Ledco 30" Automatic Laminate Cutter 110V - C300110

Instruction Manual

READ ALL PRECAUTIONS & INSTRUCTIONS CAREFULLY BEFORE OPERATING CUTTER

Setup
Instruction
Operation
Maintenance

Industrial Series 30" Cutter "Finish Line"

Operation Manual

November 2001

TABLE OF CONTENTS   Page No.

1.0 INTRODUCTION

The High Speed-30 ("Finish Line") Cutter is designed to provide a quality cutter using a wide range of papers and materials. Common applications include, but are not limited to: maps, digital imaging, packaging, posters, menus, instructional aids, signs, presentation materials, photographs, copies (B&W or color), prints, flyers, promotional sheets, and many other items.

Options include variable speed power exit table and a stand.

To assure the best performance from your new cutter, please follow the safety, installation, operation, and maintenance instructions in this manual. Read the manual before using the cutter. Keep the manual with the machine and periodically review the instructions. This manual also contains the warranty. Additional copies are available from the manufacturer.

We take this opportunity to thank you for selecting a LEDCO cutter and to assure you of our commitment to your satisfaction with our products.

As you unpack your new cutter please complete the following information. Always have this information ready when calling.

Dealer
Where Purchased_____

Installation Date_____ Serial #_____

Ledco, Inc. 4265 North Main Street   Hemlock, NY 14466
              Fax: 585-367-2978   Phone: 585-367-2392

1.1 FEATURES & BENEFITS

Your new cutter has several standard features that set it apart from other models

- <u>Variable Speed</u>   The cutter operates at any speed up to 150 fpm (actual output may vary depending on number of cuts per min.).

- <u>Levers to open & close feed rollers</u>   The levers hold the rolls open while you thread and straighten the web.

- <u>Feed table with easily adjustable guides</u>   The feed table supports the web during threading and the guides adjust with a single screw and are machined square for precise web travel.

- <u>Total electrical operation</u>   The unit is very convenient, only requiring a 115V, 15 amp outlet or depending on model, 208V-240V single phase, 50/60 cycle, 13amp outlet.

- <u>Active mode variables displayed</u>   The control panel displays all settings before, during and after operation (except during adjustment of a particular function).

- <u>Speed adjustment during operation</u>   The speed can be adjusted during operation without stopping. You merely have to push the speed + or - button and the machine will incrementally adjust itself after each cut until you push the enter key.

- <u>Nose, tail, and length adjustment during operation</u> The nose, tail, and length may be adjusted during operation without stopping. You merely have to push the required + or – button and the machine will adjust itself after the next cut .01 inches or .2 millimeters.

- <u>Cutting blades are interchangeable</u>   If the blades should ever become dull, they can simply be rotated top to bottom for a new cutting edge.

1.2 OPTIONS

- <u>Locking Stand Castors</u> Locking castors available for easy and fast setup.

- <u>Single Side Lamination Cutting Attachment</u> Tensions web for accurate cutting of single side lamination.

1.3 SPECIFICATIONS

	US	Europe
Maximum web width	30"	762mm
Speed	0-150 FPM	0-45 MPM
Maximum cutting thickness	up to 50mil	up to 1.27mm
Dimensions	58L 20H 27W	1473mm L 508mm H 686mm W
Shipping Dimensions	76L 54H 43W	1931mm L 1359mm H 1093mm W
Weight/Shipping weight	400 Lbs.	182 Kg
Electrical	115V 12amp	208-240V single phase 50-60Hz 6amp
Electrical connector	NEMA 5-15R	Consult Dealer

1.4 PRINCIPLES OF OPERATION

FEED MODE (FD): This is used when you want something cut to a specified length (also known as sheeting).
- Set the length and speed.
- Start the machine. The feed rolls push the web to the prescribed distance and stop.
- The blade activates and shears the web.
- The cutter will go through multiples of this cycle until told to stop.

REGISTRATION MODE (RG): This is used when you would like to have something trimmed before or after a sensed edge front (nose) and or rear (tail).
- Set the front edge (nose) to trim either before or after the sensed edge.
- Set the rear edge (tail) to trim either before or after the sensed edge.
- Set the speed.
- Load your substrates laminated in transparent to semitransparent web, with a small gap between each sheet.
- Start the machine. The feed rolls push the material forward until the fiber optic sensor senses the nose. Upon sensing the nose, they move the prescribed distance and stop.
- The blade activates and shears the web.
- The feed rollers start and push the web forward until the fiber optic sensor senses the tail edge. Upon sensing the tail, they move the prescribed distance and stop.
- The blade activates and shears the web.
- It goes through multiples of this cycle until told to stop.

REGISTRATION FEED MODE (RF): This is used when you would like to have something trimmed before or after a sensed edge front (nose) and cut to a specified length.
- Set the front edge (nose) to trim either before or after the sensed edge.
- Set the length and speed.
- Load your substrates laminated in transparent to semitransparent web, with a small gap between each sheet.
- Start the machine. The feed rolls push the material forward until the fiber optic sensor senses the nose. Upon sensing the nose, they move the prescribed distance and stop.
- The blade activates and shears the web.
- The feed rolls start and push the web to your prescribed distance and stop.

- The blade activates and shears the web.
- The cutter will go through multiples of this cycle until told to stop.

<u>BATCH MODE</u>: This is used when you need a specific amount cut or trimmed and would like the machine to stop or pause after such amount is reached. This is used in conjunction with the first three modes.

1.5 WARRANTY

This cutter is guaranteed against defects in material and workmanship for a period of two years after date of shipment. Defective parts will be replaced without cost within the warranty period, provided the cutter has not been abused, altered or operated contrary to instructions. Ledco, Inc. shall not be liable for any alterations or repairs except those made with its written consent.

This obligation under warranty shall not extend to the following:
- The adjustment or replacement of parts which are the normal responsibility of the owner. For example, rubber rolls, blade sharpening, scratched or chipped paint, loose fasteners (screws, nuts, etc.), or other items that show wear under normal use; i.e. "normal wear parts".

- Normal operating adjustments to speed, length, etc.

- Parts that are not manufactured by Ledco, Inc. If the individual manufacturer warrants these items, their warranty is, in turn, passed on to the original purchaser of the autocutter. Ledco, Inc. does not incur any obligation or liability as a result of the warranties, which are the sole responsibility of the appropriate individual manufacturer.

Any cutter that proves defective during the warranty period may be returned to Ledco, Inc. unless it is decided that the necessary repairs can be made during a service call. <u>Notice of the defect should be submitted in writing or by phone to Ledco before any steps are taken to repair or return the machine. Phone: 585-367-2392 Fax: 585-367-2978</u>

If the machine is returned, the following should accompany it.
- Customer name, address and phone number
- Written particulars regarding the malfunction
- Date of installation
- Serial number of the machine.
- RA number on outside of box

**Send all returned equipment freight PREPAID to:
Ledco, Inc., 4265 North Main Street, Hemlock, NY 14466**

If your machine needs servicing after the warranty has expired, please contact your dealer. Ledco, Inc. does offer technical support if your dealer is unable to assist.

This warranty is expressly in lieu of all other warranties expressed or implied. This includes the warranties of Merchantability and Fitness For Use and of all other obligation or liabilities of Ledco, Inc. Ledco neither assumes nor authorizes any other person to assume it for any other obligation or liability in connection with the sale of this cutter except as provided for above.

Further, this warranty will not apply to any machine or part thereof which has been damaged as result of an accident or as a result of abuse, misuse, or neglect of the machine. The warranty is also void if the cutter has been altered or repaired by any other than an authorized repair facility or dealer. If you have any questions about this warranty, contact Ledco.
Phone: 585-367-2392
Fax: 585-367-2978
Email: www.ledco@ledcoinc.com

2.0 UNPACKING AND INVENTORY

The cutter arrives fully assembled. Upon arrival, inspect the unit immediately and thoroughly using the packing list that accompanies the shipment. Please follow these steps to correct any problem with your shipment. Ledco, Inc. cannot accept any responsibility for damage or loss unless you notify us within ten days of receipt of shipment and follow these procedures:

BREAKAGE OR DAMAGE: It is imperative that any shipping damage is reported and a claim is filed with the delivering carrier immediately upon receipt of damaged shipment. The procedure for reporting damage depends on the method of shipment. Please note damage on bill of lading.

FREIGHT, EXPRESS, or TRUCK DELIVERY: According to the contract terms and conditions of the carrier, the responsibility of the shipper ends at the time and place of shipment. The carrier then assumes full responsibility for the shipment.

1.   Notify Ledco **IMMEDIATELY**.

2.   Hold damaged goods with container and packing for inspection by the examining agent. Ledco will arrange the inspection.

3.   **DO NOT RETURN ANY GOODS TO LEDCO PRIOR TO AUTHORIZATION BY LEDCO**.

4.   Submit a copy of the inspector's report to Ledco. Ledco will file the claim with the carrier. Ledco will replace your machinery if necessary. You will be credited for the damaged machinery when the claim is processed.

SHORTAGE:

1.   Check the packing list notations. The apparent shortage may have been marked as an international short-shipped (back-ordered) item.

2.   Examine the container and packing material, particularly for smaller items.

3.   Make certain that unauthorized personnel prior to complete unpacking did not remove the item and inventory.

4. Call us and send immediate written notification of the shortage.

<u>INCORRECT SHIPMENT:</u>

1. If the material you receive does not correspond with your order, notify Ledco immediately. Include the order number and item(s).

2. Hold item(s) until return instructions are received.

RETURNS: DO NOT RETURN DAMAGED OR INCORRECT ITEMS UNTIL YOU HAVE RECEIVED SHIPPING INSTRUCTIONS AND AN AUTHORIZATION NUMBER FROM LEDCO.

3.0 SAFETY PRECAUTION

DO NOT OPERATE THIS MACHINE UNTIL YOU READ AND FULLY UNDERSTAND THE FOLLOWING SAFETY PRECAUTIONS.

1. Never operate this machine without reminding yourself that a cutter is a potentially dangerous tool. If misused, used carelessly, or used without observing the rules of safe operation, very serious injury can result.

2. Never operate this machine without all guards, housings, safety shields, stop switches or other safety devices in place and fully operational.

3. Never operate this machine unless you have been fully trained and have received and fully understood all operating instructions. Make sure you know how the machine works and how it is controlled.

4. Never operate this machine if it is not working properly or if you notice any abnormality in its performance.

5. Never tamper with, rewire, or bypass any control or safety device on this machine.

6. Never attempt to clean feed rollers while the power is on.

7. Never remove the machine housing or attempt any kind of maintenance without disconnecting power to the unit.

8. Always be sure all persons are clear of the machine before pushing the start button, especially when multiple operators or observers are present.

9. Never wear loose clothing, ties, jewelry or any item, which could get caught in the rollers or machinery when operating the machine. Operators with long hair must put their hair up before running the machine.

10. Always keep your hands clear of any moving parts or blades except when the power is off and you intend to adjust the cutter or change the blade.

11. Because casters raise the center of gravity and increase the risk of tipping, use a minimum of two people to move the machine. Move slowly, and avoid any obstructions.

NOTICE TO EMPLOYER: A copy of these safety precautions must be given to all operators, set-up personnel, maintenance people, and supervisors of this machine. A copy should also be hung on the machine readily accessible and visible to the operator. Additional copies are available upon request.

IMPORTANT: Where a language barrier or insufficient schooling would prevent a person from reading and understanding these safety precautions, you should either translate this information or have it read or interpreted to the person, and get assurance that it is understood.

4.0 SETUP & OPERATION

This section explains, in short, how to setup and run your new cutter. The individual controls and settings will be more thoroughly explained in 5-2.

1. Remove all packing straps, rubber bands, tape, and plastic ties from the machine.

2. Prepare web for trimming.

    *   When cutting directly from the laminator, first run about 6 feet or 2 meters of material through the laminator.

    *   When cutting material previously processed, make sure the web path is unobstructed and the material runs freely.

    *   Rewound material should be taken from a driven unwind.

    *   Shorter lengths can be placed in a box and pulled to the cutter from the top.

    *   Any drag on the web can adversely affect accuracy.

3. Place cutter at least 1 1/2 feet or 1/2 meter behind laminator when using thin films (1 – 7 mil). If using thicker films (5 – 20 mil), place cutter up to 4 feet or 1 1/4 meters. This will allow the film to cool.

4. Thread the web under front dancer bar (loop control bar).

    *   Place the web on top of feed table and push under safety shield at rear of feed table until it stops.

    *   Then raise feed rollers by lifting the small levers located at the rear of the machine.

    *   Push the web through until it can be seen coming out of the rear of the machine and then pull it from behind until tight.

    *   Move the web side to side until it is squarely running through the cutter and close the rollers.

5. Adjust side guides to web width. Leave just a slight clearance on each side as not to bind and still allow the web to flow freely through the cutter.

6. Plug the machine into proper outlet.
   115v standard 25"   115v 15amp

   220v standard 25"   220v 12amp

7. Insert key into power switch and turn to on position. Check the two EMERGENCY STOP BUTTONS. They should be in the up position. If buttons are depressed, turn clockwise slightly until they pop up.

8. When you look at the control screen, the values are shown above or below their respective labels.

   • In the upper left hand corner is the MODE label and below it is the two letter setting of FD for feed to length, RG for registration or RF for registration feed mode.

   • Just to the right is the SPEED label and below the value in feet per minute or meters per minute depending on the unit setting.

   • The next label to the right is the LENGTH setting in either inches or millimeters depending on the unit setting.

   • The last label on the top is the COUNT and below it is the value.

   • In the lower left hand corner is the UNIT label and above it displayed either "in" for inches or "mm" for millimeters.

   • The next label to the right is the NOSE setting and if the RG or RF mode is active, a value will be displayed in either inches or millimeters depending on unit setting.

   • The next label to the right is the TAIL setting and if the RG or RF mode is active, a value will be displayed in either inches or millimeters depending on unit setting.

   • The last label on the bottom right is the BATCH label and above it the value.

9. You may adjust the settings for your first job by pushing the corresponding button on the keypad once and follow display prompts, or from the factory we have a simple feed to length program loaded and ready for use. The program consists of FD mode, 25-fpm speed, 1.000-inch length, "in" units, no nose, no tail and 0.0 batch. If you would like to get a feel for the machine, you could run a few of these strips.

- Before you push the start button, make sure you have some material loaded that you don't mind cutting into 1 inch strips.

- Now, if you're ready, you can push the start button and run a few strips, the machine will keep cutting until you either push the stop button or the front dancer bar (loop detector) raises and pauses the machine.

- CAUTION: After the front dancer bar (loop detector) has been activated the machine will be in a paused state and you cannot change settings or otherwise operate the cutter without first running enough material to allow the front dancer to swing down and activate the cutter and then push the stop button.

10. When you are satisfied with the current settings, you may either reset to 0 or key in a beginning count. Then push the save button. This will save the current program settings in case you lose power or turn the machine off.

   - CAUTION: If you turn the machine off without the current program being saved it will revert back to the last saved program.

4.1 CONTROLS & SETTING PARAMETERS

This section will explain, in depth, the use and settings for proper operation of the cutter.

4.1.1 SIDE GUIDES

Each side guide is adjustable side to side with a small angular adjustment. A single knurled plastic screw is used for side to side adjustment. Adjust side guides to web width leaving just a slight clearance (approximately 1/32" or 1mm on each side). This will allow the web to be accurately guided through the machine. Angular adjustment is accomplished by using 5/32" hex wrench to loosen button head screw. Then loosen and tighten opposing knob screws.

4.1.2 MODE SETTING

FD (Feed Mode): This is used when you want something cut to a specified length (also known as sheeting).
1. Set the length and speed.
2. Start the machine. The feed rolls push the web to the prescribed distance and stop.
3. The blade activates and shears the web.
4. Then it goes through multiples of this cycle until told to stop.

RG (Registration Mode): This is used when you would like to have something trimmed before or after a sensed edge front (nose) and/ or rear (tail).
1. Set the front edge (nose) to trim either before or after the sensed edge.
2. Set the rear edge (tail) to trim either before or after the sensed edge.
3. Set the speed.
4. Load your substrates laminated in transparent to semitransparent web, with a small gap between each sheet.
5. Start the machine. The feed rolls push the material forward until the fiber optic sensor senses the nose. Upon sensing the nose, they move the prescribed distance and stop.
6. The blade activates and shears the web.
7. The feed rollers start and push the web forward until the fiber optic sensor senses the tail edge. Upon sensing the tail, they move the prescribed distance and stop.
8. The blade activates and shears the web.
9. The cutter will go through multiples of this cycle until told to stop.

<u>RF (Registration Feed Mode):</u> This is used when you would like to have something trimmed before or after a sensed edge front (nose) and cut to a specified length.

1. Set the front edge (nose) to trim either before or after the sensed edge.
2. Set the length and speed.
3. Then load your substrates laminated in transparent to semitransparent web, with a small gap between each sheet.
4. Start the machine. The feed rolls push the material forward until the fiber optic sensor senses the nose. Upon sensing the nose, they move the prescribed distance and stop.
5. The blade activates and shears the web.
6. The feed rolls start and push the web to your prescribed distance and stop.
7. The blade activates and shears the web.
8. The cutter will go through multiples of this cycle until told to stop.

Changing mode setting

1. Press the MODE button (located upper right hand corner of keypad).
2. You will see displayed in window F1-FD, F2-RG and F3-RF. The instructions are telling you to either push the F1 button for FD (Feed Mode), F2 button for RG (Registration Mode) or the F3 button for RF (Registration Feed Mode). Press the required button to select.

4.1.3 SPEED SETTING

The speed is displayed on the screen in the upper left-hand corner below the speed legend. The speed will be displayed from 0-150 feet per minute or if in metric mode 0-45 meters per minute.

Changing speed while machine is stopped.

1. Press the SPEED button.
2. On the number pad, key in your speed.
3. Press the ENTER button to accept your keyed entry.

To increase the speed while machine is running.

1. Press the SPEED + button. The machine will increase in speed incrementally by 2 feet per minute or .3848 meters per minute.
2. The speed will continue to increase with every cut.
3. When you are satisfied with the current speed, press the ENTER button to accept.

To decrease the speed while the machine is running.

1. Press the SPEED - button. The machine will decrease in speed incrementally by 2 feet per minute or .3848 meters per minute.
2. The speed will continue to decrease with every cut.
3. When you are satisfied with the current speed, press the ENTER button to accept.

Optimizing your speed setting

The perfect setting would be having the web between the laminator and the cutter never touch the floor or raise the dancer bar and pause the cutter during a job. We don't live in a perfect world. The next best thing would be to adjust the speed to cause the cutter to pause every once in awhile rather then having the web drag on the floor. Use caution when setting speed. If you set the speed too fast, it will approach and raise the dancer so fast it will not have time to pause before the web pulls tight. When the web pulls tight, the rolls will lose traction and accuracy. If you set the speed too slow, it will drag on the floor and pick up dust and dirt. This will collect on the rolls and cause them to lose traction and accuracy. This is where you use the increase and decrease speed while the machine is running to fine tune the speed. Always remember to push the enter button to stop the speed from incrementally changing when using the speed change while machine is running.

4.1.4 LENGTH SETTING

The length is only displayed and set during FD MODE (FEED MODE) or RF MODE (REGISTRATION FEED MODE). The length is displayed on the upper middle screen just below the length legend. The length may be adjusted from 0-999 inches or 0-9999 millimeters.

Changing length while machine is stopped.

1. Press the LENGTH button.
2. On the number pad, key in your required length.
3. Press the ENTER button to accept.

To increase the length while machine is running.

1. Press the LGTH + button. The length will increase by .01 inches or .2 mm after the next cut.

To decrease the length while machine is running.

1. Press the LGTH - button. The length will decrease by .01 inches or .2 mm after the next cut.

4.1.5 COUNT

1. The count is displayed in the upper right corner of the screen just below the count legend. The count registers from 0-999999.

Resetting count to zero

1. Press the COUNT button.
2. The screen will display F1-ZERO and F2-ADJUST. Press F1 to reset to zero.

Adjusting the count

The count may be adjusted when the machine is stopped.
1. Press the COUNT button.
2. The screen will display F1-ZERO and F2-ADJUST. Press the F2 button.
3. On the number pad, key in your adjusted count.
4. Press the ENTER button to accept.

4.1.6 UNITS

The units may be displayed in in-inches or mm-metric. The unit of measure is displayed on the lower left corner of the screen above the unit legend.

Changing the unit of measure

1. Press the in-mm button.
2. The Screen will display F1-in (inches) and F2-mm (metric). Press F1 for inches or F2 for metric.

4.1.7 NOSE SETTING

The nose setting is only displayed and set during RG MODE (REGISTRATION MODE) or RF MODE (REGISTRATION FEED MODE). The nose setting is displayed on the lower left screen above the nose legend. The nose setting may be adjusted from –9.999 to +9.999 inches or –99.99 to +99.99 millimeters.

Changing the nose setting while machine is stopped

1. Press the NOSE button.
2. The screen displays F1/+/-. You may either press the F1 button, the NOSE + button or the NOSE - button. When you press the F1 button, go to the number pad and key in the required distance. When you press the NOSE + button or the NOSE - button, the current setting will increase or decrease .01 inches or .2 millimeters every keystroke.
3. Press the ENTER button to accept.

To increase the nose setting while the machine is running

1. Press the NOSE + button. The nose distance will increase .01 inches or .2 mm after the next cut. Note: The distance will only increase one increment of .01 inches or .2 millimeters per cut no matter how many times you push the NOSE + button; and after the cut in order to increase more, you have to press the NOSE + button again.

To decrease the nose setting while the machine is running

1. Press the NOSE - button. The nose distance will increase .01 inches or .2 mm after the next cut. Note: The distance will only decrease one increment of .01 inches or .2 millimeters per cut no matter how many times you push the NOSE – button; and after the cut in order to increase more, you have to press the NOSE - button again.

4.1.8 TAIL SETTING

The tail setting is only displayed and set during RG MODE (REGISTRATION MODE). The tail setting is displayed on the lower right screen above the tail legend. The tail setting may be adjusted from –9.999 to +9.999 inches or –99.99 to +99.99 millimeters.

Changing the tail setting while machine is stopped

1. Press the TAIL button.
2. The screen displays F1/+/-. You may either press the F1 button, the TAIL + button or the TAIL - button. When you press the F1 button, you go to the number pad and key in the required distance. When you press the TAIL + button or the TAIL - button, the current setting will increase or decrease .01 inches or .2 millimeters every keystroke.
3. Press the ENTER button to accept.

To increase the tail setting while the machine is running

1. Press the TAIL + button. The tail distance will increase .01 inches or .2 mm after the next cut. Note: The distance will only increase one increment of .01 inches or .2 millimeters per cut no matter how many

times you push the TAIL + button; and after the cut in order to increase more, you have to press the TAIL + button again.

To decrease the tail setting while the machine is running

1. Press the TAIL - button. The tail distance will decrease .01 inches or .2 mm after the next cut. Note: The distance will only decrease one increment of .01 inches or .2 millimeters per cut no matter how many times you push the TAIL – button; and after the cut in order to decrease more, you have to press the TAIL - button again.

4.1.9 BATCH SETTING

The batch setting is displayed on the lower right corner of the screen above the batch legend. The batch can be set from 0-99999. The BATCH MODE may be used in conjunction with all the other modes. The BATCH MODE may be set to stop or pause. When using pause between batches, the dwell is adjustable in seconds from 0-99999.

Changing the batch setting

1. Press the BATCH button
2. The screen will display F1-ON, F2-OFF or F3-CANCEL. You may either press F1 to turn batch on, press F2 to turn batch off or F3 to cancel (back out of program without changes). If you press F1, continue.
3. The screen will display ENTER BATCH and display the current batch amount in the lower left hand corner. Either press the ENTER button to accept the current batch amount or go to the number pad, key-in the required batch amount, and press the ENTER button to accept.
4. The screen will display BATCH WITH DWELL?, F1-DWELL and F2-STOP. Either press F1 for batch with dwell or press F2 to cut a specific amount and then stop. If you press F1, continue.
5. The screen will display ENTER BATCH DWELL and display the current dwell time (in seconds) in the lower left corner. Either press the ENTER button to accept the displayed dwell time or go to the number pad and key in your new dwell time (in seconds). Then press the ENTER button to accept.

4.1.10 SAVE BUTTON

The save button is used for saving the current cutter configuration. It is recommended to save the configuration after you change parameters on current jobs or before you power down the machine. If you do not save the parameters, when powered back up it will revert to the previously saved parameters including the count.

Saving the current settings

1. Press the SAVE button.
2. The screen will display DO YOU WANT TO SAVE, F1-OK and F3-CANCEL. Press the F1 button to ok the save or Press the F3 button to cancel the save.

4.2 THREADING THE CUTTER

1. Place cutter at least 1 1/2 feet or 1/2 meter behind laminator when using thin films (1 – 7 mil). If using thicker films (5 – 20 mil), place cutter up to 4 feet or 1 1/4 meters. This will allow the film to cool. Then Center and square the cutter to the laminator as close as possible.

2. Thread the web under front dancer bar (loop control bar).

   • Place the web on top of feed table and push under safety shield at rear of feed table until it stops.

   • Then raise feed rollers by lifting the small levers located at the rear of the machine.


   • Push the web through until it can be seen coming out of the rear of the machine and then pull it from behind until tight.

   • Move the web side to side until it is squarely running through the cutter and close the rollers.

3. Adjust side guides to web width. Leave just a slight clearance on each side as not to bind and still allow the web to flow freely through the cutter.

4.3 ADJUSTING THE FIBER OPTIC SENSOR

This section explains in detail the adjusting of the fiber optic sensor. Use this section when experiencing a variance or lack of nose and/or tail registration.

1. Remove front cover from the photoelectric switch.
2. Between the sheets to be cut off, there are clear or transparent gaps of plastic. Make sure the fiber optic sensors are lined up between one of these clear or transparent gaps.
3. In lower left of photoelectric switch face is a small switch. Slide switch up to the SET position.
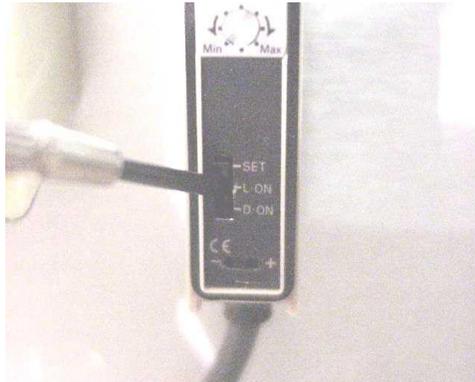
4. With the machine powered up, place a small screwdriver in the screw slot located in the front of the photoelectric switch.

5. Turn the adjusting screw counter clockwise until you hear small clicking sounds and the little green light is the only light on.
6. Turn the screw slowly clockwise.

- First, the green light will go out.
- Second, the red light will come on.
- Third, keep turning slowly and the green light will start coming on dimly. Keep turning until the green light becomes bright and stable. Then turn it ¼ turn more.

7. In lower left of photoelectric switch face slide small switch down to L ON position.

8. The Sensor should be adjusted properly.
9. Replace the front cover on the switch and you are ready to go.

5.0 MAINTENANCE

This section explains the schedule and the maintenance in detail.

5.1 MONTHLY SERVICE SCHEDULE

5.1.1 BELT TENSIONING & DRIVE BELT THREADING DIAGRAM

Checking belt tension between clutch and cutoff motor

1. Disconnect power to machine.
2. When facing the front of the machine, open the large access door on the right housing.
3. Pinch the belt between your thumb and forefinger and move side to side. The belt shouldn't be loose or too tight. It should be just tight enough not to sag.
4. If the tension seems good, close the access door. If it doesn't feel right, proceed to adjusting belt tension.

Adjusting belt tension

1. Using a 5/32" hex wrench, loosen the four motor mounting screws and slide motor until desired tension is attained.
2. Tighten the mounting screws.
3. Close the access door.

Checking belt tension between stepper motor and rubber rollers

1. Disconnect power to machine.
2. When facing the front of the machine, open the large access door on the left housing.
3. To remove any slack in the belt trapped in between the rest of the pulleys, pinch together the belt above the motor pulley while lifting and lowering the top rubber roll-lifting lever in the back of the machine.
4. On the longest stretch pinch the belt between your thumb and forefinger and move side to side. For accuracy this belt should be just a little tight.
5. If the tension seems good, close the access door. If it doesn't feel right, proceed to adjusting belt tension.

Adjusting belt tension

1. Using a 5/32" hex wrench, loosen the four motor mounting screws and let the weight of the motor tighten the belt until desired tension is attained.
2. Tighten the mounting screws.
3. Close the access door.

DRIVE BELT THREADING DIAGRAM
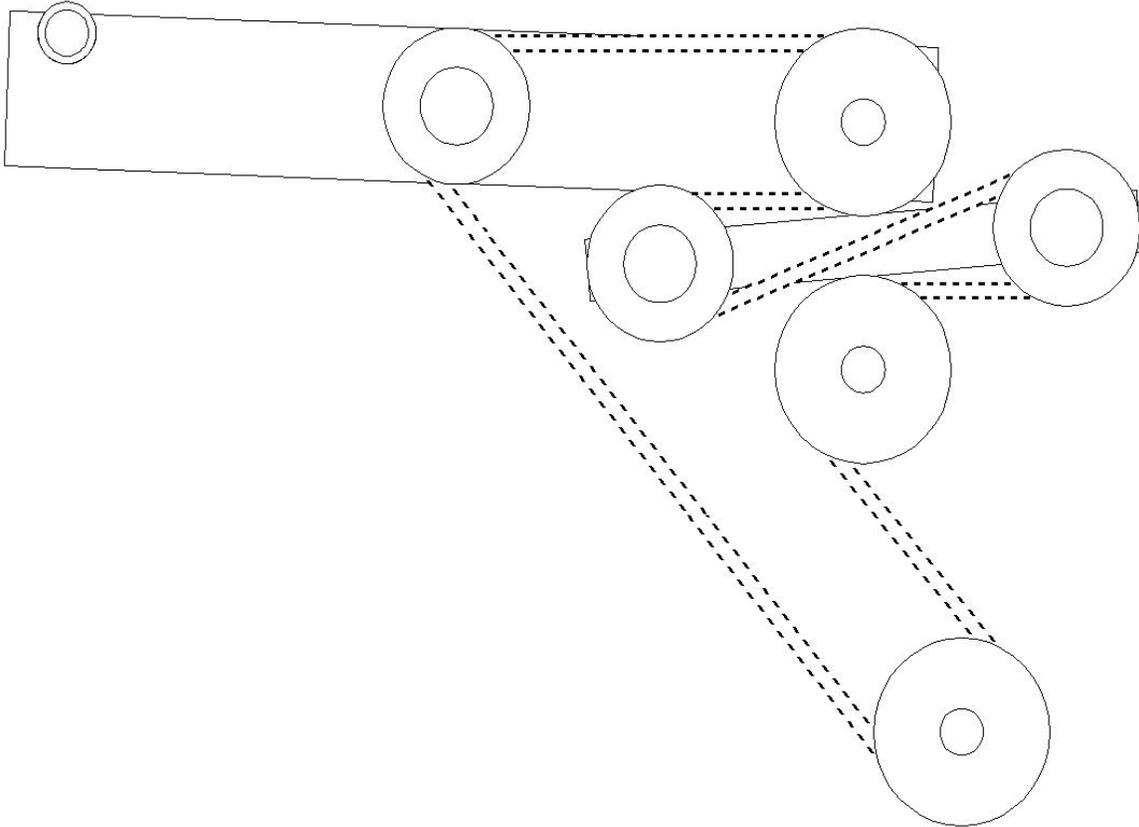
Checking belt tension in exit table

1. Disconnect power to machine.
2. Remove the four screws from the top of the exit table control box.
3. With your forefinger apply pressure to the top of the belt. The belt shouldn't be loose or too tight. It should be just tight enough not to sag.
4. If the tension seems good, replace the top of the exit table. If it doesn't feel right, proceed to adjusting belt tension.

Adjusting belt tension

1. Using a 5/32" hex wrench, loosen the two control box mounting screws (to access one of the screws you will have to turn the large pulley until the access hole drilled through the pulley lines up with the mounting screw). Then push the control box towards the machine until desired tension is attained.
2. Tighten the mounting screws.
3. Replace the top of the exit table.

5.1.2 CLEANING RUBBER ROLLS

1. Disconnect power to machine.
2. Lift the top safety hood up from behind and set it down on the exit table.
3. Use a clean rag and spray the rag until damp with a cleaning solution (we recommend an all purpose cleaner & degreaser manufactured by Finger Lakes Chemical, Inc. named ENVIRONMENTALLY CONSCIOUS SAFER STUFF SAFER THAN SOLVENTS; to order, call 1-800-876-0222 fax 1-716-325-4514).
4. Start on left side, with the damp rag in left hand, place rag on rubber roll across four or five rubber roll segments at a time, turn the roll with your right hand for several revolutions. Do this progressively down the roll till past halfway and switch hands and finish the rest off the roll.
5. Return top safety hood to closed position.

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