head position by moving the container pressure arm left or right. You have a limited range to move this if you would still like to use the container pressure arm to keep pressure on the container for optimal label application. If you move it too far to the left, the arm will no longer contact the container. In this case, it may be better to change the container's orientation (see #1).



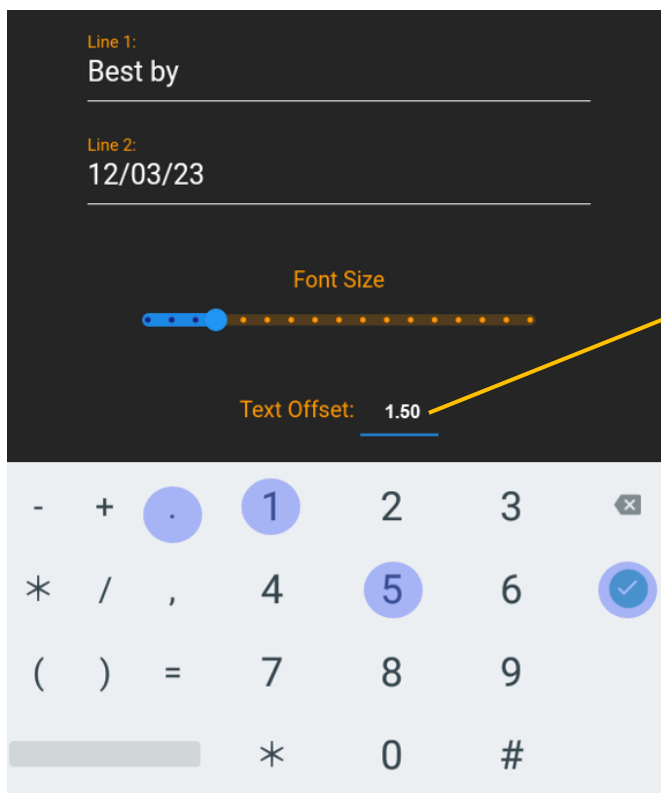
3. **Adjust the Text Offset to change where the tag prints around the circumference.** You can only move the tag in one direction. For example: to move the tag slightly to the right, you increase the text offset just a little.



In this case, we would like to move the tag to the right, so it is directly on the back of the container relative to the position of the label. Use a paper roller or flexible tailor ruler to measure how far to move the tag.

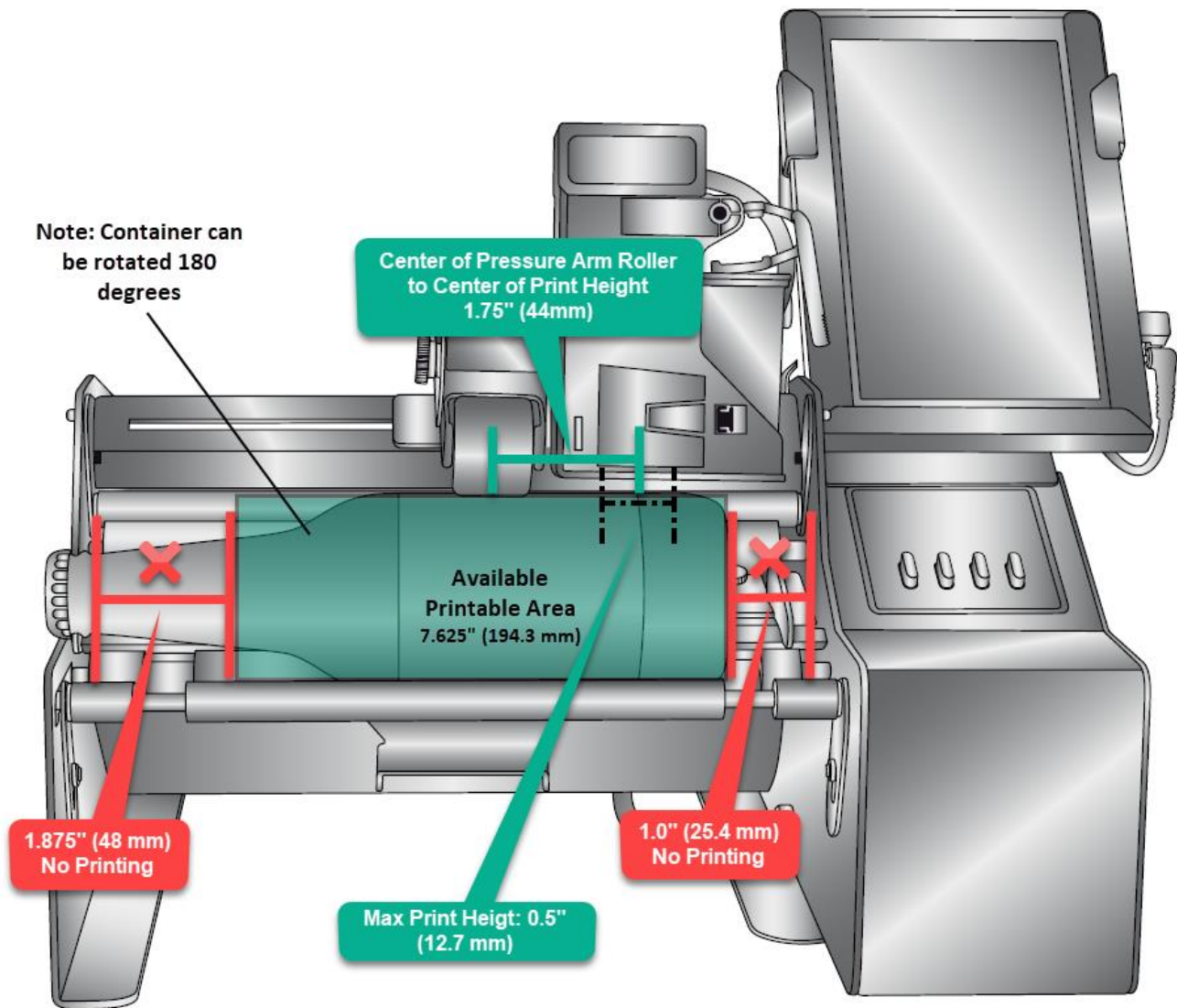


13. Press "Text Offset" on the touch screen to enter the amount you would like to move the tag. The maximum offset is 17".



Touch here to  
adjust Text Offset

## 2G Print Position Specifications

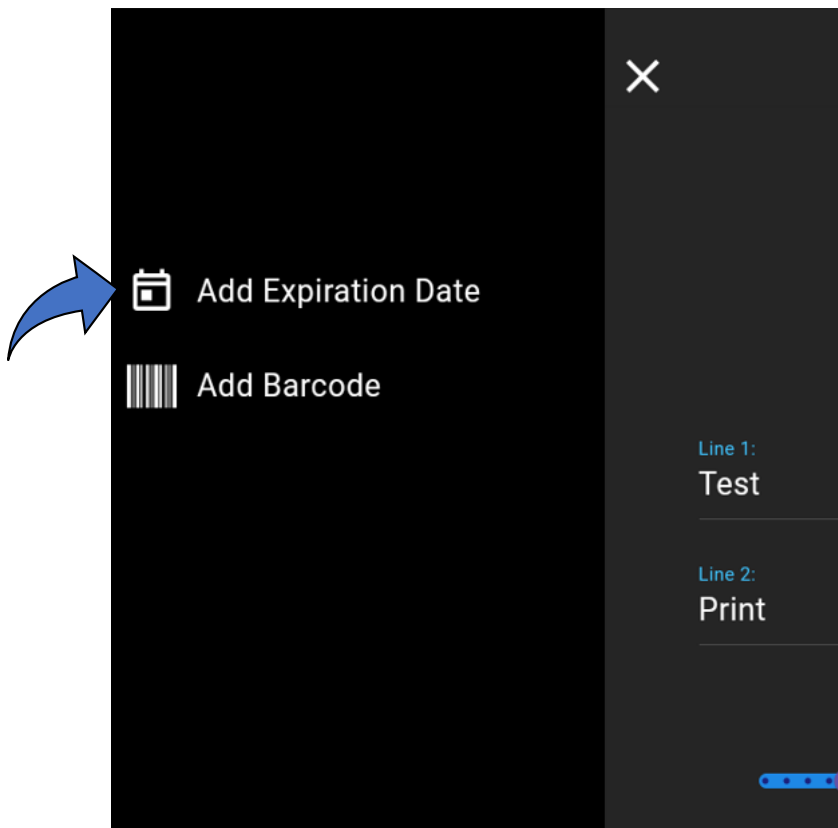




## 2H Create Automated Expiration Dates

If your product has an expiration, best-by date, or manufacture date you would like printed on your container, you can use this feature to automate the process by adding a date offset from the current date, so you don't always have to change the expiration date every time you apply labels and add tags.

1. To enable this feature, press the menu icon in the upper left corner of the screen.



2. First, you will need to set the Current Date. This will be stored in the system as long as power is connected to the date coder. If power is removed, you will be prompted to enter the date again if you choose a tag that contains an auto-calculated date. **Note:** You can switch off the applicator without disconnecting power to the Date Coder.

**Configure Expiration Date**

Current Date: No Date Set

Line: Line 1 ▾

Header: None ▾

Format: MM-dd-yyyy ▾

Offset: Days ▾

**CANCEL** **CREATE**

(II) Print System Paused

3. Set the line you would like the automated date to appear.

**Configure Expiration Date**

Current Date: December 12, 2022

Line: Line 1 ▾

Header: Expires On: ▾

Format: MM-dd-yyyy ▾

Offset: Months ▾

**CANCEL** **CREATE**

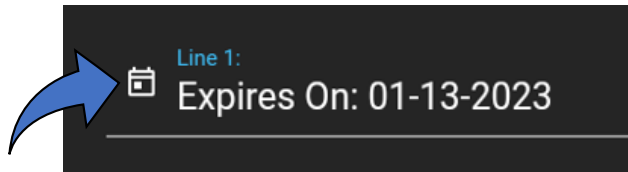
(II) Print System Paused

Offset: Days ▾

**Note:** To print the current date, set the Offset to zero Days.

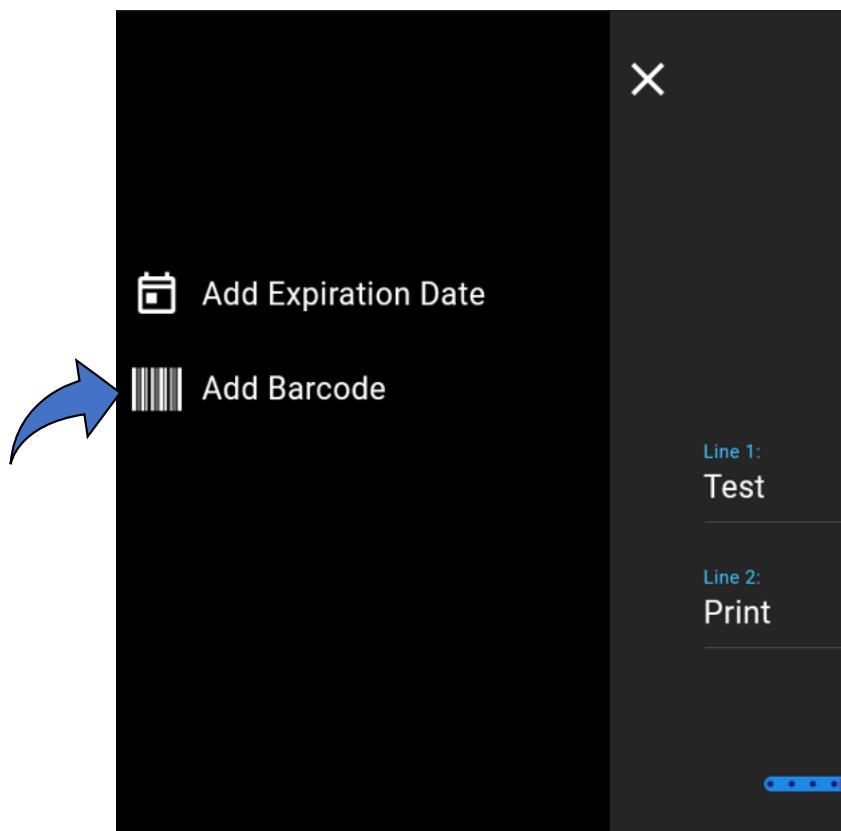


4. Choose the header from several premade options, or choose your own by selecting "Custom."
5. Set the date format.
6. Finally, set the offset, which is the number of days, months, weeks, or years from the current date you set previously. This will be the date that appears on the tag. **For example:** if the current date is 12-9-22 and you set the offset for three months, the date that appears on the tag will be 3-9-23.
7. Click Create.
8. If your tag has an automated date, you will see a calendar icon on the line with the automated date.



## 2I Adding Barcodes

1. You can print traditional (1D) and 2D barcodes. Press the menu button in the upper left corner to access barcode Settings.



2. Choose your Barcode data and type. A preview will appear below. You can place the barcode before (Prepend) or after (Append) you date code information.


**PRIMERA TECHNOLOGY, INC.** Ink: 100% Prints: 1360

## Configure Barcode

Barcode Type: Data Matrix ▾

Barcode Data:

Prepend ☐ Append ☒



**Description**

A Data Matrix is a two-dimensional barcode consisting of black and white 'cells' or modules arranged in either a square or rectangular pattern, also known as a matrix.

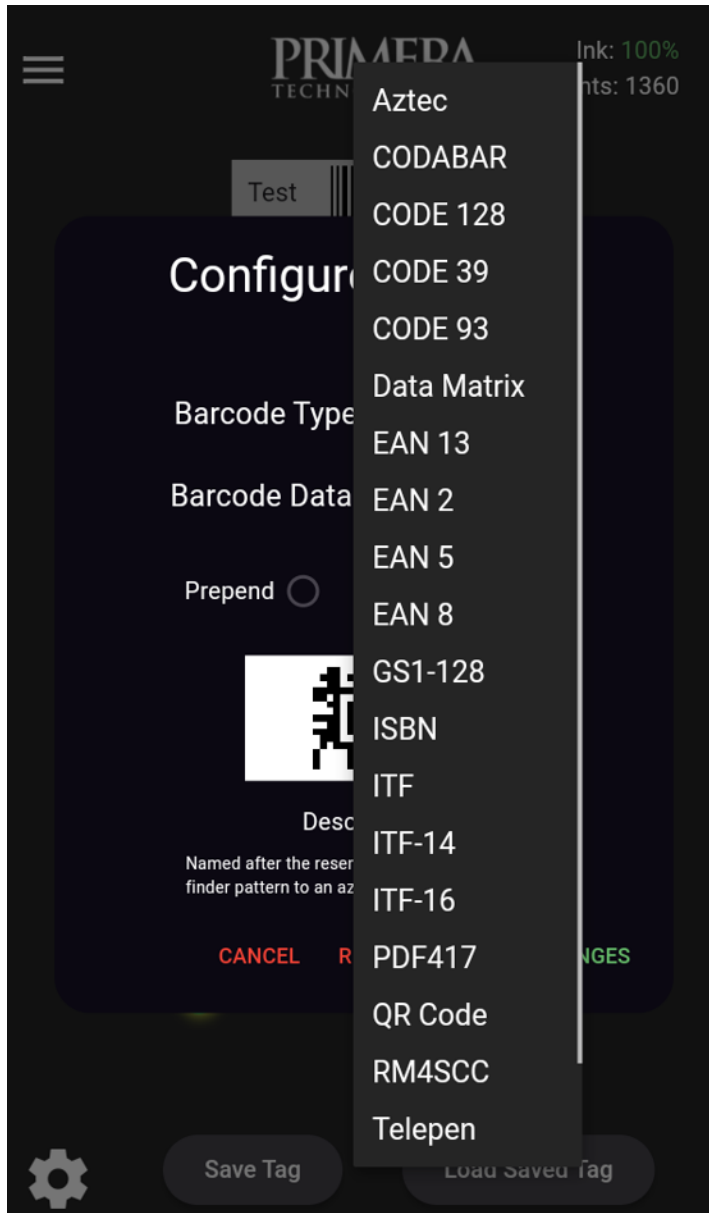
**CANCEL** **CREATE**

**Save Tag** **Load Saved Tag**

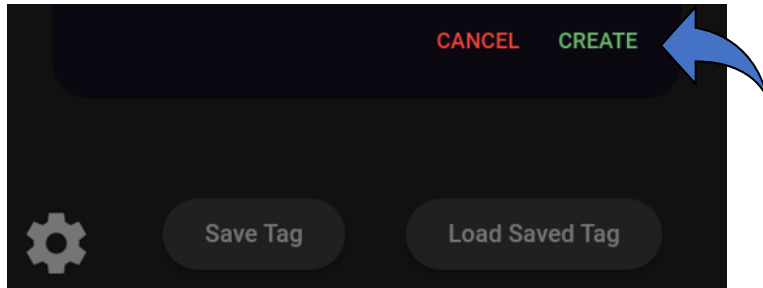
**Callouts:**

- Choose your barcode type
- Enter the data/text to be encoded in the barcode
- Choose to prepend or append the barcode to the date code
- Preview
- Press "Create" to save your barcode settings

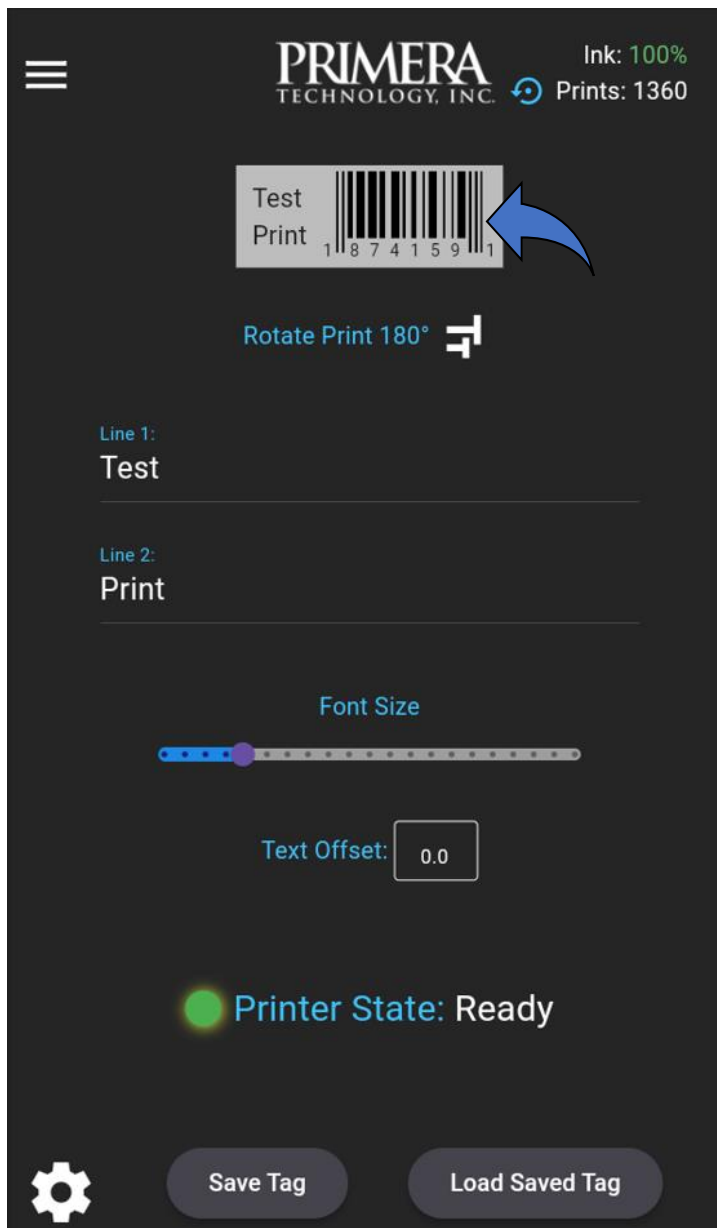
3. Many Barcode types are available.



4. Press CREATE to save your barcode and return to the main screen.



5. Your barcode preview will appear on the main screen as well.

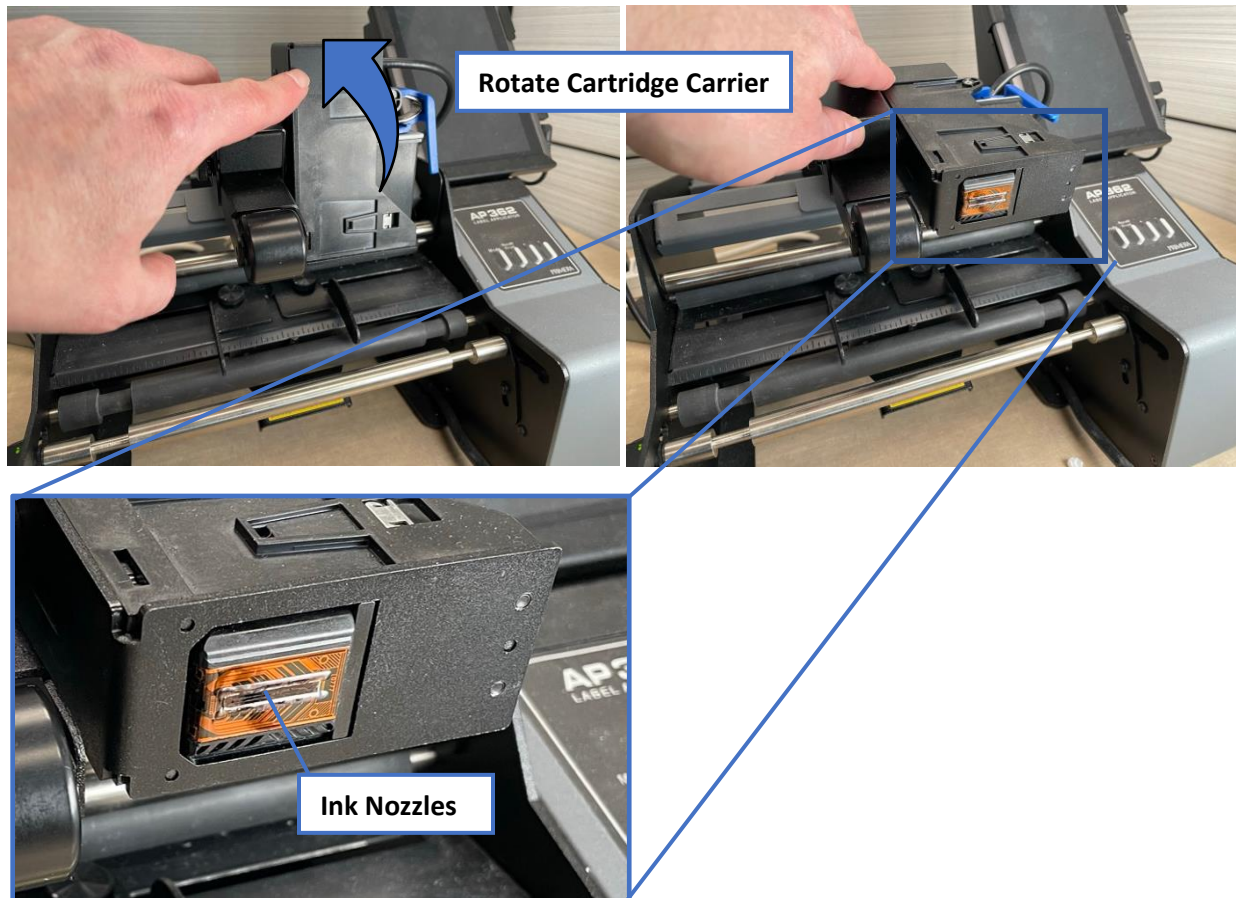


## Section 3: Maintenance and Troubleshooting

### 3A Cartridge Cleaning – Nothing is Printing

Check [this article](#) for all troubleshooting steps. However, If you have not used the AP-CODE Date Coder for some time you may need to clean the nozzles.

1. Do not remove the cartridge for this procedure. Instead, the entire cartridge carrier can be rotated sideways for cleaning.

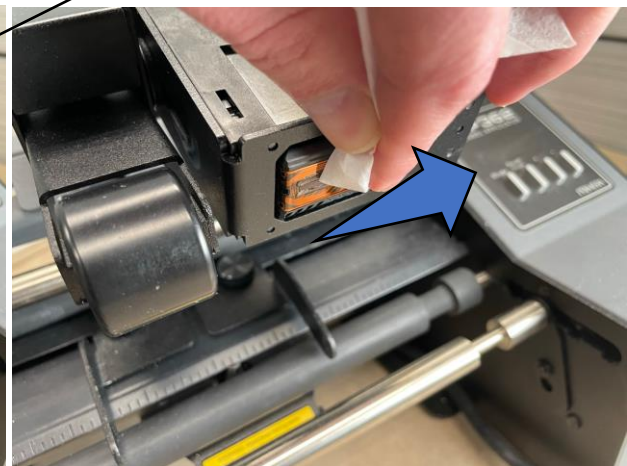


2. Use the provided alcohol pad/glasses wipe or fold up a lint-free cloth several times and wet it with isopropyl alcohol. The ink nozzles are in a single row centered on the bottom of the cartridge; they are recessed slightly, so take care to clean them and not just the surrounding area. Press them into the pad until ink flows out, then wipe away any excess ink using the alcohol pad.

**Note: If you don't have a alcohol pad you can use a dry tissue.**



**Alcohol Pad**



**Press and hold for 10 seconds.**

**Repeat until ink starts to flow.**



## 3B Tag Removal

If you accidentally print in a location you did not intend, you can remove the print entirely by using isopropyl alcohol to clean the print from the container. This works best on glass and plastic or metal.

## Section 4: Technical Support

If you have difficulties operating your Printer, contact technical support using one of the methods listed below.

| Source                 | Location   |
|------------------------|--|
| Primera Knowledge Base | <a href="http://www.primera.com/kb">www.primera.com/kb</a>   |
| Email Support          | <a href="http://www.primera.com/customer-support">www.primera.com/customer-support</a>   |
| Phone Support          | <b>763-475-6669</b> (Mon - Fri 7 a.m. - 10 p.m CST and Saturday 11 a.m. – 8 p.m.)  |
| Chat                   | <a href="http://www.primera.com">www.primera.com</a> – see chat icon in lower right corner (Mon - Fri 7 a.m. - 10 p.m CST and Saturday 12 noon – 9 p.m.) |

## Section 5: Technical Specifications

**Print Method:** Inkjet

**Print Resolution:** 600 dpi

**Ink:** Solvent Black

**Print Height:** 0.0625" - 0.5" (1.58mm – 12.7mm) 2D Barcode height is set at .5" (12.7 mm)

**Print Width/Length:** Up to 21" (Touch Screen Preview will only show up to 3.25")

**Font Size:** 6pt – 32 pt

**Print Speed:** Prints in 1 second while applying the label

**Dimensions:** Tablet: 4.8"W x 7.1"H x 0.5"D (121.9mm W x 180.3mm H x 12.7mm D)

Base: 5"W x 6"H x 4"D (127mm W x 152.4mm H x 101.6mm D)

Cartridge Holder: 5"W x 4.5"H x 2.2"D (127mm W x 114.3mm H x 55.9mm D)

**Weight:** Printer (Base and Cartridge Holder): 2 lb 6 oz (38 oz)

Tablet: 7.6 oz

**Agency Certifications:** UL, UL-C, CE, FCC Class A

**Works With:** AP360, AP362 and AP380 Label Applicators

## Section 6: Certifications and Environmental Policy

### **EMC:** Class B

Human operator intervention is acceptable for this product in an ESD event. This means it is possible that static electricity may be discharged when touching the screen, which may restart the tablet.

### **FCC:**

*NOTE: This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference, in which case the user will be required to correct the interference at his own expense.*

## Environmental Policy

The European Union (EU) has developed the WEEE (Waste Electrical and Electronic Equipment) Directive (WEEE Directive 2012/19/EU) to ensure that systems for collection, treatment, and recycling of electronic waste will be in place throughout the European Union.

Electrical and electronic equipment (EEE) contains materials, components, and substances that may be hazardous and present a risk to human health and the environment when waste and electronic equipment (WEEE) is not handled correctly.

Equipment marked with the below crossed-out wheeled bin is Electrical and electronic equipment (EEE).

The crossed-out wheeled bin symbol indicates that the product is EEE and must be collected separately, in accordance with the WEEE Directive 2012/19/EU.



Users of EEE must not discard WEEE together with household waste. Users must follow local recycling regulations to reduce adverse environmental impacts in connection with disposal of WEEE and to increase opportunities for reuse, recycling, and recovery of WEEE. As a user of this EEE, you have an important role in recycling this equipment and contributing to the protection of the environment and the conserving of natural resources.

When a product reached its end of life, contact us at [environment@primera.com](mailto:environment@primera.com) or +1-763-475-6676 to arrange its recycling. Primera will work with you to arrange for the recycling of the product.