NRTL C30 AUTOCUTTER – A

ASSEMBLY PROCEDURES

AUGUST 2007

NRTL C30 AUTOCUTTER – A

ASSEMBLY PROCEDURES

AUGUST 2007

NRTL C30 AUTOCUTTER – A

ASSEMBLY PROCEDURES

AUGUST 2007

NRTL C30 AUTOCUTTER – A

ASSEMBLY PROCEDURES

AUGUST 2007

C30 AUTOCUTTER STAND ASSEMBLY

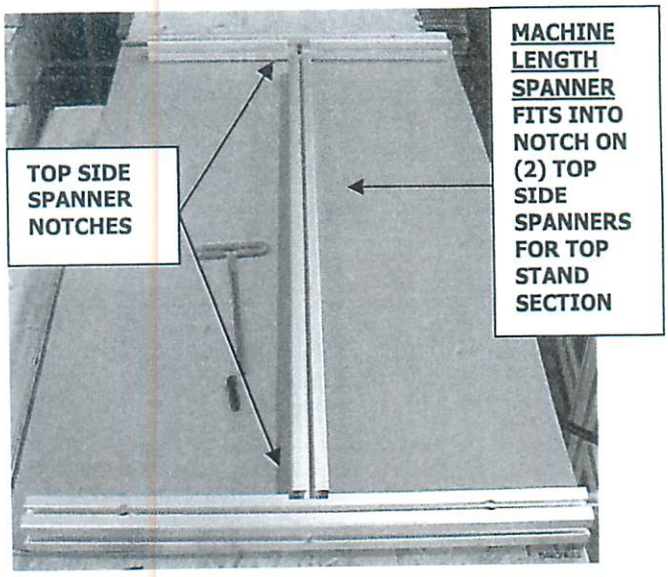
1) THE ASSEMBLY OF A STURDY, EXTRUDED STAND IS REQUIRED FOR THE C30 AUTOCUTTER. THE CHASSIS IS BUILT ON THE COMPLETED STAND WITH "IN HOUSE" CASTERS ATTACHED. THE C30 AUTOCUTTER IS SHIPPED ON THE STAND. STAND ASSEMBLY IS AS FOLLOWS.

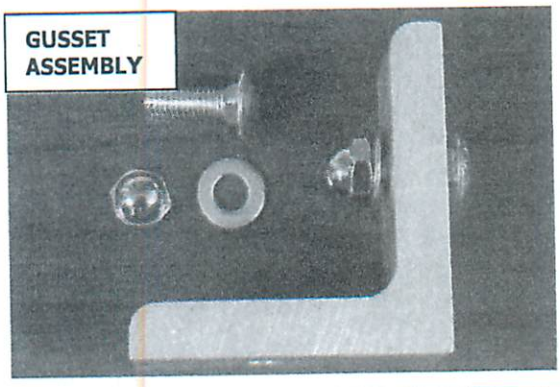
2) CHECK THE "BILL OF MATERIAL" FOR THE 30" AUTOCUTTER 110V OR 220V W/STAND AND CASTERS. PLACE THE APPROPRIATE STAND PIECES ON A CLEAN WORKTABLE. THE CONNECTIONS ARE MADE WITH (4) 5/16-18 X 1 CARRIAGE BOLTS (.312G0A16), (16) FLAT WASHERS SAE, (12) 5/16-18 ACORN NUTS, (4) 5/16-18 HEX NUTS, (18) 5/16-18 X 1 ½ SHCS, (4) 5/16-18 X 2 SHCS, AND (6) 5/16-18 X 3 SHCS AS26.

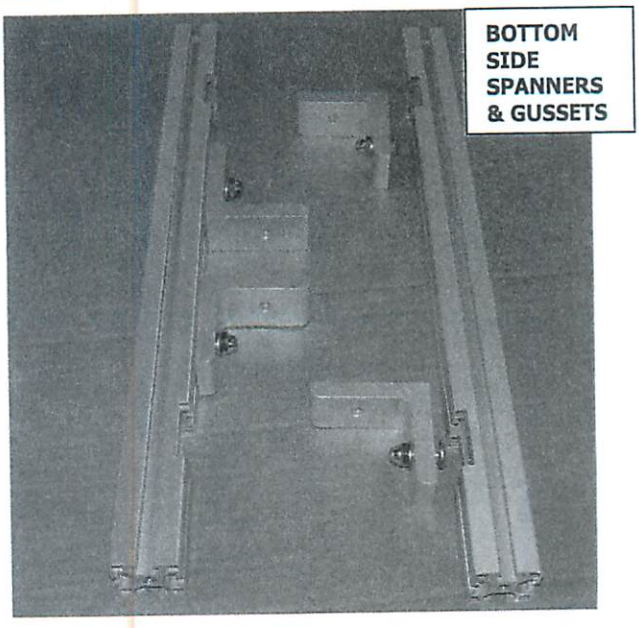
3) FROM AS23 PLACE (2) TOP SIDE SPANNERS (C30 135.4C) ON A WORKTABLE WITH NOTCHES FACING EACH OTHER, INWARD AND MATCHING COUNTERBORES UPWARD. ALIGN A TOP WIDTH SPANNER (C30 135.4AT) WHICH HAS TWO HOLES IN THE CENTER TO ACCOMMODATE MOUNTING PLATE, HOLES ARE ORIENTED FRONT AND BACK. INSERT TOP SPANNER BETWEEN THE TWO NOTCHES ON THE TOP SIDE SPANNERS AND CONNECT USING (2) 5/16-18 X 1 ½ SHCS. SET THIS TOP SECTION ASSEMBLY ASIDE.

4) ASSEMBLE (4) STAND GUSSETS (LC38 135.4G AS01 BY INSERTING A 5/16-18 X 1 CARRIAGE BOLT AS PICTURED. ADD A 5/16 FLAT WASHER TO THE CARRIAGE BOLT THREADS AND SNUG A 5/16-18 ACORN NUT ONTO THREADS.

5) PLACE (2) BOTTOM SIDE SPANNERS (C30 135.4B) ON THE WORKTABLE WITH BOTH NOTCHES ALIGNED FACING EACH

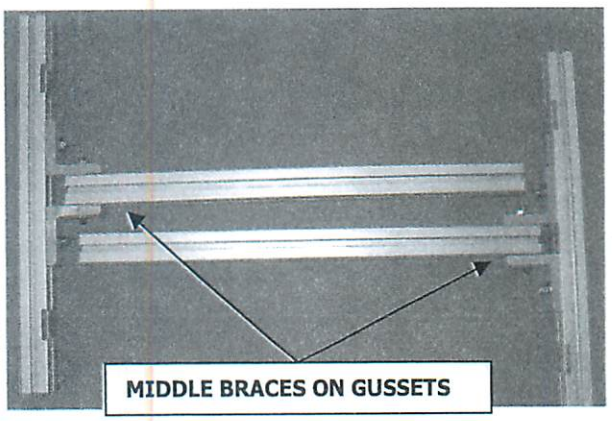




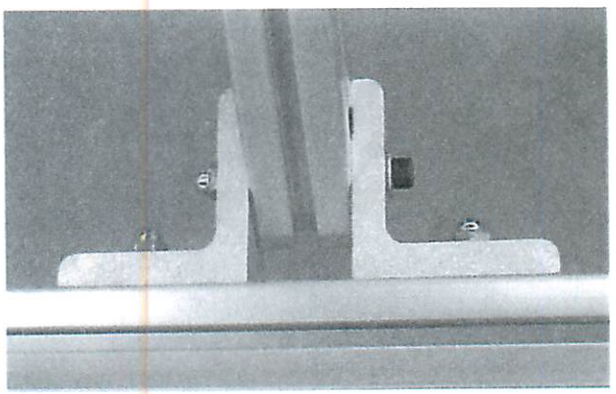


OTHER (INWARD). SLIDE THE ASSEMBLED CARRIAGE BOLTS BETWEEN NOTCHES ON THE INSIDE OF BOTH BOTTOM SIDE SPANNERS, AS PICTURED. SNUG STAND GUSSETS, AS THEY WILL BE SECURED LATER.

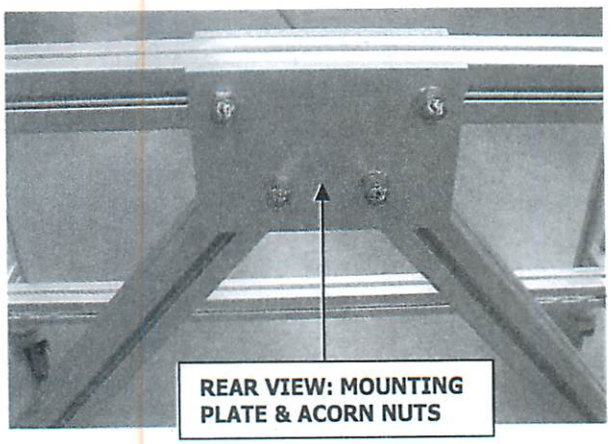
6) ATTACH (2) MIDDLE BRACES (C30 135.4J) AS23 BETWEEN THE GUSSETS ON THE SIDES. USE 5/16 X 3 SHCS AS26 WITH A 5/16 FLAT WASHER, ON THE OTHER SIDE OF THE MIDDLE BRACE ADD ANOTHER 5/16 FLAT WASHER AND A 5/16-18 ACORN NUT. SOCKETHEADS FACE FRONT.


MIDDLE BRACES ON GUSSETS

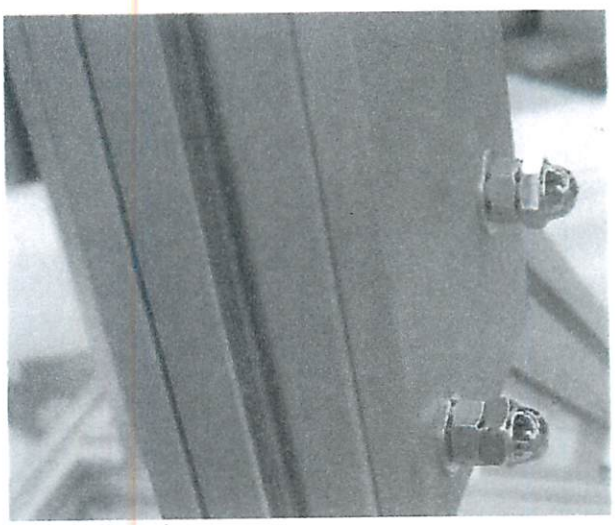
7) ATTACH (2) MIDDLE BRACE MOUNTING PLATES (I30 135.4I) AS25 LOOSELY TO THE FRONT AND REAR SIDES OF THE TOP WIDTH SPANNER. INSERT (2) 5/16-18 X 3 SHCS WITH A 5/16 FLAT WASHER SAE THROUGH THE MOUNTING PLATE, (THE SOCKETHEAD FACES THE FRONT) WIDTH SPANNER AND THE SECOND MOUNTING PLATE. ADD ANOTHER 5/16 FLAT WASHER SAE ONTO THE THREADS, THEN A 5/16 HEX NUT AND A 5/16-18 ACORN NUT. DO NOT TIGHTEN YET.



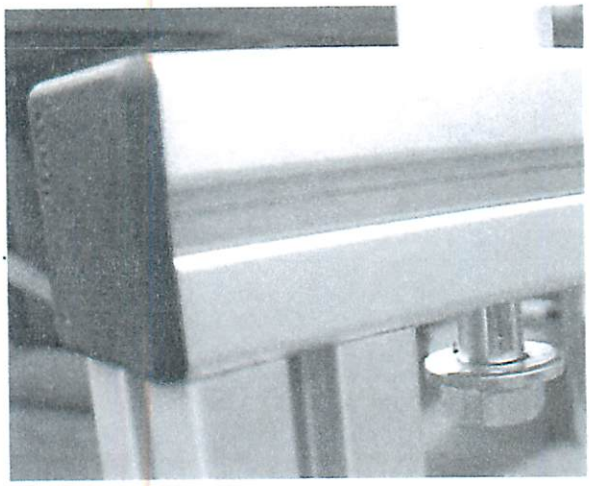
8) THE BOTTOM FRONT WIDTH SPANNER (C30 135.4AA) AS23 HAVING (8) INNER COUNTERBORED HOLES WHICH ARE ORIENTED FRONT AND BACK WITH ***COUNTERBORES FACING THE REAR*** OF THE STAND/MACHINE WHEN ASSEMBLED. THESE HOLES ARE TO LINK THE LAMINATOR TO THE CUTTER. FIT THE BOTTOM FRONT WIDTH SPANNER INTO THE NOTCHES ON THE BOTTOM SIDE SPANNERS. USE (2) 5/16–18 X 1½ SHCS TO SECURE. ATTACH A MACHINE LENGTH SPANNER (C30 135.4A) AS23 TO THE REAR NOTCHES OF THE BOTTOM SIDE SPANNERS. USE (2) 5/6-18 X 1 ½ SHCS.


REAR VIEW: MOUNTING PLATE & ACORN NUTS

9) ATTACH THE (4) LEGS (C30 135.4D) AS23 WITH THE RECESS FITTING OVER THE ENDS OF THE BOTTOM SIDE SPANNERS. SECURE THE LEGS TO THE BOTTOM SIDE SPANNERS USING (4) 5/16-18 X 1 ½ SHCS.

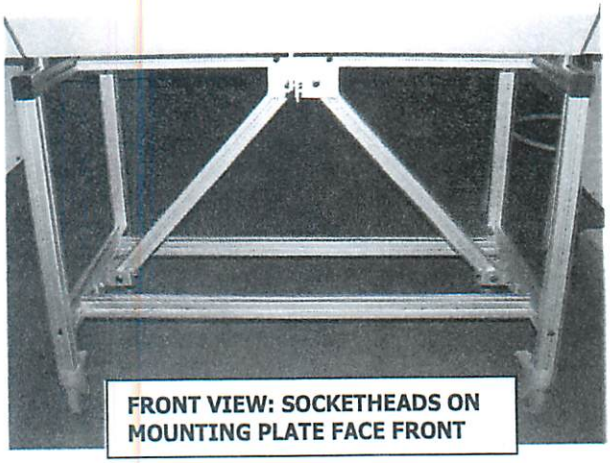


10) THREAD (4) "IN HOUSE" CASTERS ONTO THE SHORTER ENDS OF THE LEGS. THESE WILL BE REMOVED AND RETURNED WHEN MACHINE IS SHIPPED. NEW CASTERS ARE SENT WITH THE C30 AUTOCUTTER.



11) LOOSELY ATTACH THE ASSEMBLED TOP SECTION TO THE LONG END OF THE LEGS, WITH THE MOUNTING PLATE SOCKETHEADS FACING THE FRONT. USE (4) 5/16-18 X 2 SHCS FOR THIS CONNECTION.

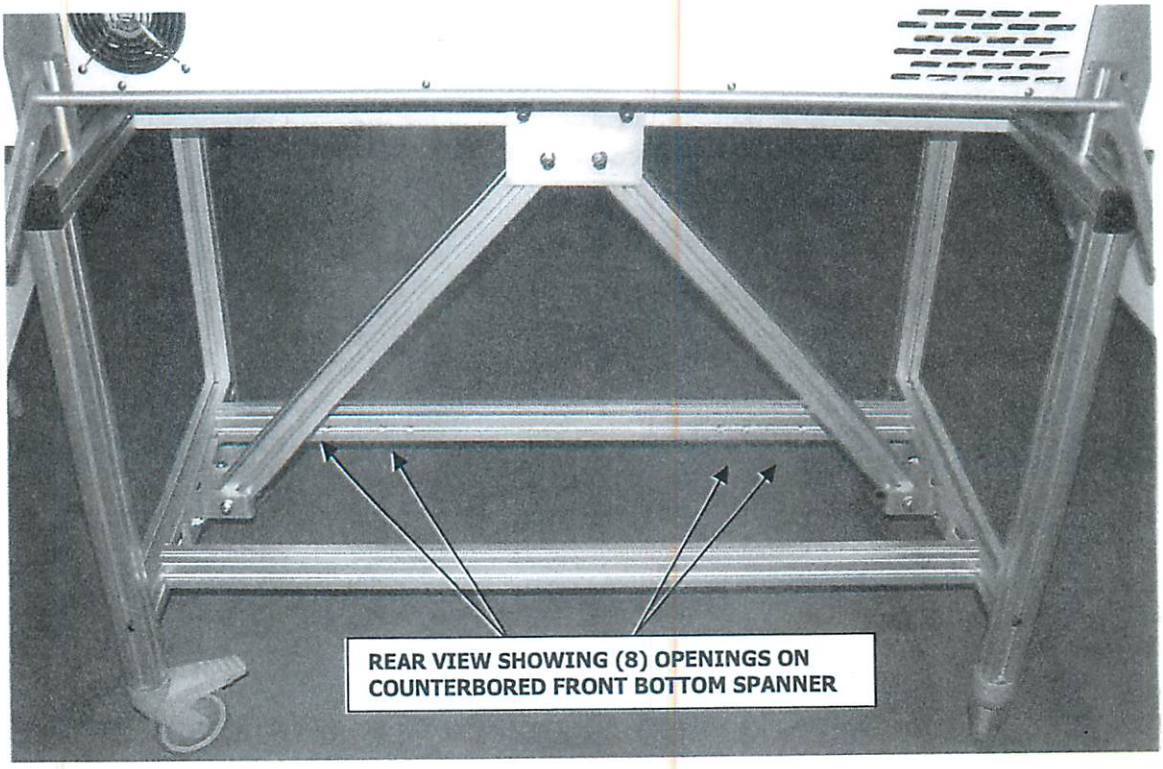
12) FIT THE UPPER PART OF THE MIDDLE BRACES INTO THE LOWER HOLES OF THE MIDDLE BRACE MOUNTING PLATES AND INSERT (2) 5/16-18 X 3 SHCS WITH A 5/16 FLAT WASHER SAE THROUGH THE FRONT MOUNTING PLATE, BRACE BAR AND REAR MOUNTING PLATE. ADD ANOTHER 5/16 FLAT WASHER SAE, A 5/16-18 HEX NUT AND A 5/16-18 ACORN NUT.



FRONT VIEW: SOCKETHEADS ON MOUNTING PLATE FACE FRONT

13) ALIGN AND TAP (4) EXTRUDED STAND END CAPS (PRC250) AS01 INTO THE EXPOSED ENDS OF THE TOP SIDE SPANNERS.

14) TIGHTEN ALL CONNECTIONS INCLUDING MOUNTING PLATE AND GUSSETS.



REAR VIEW SHOWING (8) OPENINGS ON COUNTERBORED FRONT BOTTOM SPANNER

OLD STYLE/NOT TOUCHSCREEN

C30 AUTOCUTTER
MOTOR PREPARATION

1) BOTH THE STEPPER MOTOR (PRM2102.1) AS16 AND THE LARGER GEARMOTOR FOR C25 GLP3338 (PRM1990) AS04 NEED TO HAVE WIRE PREPARATION BEFORE THEY ARE INSTALLED.

2) REMOVE THE MOTOR PLUG LEAD FROM THE SMART STEP (THIS HAS THE BLACK JUMPER WIRE ALREADY).

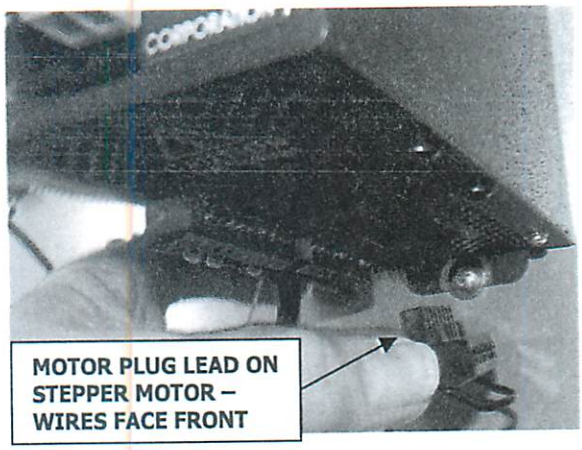
3) SHORTEN THE STEPPER MOTOR CORD TO 33" REMAINING AND EXPOSE WIRES ABOUT AN INCH. CLEAR CAP (PRT289) THE ORANGE AND BROWN WIRE TOGETHER. CLEAR CAP THE YELLOW AND BLUE WIRES TOGETHER. (THE YELLOW AND BLUE ARE IN THE SAME TERMINAL CONNECTION.)

4) DISCARD THE CONNECTION COVER/CAP ON STEPPER MOTOR CORD. THE REMAINING CORD PLUG WIRES FROM THE STEPPER MOTOR ARE CONNECTED TO THE SMART STEP MOTOR PLUG LEAD BY INSERTING AN OPEN WIRE END INTO THE SMART STEP AS FOLLOWS: GREEN WIRE TO "A+" ~ WHITE WIRE TO "A-" ~ UNCOVERED GROUND WIRE TO THE MIDDLE "GROUND", BLACK WIRE TO "B+" AND RED WIRE TO "B-".

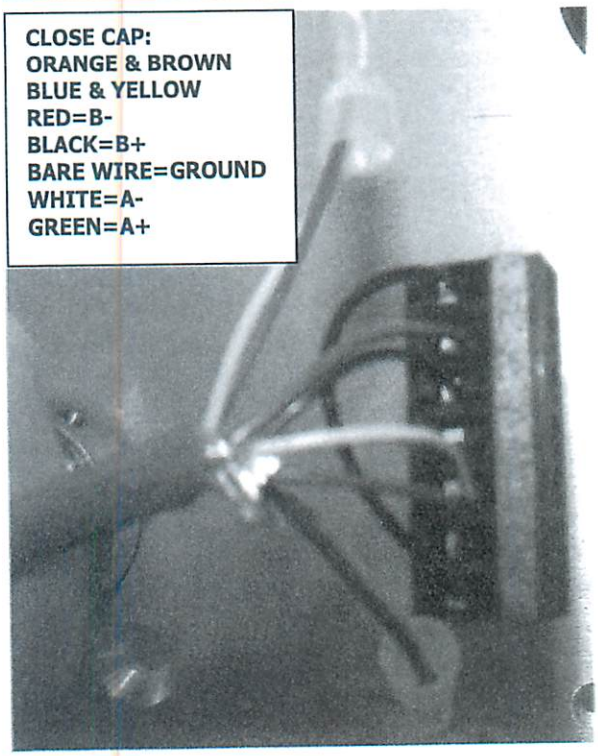
5) THE LARGER PLUG MAY BE DISCARDED.

6) TAP THE (4) SIDE PANEL CONNECTION OPENINGS OF THE STEPPER MOTOR WITH A ¼ X 28 TAP. CLEAN FILINGS AWAY FROM MOTOR.

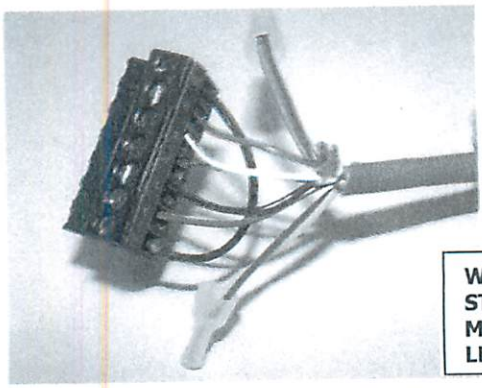
7) CUT 12" OF 16 GAUGE GREEN/YELLOW GROUND WIRE. CRIMP A BLUE RING CONNECTOR (PRT294) ONTO ONE END OF THIS WIRE. REMOVE THE (4) MOTOR WIRE HOUSING SCREWS ON THE GEARMOTOR. SET CAP AND SCREWS ASIDE. REMOVE THE GREEN HEX HEAD SCREW IN THE MOTOR WIRE HOUSING. CONNECT THE GREEN GROUND WIRE



MOTOR PLUG LEAD ON STEPPER MOTOR – WIRES FACE FRONT



CLOSE CAP:
ORANGE & BROWN
BLUE & YELLOW
RED=B-
BLACK=B+
BARE WIRE=GROUND
WHITE=A-
GREEN=A+



WIRED STEPPER MOTER LEAD

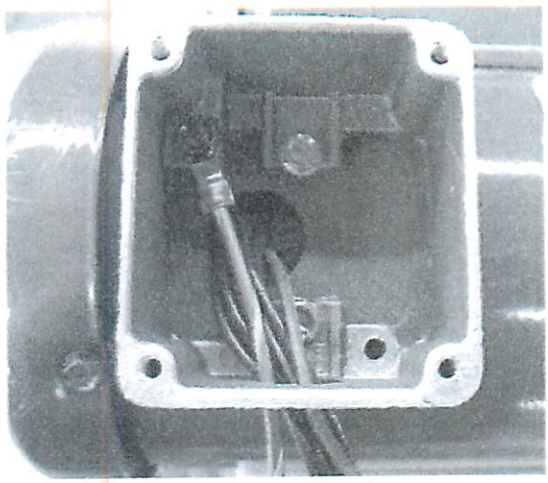
ALONG WITH A #10 STAR WASHER AND SECURE THE GREEN HEX HEAD SCREW BACK IN PLACE.

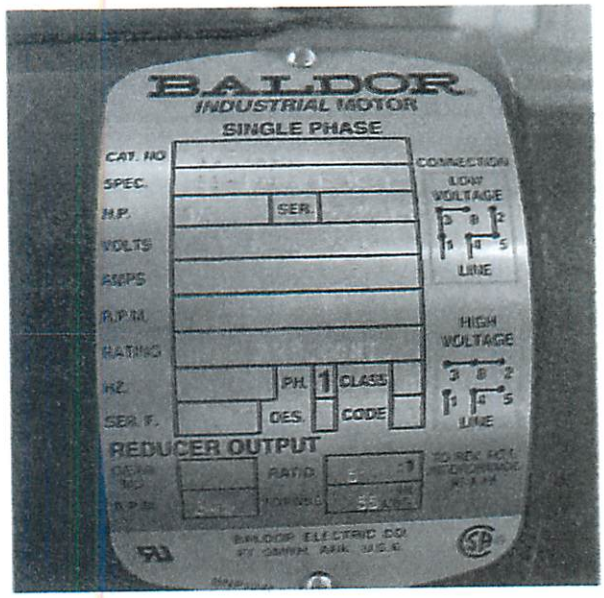
8) COVER WIRE BUNDLE THAT TOUCHES WIRE HOUSING EXIT OPENING WITH ELECTRICIAN TAPE. EXIT GROUND WIRE ALONG WITH THE OTHER MOTOR WIRES.

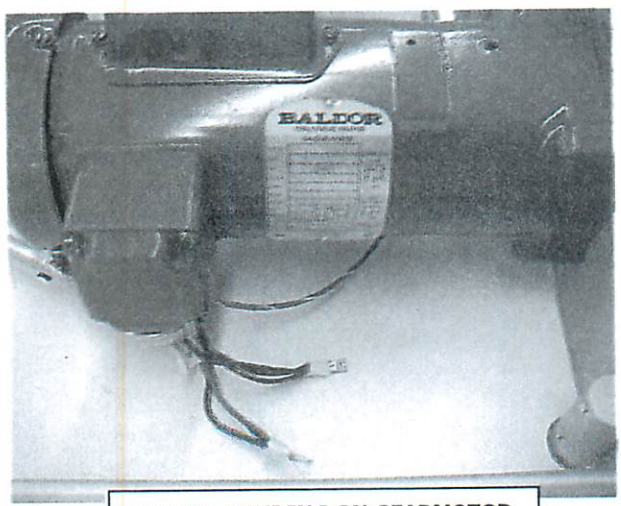
9) REPLACE MOTOR WIRE HOUSING COVER WITH ORIGINAL SCREWS.

10) FOLLOW THE WIRING DIAGRAM ON THE GEARMOTOR FOR A 110 VOLT (LOW VOLTAGE). THE MOTOR WIRES ARE INDIVIDUALLY NUMBERED. CONNECT WIRES AS PER DIAGRAM AND TERMINATE USING (2) YELLOW FEMALE (PRT293). ***THE 220 VOLT MACHINES RECEIVE A DIFFERENT MOTOR (PRM2001)***.

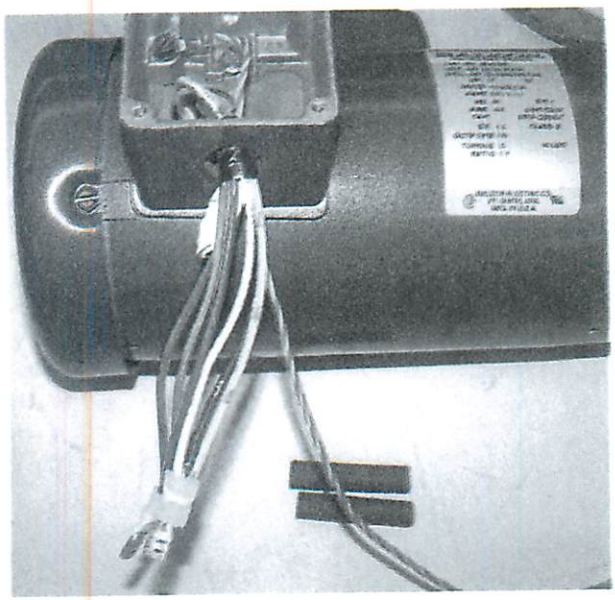
11) PLACE 2" OF 3/8" BLACK INSULATION TUBING (PRI164) CAB1 OVER FEMALE CONNECTORS FOR LATER USE. SET ASIDE.







110 VOLT WIRING ON GEARMOTOR



C30 AUTOCUTTER
SIDE PANEL ASSEMBLY

1) THE MAJORITY OF THE C30 AUTOCUTTER SIDE PANEL ASSEMBLY IS COMPLETED AFTER THE SIDE PANELS ARE ON THE STAND. TWO ASSEMBLIES PRECEDE STAND ATTACHMENT.

2) ATTACH (4) FEET MOUNTING SHAFT EXTENSIONS (LC38 048.4) AS30, TWO EACH ON THE BOTTOM OF THE LEFT SIDE PANEL (C30 090.4LA) AS23 AND THE RIGHT SIDE PANEL (C30 090.4RA) AS24. USE (8) 5/16-18 X ¾ FHSH INSERTED FROM OUTER COUNTERSUNK HOLES.

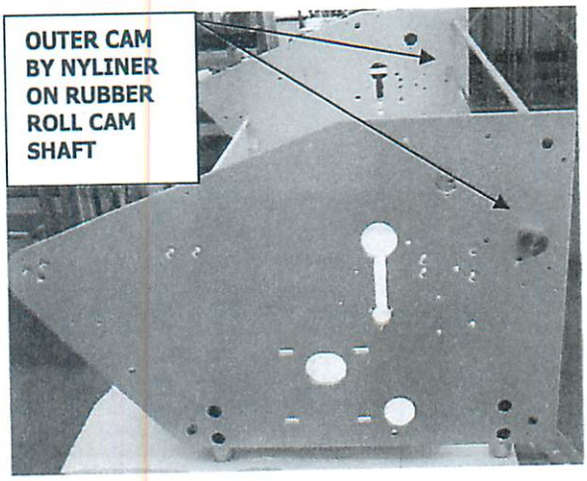
3) ATTACH THE BOTTOM HOUSING (C30 093.4A) AS23 BETWEEN THE SIDE PANELS USING (4) 10 X ¾ PH SMS.

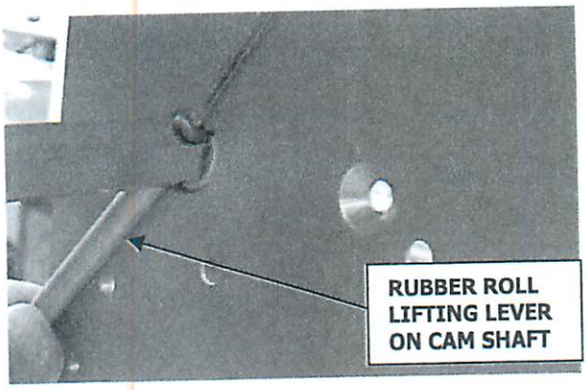
4) INSERT (2) WHITE BEARING NYLINERS (PRB059) AS02 FLANGE IN RECESS, FOR THE RUBBER ROLL CAM SHAFT (C30 134.4) AS23. INSERT CAM SHAFT, ORIENTED WITH INNER HOLES UPWARD/INWARD AND SECURED ON THE OUTER SIDE PANELS WITH (2) CAMS (C25 133.4) AS11. *CRITICAL THAT THE CAMS* ARE FLAT SIDE DOWNWARD AND SET SCREW UPWARD. SECURE CAMS TO SHAFT WITH (2) 10-32 X 3/4 SS.

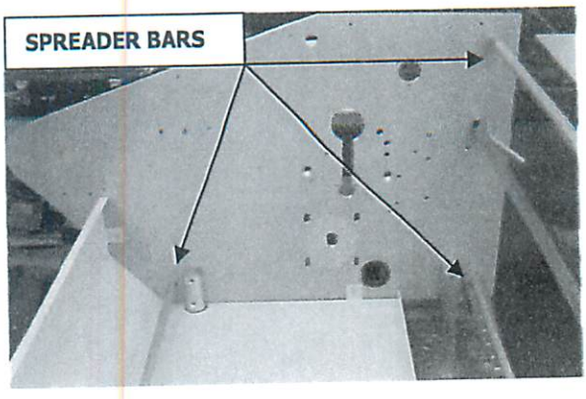
5) ATTACH (2) RUBBER ROLL LIFTING LEVERS (C25 132.4) AS11 ONTO THE RUBBER ROLL CAM SHAFT THROUGH THE HOLES ON THE CAM SHAFT. USE (2) 10-32 X ¾ BHSH. CRITICAL: FLAT OF CAM SHOULD BE DOWNWARD AND LIFTING LEVER SHOULD BE DOWNWARD.

6) *AFTER* THE RUBBER ROLL CAM SHAFT IS INSTALLED ADD (3) SPREADER BARS (C30 111.4) AS23. *BEFORE* SECURING SPREADER BARS ADD (2) EXIT TABLE SUPPORT BARS (C30 306.4) AS11 ORIENTED WITH THE NOTCHED CHANNELS FACING *UPWARD*, ONTO THE REAR BOTTOM SPREADER BAR. THEN









SECURE ALL THREE SPREADER BARS WITH (6) ¼-20 X ¾ BHSH.

7) INSERT (1) 10-32 X ¾ BHCS FROM THE INSIDE REAR LEFT SIDE PANEL FOR THE GROUND WIRE CONNECTIONS. ON THE OUTSIDE ADD A #10 STAR WASHER.

8) MOVE THE CHASSIS SKELETON ONTO THE STAND ASSEMBLY. ***REMEMBER*** THE COUNTERBORED HOLES ON THE BOTTOM FRONT WIDTH SPANNER OF THE STAND FACE THE REAR OF THE CUTTER. SECURE THE FEET MOUNTING SHAFT EXTENSIONS TO THE STAND USING (4) ½-13 X 2 ½ HEX BOLTS (.500HDA40) CP04 WITH A ½ FLAT WASHER SAE (.500JJC01) ON EACH BOLT. USE A WRENCH TO TIGHTEN.

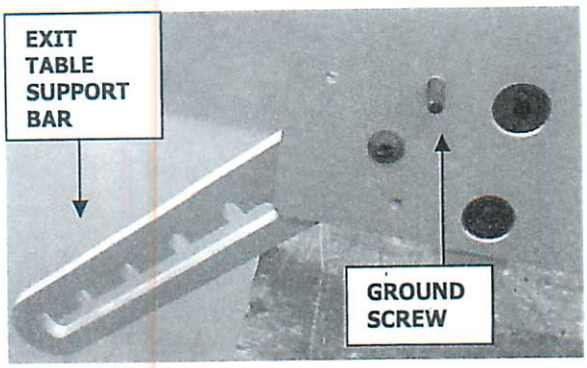
9) INSERT (2) SNAP BUSHINGS (PRB088) AS27, ONE PER SIDE PANEL, FLANGE OUTWARD, TO HOLD HARNESS WIRES.

10) INSERT (1) SNAP BUSHING (PRB062) CP03 ON THE UPPER LEFT SIDE PANEL, FLANGE INWARD FOR POSITION SENSOR.

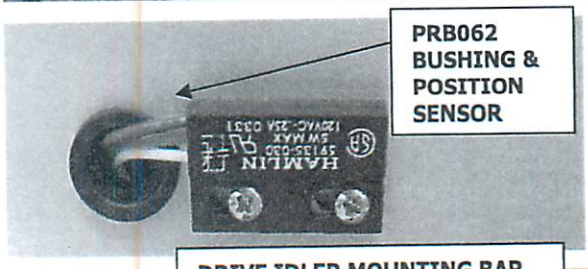
11) SECURE THE HAMLIN POSITION SENSOR (PRS360) AS21 TO THE INNER LEFT SIDE PANEL. POSITION THE RED WIRE UPWARD AND SECURE WITH (2) 4-40 X 3/8 PH. INSERT WIRES THROUGH SNAP BUSHING. TRIM RED WIRE TO 1 ½" ON OUTER SIDE PANEL AND CLEAR CAP WITH A (PRT289).

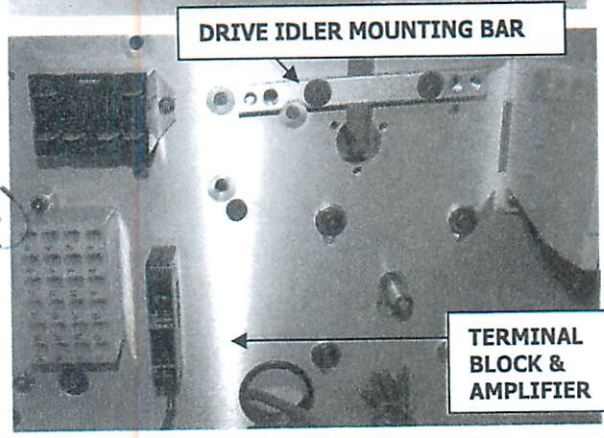
12) SECURE THE DRIVE IDLER MOUNTING BAR (C25 055.4) AS11 TO THE OUTSIDE LEFT SIDE PANEL THROUGH THE COUNTERSUNK HOLES INTO THREADS. USE (2) ¼-20 X ¾ FHSH. ORIENT NOTCH DOWNWARD TOWARD REAR.

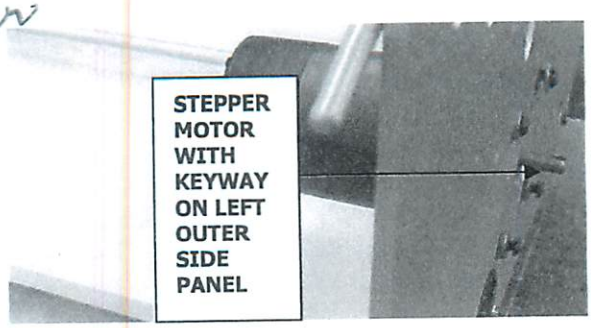
13) ATTACH THE PREWIRED STEPPER MOTOR (PRM2102) AS24 TO LEFT SIDE PANEL, WIRES FACING THE REAR OF THE CUTTER. USE (4) ¼-28 X ¾ BHSH WITH (4) ¼ X 5/8 X 1/8 FLAT WASHERS. LOOSELY SECURE TO UPPER CHANNELS IN SIDE PANEL.











14) SECURE THE USD TERMINAL BLOCK (PRT150) ~~AS21~~ THROUGH THE DIAGONAL OPENINGS ON THE LEFT SIDE PANEL WITH #1-4 UPWARD. USE (2) 8-32 X ¾ SHCS WITH (2) #8 FLAT WASHERS.

15) RIGHT OF THE TERMINAL BLOCK SECURE THE OMRON AMPLIFIER (PRC276) ~~AS21~~ BRACKET THROUGH THE SLOTTED HOLES WITH (2) 4-40 X 3/8 FH. SNAP THE AMPLIFIER ONTO THE BRACKET WITH THE WIRES DOWNWARD. PLACE WIRES THROUGH PRB088 BUSHING.

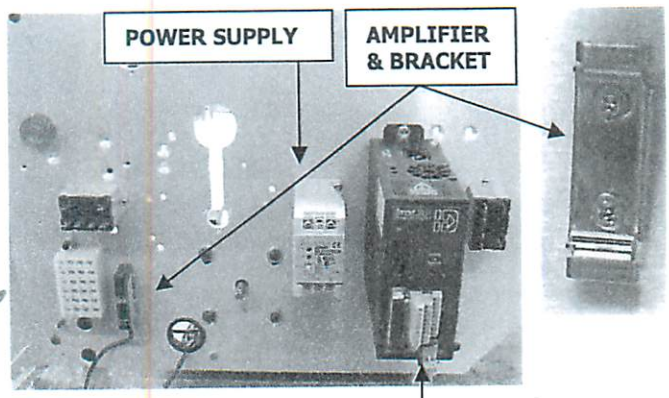
16) SECURE (2) <u>120 A/C VOLT</u> COIL RELAYS (PRR150) ~~AS21~~. THE ***DOUBLE TERMINALS*** FACE UPWARD ON THE HORIZONTAL RELAY ABOVE THE TERMINAL BLOCK AND FACE RIGHT/FRONT ON THE VERTICAL RELAY BY SMART STEP. USE (4) 8-32 X ¼ RH.

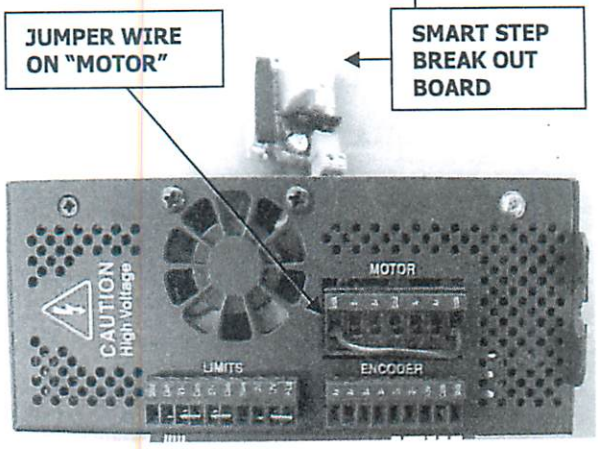
17) SECURE THE OMRON POWER SUPPLY (PRC278) ~~AS21~~ ORIENTED WITH LINE, NEUTRAL AND GROUND DOWNWARD. USE A LONG SCREWDRIVER TO THREAD (2) 8-32 X ½ PH DIAGONALLY.

18) CHECK SMART STEP (PRM2101) ~~AS24~~ BOTTOM BY ENCODER FOR JUMPER WIRE AND CONNECTORS. SECURE SMART STEP TO LEFT SIDE PANEL USING A 10-32 X ¼ TH IN THE TOP TAP AND A 10-32 X 3/8 TH IN THE BOTTOM SLOT. CONNECT THE GREEN BREAK OUT BOARD TO SMART STEP USING (2) 4-40 X ¼ FH.

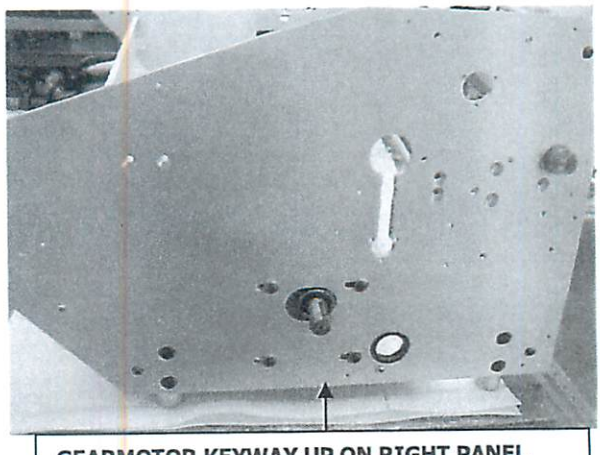
19) FROM THE OUTSIDE OF THE LEFT SIDE PANEL INSERT (2) RUBBER INSULATION GROMMETS (PRB105) ~~AS21~~. OPEN HOLES WITH SMALL SCREWDRIVER.

20) ON THE <u>RIGHT SIDE PANEL</u> INSERT PREWIRED GEARMOTOR FOR C25 (PRM1990) ~~AS23~~ WITH THE MOTOR HOUSING FACING FRONT. SNUG THE SCREWS TO THE REAR OF THE MACHINE THROUGH THE CHANNELED OPENINGS. USE (4) ¼-28 X ¾ BHSH WITH A ¼ X 5/8 X 1/8 FLAT WASHER ON EACH. THE MOTOR SHAFT KEYWAY FACES UPWARD. DO NOT OVER TIGHTEN AS MOTOR WILL





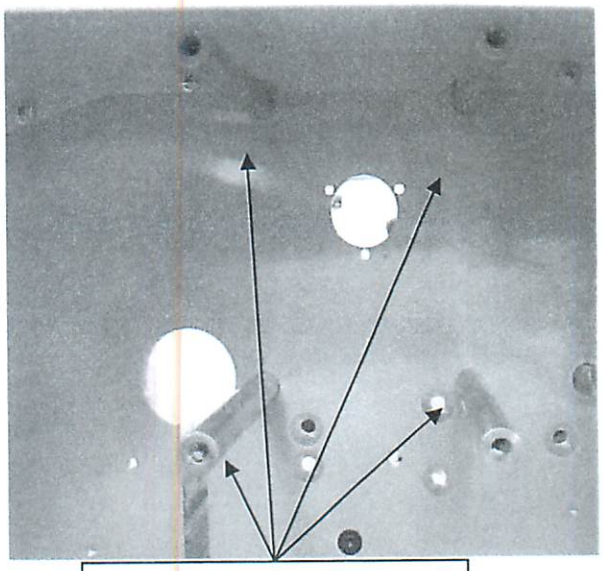




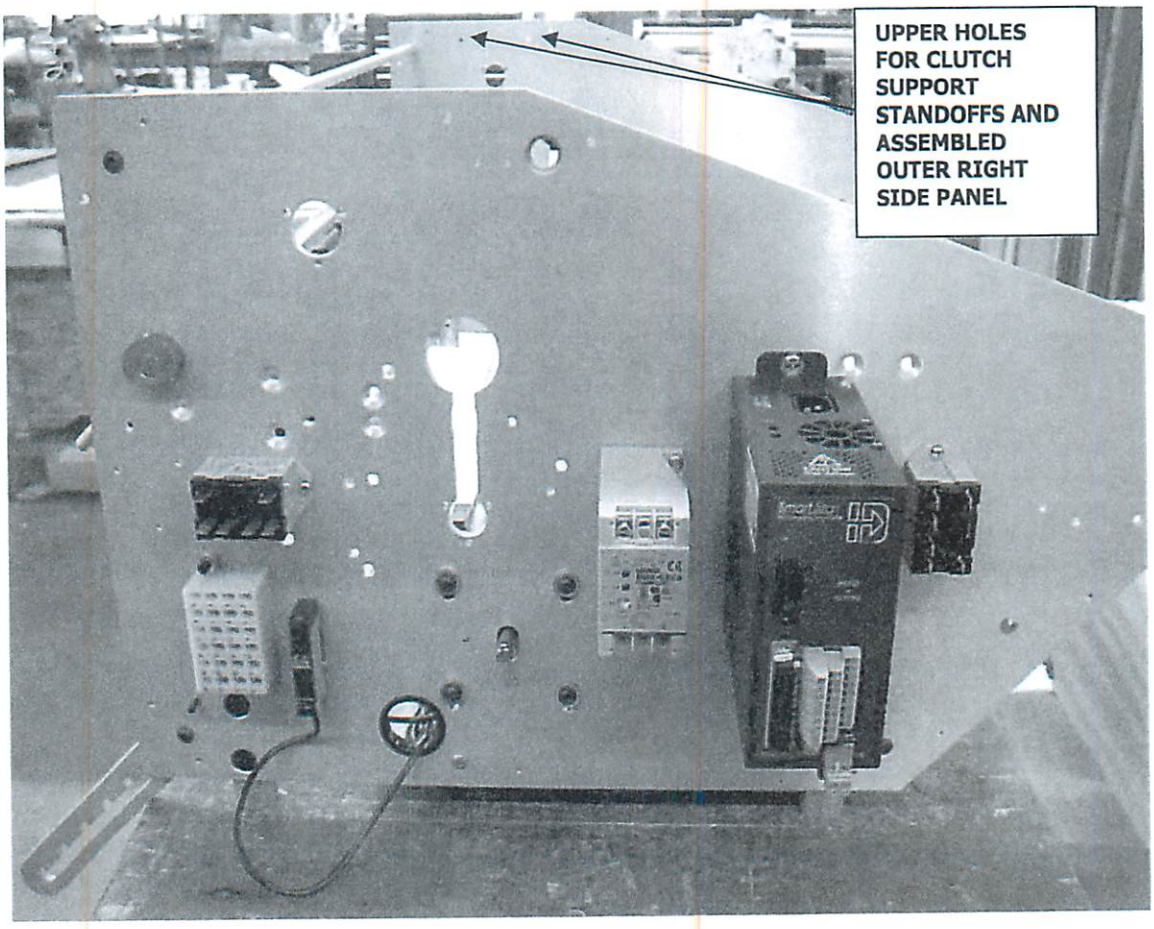
BE ADJUSTED LATER.

21) TOWARD THE RIGHT AND ABOVE THE GEARMOTOR ATTACH (4) CLUTCH SUPPORT STANDOFFS (C25 203.4) ~~AS11.~~ USE (4) ¼-20 X ¾ FHSH IN THE COUNTERSUNK OPENINGS ON THE INNER RIGHT SIDE PANEL.

Rack 11



CLUTCH SUPPORT STANDOFFS



UPPER HOLES FOR CLUTCH SUPPORT STANDOFFS AND ASSEMBLED OUTER RIGHT SIDE PANEL

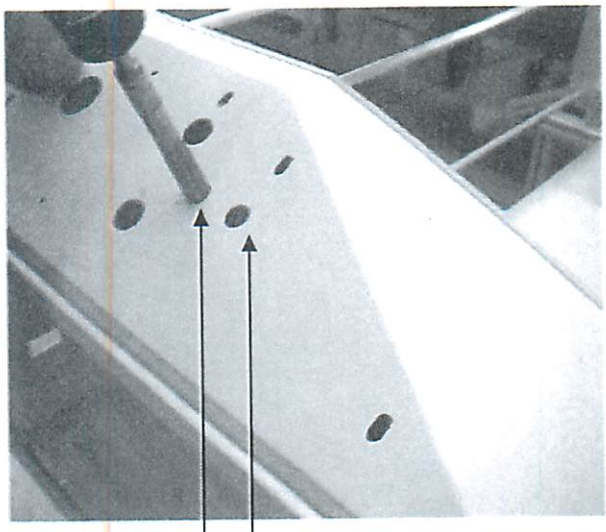
C30 AUTOCUTTER HOUSING ASSEMBLY

1) ATTACH THE LEFT SIDE HOUSING (C30 094.4L) AS17 TO THE LEFT SIDE PANEL USING (14) 10-32 X ¼ TH. ANGLE A LONG SCREWDRIVER THROUGH THE TOP ACCESS OPENING AND CONNECT THAT SCREW TO HOLD HOUSING IN PLACE. INSERT THE REMAINING SCREWS. DO NOT USE THE REAR TOP THREADS.



2) WITH A 5/8 .625 REAMER OPEN THE APERTURES FOR THE START (GREEN) AND STOP (RED) PUSHBUTTON SWITCHES, LOCATED SIDE BY SIDE ON THE LEFT HOUSING.

3) CENTER AND ADHERE NRTL AUTOCUTTER CONTROL PANEL LABEL (LAB107A) RACK 13 OVER LEFT HOUSING SWITCH APERTURES, COVERING SCREW ACCESS HOLES. CUT LABEL TO EXPOSE UPPER E-STOP WASHER "CATCH."



4) FROM AS08 ALIGN YELLOW E-STOP WASHER (PRS375) INTO "CATCH." SEPARATE E-STOP SWITCH (PRS374) BY HOLDING SPRING ON YELLOW SCREW SECTION DOWNWARD AND TWISTING. UNTHREAD BROWN NUT AND INSERT RED BUTTON WITH "TOP" INDICATION UPWARD INTO E-STOP WASHER. RETHREAD NUT AND TIGHTEN WITH CASTLE TOOL. E-STOP SWITCH CAN BE WIRED OFF OR ON RED BUTTON.

5) BELOW THE E-STOP SWITCH INSERT THE IDEC 2 POSITION KEY SWITCH (PRS003) RACK 12, "TOP" INDICATION UPWARD, ***BLUE SIDE FACES THE REAR.*** THE KEY REMAINS IN THE SWITCH. TIGHTEN WITH CASTLE TOOL.



6) FROM RACK 13 SNAP THE 16MM GREEN PUSHBUTTON (PRS361) SWITCH INTO THE "START" LOCATION ON THE CONTROL PANEL. SNAP THE 16MM RED PUSHBUTTON (PRS362) SWITCH INTO

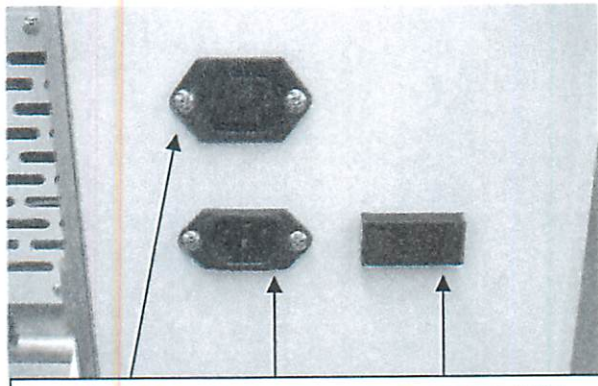
THE "STOP" LOCATION ON CONTROL PANEL. THE CURVED COLORED SECTION OF SWITCHES ORIENT TO TOP AND BOTTOM WHILE THE DEPRESSED DARK SIDES ORIENT FRONT AND BACK. TIGHTEN WITH CASTLE TOOL. CONNECT (2) OF THE 16MM NO CONTACT BLOCK (PRS363) SWITCH SECTION WITH *TERMINAL POSTS FACING OUTWARD*.



7) INSERT (2) 15 AMP FUSES (PRF108) AS07 INTO A LITTLEFUSE FUSE HOLDER (PRF145) RACK 12. ONE FUSE IS A SPARE. SNAP THE FUSE HOLDER INTO THE REAR HOUSING.

8) WITH THE SINGLE TERMINAL OPENING DOWNWARD INSERT THE QUICK DISCONNECT AC OUTLET (PRR253) RACK 11 INTO THE UPPER REAR POSITION ON THE LEFT HOUSING. SECURE TO HOUSING WITH (2) 6 X 3/8 TH SMS.

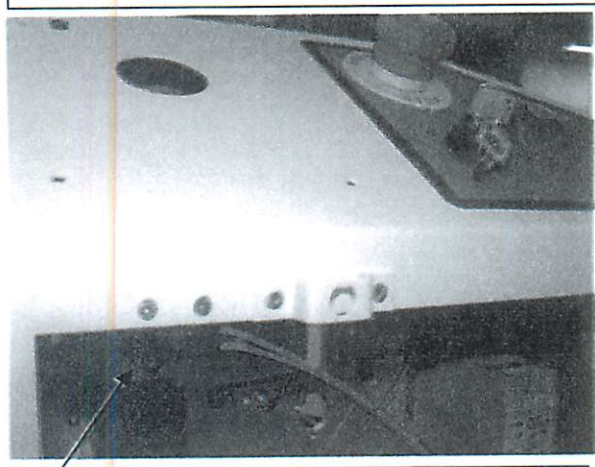
9) BELOW THE QUICK DISCONNECT AC OUTLET INSERT THE RECEPTACLE CORD PANEL MOUNT (PRC117) AS07, POSITIONING THE SINGLE TERMINAL POST DOWNWARD. USE (2) 6 X 3/8 TH SMS TO SECURE THE RECEPTACLE TO THE HOUSING.



QUICK DISCONNECT~RECEPTACLE~15 AMP FUSE

10) COUNTERSINK UPPER OPENINGS ON LEFT AND RIGHT HOUSING LIP FOR THE 4-40 FH. SECURE A HAMLIN PROXIMITY SWITCH MAGNET (PRS351) RACK 1 WITH (2) 4-40 X 3/8 FH ON THE OUTSIDE AND (2) 4-40 HEX NUTS ON THE INSIDE. WIRES FACE FRONT ON LEFT SIDE AND REAR ON RIGHT SIDE.

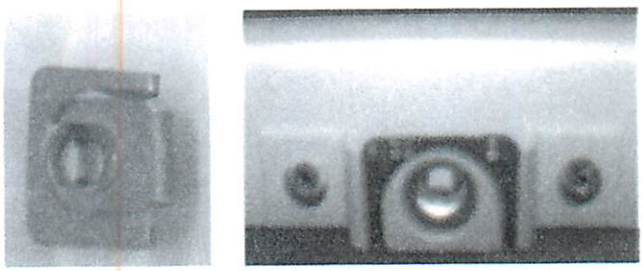
11) OPEN THE HOUSING LIP HOLES AND THE (4) DOOR LATCH BRACKET (I30 097.4) RACK 15 HOLES WITH A 1/8 DRILL. SECURE THE DOOR LATCH BRACKETS TO THE RIGHT AND LEFT HOUSING LIP WITH 1/8 ROUNDHEAD POP RIVETS.



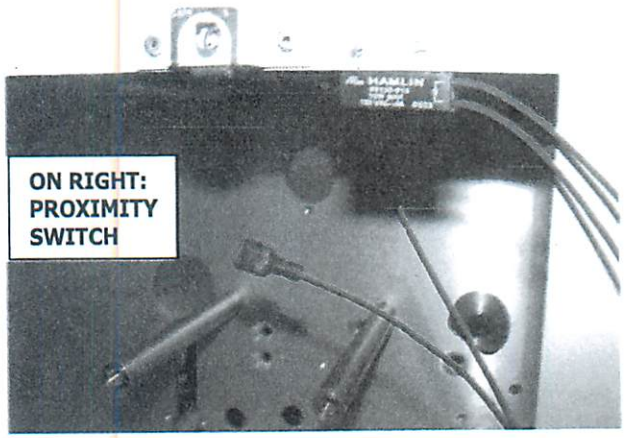
MAGNET ~ DOOR LATCH BRACKET ~ 1/8 DRILL

12) FROM THE ¼ TURN LATCH SET (PML002) AS08 CLIP (2) ¼ TURN FASTENER NUTS ONTO THE DOOR LATCH BRACKETS, WITH THE SQUARE SIDE OF THE NUT OUTWARD, CENTER OVER DOOR LATCH BRACKET OPENINGS.

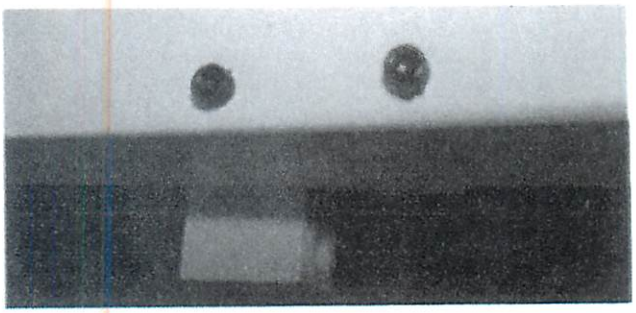
13) CONNECT THE RIGHT SIDE HOUSING (C30 094.4R) AS16 TO THE RIGHT SIDE PANEL USING (14) 10-32 X ¼ TH. DO NOT USE THE THREADS ON THE UPPER REAR, ACROSS FROM THE OPEN THREADS ON THE LEFT SIDE PANEL.



14) AFTER COUNTERSINKING THE (2) 4-40 OPENINGS ON RIGHT SIDE HOUSING LIP, SECURE A HAMLIN PROXIMITY SWITCH MAGNET (PRS351) RACK 1. USE (2) 4-40 HEX NUTS ON INSIDE. CRIMP A MALE CONNECTOR (PRT330) ONTO (1) RED MAGNET WIRE. LEAVE THE OTHER RED WIRE OPEN.

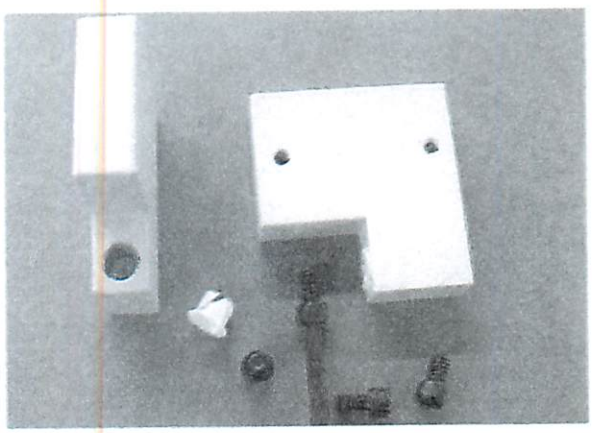


15) THE RIGHT SIDE HOUSING REQUIRES ANOTHER YELLOW E-STOP WASHER SWITCH AND E-STOP SWITCH. FIT THE E-STOP WASHER INTO HOUSING CATCH AND THEN INSTALL THE E-STOP SWITCH. *"TOP" INDICATION INWARD*. RETHREAD THE NUT ON THE RED BUTTON SECTION AND TIGHTEN WITH THE CASTLE TOOL. USE THE SAME INSTALLATION PROCEDURE AS LEFT SIDE HOUSING. THERE IS NO LABEL UNDER THE E-STOP WASHER ON THE RIGHT SIDE.



16) SNAP (2) FASTENER NUTS ONTO THE UPPER RIGHT HOUSING LIP POSITIONED AS THE LEFT HOUSING.

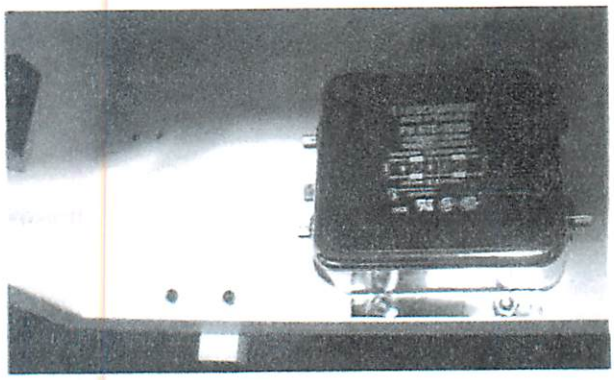
17) INSERT (4) WHITE NYLINER BEARINGS 3/16 ID (PRB202) RACK 1 INTO (4) STATIONARY HINGE BLOCKS (C25 105.4) RACK 11. ORIENT (2) HINGE BLOCKS WITH BOTH *NYLINER BEARINGS OUTWARD* AND SECURE TO BOTH LOWER HOUSINGS WITH (4) 6-32 X ¼ SHCS ON EACH SIDE.



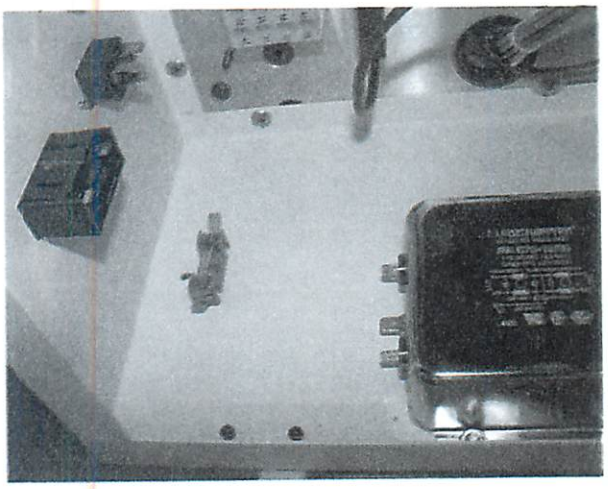
18) SECURE THE POWER FILTER (PRF142) AS07 TO THE LOWER REAR LEFT HOUSING. THE GROUND TERMINAL POST SHOULD BE FACING THE REAR/LEFT. USE (4) 8-32 X 3/8 TH FROM THE BOTTOM UPWARD, SECURED WITH (4) #10 KEPS HEX NUTS ON THE *INNER HOUSING*.



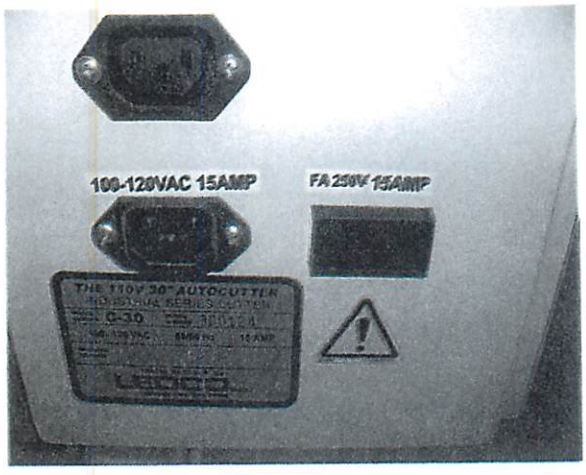
19) FOR A <u>110V AUTOCUTTER</u> SECURE (1) FUSE HOLDER (PRF126) AS07 TO THE REAR LEFT HOUSING UNDER THE RECEPTACLES. SECURE THE FUSE HOLDER WITH A 6-32 X 3/8 TH ON THE INNER HOUSING AND THREAD A #6 KEPS HEX NUT ON THE HOUSING UNDERSIDE.



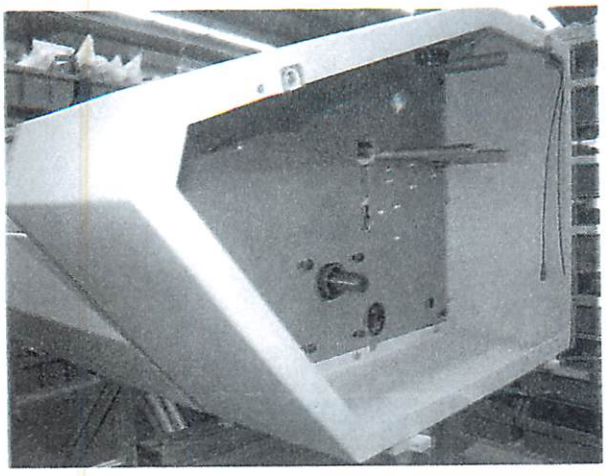
20) INSERT A "SLO BLO" CERAMIC 8 AMP FUSE (PRF124) AS07 INTO THE FUSE HOLDER. **** FOR THE <u>220V NRTL AUTOCUTTER</u> SECURE (2) FUSE HOLDERS AND INSERT (2) "SLO BLO" CERAMIC 8AMP FUSES (PRF124) AS07.

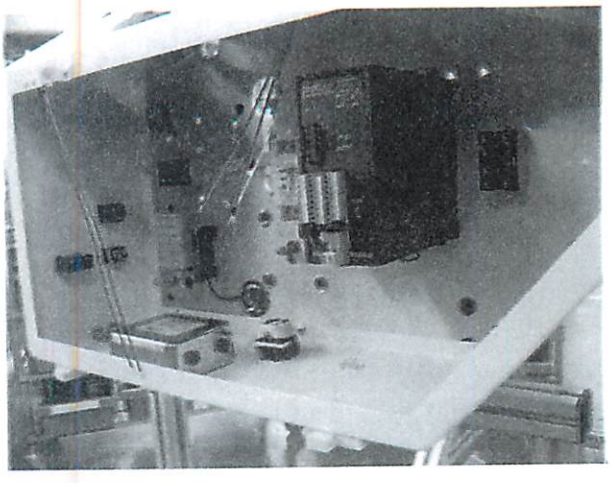


21) ON LEFT REAR HOUSING ADHERE A 100-120VAC 15 AMP LABEL NRTL (LAB120) AS09 ABOVE OUTLET PLUG. ***MAKE*** A 250V 15 AMP LABEL AND ADHERE ABOVE FUSE.



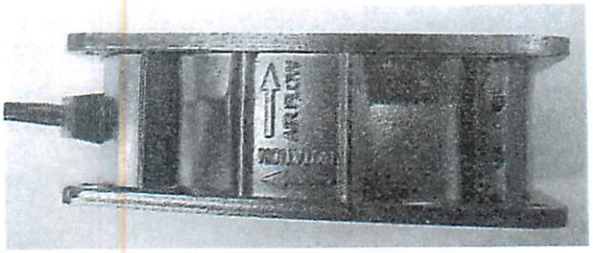




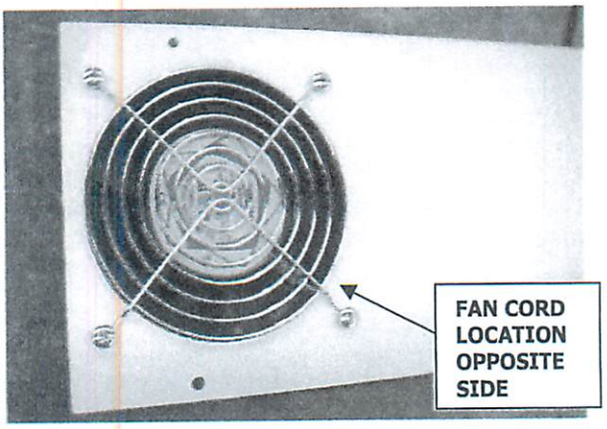


C30 AUTOCUTTER
BOTTOM HOUSING BACK DOOR & BOTTOM CUT OFF BLADE

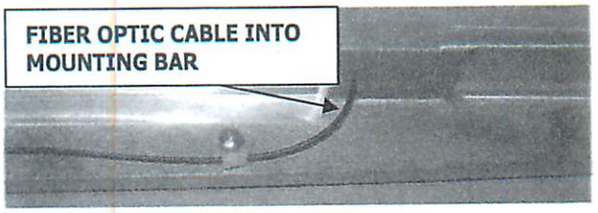
1) IN PREPARATION OF THE BOTTOM HOUSING BACK DOOR (C30 093.4B) AS16 FOR THE CHASSIS, FIRST INSERT THE FAN CORD (PRF116) LD04 INTO THE AXIAL FAN FOR EDUCATOR ***120VOLT*** (PRF133) LD04.

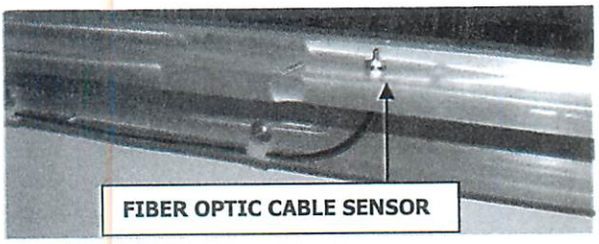


2) ORIENT THE FAN WITH THE CORD TOWARD THE INSIDE OF THE BOTTOM HOUSING BACK DOOR AND THE FAN'S AIR FLOW OUTWARD (SEE ARROWS ON FAN). THE FAN CORD FACES INWARD AND DOWN ALONG LOWER EDGE AND WILL LOCATE BEHIND GEARMOTOR. FROM THE OUTSIDE CONNECT THE SMALL FAN GUARD (PRF120) AS07 THROUGH THE BACK DOOR TO THE AXIAL FAN USING (4) 10 X ½ PH SMS. SET THIS ASSEMBLY ASIDE.

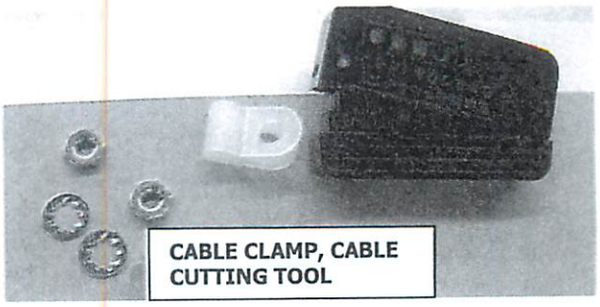


3) PREPARE A BOTTOM CUT OFF BLADE MOUNTING BAR (C30 110.4) AS16. BY THREADING AN OMRON FIBER OPTIC CABLE (PRC277) RACK 12 FROM THE BOTTOM UPWARD, INTO THE MIDDLE SECTION OF THE BOTTOM CUT OFF BLADE MOUNTING BAR. THREAD THE FIBER OPTIC SENSOR THROUGH THE BAR UNTIL IT IS FLUSH WITH UPPER LIP. SECURE WITH WASHER AND NUT PROVIDED IN FIBER OPTIC PACK. THE CABLE IS DELICATE, BE CAREFUL WHEN THREADING INTO THE CUT OFF BAR.



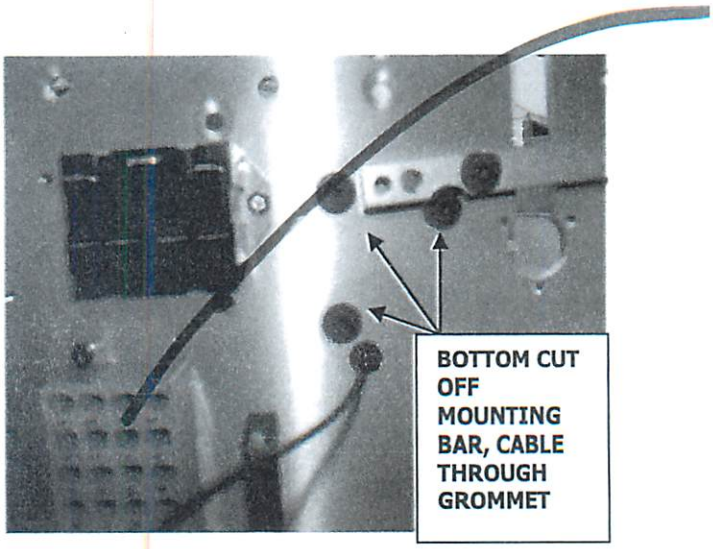


4) SECURE (4) CABLE CLAMPS (PRC271) RACK 12, ORIENTING THE CABLE LOOPS TO FACE ***DOWNWARD*** ONTO THE FRONT OF THE BOTTOM CUT OFF BLADE MOUNTING BAR, WHICH WILL HOLD THE FIBER OPTIC CABLE. SECURE CABLE CLAMPS WITH 8-32 X ¼ TH. SLIDE THE FIBER OPTIC CABLE THROUGH THE CABLE CLAMP LOOPS.



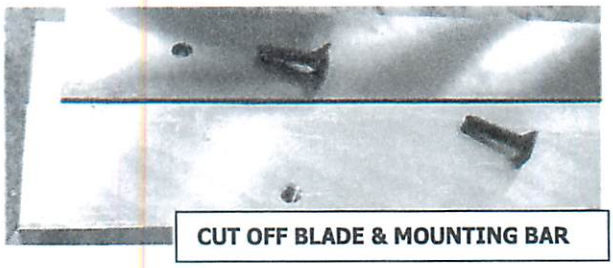
5) FROM THE REAR OF THE CUTTER SECURE

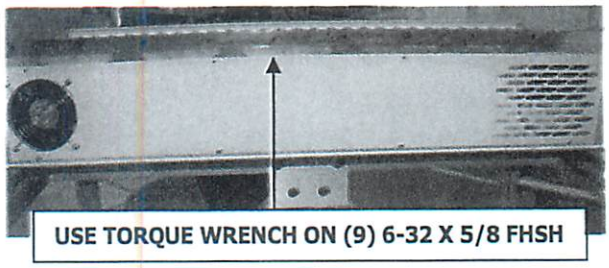
THE BOTTOM CUT OFF BAR, WITH THE FIBER OPTIC CABLE DOWNWARD AND IN FRONT BETWEEN THE SIDE PANELS. LOOSELY START THE (2) VERTICAL ¼-20 X ¾ FHSH THROUGH THE OUTER COUNTERSUNK OPENINGS TO ALIGH THE MOUNTING BAR. START THE ¼-20 X ¾ FHSH TOWARD THE FRONT OF THE CUTTER. TIGHTEN VERTICLE SCREWS FIRST, TIGHTEN THE THIRD SCREW ON EACH SIDE.



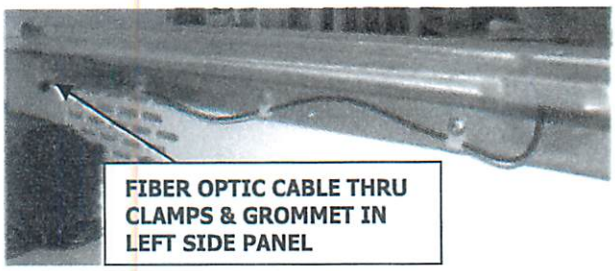
6) ***VERY CAREFULLY*** ALIGN A CUT OFF BLADE (C30 400.4) AS16 ***WHICH IS SHARP ON BOTH SIDES*** AND CAN BE HELD WITH A RAG TO PROTECT YOUR HANDS. THE CUT OFF BLADE WILL BE CLOSER TO THE RIGHT SIDE PANEL. LOOSELY START A 6-32 X 5/8 FHSH (.138BAB10) ON THE END THREADS BY THE RIGHT SIDE PANEL. RAISE THE BLADE AND START THE MIDDLE THREADS. START ALL REMAINING THREADS. USE THE BLADE'S WEIGHT TO LEVEL THE CUTTING BLADE. WITH A TORK WRENCH, TIGHTEN THE CENTER SCREW, TIGHTEN THE SCREWS ON EITHER SIDE OF THE CENTER, WORKING YOUR WAY OUTWARD TO THE ENDS. BE CAREFUL OF THE FIBER OPTIC CABLE.

Top threads

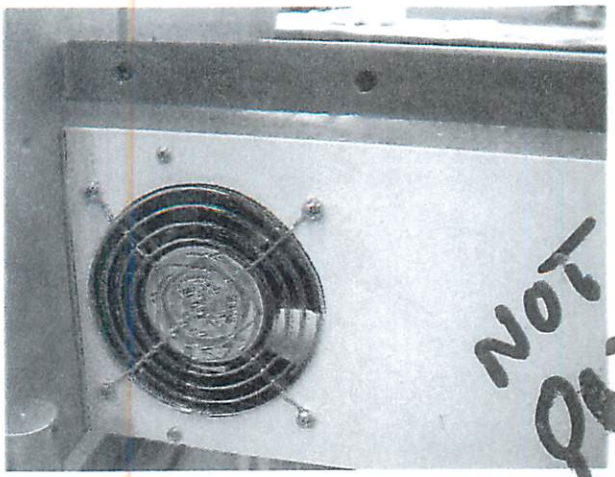




7) INSERT THE END OF THE FIBER OPTIC CABLE THROUGH THE LOWER GROMMET ON THE INNER LEFT SIDE PANEL, IN LINE WITH CLAMPS.



8) SECURE THE ASSEMBLED BOTTOM HOUSING BACK DOOR, WITH THE AXIAL FAN LOCATED BEHIND THE GEARMOTOR BY THE RIGHT SIDE PANEL. USE (4) 8 X 3/8 PH SMS TO CONNECT THE BOTTOM HOUSING BACK DOOR TO THE BOTTOM HOUSING LIP. LIFT THE DOOR AS YOU ARE TIGHTENING THE SCREW, SO YOU CAN SEE THE UPPER DOOR HOLES ALIGN WITH THE THREADS ON THE CUT OFF MOUNTING BAR.



9) CONNECT THE BOTTOM CUT OFF BLADE MOUNTING BAR TO THE UPPER PORTION OF THE BOTTOM HOUSING

Not Put Yet

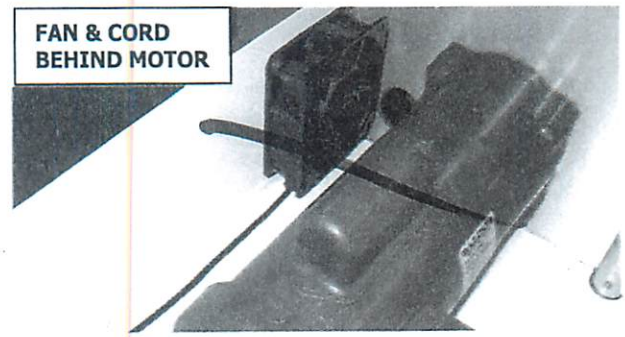
BACK DOOR USING (4) 8-32 X 3/8 RHMS ON THE LOWER TAPPED THREADS. ALWAYS BE AWARE OF THE SHARP, EXPOSED BLADE WHILE MAKING FURTHER ASSEMBLY. DO NOT CUT FIBER OPTIC CABLE ON BLADE WHILE WORKING.

10) ATTACH THE DANCER MOUNTING BAR (C30 288.4) AS17 TO THE INNER RIGHT SIDE PANEL. SOMETIMES THE ENDS OF THE DANCER MOUNTING BAR NEED TO BE COUNTERSUNK, OVER THE THREADS. USE (2) ¼-20 X ¾ FH SH THROUGH FRONT OF OUTER RIGHT SIDE PANEL.

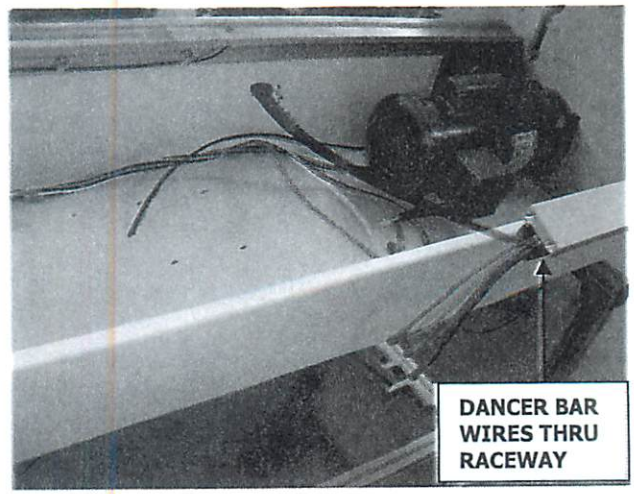
11) ALIGN 20" OF ELECTRICAL RACEWAY (PRC076) AS10 AFTER TRIMMING ENDS, WITH THE DANCER MOUNTING BAR UNDERSIDE. CENTER AROUND THE WIRE OPENING IN RIGHT SIDE PANEL, BETWEEN DANCER BAR SCREWS. ADHERE, BUT <u>DO NOT CLOSE RACEWAY</u>.

12) FROM THE LEFT SIDE PANEL SNAP BUSHING, INSERT WIRING HARNESS (PRW353) RACK 13 ENDS UNTIL THE HARNESS SPLITS WITH YELLOW WIRES. CONTINUE HARNESS THROUGH BOTTOM MOTOR COVER AND RIGHT SIDE. THE (4) LONGEST WIRES GO THROUGH DANCER BAR RACEWAY.









OBSOLETE

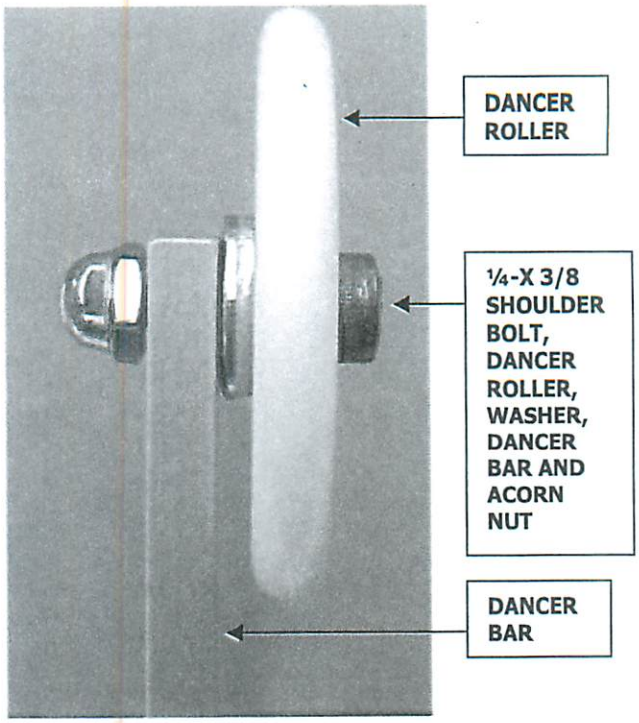
C30 AUTOCUTTER
DANCER BAR ASSEMBLY

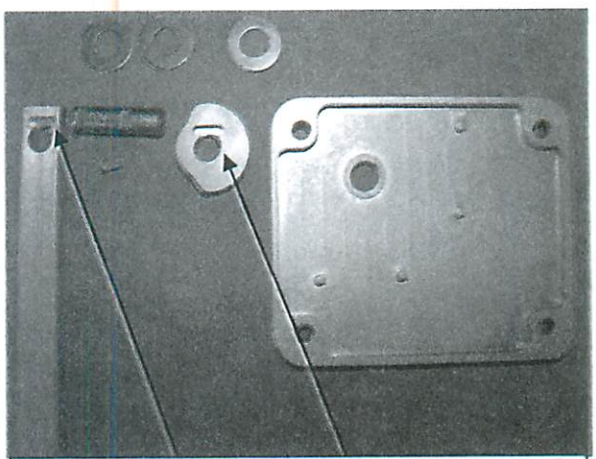
1) THE DANCER ASSEMBLY PURPOSE IS TO STOP THE CUTTER WHEN THE LAMINATING ROLL HAS STOPPED. THE DANCER ROLLER RAISES AS THE LAMINATE TIGHTENS. WHEN THE DANCER ROLLER REACHES A CERTAIN POINT THE ACTUATOR SWITCHES LOCATED IN THE DANCER HOUSINGS ENGAGE, TURNING OFF THE CUTTER.

2) PLACE APPROPRIATE DANCER ASSEMBLY PIECES ON A CLEAN WORKTABLE.

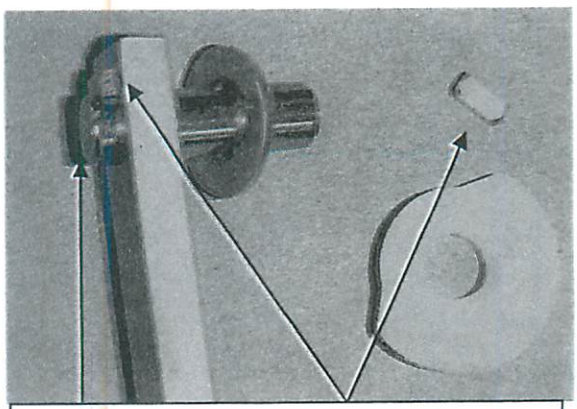
3) THE DANCER ROLLER (C30 292.4) RACK 11 IS CONNECTED TO THE DANCER BAR (C30 289.4) RACK 11 ORIENTED SO THE DANCER ROLLER IS ON THE RIGHT SIDE OF THE DANCER BAR AND THE ***ACORN NUT IS ON KEY SIDE***, FACING THE LEFT SIDE PANEL. INSERT A ¼-X 3/8 SHOULDER BOLT (.250IAC06) THROUGH THE DANCER ROLLER. ADD A ¼ X 5/8 X 1/8 FLAT WASHER ONTO THE SHOULDER BOLT. INSERT THE SHOULDER BOLT THREADS THROUGH THE DANCER BAR. SECURE SHOULDER BOLT TO DANCER BAR WITH A 10-32 ACORN NUT. USE A WRENCH TO TIGHTEN THE ACORN NUT.

4) ASSEMBLE THE UPPER SECTION OF THE DANCER BAR ORIENTED WITH THE LOWER DANCER ROLLER ON THE RIGHT AND THE ACORN NUT FACING LEFT. INSERT THE DANCER ACTUATING ROD (C30 290.4) RACK 11 THROUGH THE DANCER BAR FROM THE RIGHT, WITH THE KEYWAY CLOSEST TO THE EDGE PASSING THOUGH THE DANCER BAR. PLACE A 1/8 SQ X ¼ LG STRAIGHT KEY (H850 178.4) RACK 9 INTO THE LEFT KEYWAY AND SLIDE IT INTO THE KEYWAY APERTURE IN THE DANCER BAR. HOLD THE KEY IN PLACE AND SLIDE A 5/16 FLAT WASHER SAE ONTO THE RIGHT SIDE OF THE DANCER ACTUATING ROD. INSERT THE RIGHT END OF THE ROD INTO THE DANCER HOUSING LEFT (C30 287.4L) RACK 11. PLACE ANOTHER 5/16 FLAT WASHER SAE ON THE DANCER ROD. FIT A SECOND



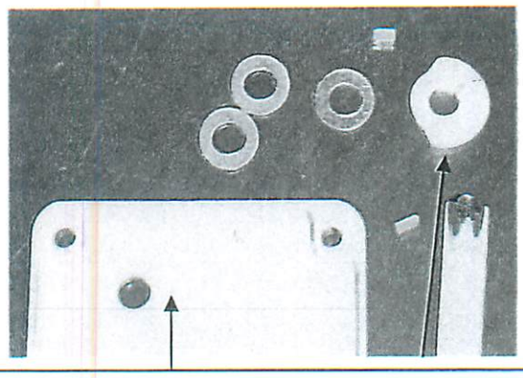


KEYWAYS: DANCER BAR, SWITCH ACTUATOR



DANCER ACTUATING ROD, (2) KEYS FOR ROD

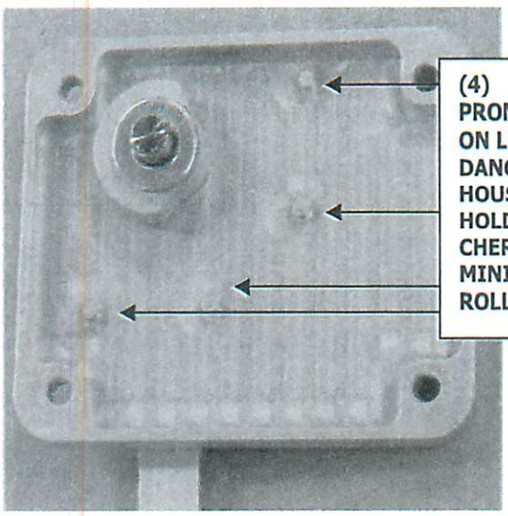
KEY INTO THE MIDDLE KEYWAY AND SLIDE THE DANCER SWITCH ACTUATOR (C30 291.4) RACK 11 OVER KEY. PLACE A THIRD 5/16 FLAT WASHER SAE ON THE END OF THE DANCER ACTUATING ROD.

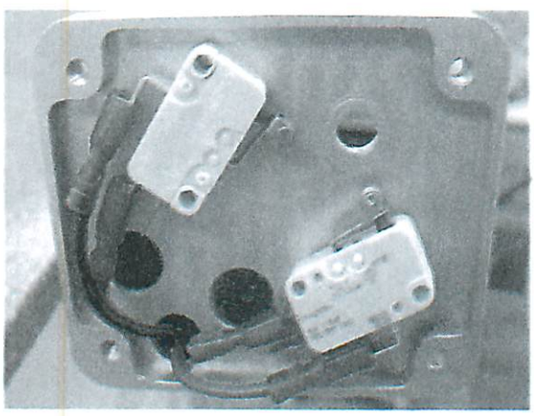


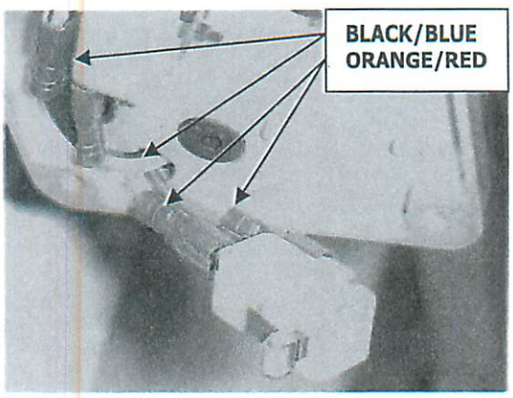
DANCER HOUSING, DANCER SWITCH ACTUATOR, KEYS

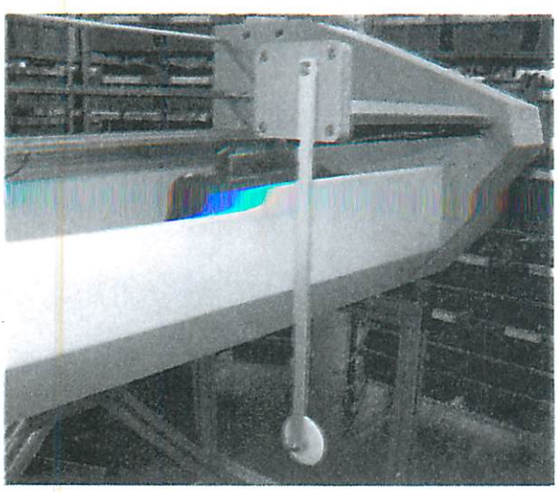
5) ATTACH THE DANCER HOUSING RIGHT (C30 287.4R) RACK 11 TO THE DANCER MOUNTING BAR WITH (2) ¼-20 X ¾ FHSH, RUNNING WIRES THROUGH THE WIRE OPENING. POSITION (2) CHERRY MINIATURE ROLLER SWITCHES (PRS370) RACK 13 <u>WITH THE ROLLERS FACING EACH OTHER</u>, ON THE PRONGS OF THE RIGHT HOUSING. WIRE LOWER RIGHT SWITCH: RED ON LONG SIDE, ORANGE OUTSIDE BOTTOM; UPPER SWITCH: BLACK ON LONG SIDE, BLUE ON MIDDLE POST.

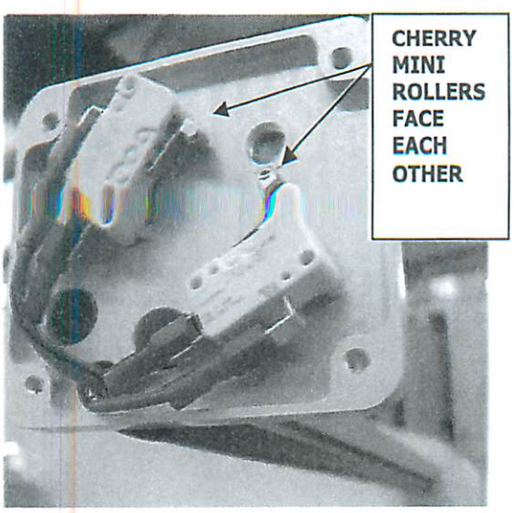
6) CONNECT BOTH DANCER HOUSING ASSEMBLIES TOGETHER, FITTING PRONGS ON CHERRY SWITCHES. USE (4) 10-32 X ½ FH TO SECURE HOUSINGS.











C30 AUTOCUTTER
GUILLOTINE/CLUTCH ASSEMBLY

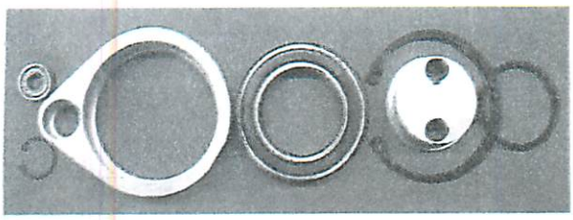
1) MAKE (2) OF THE FOLLOWING GUILLOTINE CONNECTING BLOCK ASSEMBLIES: PRESS A ROLLER BEARING (PRB075) RACK 12 INTO THE SMALLER COUNTERBORED OPENING ON THE GUILLOTINE CONNECTING BLOCK (C30 251.4) RACK 11. SECURE THE BEARING WITH ROTOR CLIP HO RING (PRC275) RACK 12.

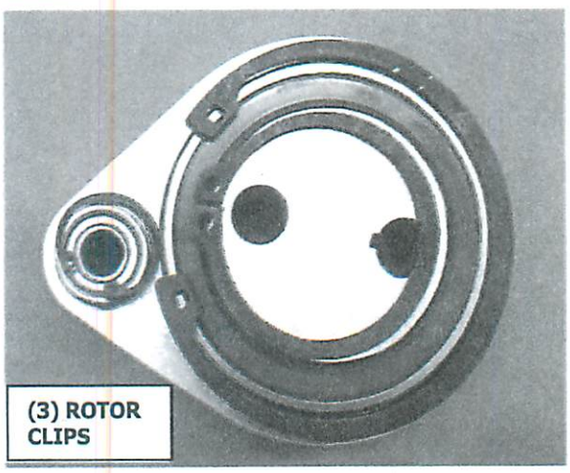
2) FROM RACK 12 PRESS A 6000 SERIES BALL BEARING (PRB106) INTO THE LARGER COUNTERBORED OPENING OF THE GUILLOTINE CONNECTING BLOCK. SECURE THE BEARING WITH A ROTOR CLIP HO RING (PRC274).

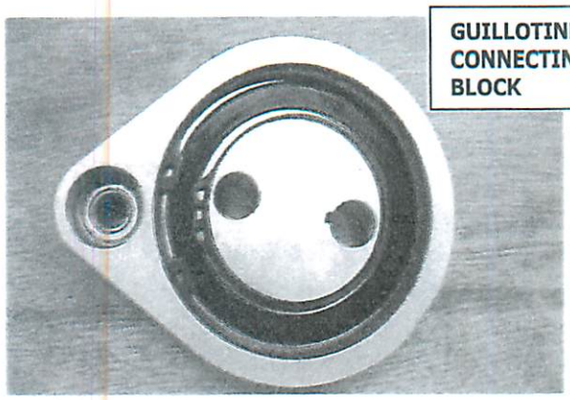
3) PRESS THE GUILLOTINE CAM (C30 250.5) RACK 11 INTO THE 6000 SERIES BALL BEARING, ***ALL ROTOR CLIPS SAME SIDE***. SECURE GUILLOTINE CAM WITH A ROTOR CLIP SH RING (PRC273) RACK 12.

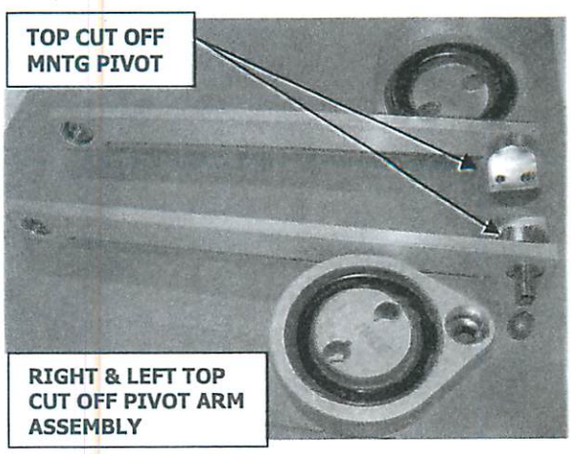
2) MAKE A RIGHT AND LEFT TOP CUT OFF PIVOT ARM ASSEMBLY: ARBOR PRESS (4) ROLLER BEARING (PRB075) RACK 12 INTO THE RECESSED ENDS OF (2) TOP CUT OFF PIVOT ARMS (C25 057.4) RACK 11. SECURE BEARINGS WITH (4) ROTOR CLIP HO RINGS (PRC275) RACK 12.

4) ORIENT THE OFFSET ENDS OF THE TOP CUT OFF PIVOT ARMS DOWNWARD ON A WORKTABLE, WITH THE ***ROTOR CLIP RINGS FACING INWARD***, TOWARD EACH OTHER. FROM THE INSIDE, INSERT THE SHAFT OF A TOP CUT OFF MOUNTING PIVOT (C25 116.4) RACK 11 THROUGH THE BALL BEARINGS OF THE RIGHT AND LEFT TOP CUT OFF PIVOT ARMS. PLACE A TOP CUT OFF SPACER (C25 216.4) RACK 11 ON EACH SHAFT. INSERT THE SHAFT THROUGH THE BALL BEARINGS IN THE GUILLOTINE CONNECTING BLOCKS, WITH THE ROTOR RINGS FACING







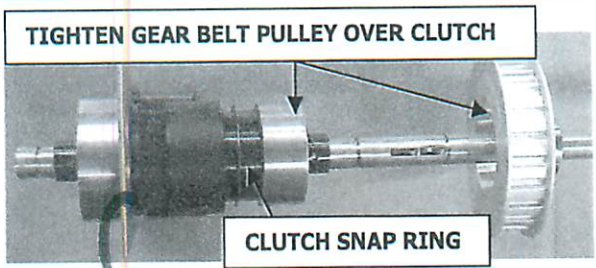


INWARD. FROM THE OUTSIDE OF THE GUILLOTINE MOUNTING BLOCKS ADD A ¼ FLAT WASHER SAE AND SECURE THIS ASSEMBLY WITH A ¼-20 X ¾ TH INTO THE CUT OFF MOUNTING PIVOT SHAFT THREADS. THE SCREW WILL TIGHTEN THE ROLLER BEARING.

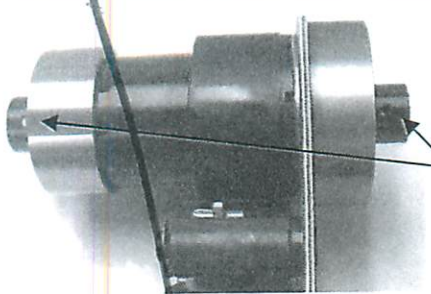


5) BEFORE PREPARING THE CLUTCH ASSEMBLY TEST THE BALL BEARING (PRB038) AS02 OVER THE CUT OFF CAM SHAFT (C30 253.4) AS23 TO SEE IF SHAFT NEEDS SANDING. IF SANDING IS REQUIRED WORK FROM THE CLUTCH END, PAST THE (3) SNAP RING GROOVES. SLIDE THE BALL BEARING PAST THE KEYWAYS AND ADD A CLUTCH GEAR BELT PULLEY (PRG001C) AS21 WITH <u>COUNTERSUNK HOLES FACING THE BALL BEARING, INWARD</u> OVER KEYWAYS.

TIGHTEN GEAR BELT PULLEY OVER CLUTCH

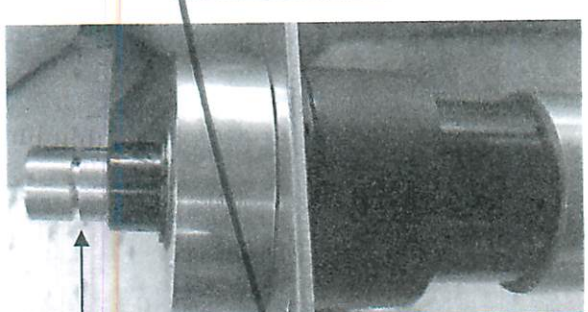


CLUTCH SNAP RING



SPRING PIN HOLES ON CLUTCH JOURNALS

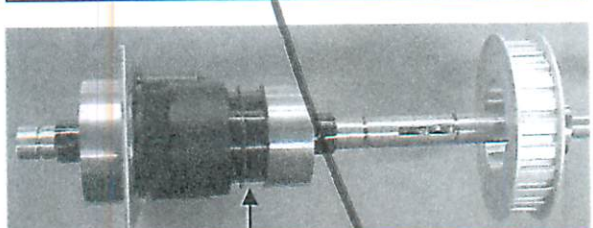
6) SLIDE THE 120V ½ STOP SUPER SERIES CLUTCH (PRC272) AS21 ONTO CAM SHAFT, <u>WITH CLUTCH PLATE TOWARD THE SHAFT END</u> AND THE CLUTCH <u>TERMINAL POSTS OPPOSITE THE KEYWAYS</u>. MEASURE 3/16" BETWEEN OUTER CLUTCH JOURNAL END AND FIRST RETAINING RING GROOVE.



3/16" BETWEEN CLUTCH JOURNAL & SNAP RING

7) ALIGN SPRING PIN OPENINGS UPWARD WITH KEYWAYS ON SHAFT. ADJUST SPRING PIN OPENINGS BY RELEASING SNAP RING ON CLUTCH, SLIDE CYLINDER OFF TEETH TO DESIRED POSITION, RETURN OVER TEETH AND RECHECK.

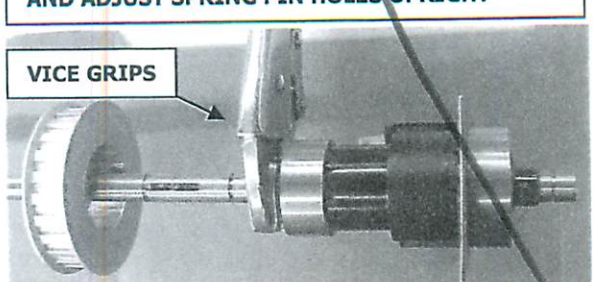
8) REMEASURE 3/16" DISTANCE, SECURE <u>INNER CLUTCH SHAFT</u> TO CAM SHAFT WITH VICE GRIPS. CHECK THAT SPRING PIN OPENINGS AND KEYWAYS ARE UP.



RELEASE CLUTCH SNAP RING, SLIDE CYLINDER AND ADJUST SPRING PIN HOLES UPRIGHT

9) USE A SHARP 1/8" DRILL TO OPEN SPRING PIN HOLES ON CAM SHAFT HALF WAY FROM ONE DIRECTION, TURN OVER CAM SHAFT AND OPEN FROM OTHER DIRECTION UNTIL THE OPENINGS MEET. SECURE CLUTCH TO CAM SHAFT THROUGH DRILLED OPENINGS WITH (2) 1/8 X ¾ SPRING PINS. CENTER SPRING PINS IN SHAFT. REMOVE VICE GRIPS.

VICE GRIPS



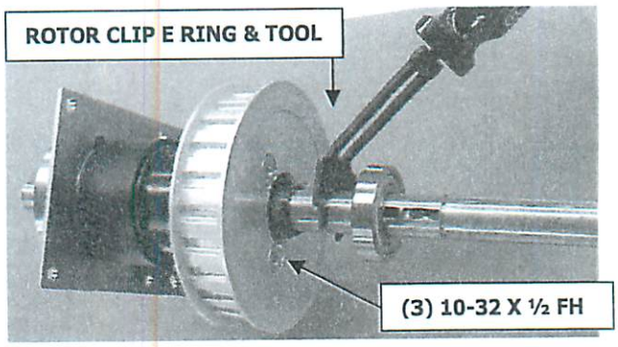
10) SLIDE THE CLUTCH GEAR BELT PULLEY OVER KEYWAYS, SPRING PIN AND CLUTCH

SHAFT. SECURE PULLEY TO INNER CLUTCH USING (3) 10-32 X ½ FH.

11) USE ATTACHMENT TOOL TO ADD A ROTOR CLIP E RING (PRC270) AS21 ONTO THE CUT OFF CAM SHAFT INTO RETAINING GROOVE WITH ROLLER BEARING ON KEYWAY SIDE. SLIDE THE BALL BEARING (PRB038) AS02 OVER KEYWAYS ON SHAFT.

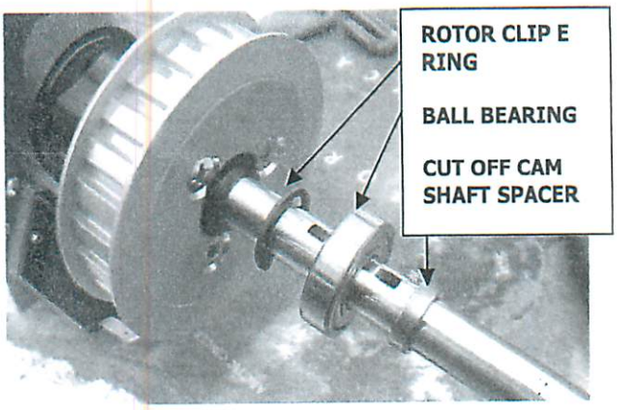
Pack 12

AS01



12) SLIDE A CUT OFF CAM SHAFT SPACER (C25 252.4) AS11 UP THE LENGTH OF THE CAM SHAFT, NEXT TO THE KEYWAYS.

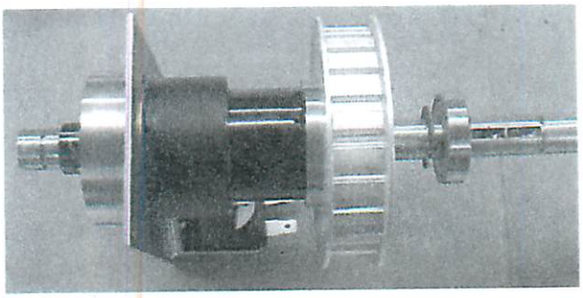
Pack 11

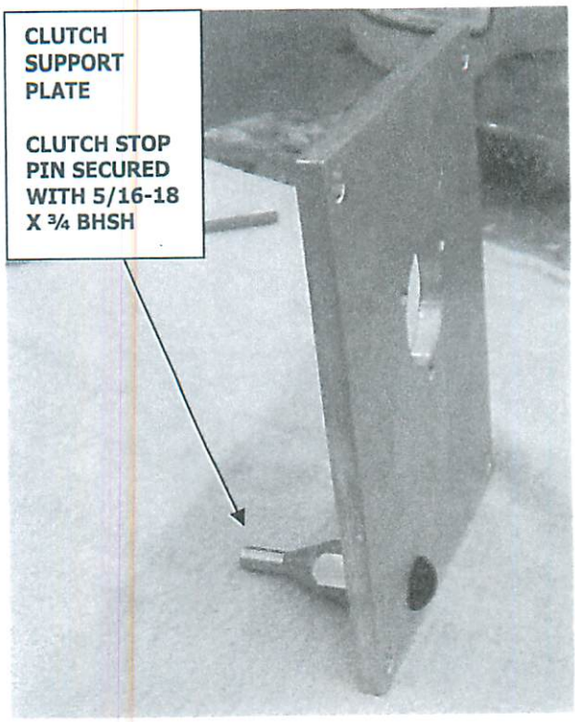


13) THE ASSEMBLY NOW ON THE CUT OFF CAM SHAFT WILL GO ON THE RIGHT SIDE PANEL. STORE THE ASSEMBLY UNTIL READY FOR CHASSIS COMPLETION.

14) PREPARE THE CLUTCH SUPPORT PLATE, (C30 204.4) AS11 BY ORIENTING IT WITH THE CLUTCH ASSEMBLY SO THE CLUTCH STOP PIN (C30 205.4) AS11 FACES INWARD TOWARD THE SIDE PANEL AND IS IN THE LOWER LEFT CORNER (TOWARD THE FRONT OF THE MACHINE). SECURE THE CLUTCH STOP PIN TO THE CLUTCH SUPPORT PLATE USING A 5/16–18 X ¾ BHSH FROM THE OUTSIDE, THROUGH THE SUPPORT PLATE INTO THE THREADS OF THE CLUTCH STOP PIN. STORE WITH CAM SHAFT ASSEMBLY.

FROM Pack 11



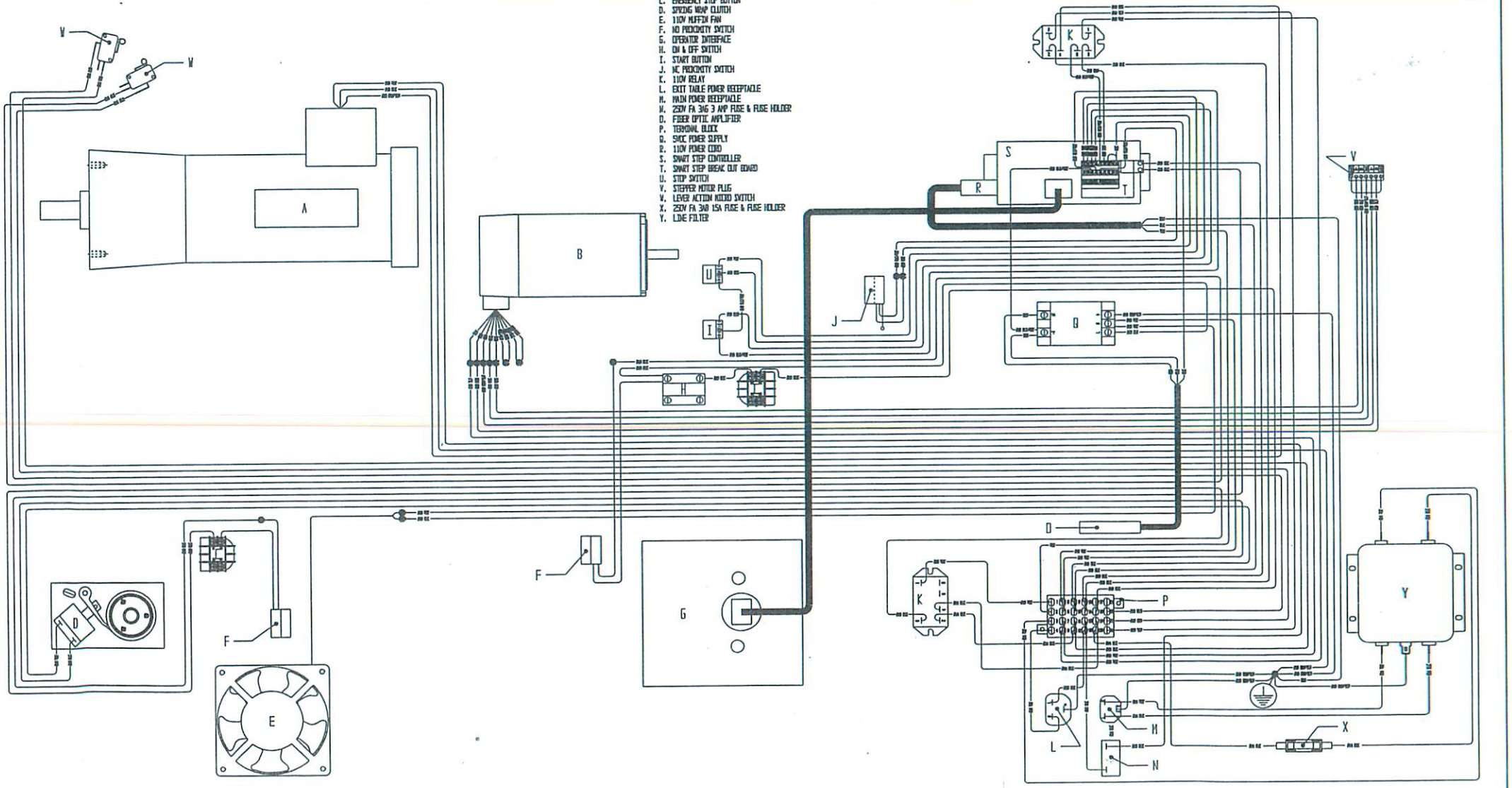


PRW353

30" AUTOCUTTER 100V - 120V WIRING DIAGRAM

LEGEND

A. 110V SPLIT CAPACITOR MOTOR
B. STEPPER MOTOR
C. EMERGENCY STOP BUTTON
D. SPRING WRAP CLUTCH
E. 110V MUFFIN FAN
F. NO PROXIMITY SWITCH
G. OPERATOR INTERFACE
H. ON & OFF SWITCH
I. START BUTTON
J. NC PROXIMITY SWITCH
K. 110V RELAY
L. EXIT TABLE POWER RECEPTACLE
M. MAIN POWER RECEPTACLE
N. 250V FA 3AG 3 AMP FUSE & FUSE HOLDER
O. FIBER OPTIC AMPLIFIER
P. TERMINAL BLOCK
Q. 5VDC POWER SUPPLY
R. 110V POWER CORD
S. SMART STEP CONTROLLER
T. SMART STEP BREAK OUT BOARD
U. STOP SWITCH
V. STEPPER MOTOR PLUG
W. LEVER ACTION MICRO SWITCH
X. 250V FA 3AB 15A FUSE & FUSE HOLDER
Y. LINE FILTER



C30 AUTOCUTTER 110V WIRING

1) WIRE THE LEFT SIDE OF THE CUTTER USING HARNESS FOR 30" AUTOCUTTER (PRW353) RACK 12. THE BUNDLE WITH QUICK CONNECT ENDS FACES THE REAR. KEEP WIRES AWAY FROM SCREW POINTS THAT HOLD BACK DOOR.

2) LAY OUT JUMPER WIRES IN BAG #1. FOLLOW WIRING DIAGRAM FOR 110V C30 AUTOCUTTER. CONNECT THE FULLY INSULATED JUMPER TERMINALS ONTO REAR 15 AMP FUSEHOLDER, RECEPTACLE AND AC OUTLET. THE QUICK CONNECT TERMINALS INSERT INTO THE USD TERMINAL BLOCK. ***IT IS CRITICAL TO HAVE QUICK CONNECT TERMINALS COMPLETELY INTO USD TERMINAL BLOCK OPENINGS.***

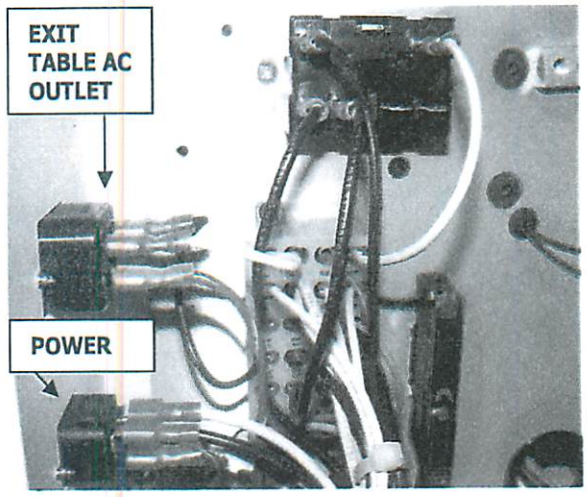
3) CONNECT AC OUTLET TO USD TERMINAL BLOCK, 18 GAUGE: 3 ½" WHITE= #4; 4" BLACK=#16; 6" GREEN TO GROUND.

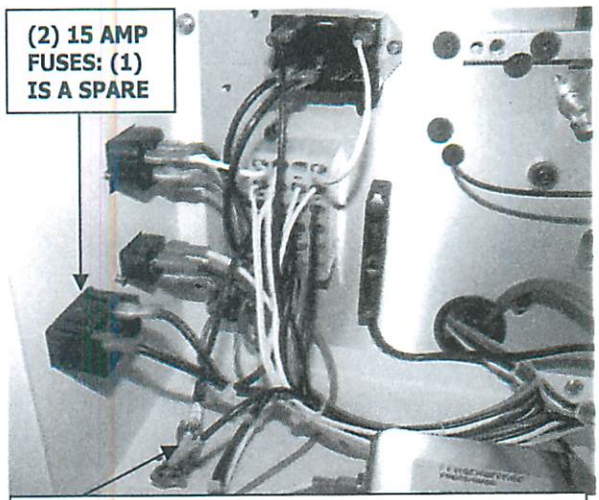
4) REAR RELAY TO USD TERMINAL BLOCK: 5" WHITE 18 GAUGE RELAY #1=BLOCK #1; 4" BLACK 14 GAUGE RELAY #2=12; 6 ½" BLACK 14 GAUGE RELAY #4=19; HARNESS BUNDLE BLACK FIF RELAY #0

5) POWER RECEPTACLE TO POWER FILTER USES 14 GUAGE WIRE: 9" WHITE INNER RECEPTACLE TERMINAL TO INNER 'LINE'; 9" BLACK OUTER RECEPTACLE TERMINAL TO OUTER 'LINE' AND 4" GREEN TO GROUND SCREW.

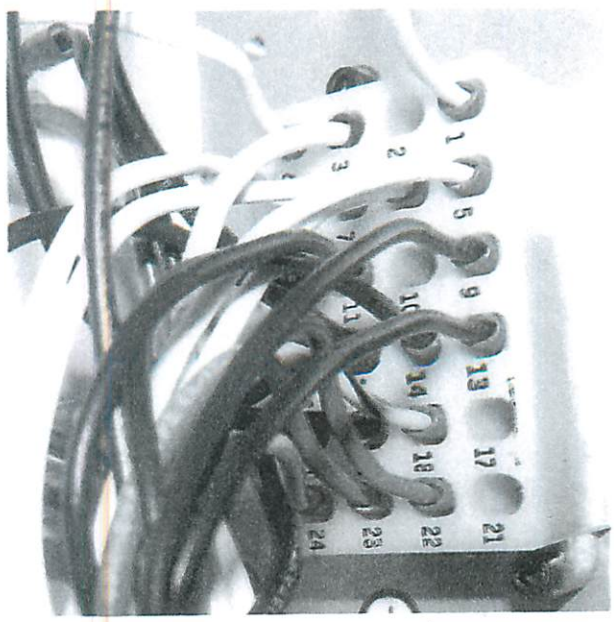
6) POWER FILTER 'LOAD' TERMINALS USE 14 GAUGE WIRE; INNER 20" WHITE TO USD BLOCK=3; OUTER 17" BLACK TO INNER 15 AMP FUSE TERMINAL; 9" GREEN TO GROUND SCREW. **15 AMP FUSE OUTER POST, 7" BLACK 14 GAUGE, TO USD TERMINAL BLOCK=20.

7) FROM HARNESS BUNDLE: YELLOW=24; RED=23; BLUE=22; YELLOW/BLACK=18. THE (4) WHITE WIRES=5, 6, 7 AND 8. TEST THE (5) BUNDLE BLACK WIRES WITH METER ON "BEEP" BY PLACING





BLACK MOTOR WIRE ONOUTER 8 AMP FUSE POST

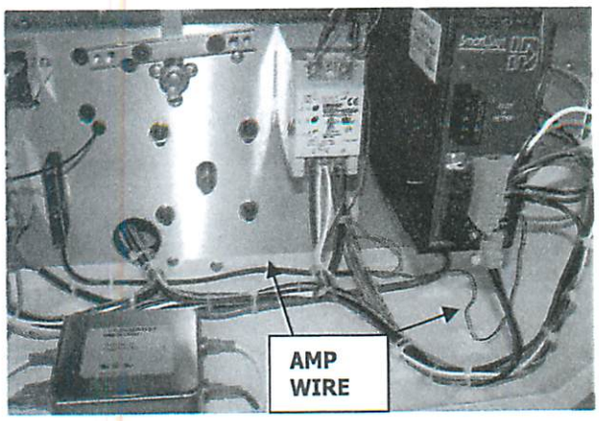


LEAD IN THE FIF CONNECTOR ON BLACK HARNESS WIRE END THAT WILL TERMINATE WITH GEARMOTOR AND EACH BLACK BUNDLE WIRE UNTIL "BEEP" IS LOCATED. INSERT THE BLACK GEARMOTOR WIRE ONTO OUTER 8 AMP FUSE TERMINAL POST. THE REMAINING BLACK BUNDLE WIRES CONNECT ON USD TERMINAL BLOCK=9, 11, 13 AND 14. ** 6" BLACK INNER 8 AMP TO USD 15.

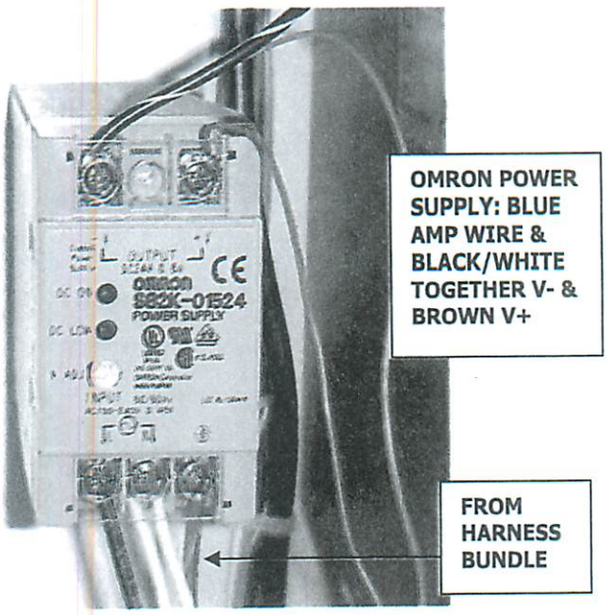


8) USD TERMINALS 17 & 21 ARE <u>UNUSED</u>.

9) CONNECT BLACK/WHITE JUMPER BETWEEN <u>FRONT RELAY</u> #6 AND 1ST TIER "COM." CONNECT BROWN JUMPER WIRE BETWEEN RELAY #8 AND 1ST TIER "IN4.".

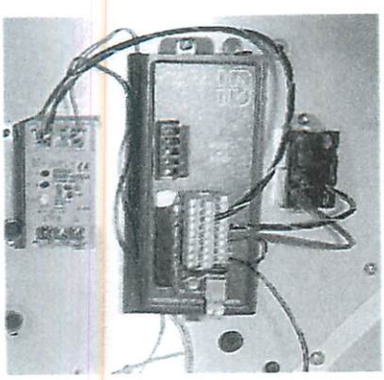


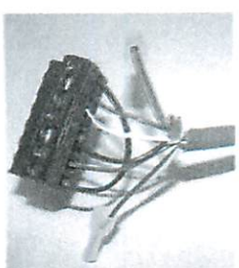
10) MEASURE LOWER WIRE ON AMPLIFIER TO LAY ALONG INNER HOUSING LIP UNTIL REACHING STEPPER MOTOR. CONTINUE MEASURING OUTWARD TO BREAK OUT BOARD AND POWER SUPPLY SCREWS. CUT OFF EXCESS AMPLIFIER WIRE. *VERY CAREFULLY* STRIP BLACK SHEATHING FROM AMPLIFIER WIRES AT POWER SUPPLY POINT. CUT A 1" JUMPER FROM THE TRIMMED BLACK AMP WIRE. TWIST ONE JUMPER END WITH THE AMPLIFIER BLACK END CLOCKWISE, ***<u>AS ALL WIRE STRANDS NEED TO INSERT INTO RECEIVER</u>*** AND CONNECT BOTH TO 1ST TIER "IN1" ON BREAK OUT BOARD. CONNECT THE SINGLE JUMPER END TO "IN3". THE AMPLIFIER WIRE IS <u>DEDICATED</u> AND NOT TIED WITH OTHER WIRES AS THE BLACK WIRE EASILY PICKS UP SIGNALS. TIE DOWN AMP WIRE WITH 5½" CABLE TIES AND BRADY PRESS CLIPS. DOUBLE BLUE AMP WIRE WITH BLACK/WHITE JUMPER FROM 2ND TIER (MIDDLE) UPPERMOST "COM" ON OF BREAK OUT BOARD AND CONNECT TO OMRON POWER SUPPLY TOP LEFT "-V". CONNECT BROWN AMP WIRE TO "+V" ON POWER SUPPLY TOP RIGHT.



11) TIE HARNESS IN FRONT OF AMP WIRE.

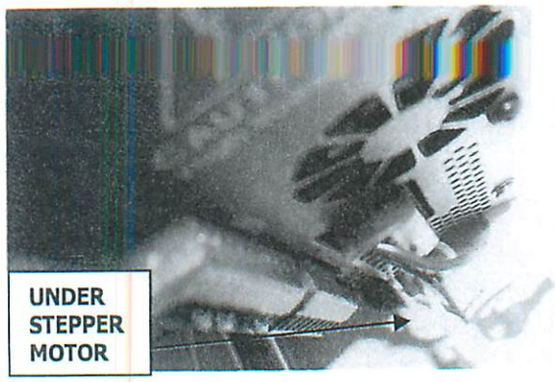
12) CONNECT OPEN BLACK WIRE TO "L" ON <u>OMRON POWER SUPPLY</u> SCREW, (2) OPEN WHITE WIRES TO EITHER SIDE OF "N" NEUTRAL IN CENTER AND GREEN



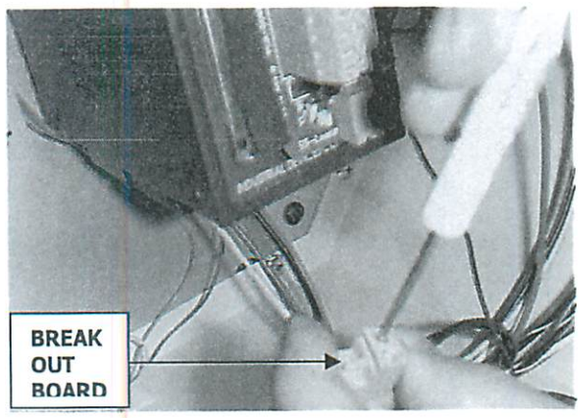


GROUND WIRE TO RIGHT. SEE POWER SUPPLY PICTURE ON PREVIOUS PAGE.

13) FROM UNDER THE SMART STEP, PLUG IN THE PREWIRED STEPPER MOTOR CORD AND DRIVE MOTOR CLIP WITH BLACK JUMPER. PRIOR TO ***FEBRUARY 2007*** THE FOLLOWING STEPPER MOTOR WIRING WAS USED. BE CERTAIN ***ALL WIRE STRANDS INSERT INTO DRIVE CLIP RECEIVERS***. CONNECT: ORANCE TO B-, BLACK TO B+, GREEN/GROUND TO GND, RED TO A- AND YELLOW TO A+. SNAP DRIVE CLIP BACK ONTO SMART STEP WITH THE YELLOW WIRE ON THE LEFT TOWARD THE REAR OF C30.

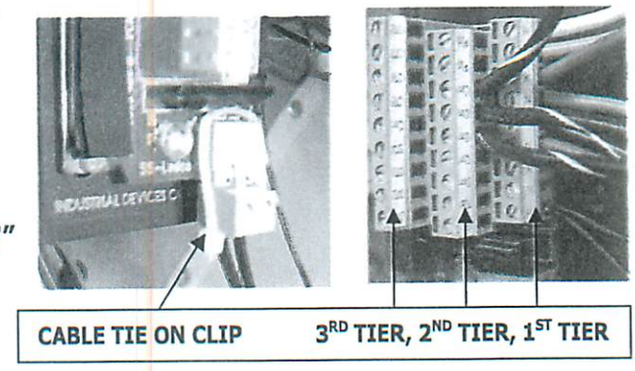


14) UNCLIP THE BOTTOM SECTION ON THE GREEN BREAK OUT BOARD AND CONNECT THE (2) OPEN ENDED BLACK WIRES FROM THE HARNESS BUNDLE ACCORDING TO WIRING DIAGRAM. CLIP SECTION BACK ON AND SECURE IT WITH A SMALL 4" CABLE TIE (PRC082).



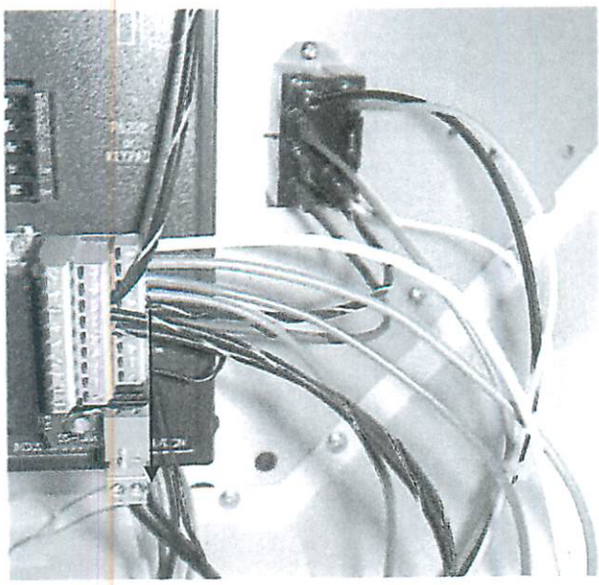
15) CONNECT OPEN ENDED GRAY TO 1ST TIER ON BREAK OUT BOARD "IN5" ABOVE BLACK/WHITE AND BROWN JUMPERS TO RELAY. CONNECT OPEN ENDED BLUE TO "IN6", ORANGE TO "IN7" AND WHITE TO TOP "IN8".

16) CONNECT (2) BLACK/WHITE OPEN WIRES TO THE 2ND TIER ON BREAK OUT BOARD 2ND AND 3RD "COM" FROM TOP.



17) CONNECT FRONT RELAY WITH FULLY INSULATED WIRES FROM HARNESS: YELLOW TOP RIGHT "0", WHITE BOTTOM RIGHT "1", BLACK WIRE TOP LEFT "2", ORANGE UNDER BLACK "4". FROM THE BREAK OUT BOARD THE BLACK/WHITE IS ON RELAY "6" AND BROWN IS ON "8".

18) CABLE TIE AND ARRANGE WIRES NEATLY ON THE FRONT SECTION OF WIRING. THE HARNESS WIRES ARE TIED SEPARATE FROM THE AMPLIFIER WIRES. BE PARTICULARLY CAREFUL OF THE BLACK AMPLIFIER WIRE. SECURING WITH BRADY PRESS CLIPS.



19) FROM LEFT SIDE WIRING HARNESS CONNECT THE FULLY INSULATED BLACK WIRE TO TOP LEFT RELAY POST #0.

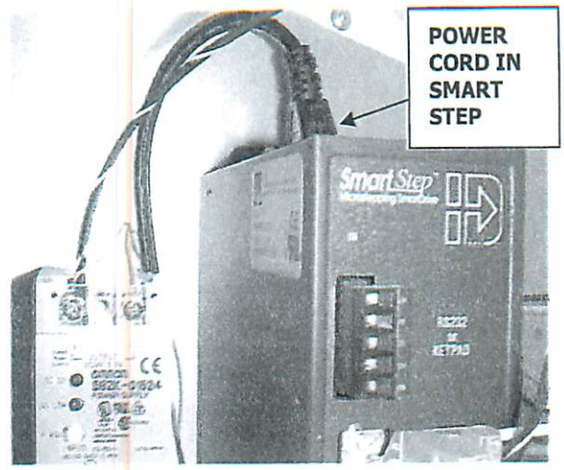
20) REMOVE THE POWER CORD FROM THE STEPPER MOTOR "ALL SET" BOX. CUT CORD TO LEAVE 36" REMAINING ON RECEPTACLE. INSERT INTO TOP OF SMART STEP, WITH GROUND POST TOWARD FRONT. THREAD POWER CORD BETWEEN POWER SUPPLY AND SMART STEP. STRIP 6" OF BLACK SHEATHING OFF POWER CORD END. CRIMP A BLUE RING CONNECTOR (PRT294) ONTO THE GREEN/GROUND WIRE. CRIMP A QUICK CONNECT (PRT302) ONTO THE <u>BROWN OR BLACK</u> WIRE AND THE <u>BLUE OR WHITE</u> WIRE (COLOR DEPENDS ON MANUFACTURER). BLACK/BROWN WIRE CONNECTS TO TERMINAL BLOCK 10 AND WHITE/BLUE CONNECTS TO BLOCK 2.

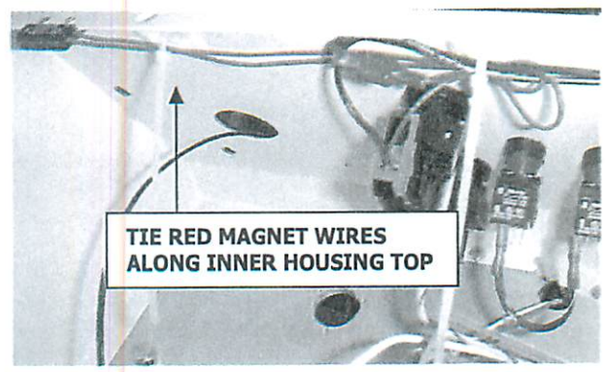
21) ADD A #10 STAR WASHER ONTO THE GROUND SCREW THREADS AND ADD (5) GROUND RING TERMINALS FROM THE HARNESS AND SMART STEP POWER CORD. SECURE GROUND WIRES WITH #10 KEPS HEX NUT.

22) CRIMP A RED MALE (PRT330) ONTO ONE OF THE RED PROXIMITY SWITCH MAGNET WIRES, LOCATED ON THE LEFT HOUSING LIP. CONNECT THIS WITH THE RED FEMALE ON <u>LONG BLACK HARNESS WIRE</u>. CONNECT ***BOTH*** THE OPEN REMAINING RED SWITCH MAGNET WIRE, AND THE OPEN LONG BLACK WIRE TO THE <u>OUTER</u>, **OPPOSITE THE LEVER SIDE, 2 POSITION KEY SWITCH. USE BRADY PRESS CLIPS AND SECURE THESE WIRES TO THE TOP OF THE HOUSING.

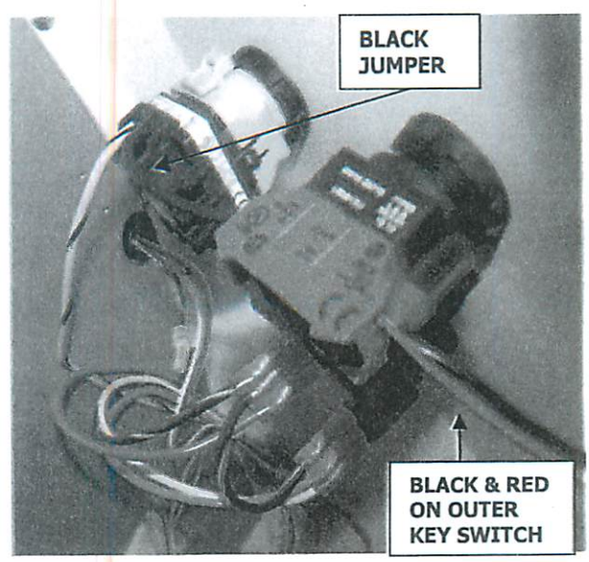
23) THE (2) REMAINING JUMPERS FROM THE PACKET #1 ARE A BLACK/WHITE WHICH CONNECTS THE START AND STOP SWITCHES AND AN OPEN ENDED BLACK CONNECTING THE INNER SECTION OF THE 2 POSITION KEY SWITCH, LEVER SIDE, WITH THE OUTER SECTION OF THE EMERGENCY PUSHBUTTON ACTUATOR.

24) CONNECT THE REMAINING BUNDLE OF WIRES RUNNING THEM BETWEEN THE POWER SUPPLY AND THE SMART STEP



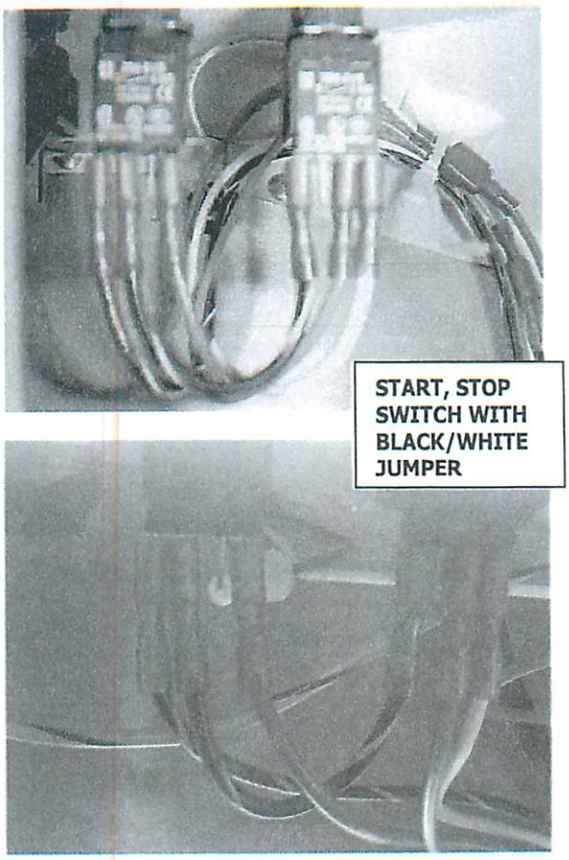






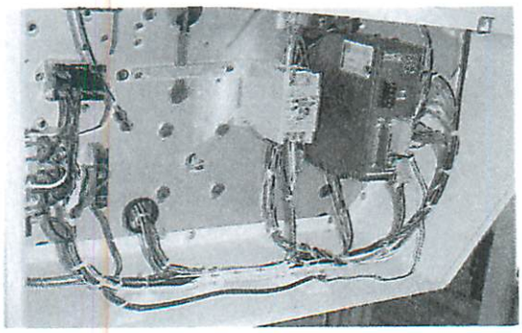
ALONG WITH POWER CORD. SECURE TO SIDE PANEL WITH CABLE TIES AND BRADY PRESS CLIPS. CONNECT THE OPEN ENDED YELLOW/BLACK TO THE INNER EMERGENCY ACTUATOR, OPPOSITE JUMPER WIRE END.

25) COMPLETE WIRING OF START AND STOP SWITCHES. THE GREEN LIGHTED START SWITCH IS ON THE LEFT AND RECEIVES A BLACK/WHITE ON LEFT TERMINAL POST, NEXT IS THE JUMPER, THEN AN UNUSED POST FOLLOWED BY A BLUE WIRE. THE RED LIGHTED STOP SWITCH FROM THE LEFT SIDE HAS THE JUMPER, AN UNUSED POST, ORANGE AND WHITE ON RIGHT.

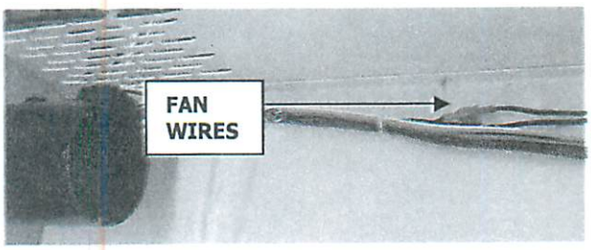


26) TRIM THE BLUE AND WHITE WIRES ON THE HAMLIN PROXIMITY SWITCH LOCATED ON LEFT SIDE PANEL, LEAVE 6" ON THE SWITCH WIRES. THE RED WIRE IS TRIMMED 2" AND CLEAR CAPPED. THE BLUE AND WHITE WIRES ARE EACH TERMINATED WITH A RED MALE (PRT330). CONNECT THE GRAY FROM THE HARNESS WITH THE WHITE SWITCH WIRE AND THE BLACK/WHITE TO THE BLUE PROXIMITY SWITCH WIRE.

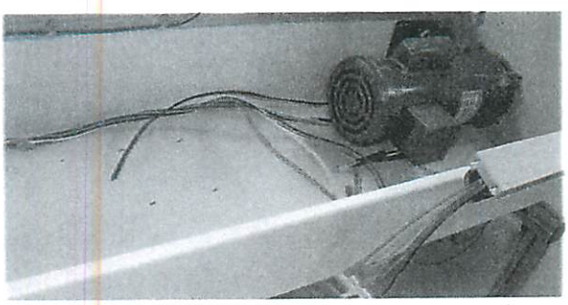
27) NEATLY CABLE TIE REMAINDER OF WIRES IN LEFT SIDE HOUSING. SECURE TO HOUSING WITH BRADY PRESS CLIPS.



28) PROCEED TO THE BOTTOM HOUSING AND CONNECT THE (5) STEPPER MOTOR WIRES TO THE WIRE HARNESS, MATCHING LIKE WIRE COLORS. WHEN SECURING WIRES TO BOTTOM HOUSING WITH BRADY PRESS CLIPS KEEP ABOUT AN INCH FROM THE SCREW POINTS THAT HOLD THE BACK DOOR, SO THE WIRES ARE NOT DAMAGED FROM SHARP ENDS.

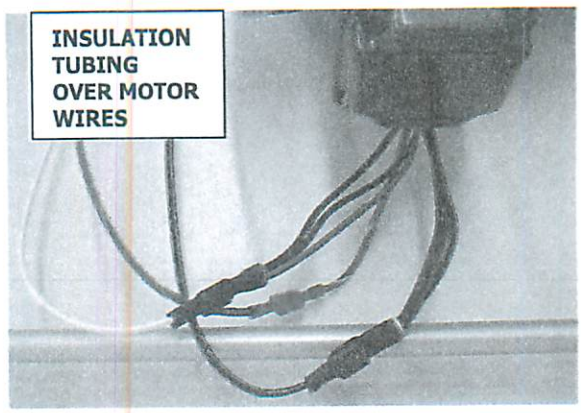


29) MEASURE AXIAL FAN WIRE TO WHITE AND BLACK CONNECTING HARNESS WIRES BY STEPPER MOTOR. TRIM FAN WIRES IF NECESSARY. SPLIT THE FAN WIRES AND TERMINATE EACH SPLIT WITH A MALE CONNECTOR (PRT330). CONNECT TO HARNESS WIRES.



30) PLACE BLACK INSULATION TUBING OVER

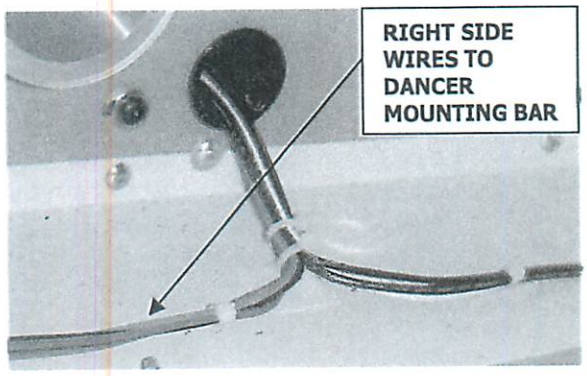
GEARMOTOR WIRES AND CONNECT TO HARNESS: HARNESS BLACK TO ALL THREE BLACK WIRES AND HARNESS WHITE TO MOTOR COMBINATION WITH WHITE OR RED (COLOR DEPENDS ON MOTOR MANUFACTURER). COVER THE CONNECTION WITH INSULATION TUBING AND HEAT SHRINK. USE BRADY PRESS CLIPS TO GUIDE WIRES AS SHOWN IN PICTURE.



31) SEPARATE THE WIRES EXITING THE RIGHT SIDE PANEL. THE BLACK AND WHITE GROUP LAY TOWARD THE REAR OF THE MACHINE AND THE COLORED ORANGE, RED, BLUE AND BLACK WIRES LAY TOWARD THE FRONT.

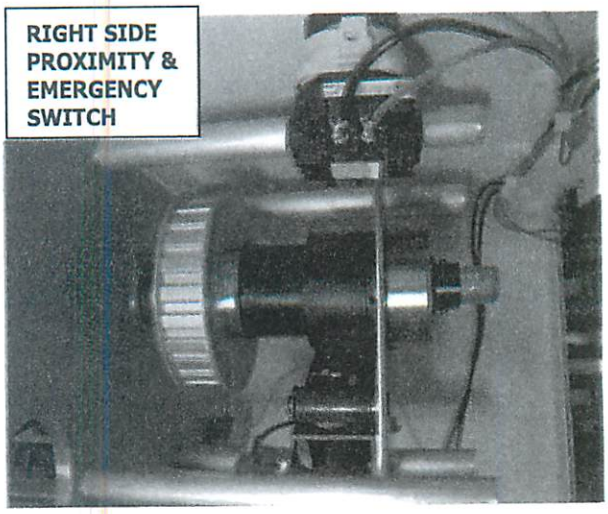


32) PASS THE MULTI COLORED WIRE BUNDLE THAT FACES THE FRONT THROUGH THE DEBURRED ENTERANCE IN THE SIDE PANEL AND INTO THE RACEWAY ON THE BOTTOM OF THE DANCER MOUNTING BAR. RUN THESE WIRES ALL THE WAY ALONG THE RACEWAY UNTIL THE (4) CONNECTORS EXIT THE RACEWAY AND CAN BE SECURED TO CHERRY MINIATURE ROLLERS IN THE DANCER HOUSING. SEE DANCER ASSEMBLY PAGES FOR PROCEDURES. AFTER CONNECTING DANCER WIRES, ADJUST WIRE LENGTH THROUGH RACEWAY AND CLOSE RACEWAY.

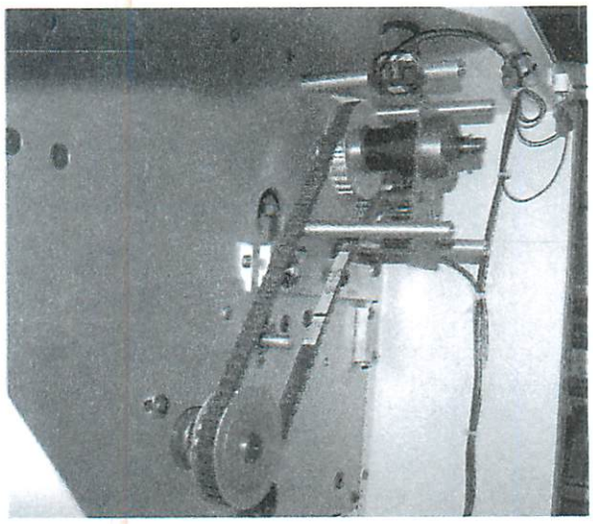


33) ***AFTER THE CLUTCH ASSEMBLY IS CONNECTED:*** TOWARD THE REAR OF THE RIGHT HOUSING ATTACH THE FLAG CONNECTORS ON THE WHITE AND BLACK WIRE TO THE CLUTCH ASSEMBLY.

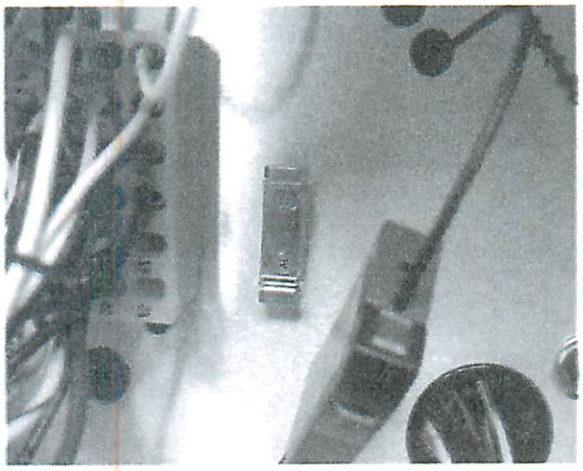
34) CRIMP A MALE CONNECTOR (PRT330) ONTO ONE OF THE RED PROXIMITY SWITCH MAGNET WIRES LOCATED ON THE HOUSING LIP. CONNECT THIS WITH THE RED FEMALE ON THE BLACK HARNESS WIRE. CONNECT THE OPEN REMAINING MAGNET WIRE TO THE OUTER SECTION OF THE EMERGENCY SWITCH ACTUATOR. CONNECT THE OPEN ENDED BLACK HARNESS WIRE TO THE INNER SECTION OF THE EMERGENCY SWITCH. REPLACE YELLOW CAP ON RELEASE LEVER.

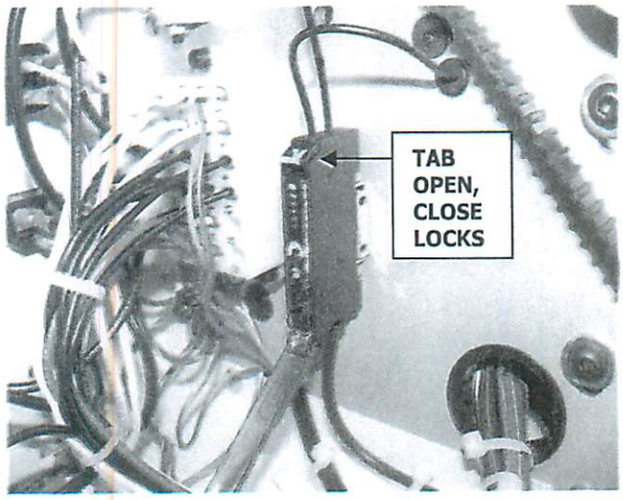


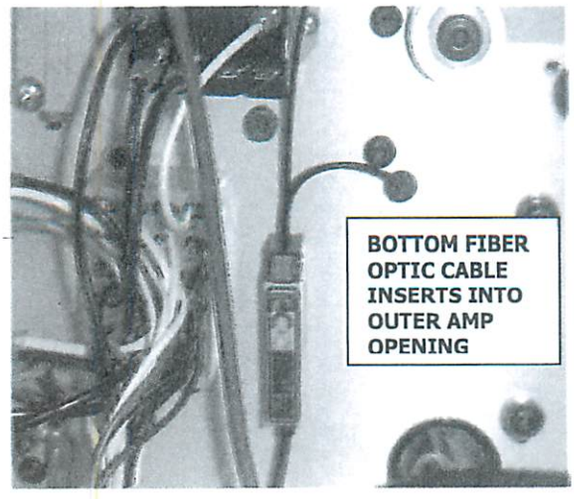
35) THREAD THE FIBER OPTIC CABLES THROUGH THE RUBBER GROMMETS IN THE LEFT SIDE WHEN THE BOTTOM AND TOP SENSOR HOLDERS ARE INSTALLED.



36) REMOVE THE FRONT AMPLIFIER COVER BY DISCONNECTING THE SNAP UNDERNEATH. OPEN THE CONNECTION HOLES ON TOP OF THE AMPLIFIER BY PULLING OUT PLASTIC TAB, THE RUBBER GROMMET STAYS ON AMPLIFIER. MEASURE THE FIBER OPTIC CABLE TO LEAVE A COMFORTABLE LOOP AT THE TOP AND CUT THE CABLE WITH THE TOOL SUPPLIED. USE ANY OF THE THREE LARGER HOLES TO CUT THE FIBER OPTIC CABLE BUT USE EACH HOLE ONLY ONCE. CONNECT THE LOWER FIBER OPTIC CABLE TO THE OUTER TOP OPENING ON THE AMPLIFIER AND CONNECT THE TOP FIBER OPTIC CABLE TO THE INNER AMPLIFIER OPENING. SNAP UPPER TAB CLOSED AND REPLACE FRONT ON AMPLIFIER.



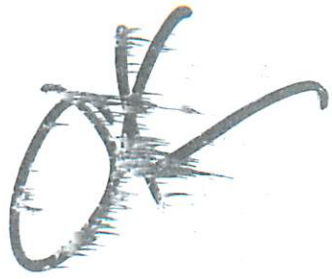




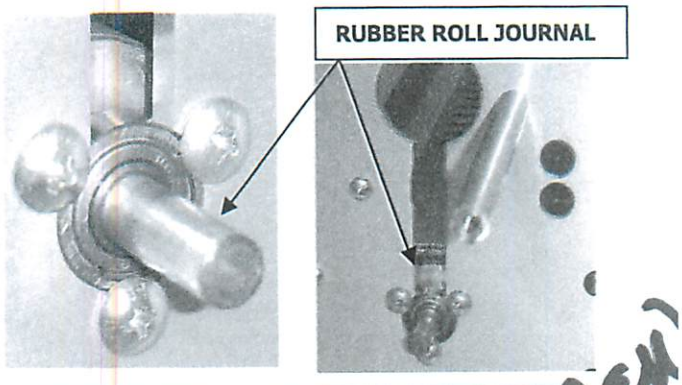


TOOL FOR CUTTING FIBER OPTIC CABLE

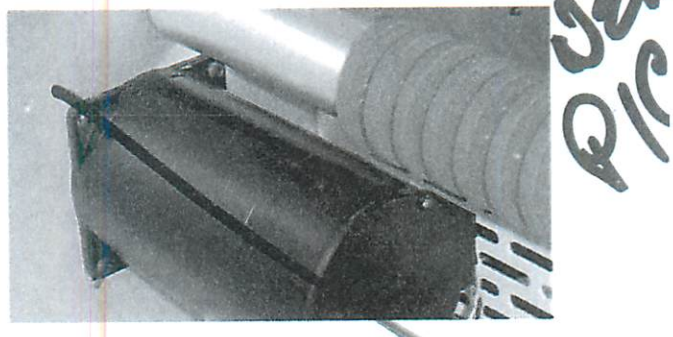
C30 AUTOCUTTER CHASSIS COMPLETION



1) INSERT THE BOTTOM 30" CUTTER RUBBER ROLL (C30 040.4) AS16 WITH THE JOURNAL KEYWAY ON THE LEFT SIDE INTO THE JOURNAL OPENINGS IN SIDE PANELS. SLIDE A ROLLER BEARING (PRB075) RACK 12 ONTO EACH JOURNAL. THE ROLLER BEARINGS ARE HELD IN THE SIDE PANELS WITH (3) 10-32 X ¼ TH THREADED FROM THE OUTSIDE. BEARINGS MUST MOVE FREELY AND NOT BE PINCHED BY SCREWS.



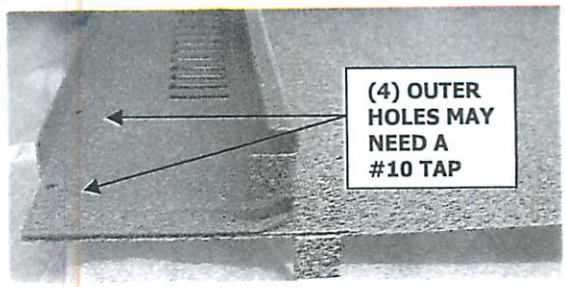
2) FROM THE FRONT OF THE CUTTER, ORIENT THE BOTTOM STRIPPER (C30 096.4B) AS16 WITH THE SLOTS TOWARD THE REAR FITTING OVER THE BOTTOM RUBBER ROLL, AND THE FRONT LIP DOWNWARD. ***BE VERY CAREFUL OF REAR BLADE.*** CONNECT THE REAR OF THE BOTTOM STRIPPER TO THE BOTTOM CUT OFF BAR THROUGH THE COUNTER-SUNK HOLES IN BOTH. USE (3) 6-32 X 3/8 FH. ***SCREWS MUST BE FLUSH SO PAPER DOESN'T CATCH DURING RUN.***



3) ATTACH THE BOTTOM STRIPPER TO THE RIGHT AND LEFT SIDE PANELS THROUGH THE TABS ON THE FRONT AND REAR SIDES. SECURE WITH (4) 10 X ¾ PH SMS. A DROP OF OIL ON SCREW POINT MAY HELP THREADING.

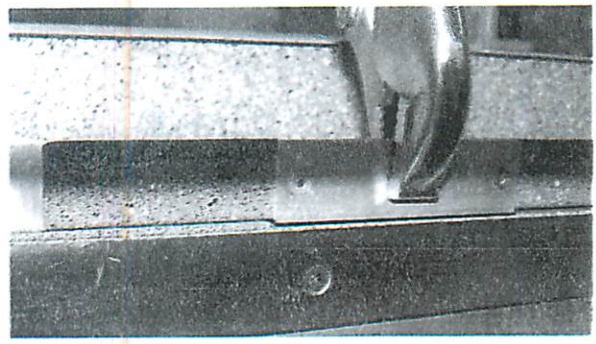


4) PLACE THE TOP STRIPPER (C30 096.4T) AS16 ON THE BOTTOM STRIPPER, ALIGNING RUBBER ROLL SLOTS. THE LARGER LIP FACES UPWARD TOWARD THE FRONT. LINE UP THE (2) OUTER HOLES ON BOTH SIDES IN THE REAR OF THE TOP AND BOTTOM STRIPPERS WITH THE BOTTOM CUT OFF BAR. IF THEY DO NOT ALIGN, THEY SHOULD BE OPENED USING A #10



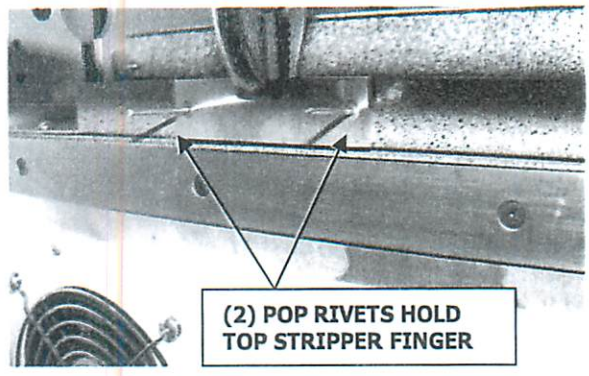
OK

TAP. CONNECT THE SPRIPPERS TO THE BOTTOM CUT OFF BAR USING (4) 10-32 X 3/8 RH.

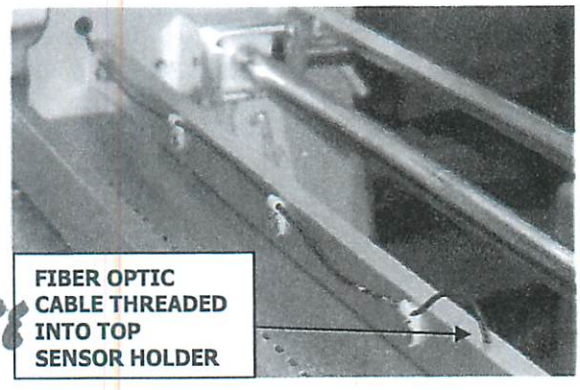


5) SECURE THE TOP STRIPPER TO THE SIDE PANELS WITH (2) 10 X ¾ PH SMS ***AFTER*** THE TOP AND BOTTOM STRIPPERS ARE CONNECTED TO THE CUT OFF BAR.

6) ALIGN THE 3" TOP STRIPPER FINGER (C25 096.4TF) RACK 11 WITH REAR, OUTER EDGE OF THE TOP STRIPPER PLATE. COUNTERSINKS OUTWARD, ON CLUTCH SIDE OF THE MACHINE. ALIGN THE <u>BEVELED EDGE DOWNWARD</u> AND UPPER EDGE EVEN WITH THE TOP STRIPPER, COUNTERSINKS OVER HOLES. SECURE THE STRIPPER FINGER TO THE TOP STRIPPER WITH VICE GRIPS. SECURE TOP STRIPPER FINGER TO TOP STRIPPER LIP USING (2) 1/8 DIA FH POP RIVETS (.125B0Q06).

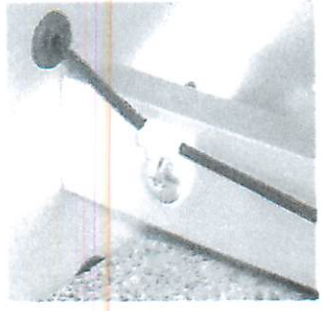


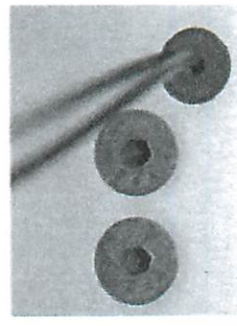
7) CONNECT (4) CABLE CLAMPS (PRC271) RACK 12 TO THE TOP SENSOR HOLDER (C30 270.4) AS16 ORIENTED WITH THE CABLE HOLDER <u>LOOPS UPWARD</u>, AND THE FIBER OPTIC CABLE THREAD, RIGHT OF CLAMPS. SECURE CABLE CLAMPS TO SENSOR HOLDER WITH (4) 8-32 X ¼ TH, ***SENSOR THREADS UPWARD.*** REMOVE



8) CONNECT THIS ASSEMBLY TO THE SIDE PANELS ORIENTING THE CABLE CLAMP LOOPS UPWARD, BELOW RUBBER GROMMET. USE (4) ¼-20 X ¾ FHSH.

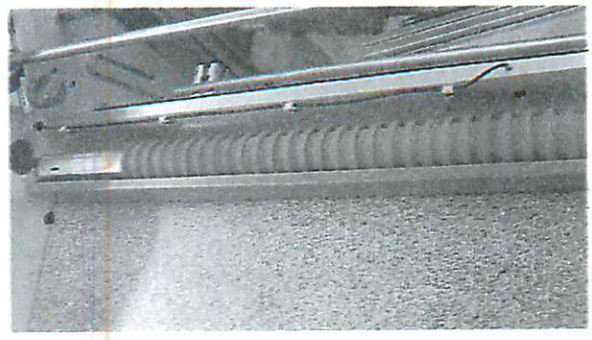
10 Left





9) ***<u>COMPLETELY</u>*** THREAD THE END OF THE REMAINING OMRON FIBER OPTIC CABLE (PRC271) DOWN INTO TOP SENSOR HOLDER. THE SENSOR SHOULD BE JUST VISABLE ON LOWER SENSOR HOLDER.

10) INSERT THE OPEN END OF THE FIBER OPTIC CABLE THROUGH THE CABLE CLAMP LOOPS AND THE RUBBER GROMMET IN THE LEFT SIDE PANEL.



11) ADD THE TOP 30" CUTTER RUBBER ROLL (C30 040.4) AS16 BETWEEN SIDE PANELS. ALIGN STRIPPER SLOTS, WITH THE <u>JOURNAL KEYWAY ON LEFT</u> SIDE.

OK

12) ADD A TOP RUBBER ROLL SPACER (C25 045.4) AS11 ONTO BOTH ENDS OF THE JOURNAL FITTING IN THE SIDE PANEL SLOTS.

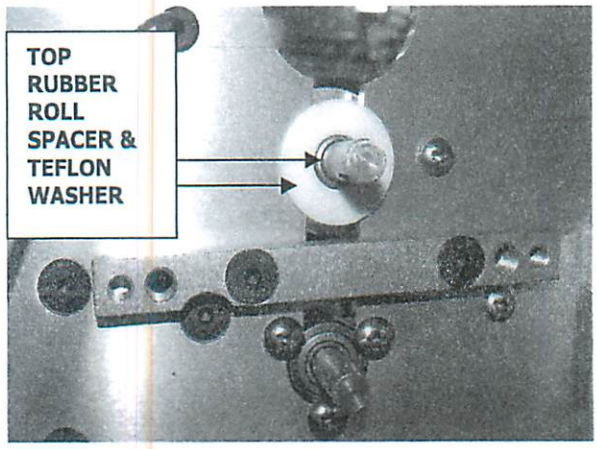
Pack 11

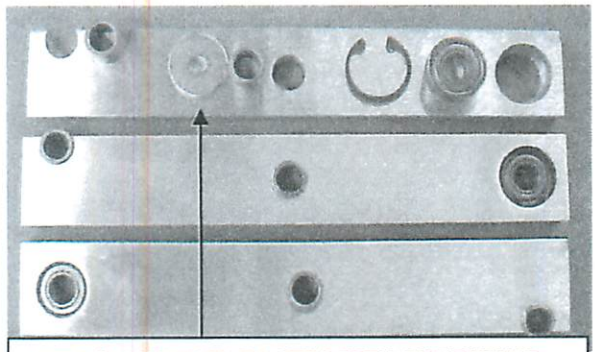
13) SET A TEFLON WASHER (PRW337) AS14 ON THE ***OUTER RIM*** OF THE SPACERS.

Pack 6

14) PREPARE THE RUBBER ROLL PIVOT ARM LEFT (C25 056.4L) AS11 AND RUBBER ROLL PIVOT ARM RIGHT (C25 056.4R) AS11 AS FOLLOWS: ARBOR PRESS A ROLLER BEARING (PRB075) AS02 INTO THE RECESS OF BOTH PIVOT ARMS. SECURE EACH ROLLER BEARING WITH A ROTOR CLIP HO RING (PRC275) AS21. ARBOR PRESS (2) "WORKED" OILITE BEARINGS (PRB111A) AS21 INTO EACH PIVOT ARM, ***MEASURED TO 1/16 ON THE INSIDE*** (SIDE FACING SIDE PANEL) ON BOTH. THE INSIDE IS <u>OPPOSITE</u> THE ROTOR CLIP HO RING AND BEARING RECESS. SET ASIDE.

Pack 11 & 2
Pack 12
Pack 12
Pack 12

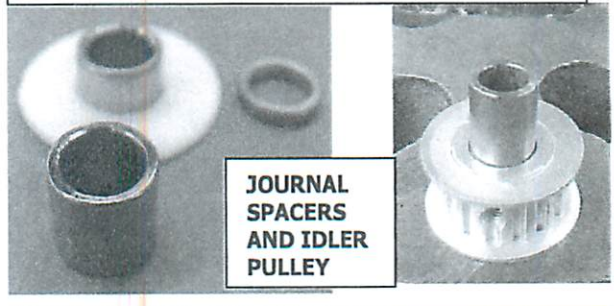




USE 1/16 WASHER TO SET DEPTH OF BEARING
<u>MEASURE THE SIDE OPPOSITE ROTOR RING</u>

15) REMOVE BOTH SET SCREWS FROM (3) IDLER PULLEYS (PRG003) AS21 AND DISCARD. ARBOR PRESS A "WORKED" OILITE BEARING (PRB040A) AS21 INTO EACH PULLEY.

Pack 12
Pack 12

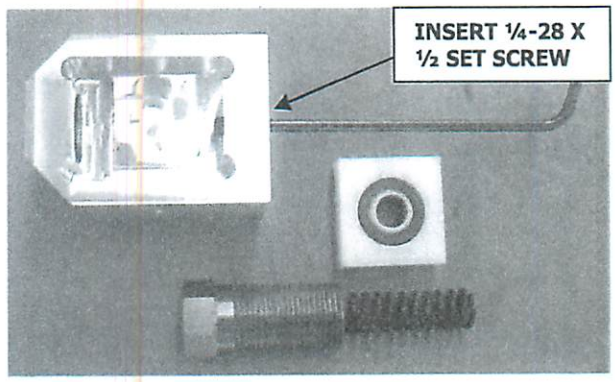


16) RETAIN 8 X 5/16 SET SCREW ***<u>ACROSS FROM THE KEYWAY</u>*** ON (3) RUBBER ROLL DRIVE PULLEYS (PRG002) AS21. REMOVE SET SCREW 90 DEGREES FROM KEYWAY AND DISCARD. SET ASIDE.

Pack 12

17) PREPARE (2) PRESSURE ROLL GUIDE (C25 120.4) AS11 ASSEMBLIES. FIRST INSERT A ¼-28 X ½ SET SCREW INTO THE THREADED ENDS OF (2) PRESSURE ROLL GUIDES.

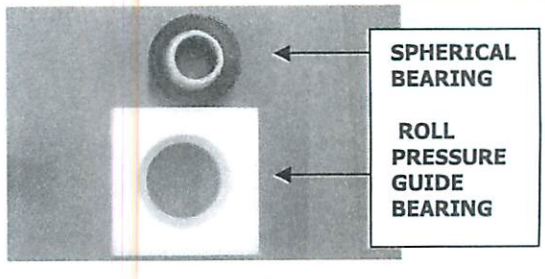
Pack 11



18) ARBOR PRESS (2) SPHERICAL BEARINGS (PRB101) AS21, ONE EACH INTO THE LARGER RECESS OF (2) WHITE TEFLON PRESSURE ROLL GUIDE BEARINGS (C25 121.4) AS11.

Pack 2
Pack 11

19) SET PRESSURE ROLL GUIDE BEARINGS INTO PRESSURE ROLL GUIDES, WITH THE ENTIRE BEARING SHOWING.



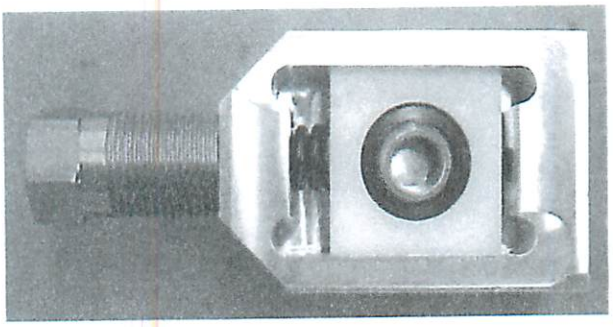
OK

20) INSERT A PRESSURE SPRING (PRS243) AS27 INTO EACH OF (2) PRESSURE ROLL PRESSURE ADJUSTERS (C25 123.4) AS11.

Pack 2

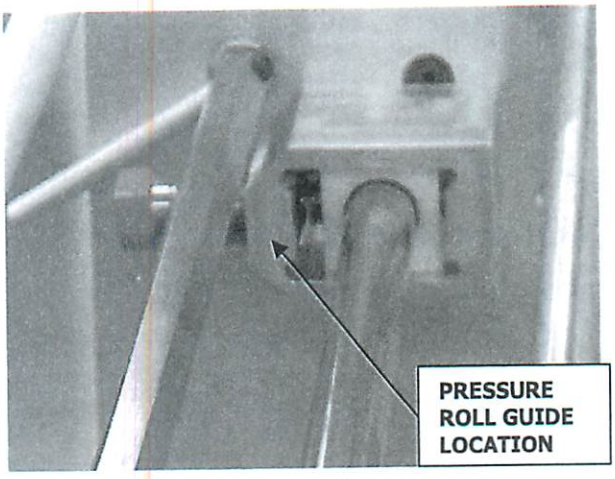
Pack 1

21) INSERT THE PRESSURE ROLL PRESSURE ADJUSTER WITH SPRING INTO THE THREADED END OF THE ROLL PRESSURE GUIDE AND GENTLY TIGHTEN ONTO THE TEFTON PRESSURE ROLL GUIDE BEARING. TOO MUCH FORCE CAN STRIP THREADS. PRESSURE ADJUSTER THREADS SHOULD JUST BE SHOWING ON INSIDE OF ROLL PRESSURE GUIDE.

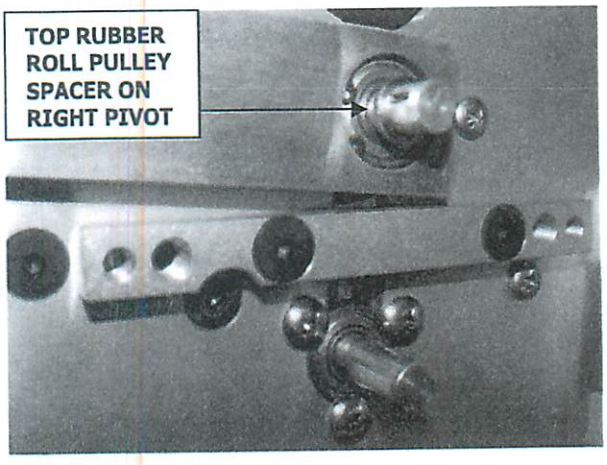


22) TEST THE ENDS OF A PRESSURE ROLL SHAFT (C30 122.4) ~~AS23~~ BY FITTING THEM INTO THE SPHERICAL BEARINGS OF THE PRESSURE ROLL GUIDE ASSEMBLIES. THE SHAFT SHOULD SPIN FREELY IN THE BEARINGS.

Left 2



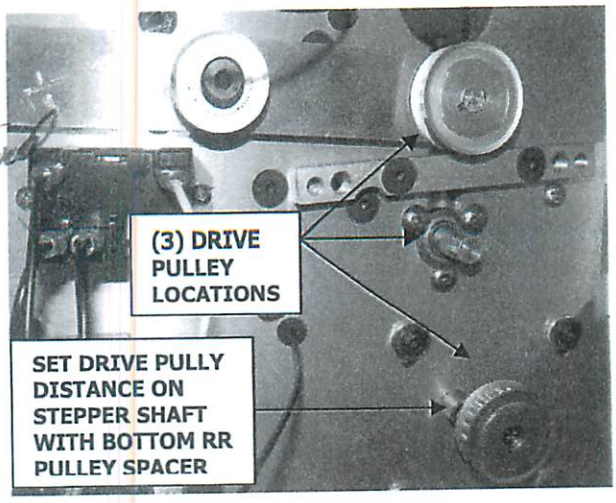
23) WITH THE PRESSURE ROLL SHAFT IN ONE OF THE SPHERICAL BEARINGS, CONNECT THAT PRESSURE ROLL GUIDE TO THE INNER SIDE PANEL, PLACING THE PRESSURE ROLL PRESSURE ADJUSTER UNDER THE RUBBER ROLL CAM SHAFT. USE (3) ¼-20 X ¾ FHSH. THEN SLIDE THE OTHER END OF THE PRESSURE ROLL SHAFT INTO THE OTHER SPHERICAL BEARING AND ATTACH TO REMAINING SIDE PANEL WITH (3) ¼-20 X ¾ FHSH.



24) SLIDE THE ROLLER BEARING ON THE RIGHT AND LEFT PIVOT ARM ASSEMBLIES OVER THE TOP RUBBER ROLL JOURNAL, NEXT TO THE TEFLON WASHER. ORIENT WITH THE REAR OILITE BEARING FACING UPWARD AND THE FLAT SIDE OF THE CAM RESTING ON THE OILITE BEARING. Retainers outward

25) ON BOTH LEFT AND RIGHT SIDES PLACE A THIN TOP RUBBER ROLL PULLEY SPACER (C30 046.4) AS11 ONTO THE TOP RUBBER ROLL JOURNAL, BY OUTER PIVOT ARM ROLLER BEARING.

Pack 1



26) PLACE (3) #303 WOODRUFF KEYS (PRK155) ~~AS21~~ IN THE TOP AND BOTTOM RUBBER ROLL JOURNAL

Pack 12

KEYWAYS AND THE STEPPER MOTOR JOURNAL BEFORE YOU SLIDE ON THE PULLIES TO EACH.

27) SECURE THE TOP RUBBER ROLL DRIVE PULLEY (PRG002) ~~AS21~~ OVER KEY, FLUSH WITH THIN SPACER BY OUTER PIVOT ARM BEARING, TIGHTEN SS.

28) PLACE A 3/8 X 1¼ SHOULDER BOLT INTO THE IDLER PULLEY. REAM WITH .3780 IF NECESSARY. THE SIDE WITH EXCESS OILITE BEARING ALWAYS GOES INWARD. SECURE *LEFT PIVOT ARM* TO LEFT SIDE PANEL THROUGH THE CENTER OILITE BUSHING.

29) SLIDE A DRIVE PULLEY OVER THE STEPPER MOTOR KEY AND MEASURE THE SPACE BETWEEN THE SIDE PANEL AND THE INNER EDGE OF THE DRIVE PULLEY USING A BOTTOM RUBBER ROLL PULLEY SPACER (C30 047.4) ~~AS11~~ AS A GUIDE. TIGHTEN DRIVE PULLEY SET SCREW.

Pack 11

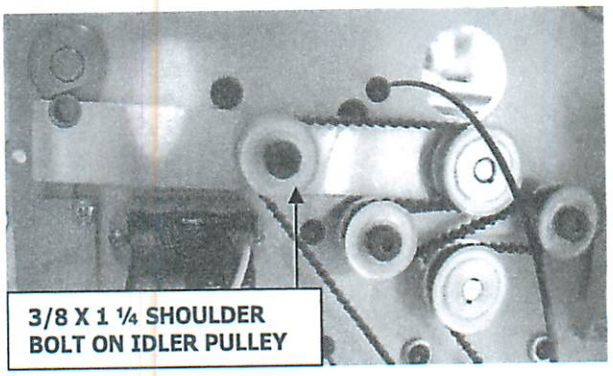
30) ON LEFT SIDE BOTTOM RUBBER ROLL JOURNAL ADD THE BOTTOM RUBBER ROLL PULLEY SPACER THAT YOU USED FOR MEASURING THE STEPPER MOTOR DRIVE PULLEY DISTANCE. SLIDE THE THIRD DRIVE PULLEY OVER THE KEY FLUSH WITH SPACER AND SECURE WITH SET SCREW.

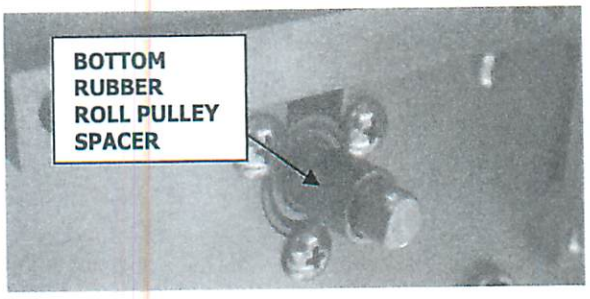
31) INSERT A 3/8 X 5/8 SHOULDER BOLT THROUGH ONE OF THE IDLER PULLEYS AND THREAD IT INTO THE DRIVE IDLER MOUNTING BAR. FOLLOW DIAGRAM AND WIND THE DUEL POSITION DRIVE BELT (PRB108) ~~AS21~~ AROUND PULLEYS AND TIGHTEN USING ANOTHER 3/8 X 5/8 SHOULDER BOLT TO CONNECT THE FINAL IDLER PULLEY. ADJUST BELT TENSION BY WEIGHT OF LOWERED STEPPER MOTOR.

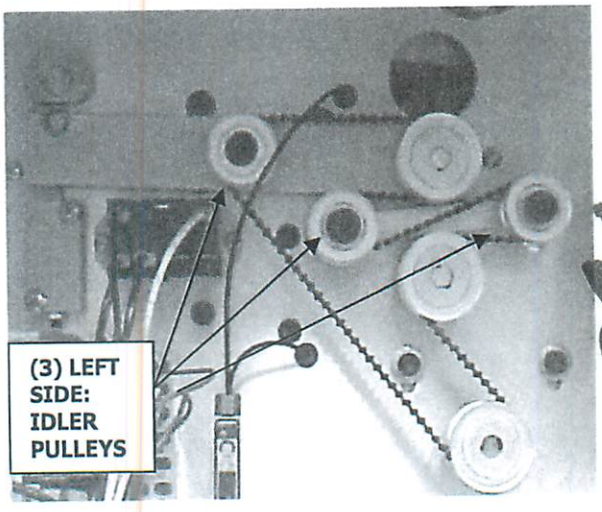
Pack 12

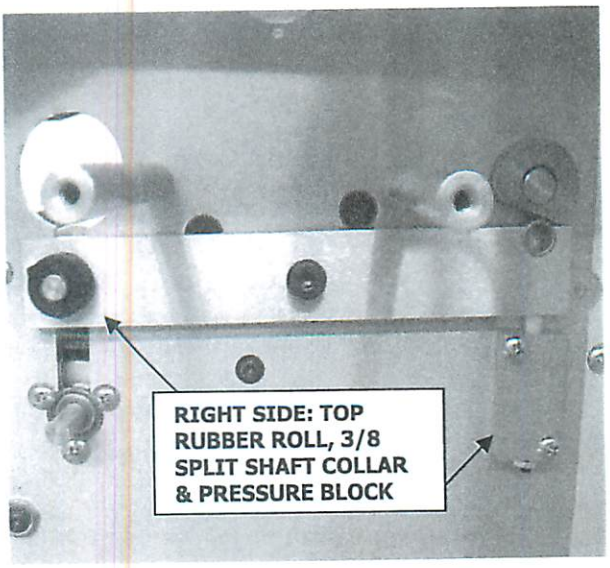
32) SECURE THE RIGHT SIDE TOP RUBBER ROLL JOURNAL TO THE PIVOT ARM *WITH THE SPACER BETWEEN THEM.* SNUG A 3/8 BORE ~~SPLIT SHAFT COLLAR~~ (PRC211) ~~AS18~~ OVER JOURNAL AND TIGHTEN.

PRC

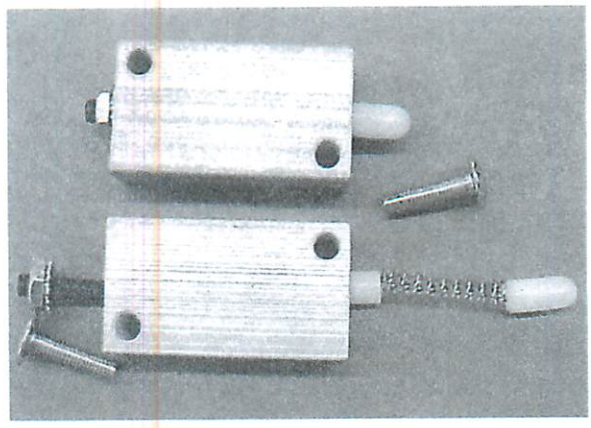




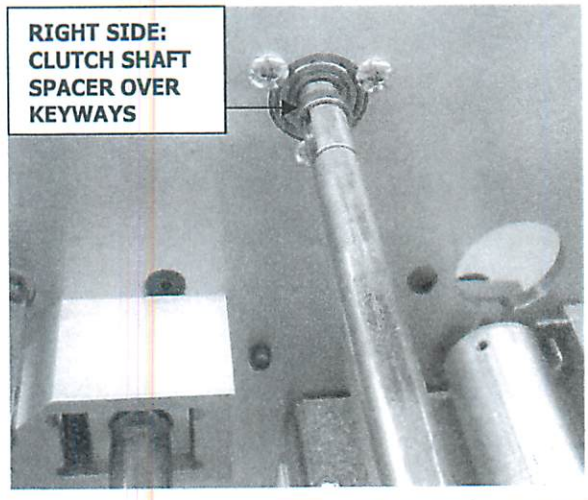




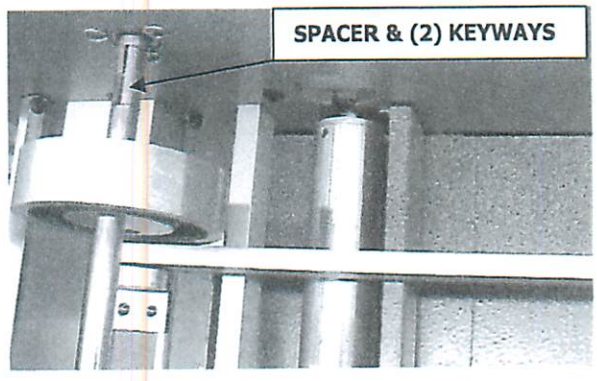
33) SECURE THE RIGHT PIVOT ARM TO THE RIGHT SIDE PANEL USING A 3/8 X 5/8 SHOULDER BOLT.

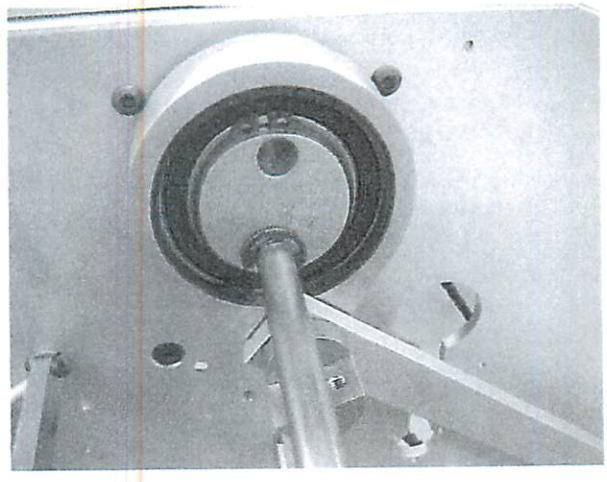


34) ASSEMBLE (2) PRESSURE BLOCKS (C25 213.4) AS11 BY FIRST THREADING A #10 KEPS HEX NUT ONTO A 10-32 X ¾ SET SCREW. LEAVE ABOUT THREE THREADS SHOWING ON THE END OF THE SET SCREW. INSERT INTO PRESSURE BLOCK THREADS AND TIGHTEN KEPS WITH WRENCH. INSERT THE SMALLER WHITE PRESSURE ADJUSTMENT PLUNGER (C25 218.4) AS11 INTO THE END OF THE PRESSURE BLOCK. THEN INSERT A LEE SPRING (PRS221) AS15 AND A WHITE PRESSURE PLUNGER (C25 217.4) AS11. THIS ASSEMBLY IS ATTACHED TO THE SIDE PANELS WITH THE PRESSURE PLUNGER TOUCHING THE REAR OF THE PIVOT ARMS. USE (2) 10-32 X ¾ TH ON EACH SIDE PANEL FOR THE PRESSURE BLOCK.



35) TIGHTEN (3) 10-32 X ¼ TH SCREWS WITH THE HEADS ON THE INNER RIGHT SIDE PANEL TO HOLD THE ROLLER BEARING IN THE GUILLOTINE/CLUTCH ASSEMBLY. LOOSELY THREAD (3) 10-32 X ¼ TH OPPOSITE THESE ON THE INNER LEFT SIDE PANEL. FROM THE RIGHT SIDE INSERT THE CUT OFF CAM SHAFT ON THE GUILLOTINE/CLUTCH ASSEMBLY *HALFWAY* ACROSS MACHINE THROUGH THE RIGHT SIDE PANEL. SLIDE THE RIGHT SIDE GUILLOTINE CAM WITH KEYWAYS ONTO THE CAM SHAFT. THE CUT OFF CAM SHAFT SPACER (C25 252.4) AS11 IS BETWEEN BEARING AND CAM. THE CUT OFF PIVOT ARMS FACE THE FRONT AND THE THREADS ON THE TOP CUT OFF MOUNTING PIVOTS FACE UPWARD AND INWARD, UNDER THE SHAFT. CLUTCH PLATE IS VERTICLE BETWEEN STANDOFFS ON RIGHT. SLIDE ON THE LEFT SIDE GUILLOTINE CAM USING HOLE WITH KEYWAYS, ARMS FORWARD, MOUNTING PIVOTS UPWARD AND INWARD UNDER SHAFT. ON THE LEFT SIDE OF THE CAM SHAFT, AFTER THE GUILLOTINE CAM ADD THE CUT OFF CAM SHAFT SPACER AND THE BALL





AS01 (PRB038) BEARING. SECURE BY 10-32 X ¼ TH.

36) SNUG SPACERS TIGHT AGAINST BEARINGS. PLACE (2) #3 WOODRUFF KEYS (MI03KEY) ~~CP04~~ IN THE RIGHT SIDE KEYWAYS ON CAM SHAFT AND SLIDE RIGHT CAM OVER KEYS. SECURE WITH ROTOR CLIP E RING (PRC270) ~~AS21~~. USE TOOL TO SECURE ROTOR CLIP E RING.

AS 13

Pack 12

37) THE LEFT SIDE MIRRORS THE RIGHT SIDE. THE BEARING IS SECURED WITH TRUSSHEAD SCREWS, SPACER IS NEXT TO THE BEARING AND (2) KEYS (MI03KEY) ARE IN KEYWAYS. SLIDE THE LEFT SIDE CAM OVER KEYS AND SECURE WITH A THE ROTOR CLIP E RING (PRC270). USE TOOL TO SECURE ROTOR CLIP ONTO CAM SHAFT.

38) ADD ANOTHER ROTOR CLIP E RING TO THE OUTER LEFT SIDE CAM SHAFT GROOVE ON SIDE PANEL.

39) PREPARE THE TOP CUT OFF MOUNTING BAR (C30 115.4) ~~AS23~~ BY ATTACHING THE CUT OFF BLADE (C30 400.4) ~~AS23~~ ALONG FLAT SIDE INTO RECESS OF THE MOUNTING BAR USE (9) 6-32 X 5/8 FHSH AND TORK DRIVER. ***BOTH EDGES OF THE BLADE ARE VERY SHARP.***

AS16
AS16

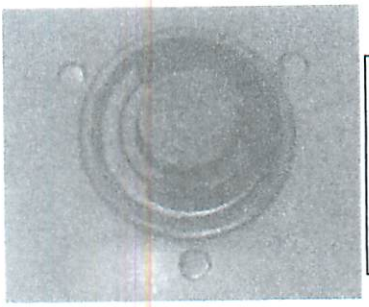
40) ORIENT THE TOP CUT OFF MOUNTING BAR ASSEMBLY ALIGNING THE <u>BLADE BRACE OFFSET TOWARD THE REAR</u> AND THE <u>BLADE DOWNWARD</u> BETWEEN SIDE PANELS. CAREFULLY ALIGN BLADE AND CONNECT TO TOP CUT OFF MOUNTING PIVOTS WITH (4) ¼-20 X ¾ FHSH.

Move up to 39) Rt

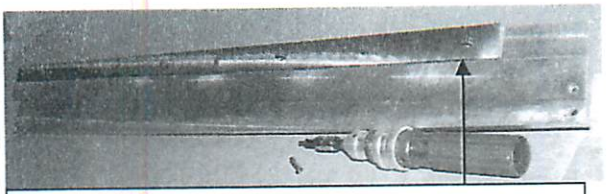
41) ATTACH (2) PIVOT ARM BLOCKS (C25 058.4) ~~AS11~~ ONE ON EACH INNER SIDE PANEL. THE COUNTERSUNK HOLES ARE LOCATED IN FRONT OF THE "SMART STEP" ON LEFT SIDE. USE (4) ¼-20 X ¾ FHSH. Circle outward

front

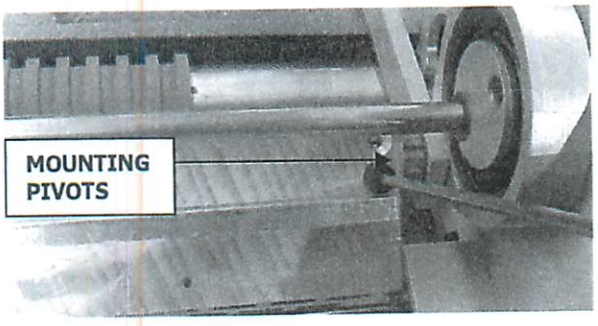
42) CONNECT THE BALL BEARINGS IN THE TOP CUT OFF PIVOT ARMS TO BOTH PIVOT ARM BLOCKS USING A 3/8 X 3/8 SHOULDER BOLT ON EACH.

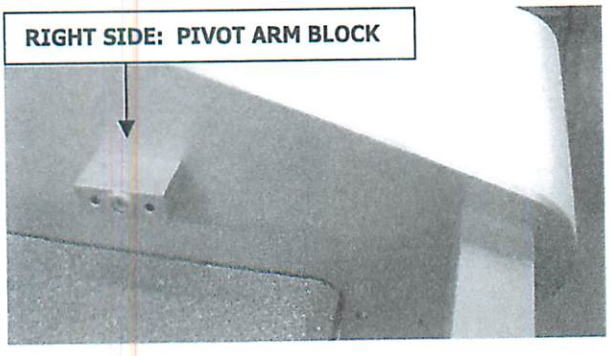


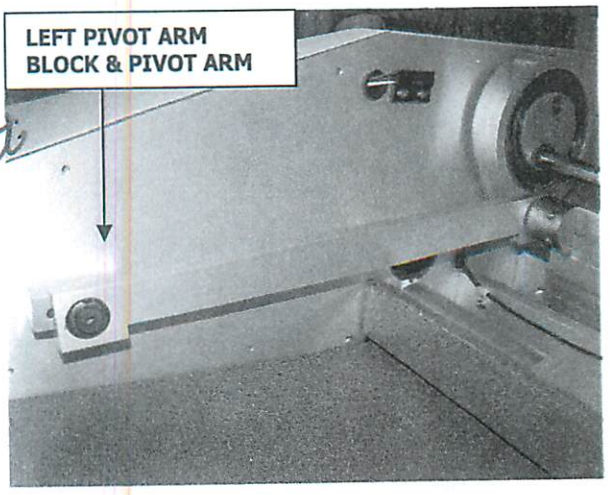
CUT OFF CAM SHAFT WITH BALL BEARING AND ROTOR CLIP E RING ON OUTER LEFT SIDE PANEL. NOTE: 3 SCREWS



TOP CUT OFF MOUNTING BAR & CUT OFF BLADE







ON RIGHT SIDE

43) ADD THE BROWNING TIMING BELT (PRB107) AS21 TO THE CLUTCH PULLEY BY PLACING BELT OVER CLUTCH ASSEMBLY AND TO THE LEFT OF THE LOWER REAR STANDOFF. SEE PHOTO ON NEXT PAGE.

Pack 12

44) THREAD A ¼-20 X ½ SET SCREW INTO THE MOTOR GEAR BELT PULLEY (PRG001) AS21. SLIDE MOTOR GEAR BELT PULLEY OVER MOTOR SHAFT KEY AND MEASURE GEAR PULLEY AND CLUTCH PULLEY TO EVEN DISTANCE FROM SIDE PANEL, APPROXIMATELY ¾ INCH. SECURE MOTOR GEAR BELT PULLEY ON MOTOR SHAFT KEY WITH SET SCREW.

Pack 12

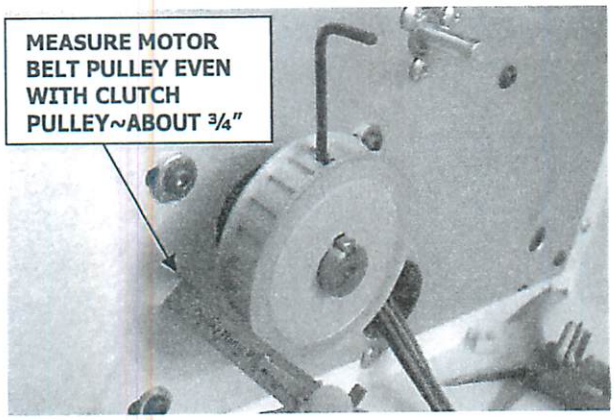
45) SPIN MOTOR SHAFT TO THREAD TIMING BELT INTO GROOVE OF CLUTCH AND MOTOR PULLEYS. LOOSEN THE MOTOR SCREWS AND ADJUST THE BROWNING TIMING BELT TENSION BY MOVING MOTOR SCREWS ALONG SLOTS IN SIDE PANEL. RETIGHTEN MOTOR SCREWS.

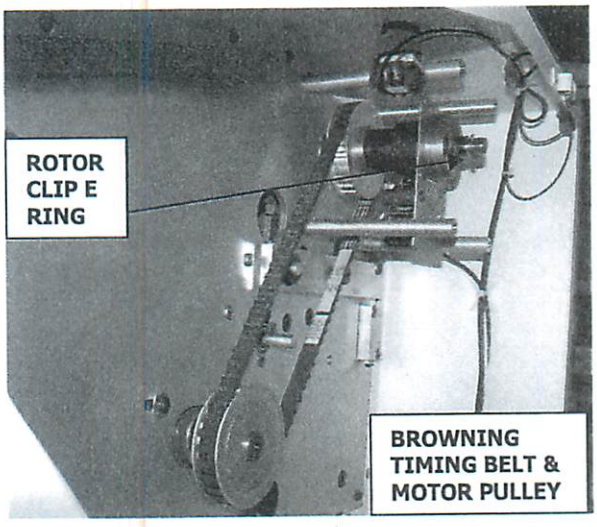
46) ATTACH THE WHITE AND BLACK WIRES WITH FLAG CONNECTORS TO THE CLUTCH TERMINAL POSTS. CONNECT THE OPEN ENDED RED MAGNET WIRE TO THE OUTER EMERGENCY SWITCH OPENING AND THE OPEN ENDED BLACK WIRE TO THE INNER OPENING BY RUNNING THE BLACK WIRE OVER THE TOP OF THE STANDOFFS. CONNECT THE MALE AND FEMALE TERMINALS ON THE REMAINING RED AND BLACK WIRES. CABLE TIE TO STANDOFFS AND SECURE WIRES WITH PRESS CLIPS.

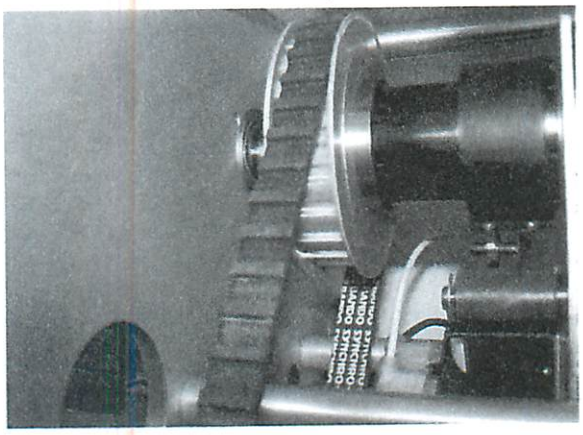
47) SNAP A ROTOR CLIP E RING (PRC270) AS21 ON THE OUTER CLUTCH SHAFT GROOVE. ADD A THIRD BALL BEARING (PRB038) TO THE CUT OFF CAM SHAFT SNUG TO THE ROTOR CLIP E RING.

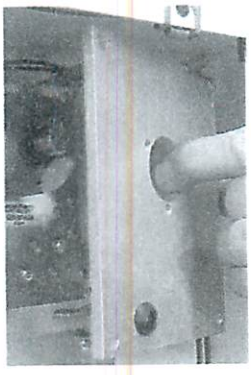
Pack 12

48) TIGHTEN (3) 10-32 X ¼ TH FROM THE OUTSIDE ONTO THE CLUTCH SUPPORT PLATE. INSERT THE CLUTCH STOP PIN INTO THE CLUTCH MOTOR PLATE OPENING ON THE LOWER LEFT OF AND SLIDE THE CLUTCH SUPPORT PLATE





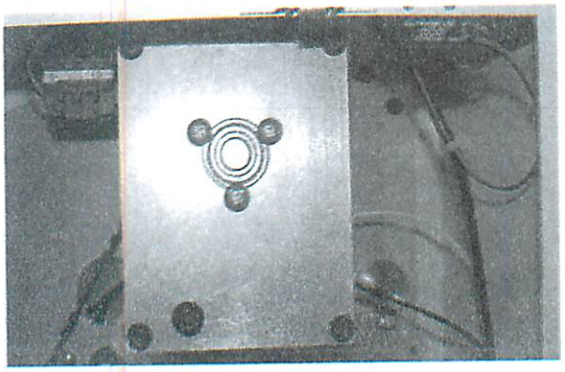




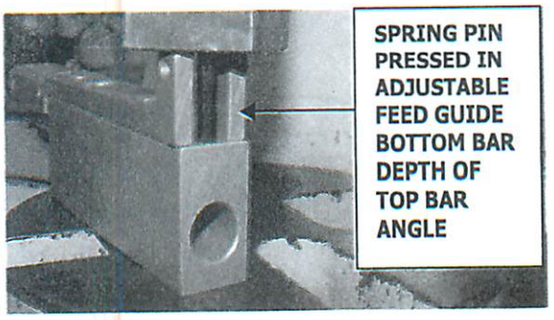


OVER THE BALL BEARING.

49) CONNECT THE CLUTCH SUPPORT PLATE TO THE (4) CLUTCH SUPPORT STANDOFFS ON THE OUTER RIGHT SIDE PANEL. USE (4) ¼-20 X ¾ BHSH TIGHTENED CORNER TO CORNER.



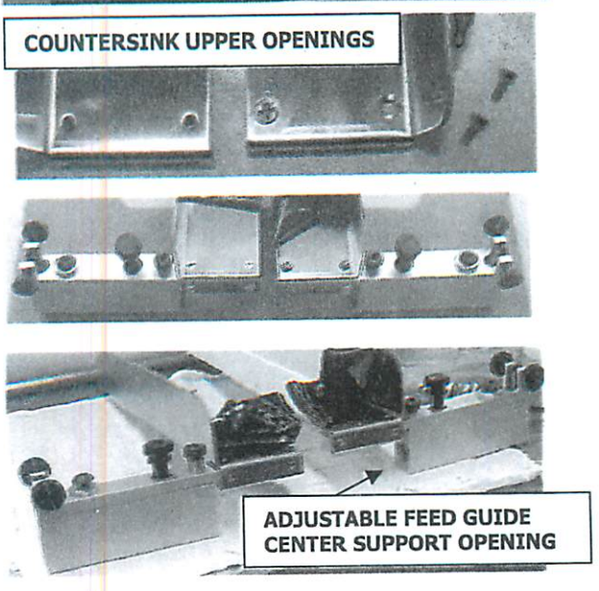
50) FROM RACK 11 PREPARE THE RIGHT AND LEFT FEED GUIDE ASSEMBLY AS FOLLOWS: ARBOR PRESS A 3/16 X 1" SPRING PIN INTO THE *UNTHREADED* END OPENING OF (2) ADJUSTABLE FEED GUIDE BOTTOM BARS (C30 097.4BB). THE SPRING PIN OPENING SHOULD FACE INWARD. MEASURE THE DEPTH OF THE SPRING PIN TO BE FLUSH WITH THE THREADED OFFSETS OF THE ADJUSTABLE FEED GUIDE TOP BAR LEFT (C30 097.4LTB) AND THE ADJUSTABLE FEED GUIDE TOP BAR RIGHT (C30 097.4RTB), AS IT RESTS ON THE ADJUSTABLE FEED GUIDE BOTTOM BAR. THE BEVELED SIDE FACES FRONT OF MACHINE.



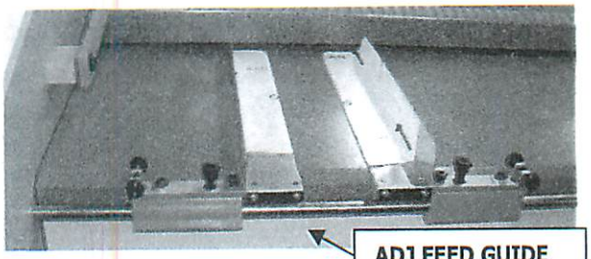
51) SNUG A ¼ X 5/8 X 1/8 FLAT WASHER AND A ¼-20 X ¾ BHSH THROUGH THE TOP BARS INTO THE BOTTOM BARS. TIGHTEN A 5/16 X 3/8 SHOULDER BOLT ONTO THE OTHER END OF THE TWO BARS TO CONNECT THEM. THREAD A 5/16-18 X 1" PLASTIC MOLDED THUMBSCREW (PRK184) AS09 INTO BOTH FEED GUIDE TOP BARS. ADD (2) SPI KNOBS (PRK177) AS08 SNUGGED ONTO THE SPRING PIN FROM THE SIDES.



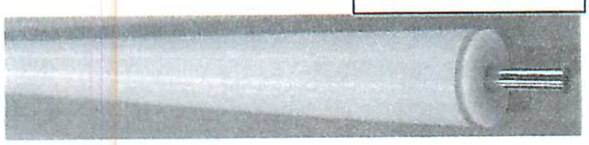
52) USE A #6 COUNTERSINK TO OPEN THE TOP HOLES ON THE ADJUSTABLE FEED GUIDE LEFT (C30 097.4L) RACK 11 AND ATTACH TO THE ADJUSTABLE FEED GUIDE TOP BAR LEFT, USING (2) 6-32 X ¼ PH IN FRONT AND (2) 6-32 X 3/8 FH ON TOP IN COUNTERSUNK HOLES. SCREWS MUST BE FLUSH OR DEEPER. USE #6 COUNTERSINK TO OPEN ADJUSTABLE FEED GUIDE RIGHT (C30 097.4R) RACK 11 AND ATTACH TO THE ADJUSTABLE FEED GUIDE TOP BAR RIGHT WITH THE SAME HARDWARE AS THE LEFT SIDE.



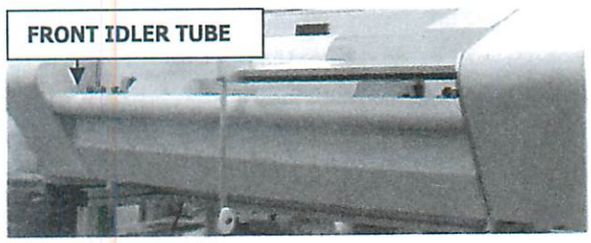
53) INSERT AN ADJUSTABLE FEED GUIDE CENTER SUPPORT (C30 097.4CS) LOFT 2 THROUGH THE OPENINGS IN THE ADJUSTABLE FEED GUIDE BOTTOM BARS. CONNECT TO THE SIDE PANELS UNDER THE BOTTOM STRIPPER USING (2) ¼-20 X ¾ BHSH. THE FEED GUIDES WILL LAY ON THE BOTTOM STRIPPER.



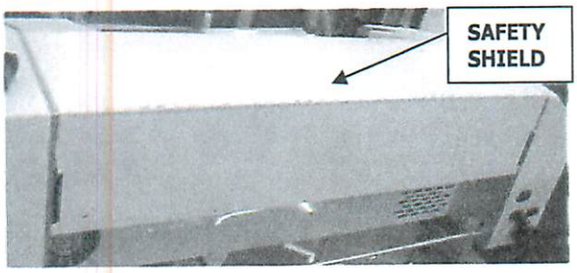
54) TAP IN (2) WHITE FRONT IDLER BEARINGS (C30 113.4) RACK 11, ONE EACH INTO BOTH ENDS OF THE PAINTED FRONT IDLER TUBE (C30 112.4) AS16.



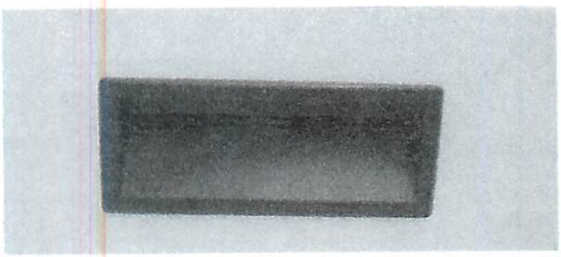
55) INSERT AN ADJUSTABLE FEED GUIDE CENTER SUPPORT (C30 097.4CS) LOFT 2 THORUGH THE FRONT IDLER BEARINGS. CONNECT THE IDLER TUBE ASSEMBLY BETWEEN THE SIDE PANELS, BELOW AND IN FRONT OF THE BOTTOM STRIPPER. USE (2) ¼-20 X ¾ BHSH.



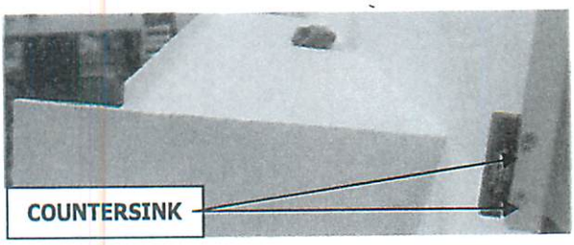
56) FROM THE REAR OF MACHINE, PLACE THE SAFETY SHIELD (C30 074.4) AS16 IN OPEN POSITION OVER GUILLOTINE ASSEMBLY. RAISE THE RUBBER ROLL LIFTING LEVERS AND CONNECT SAFETY SHIELD MOUNTING TABS BETWEEN SIDE PANELS USING (4) 10 X ¾ SMS. HOLES ARE LOCATED IN TOP REAR SIDE PANEL OPENINGS AND BEHIND PIVOT ARMS.



57) SNAP THE POCKET PULL FLUSH HANDLE (PRH150) RACK 12 INTO THE FRONT CENTER OF THE SAFETY SHIELD, SMALL LIP UP.

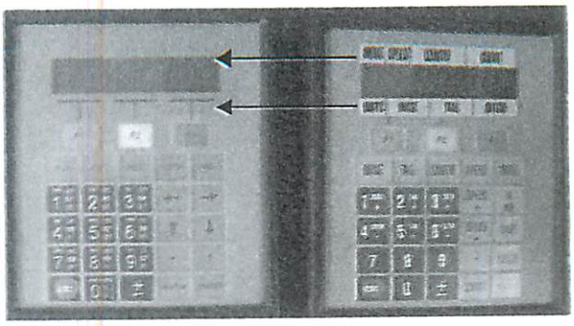


58) LIFT COVER AND COUNTERSINK (2) LEFT SIDE HOLES FROM THE OUTER LIP AND ATTACH PROXIMITY MAGNET (PRS352) RACK 1. USE 4-40 X 3/8 FH AND 4-40 HEX NUTS. DON'T OVER TIGHTEN.



59) REMOVE THE (6) OUTER SCREWS FROM THE BACK OF THE DISPLAY BOARD. REMOVE BACK PANEL. PULL TAB TO REMOVE LABEL AND REPLACE IT WITH LABEL FROM EXIT TABLE CONTROL PANEL (LAB1072) RACK 13. REPLACE SCREWS ON BACK OF DISPLAY BOARD.

60) REMOVE AND DISCARD PLASTIC COVERING OVER READ OUT SCREEN.



ADHERE SET OF (2) C30 STRIP OVERLAYS (LAB1073) RACK 13 TO DISPLAY BOARD. THE "MODE" STRIP GOES ABOVE THE READ OUT SCREEN AND THE "UNITS" STRIP GOES BELOW THE READ OUT SCREEN.

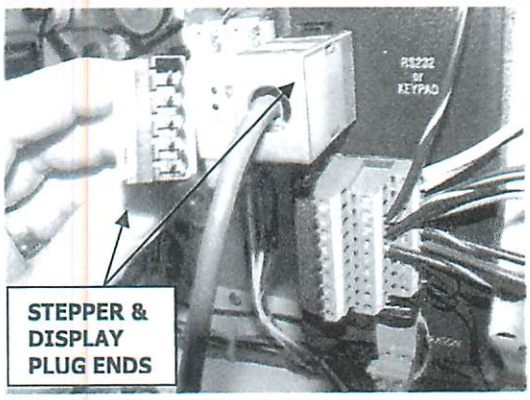
61) REPLACE BACK OF DISPLAY AND SECURE USING ORIGINAL (6) 6-32 FLATHEAD SCREWS.

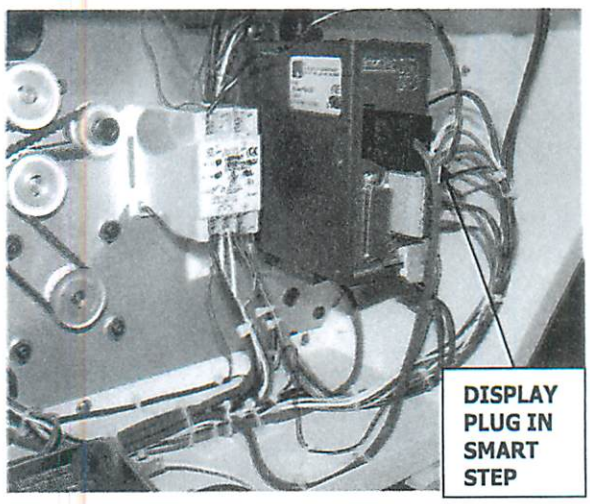
62) PLACE THE DISPLAY BOARD INTO THE LEFT HOUSING. ALIGN HOLES IN THE HOUSING WITH DISPLAY BOARD THREADS AND SECURE USING (4) 6-32 X 3/16 PH FROM INSIDE THE HOUSING.

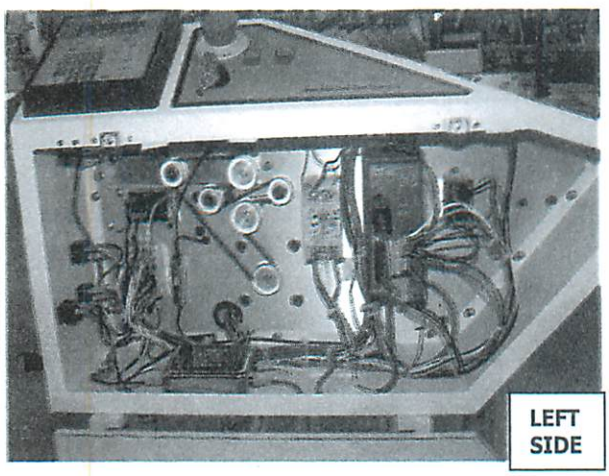
63) PLUG PRONGED DISPLAY BOARD CORD INTO DISPLAY BOARD, WITH THE OFFSET FACING INWARD. ROUTE CORD ALONG OUTER HOUSING AND PLUG THE OTHER END OF THE DISPLAY BOARD CORD INTO THE "SMART STEP" OUTER RECEPTACLE, ABOVE WIRE BOARDS, WITH THE OFFSET FACING THE FRONT OF THE MACHINE.

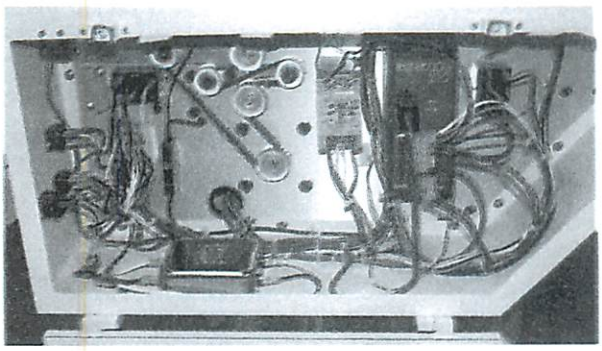
64) TIE DISPLAY CORD UPWARD ONTO THE HOUSING. RUN IT TOWARD THE FRONT AND ALONG INNER HOUSING TO THE REAR, UP AND INTO DISPLAY.

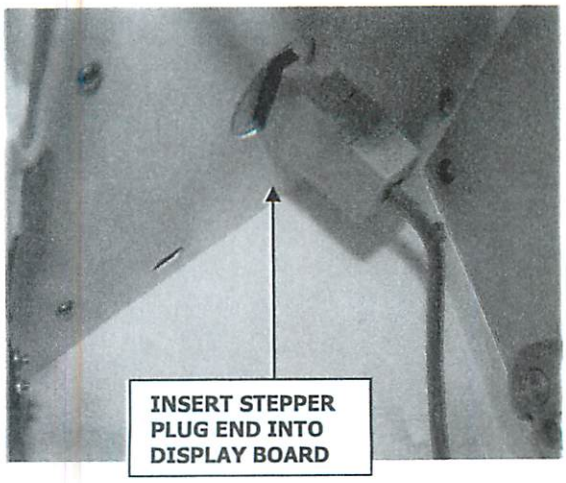






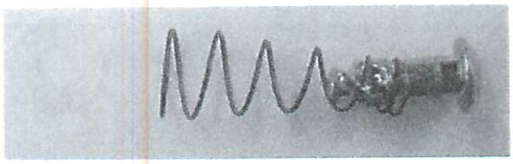






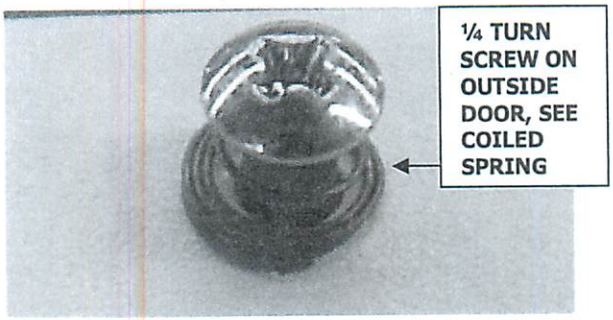
C30 AUTOCUTTER DOOR ASSEMBLY

1) THE C30 AUTOCUTTER HAS A RIGHT AND LEFT HINGED QUICK RELEASE DOOR. THE DOOR ASSEMBLY FOLLOWS.

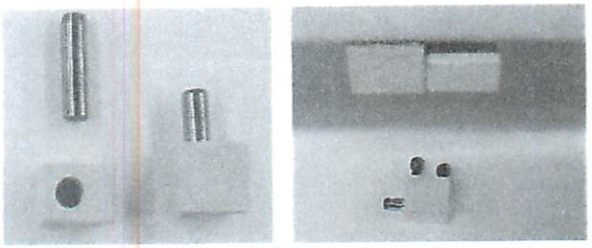


2) THE RIGHT HOUSING DOOR (C25 095.4R) ~~AS27~~ IS ASSEMBLED BY FIRST ATTACHING (2) HINGE QUARTER TURN LATCHES. USING THE QUARTER TURN DOOR LATCH KIT (PML002) ~~AS31~~ PLACE THE SMALLER END OF SPRING ON QUARTER TURN FASTENER SCREW. INSERT QUARTER TURN FASTENER SCREW INTO HOLE ON OUTSIDE OF DOOR, DEPRESSING SPRING ON OUTSIDE. FROM INSIDE, SLIDE THE PLASTIC WASHER OVER THREADS OF QUARTER TURN FASTENER SCREW UNTIL WASHER REST ON SHAFT PAST THREADS.



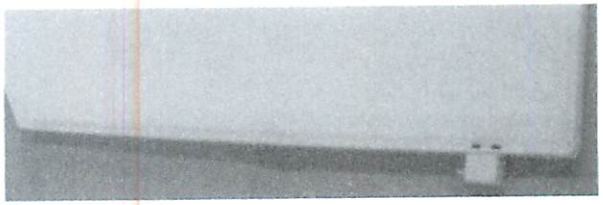


3) ARBOR PRESS (4) 3/16 X ¾ DOWEL PINS (.187J0P12) ONE EACH INTO (4) ROTATING HINGE BLOCKS (C25 106.4) ~~AS11~~. THERE ARE TWO ON EACH DOOR.

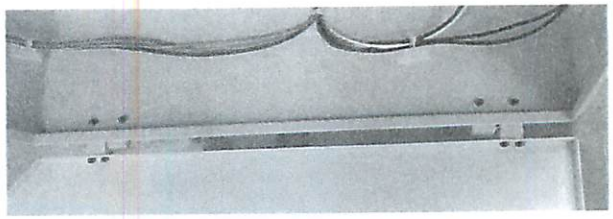


4) CONNECT (1) ROTATING HINGE BLOCK WITH DOWEL PIN TO THE LOWER LIP OF THE DOOR WITH THE DOWEL FACING INWARD. USE (2) 6-32 X ¼ SHCS.

5) THE SECOND ROTATING HINGE BLOCK IS ATTACHED WHEN THE DOOR IS CONNECTED TO THE HOUSING, SO BOTH DOWEL PINS CAN BE INSERTED INTO THE HOUSING STATIONARY HINGE BLOCKS, THE USE (2) 6-32 X ¼ SHCS TO SECURE THE SECOND ROTATING HINGE BLOCK.



6) THE LEFT SIDE HOUSING DOOR (C25 095.5.4L) ~~AS27~~ HAS (2) QUARTER TURN LATCHES. ASSEMBLE THESE LATCHES THE SAME WAY AS ON THE RIGHT SIDE HOUSING DOOR DESCRIBED ABOVE.



7) AFTER THE ROTATING HINGE BLOCKS ARE CONNECTED TO THE STATIONARY HINGE BLOCKS CLOSE DOORS TO TEST FIT. PARTIALLY OPEN THE DOOR TO JUDGE WHERE THE BEST CONNECTION IS FOR THE PROXIMITY SWITCH MAGNET HAMLIN (PRS352) ~~AS31~~ TO MATCH UP WITH THE PROXIMITY SWITCH SECURED TO THE UPPER HOUSING. ORIENT THE MAGNET ON THE DOOR SO THE THICKER PORTION OF THE MAGNET IS ALIGNED WITH THE THICKER PORTION ON THE HOUSING. CLOSE AND OPEN THE DOOR TO TEST FIT WITH MAGNET. MARK MAGNET LOCATION WITH A PENCIL AND CAREFULLY GLUE THE MAGNET TO THE INSIDE OF THE DOOR. USE BLACK LOCTITE 380 GLUE. A SMALL AMOUNT IS SUFFICIENT.

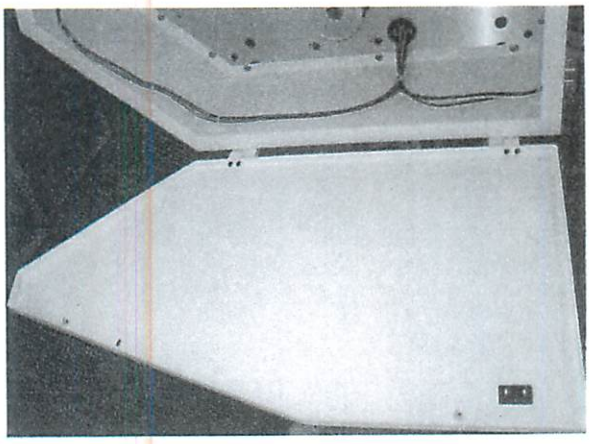
Pack 1



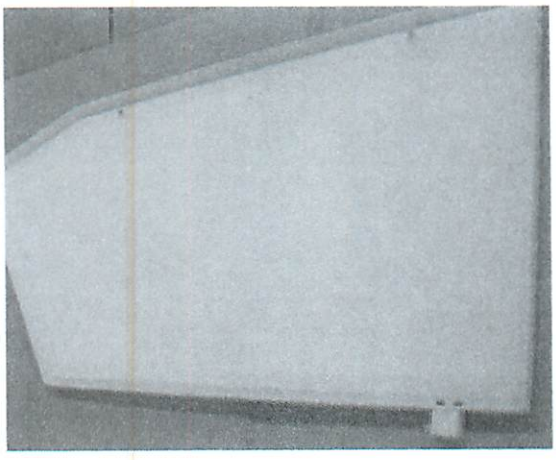
GLUE MAGNET ON INNER DOOR

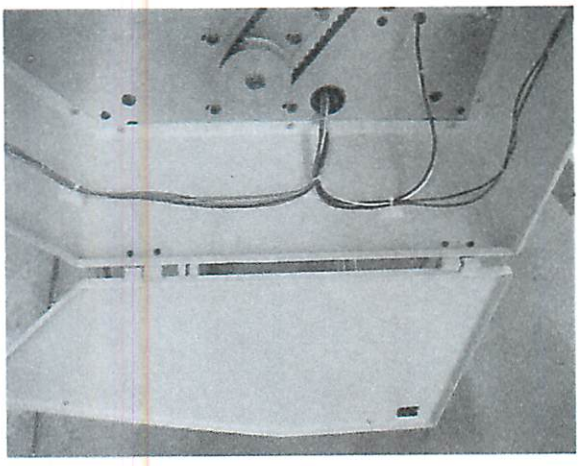
8) SECURE A PROXIMITY SWITCH MAGNET (PRS352) ~~AS31~~ TO THE OTHER DOOR LINING UP THE MAGNET AND SWITCH, USING THE SAME PROCEDURE.

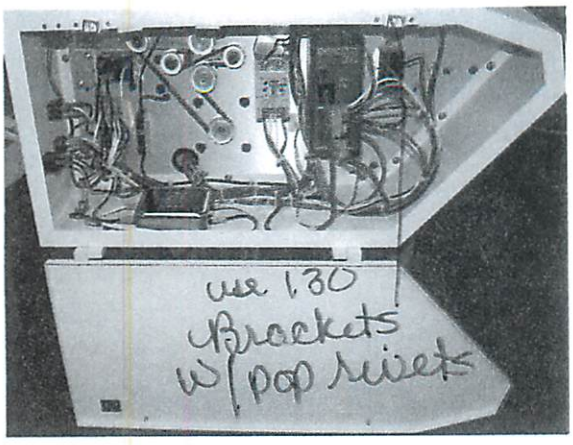
Pack 1

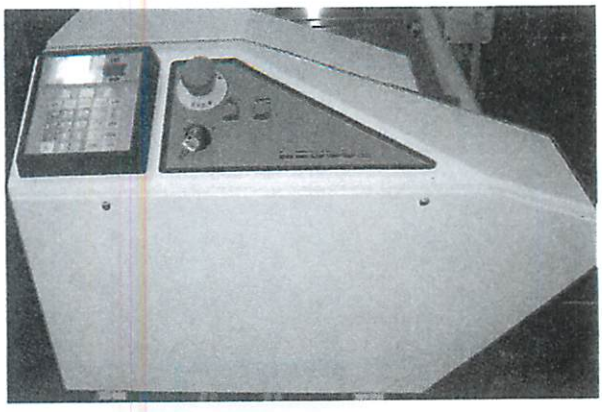


9) NO LABELS OR HANDLES ARE ON NRTL C30 AUTOCUTTER DOOR ASSEMBLIES.

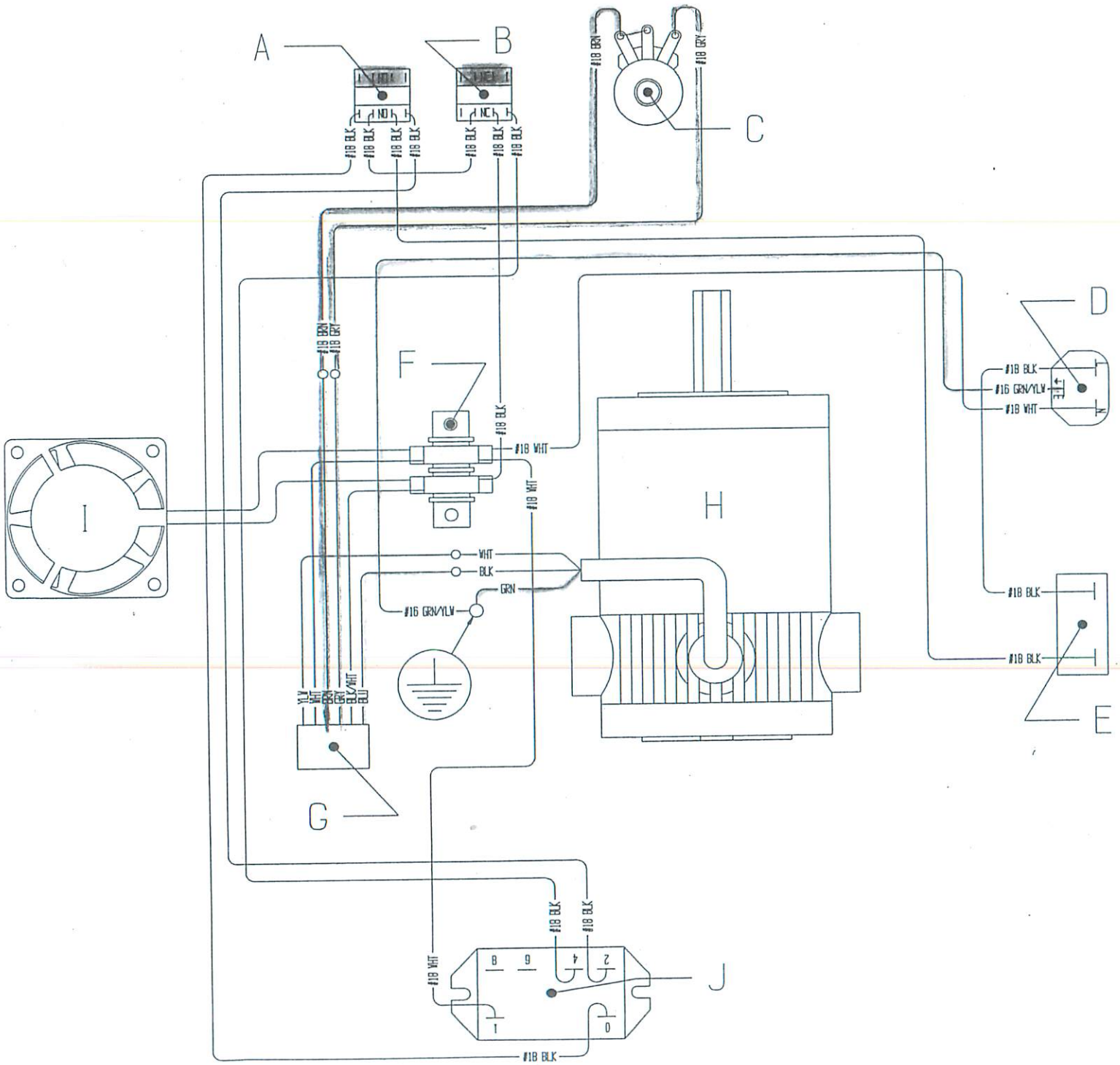








30" AUTOCUTTER 100V - 120V EXIT TABLE WIRING DIAGRAM



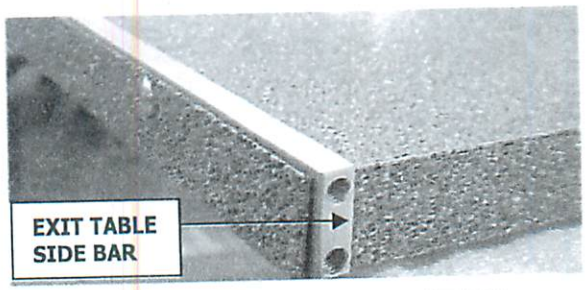
LEGEND

A. GREEN START BUTTON
B. RED STOP BUTTON
C. SPEED CONTROL POTENTIOMETER
D. 110V POWER RECEPTACLE
E. 250V FA 3AG 1.5 AMP FUSE & FUSE HOLDER
F. TERMINAL BLOCK
G. SPEED CONTROL PLUG
H. 90VDC MOTOR
I. MINI MUFFIN FAN
J. 110V DOUBLE POLE RELAY

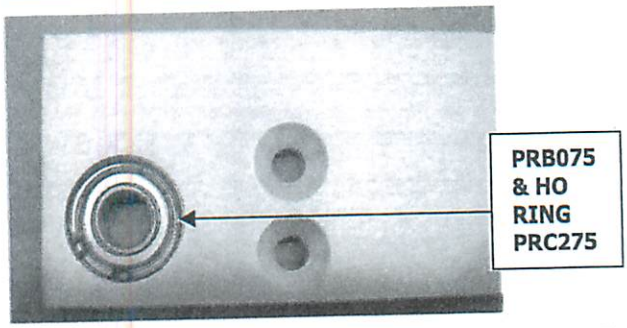
C30 NRTL AUTOCUTTER EXIT TABLE

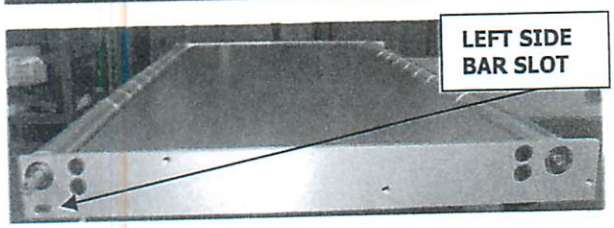
1) PLACE THE EXIT TABLE (C30 302.4) AS16 UPSIDE DOWN ON A WORKTABLE.

2) CONNECT (2) EXIT TABLE BRACE BARS (C30 305.4) AS16 TO THE INNER FRONT AND REAR EDGE OF THE EXIT TABLE, BETWEEN SLOT IN LIPS, WITH THE *BEVELED LINE OF THE BRACE BAR BY EXIT TABLE BREAK.* SECURE THE BRACE BARS WITH (6) 10-32 x 3/8 TH. BRACE BARS WILL EXTEND PAST THE EXIT TABLE WIDTH.

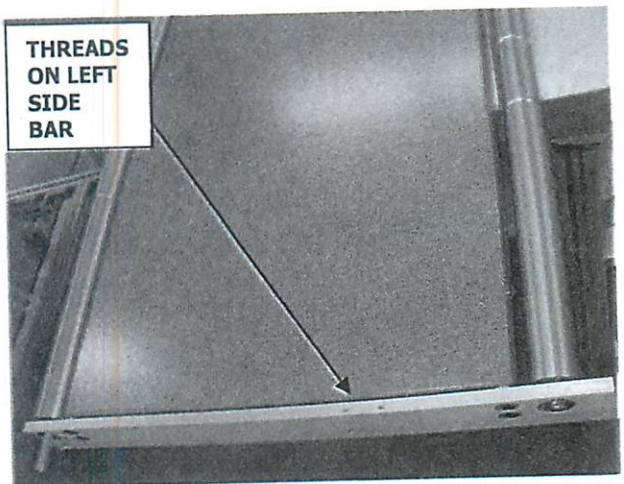


3) ARBOR PRESS (2) R6ZZ ROLLER BEARINGS (PRB075) RACK 12 *EACH* COMPLETELY INTO THE RECESSES OF AN EXIT TABLE RIGHT SIDE BAR (C30 307.4) AS17 AND EXIT TABLE LEFT SIDE BAR (C30 308.4) AS17. LEFT SIDE BAR HAS SLOT BY BEARING. SECURE EACH OF THESE ROLLER BEARINGS WITH A ROTOR CLIP HO RING (PRC275) RACK 12 SNAPPED INTO THE RECESS OVER THE ROLLER BEARING.



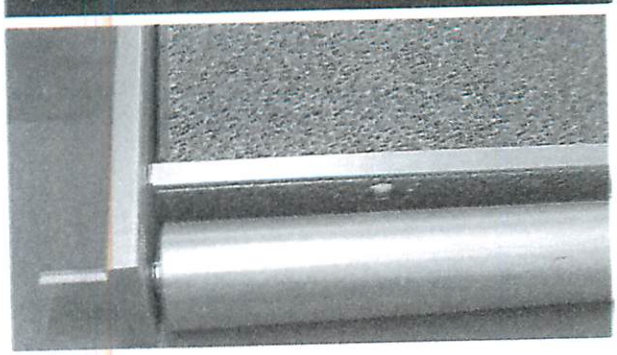


4) ATTACH THE EXIT TABLE LEFT SIDE BAR *ONLY* TO THE EXIT TABLE BRACE BARS THROUGH THE COUNTERSUNK HOLES. USE (4) ¼-20 X ¾ FHSH. THE SIDE BAR EXTENDS FURTHER PAST THE EXIT TABLE ON FRONT END THAN THE BACK END. THIS END WILL BE CONNECTED TO THE CUTTER. THE *THREADED EDGES FACE UPWARD* WHEN EXIT TABLE IS UPRIGHT.



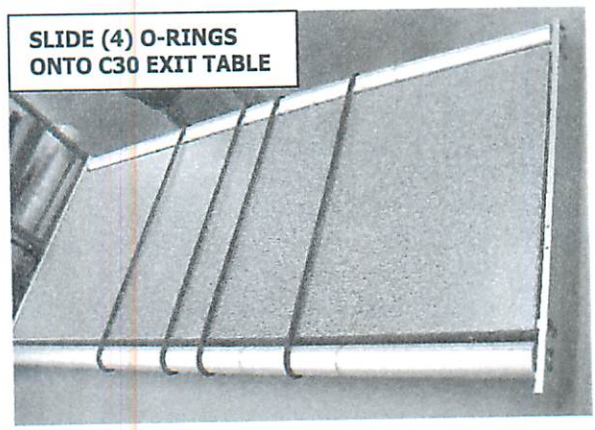
5) INSERT THE LONGER SHAFT END OF THE EXIT TABLE DRIVE ROLLER (C30 303.4D) AS16 INTO THE ROLLER BEARING ON THE EXIT TABLE LEFT SIDE BAR THAT IS CLOSER TO THE EXIT TABLE AND HAS A *CHANNEL OPENING* LOCATED ALONG THE EDGE OF THE BAR FOR THE CONTROL BOX.

6) INSERT THE SHAFT OF THE EXIT TABLE IDLER ROLLER (C30 303.4I) AS16 INTO THE ROLLER BEARING IN THE FRONT OF THE EXIT TABLE LEFT SIDE BAR. SLIDE

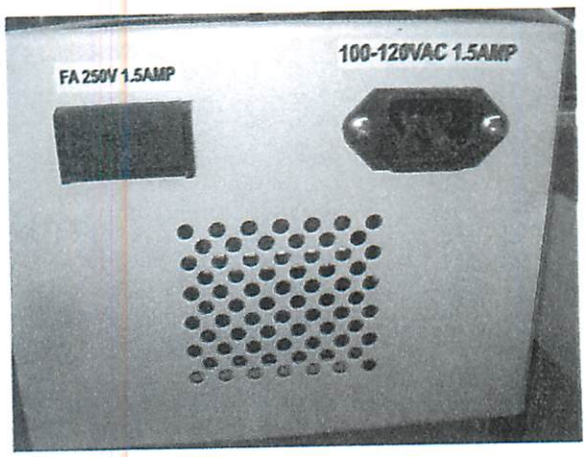


THE ROLLER BEARINGS ON THE EXIT TABLE RIGHT SIDE BAR OVER THE RIGHT SIDE DRIVE AND IDLER ROLLER ENDS. SECURE THE EXIT TABLE RIGHT SIDE BAR TO THE FRONT AND REAR BRACE BARS WITH (4) ¼-20 X ¾ FHSH.

7) SLIDE (4) O-RINGS (PRR265) RACK 12 OVER THE END OF THE EXIT TABLE ASSEMBLY AND FIT THE O-RINGS INTO THE CENTER TWO DRIVE AND IDLER ROLLER GROOVES, SKIP A GROOVE ON EITHER SIDE AND FIT THE REMAINING TWO O-RINGS INTO THE NEXT PAIR OF GROOVES. THE O-RINGS CAN BE MOVED FROM GROOVE PAIRS TO ACCOMMODATE THE WIDTH OF VARIOUS MATERIALS.



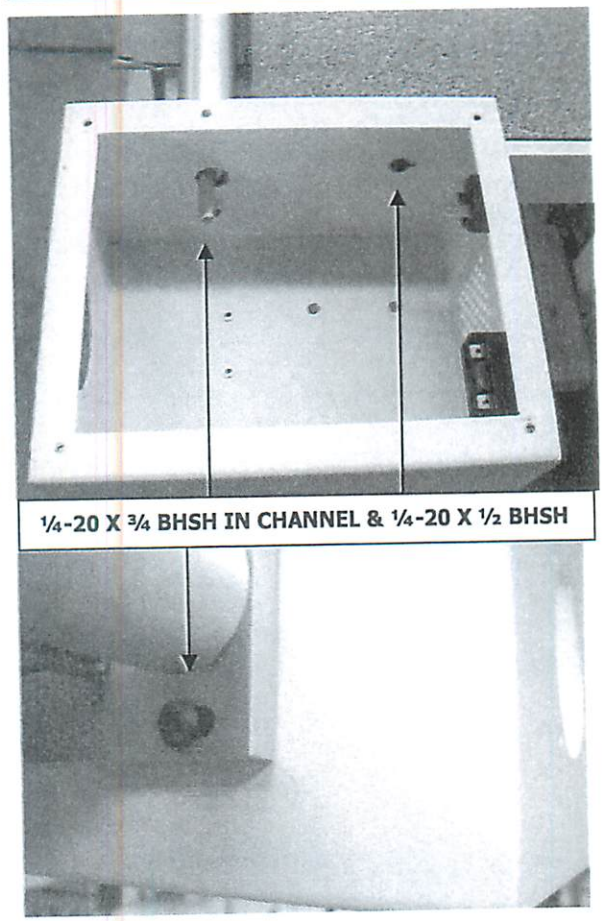
8) INSERT A CORD RECEPTACLE, PANEL MOUNT (PRC117) AS07 INTO EXIT TABLE CONTROL BOX (C30 300.4A) AS16, WITH SINGLE TERMINAL POST CLOSEST TO THE PERFORATIONS (DOWN POSITION). USE (2) 6 X 3/8 TH SMS TO SECURE. ADHERE 110-120VAC 1.5AMP LABEL (LAB121) AS09 ABOVE RECEPTACLE.



9) INSERT (2) 1.5 AMP FUSES (PRF128) AS07 INTO A FUSE HOLDER (PRF145) RACK ~~21~~. THE SECOND 1.5 AMP FUSE IS A SPARE. SNAP FUSE HOLDER IN BOX. ADHERE AN FA 250V 1.5 AMP LABEL (LAB124) AS09 ABOVE FUSE HOLDER.

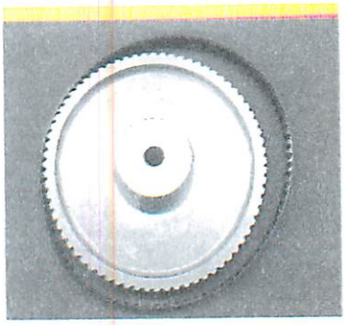
Rack 12

10) SECURE THE EXIT TABLE CONTROL BOX TO THE LEFT REAR CORNER OF THE EXIT TABLE, FITTING OVER THE DRIVE ROLLER SHAFT. USE A ¼-20 X ½ BHSH THROUGH THE INSIDE OF THE CONTROL BOX INTO THE LEFT SIDE BAR AND USE A ¼-20 X ¾ BHSH UNDER THE EXIT TABLE THROUGH THE CHANNEL IN THE LEFT SIDE BAR INTO THE THREADED LIP INSIDE THE CONTROL BOX. ***DO NOT TIGHTEN THESE SCREWS AT THIS TIME, THEY WILL BE TIGHTENED AFTER THE PULLEY, TIMING BELT AND MOTOR ARE CONNECTED.***



11) FROM RACK 12 PLACE A URETHANE KEVLAR TIMING BELT (PRB250) ONTO TEETH OF TIMING BELT PULLEY (PRG005). ALIGN ***HUB OF THE TIMING***

BELT PULLEY INWARD AND LOOSELY SNUG ONE OF THE TWO SET SCREWS ON THE FLAT OF THE DRIVE ROLLER JOURNAL, ***FULLY INWARD***. USE A LONG T-HANDLE ALLEN WRENCH THROUGH THE OPENING IN THE CONTROL BOX LIP TO REACH THE SET SCREW. THE SECOND SET SCREW IN THE TIMING BELT PULLEY IS SNUGGED ON THE ROUND OF THE DRIVE JOURNAL.

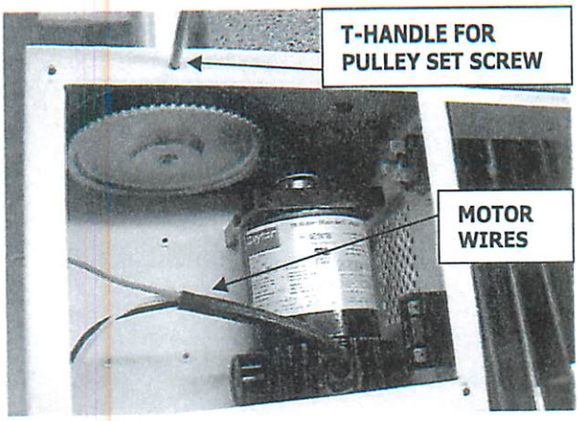


TIMING BELT PULLEY AND URETHANE TIMING BELT

12) REMOVE ONE OF THE SET SCREWS ON THE TIMING BELT PULLEY (PRG004) RACK 12. PLACE THE TIMING BELT PULLEY ON THE SHAFT OF THE DC MOTOR 4Z141B (PRM1995) AS04, WITH ***PULLEY HUB INWARD***. LOOSELY SNUG PULLEY ONTO FLAT OF MOTOR SHAFT SO THE PULLEY DOESN'T SPIN ON THE SHAFT, BUT CAN STILL MOVE UP AND DOWN THE FLAT. ***FLAT OF SHAFT FACES UPWARD***.

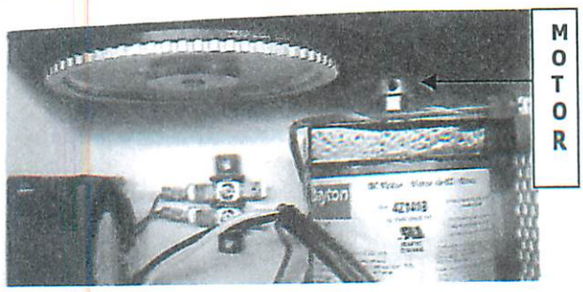


13) TRIM MOTOR CORD SO THAT 9" ARE REMAINING. STRIP OFF 4" OF BLACK WIRE INSULATION AT THE END OF THE MOTOR CORD. CRIMP A #8 BLUE RING CONNECTOR ONTO THE GREEN GROUND MOTOR WIRE. CRIMP A RED MALE CONNECTOR (PRT330) ONTO THE WHITE AND BLACK MOTOR WIRES.

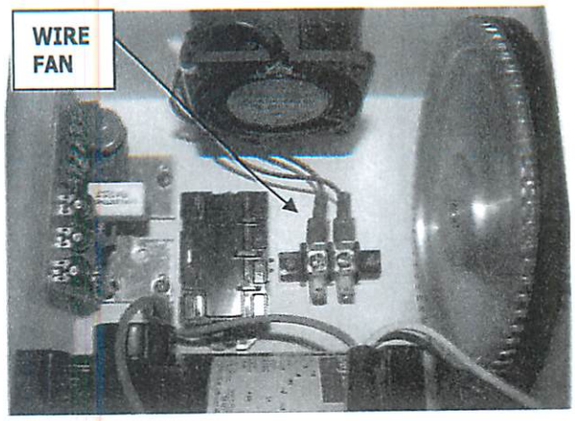


14) WITH MOTOR SHAFT FACING INWARD TOWARD EXIT TABLE, SECURE THE MOTOR TO THE EXIT TABLE CONTROL BOX WITH (4) ¼-20 X ½ BHSH.

15) FROM AS09 SECURE (2) 45 DEGREE TERMINALS (PRT307) AND (2) 90 DEGREE TERMINALS (PRT308) TO A KULKA TERMINAL BLOCK (PRT304). SECURE THE TERMINAL BLOCK TO CONTROL BOX WITH (2) 6-32 X ½ RH.



16) FROM AS09 TRIM 5" OF WIRE OFF THE 115VAC MINI FAN (PRF143) AND CRIMP ON (2) RED FEMALE CONNECTORS (PRT331). PLACE THE FAN INSIDE THE CONTROL BOX, ORIENTED WITH THE WIRES FACING UPWARD AND THE FAN LABEL INWARD ***AIR FLOW IN***. SECURE THE MINI FAN FROM THE OUTSIDE WITH THE WIRE FAN GRILL (PRF144) AND (4)



10 X ½ PH SMS. ATTACH FAN WIRES TO THE CLOSEST 45 DEGREE TERMINALS ON THE TERMINAL BLOCK. ***PULLEY = WHITE WIRE SIDE OF TERMINAL BLOCK.***

17) REMOVE BAG #2 FROM THE WIRING HARNESS (PRW353). CONNECT FEMALE END OF THE GREEN/YELLOW GROUND WIRE TO THE SINGLE TERMINAL POST ON THE RECEPTACLE.

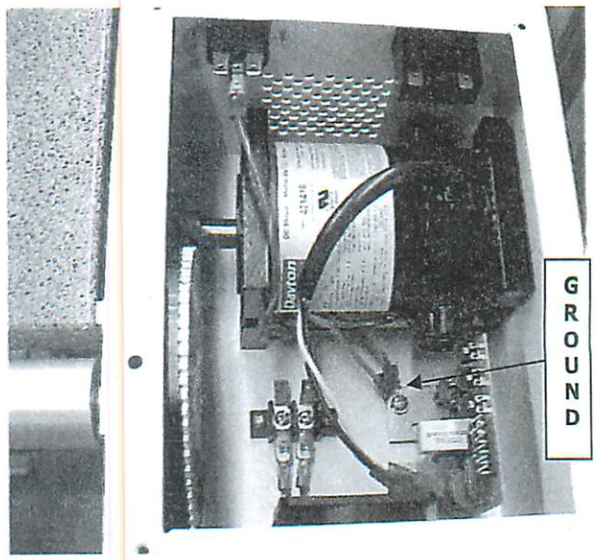
18) REMOVE THE MOLEX WIRE CONNECTION ON THE MINARIK SPEED CONTROL BOARD (PRM219) AS08. GIVE THE MOLEX UNIT TO THE WIRING DIVISION FOR FUTURE USE. CONNECT THE SPEED CONTROL BOARD BRACKET TO THE CONTROL BOX USING A (1) 6-32 X ¼ PH ON THE FAN SIDE. SECURE THE MOTOR SIDE OF BRACKET WITH (1) 6-32 X ½ RH ***AFTER*** A #8 STAR WASHER, THE GREEN GROUND MOTOR WIRE AND THE GREEN/YELLOW RECEPTACLE GROUND ARE ADDED TO SPEED BOARD BRACKET.

19) SECURE THE 120V COIL RELAY (PRR150) RACK 12 BETWEEN TERMINAL BLOCK AND CONTROL BOARD, ORIENTED WITH THE (4) TERMINAL POSTS BESIDE TERMINAL BLOCK. USE (2) 6-32 x ¼ PH.

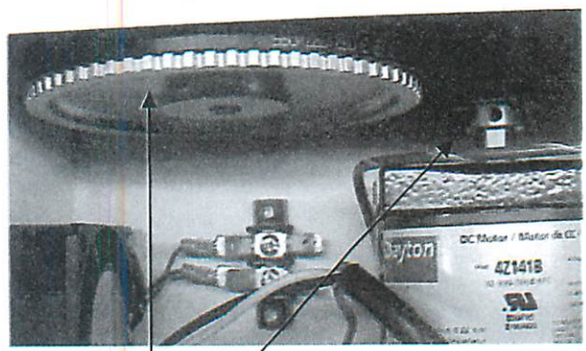
20) ALIGN PULLEY ON MOTOR SHAFT WITH PULLEY ON DRIVE ROLLER SO THE PULLEY BELT HAS AN EVEN TRACK. THEN SECURE SET SCREWS.

21) PRODUCE PROPER TENSION ON TIMING BELT BY ADJUSTING THE TWO BUTTON HEAD SCREWS HOLDING THE CONTROL BOX ON THE LEFT SIDE BAR.

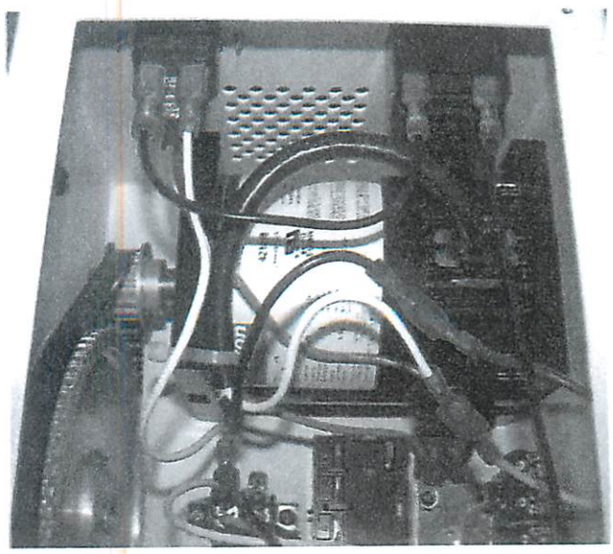
22) FROM WIRING BAG #2 CONNECT THE MOLEX WIRES ONTO THE SPEED BOARD, WITH ***BLUE WIRE CLOSEST TO THE MOTOR.*** CONNECT THE BLACK MOTOR WIRE TO THE MOLEX BLUE WIRE AND THE WHITE MOTOR WIRE TO THE MOLEX YELLOW WIRE. THE WHITE MOLEX WIRE CONNECTS TO POSITIVE 90 DEGREE TERMINAL BY PULLEY, ABOVE FAN WIRE. THE BLACK/WHITE MOLEX WIRE CONNECTS TO THE 90 DEGREE TERMINAL POST ABOVE FAN WIRE.



T-HANDLE HOUSING OPENING TO ADJUST DRIVE PULLEY SET SCREW



ALIGN DRIVE & MOTOR PULLEY TO TRACK PULLEY BELT EVENLY, THEN TIGHTEN SET SCREWS



5"

23) CONNECT THE A SHORT BLACK WIRE BETWEEN PANEL-SIDE RECEPTACLE POST AND INNER FUSE POST. CONNECT A LONGER BLACK WIRE WITH A PRT310 ON ONE END TO OUTER FUSE.

24) CONNECT A 6" BLACK WIRE BETWEEN MOTOR SIDE 90 DEGREE TERMINAL BLOCK POST, WHICH LATER CONTINUES TO RED STOP PUSHBUTTON. CONNECT A WHITE WIRE BETWEEN FUSE-SIDE RECEPTACLE POST AND POSITIVE 45 DEGREE POST ON TERMINAL BLOCK. CONNECT A WHITE WIRE BETWEEN MOTOR SIDE POSITIVE 90 DEGREE TERMINAL POST AND RELAY #1.

25) USE A .625 REAMER TO CLEAR OPENINGS ON AN EXIT TABLE CONTROL PANEL (C30 301.4A) ~~RACK 13~~ PRS16. CENTER AND ADHERE AN EXIT TABLE DECAL (LAB108A) RACK 13 ONTO EXIT CONTROL PANEL.

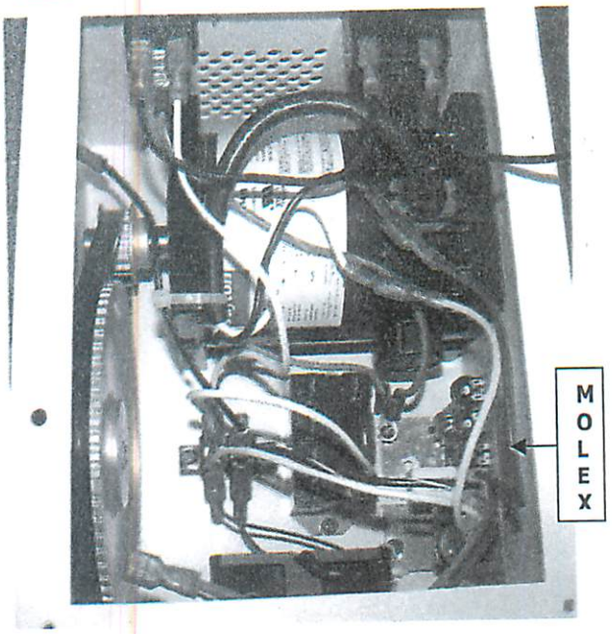
26) ALIGN THE 16MM GREEN PUSHBUTTON (PRS361) RACK 13 TO SNAP INTO CONTROL PANEL UNDER THE ARROW INDICATION WITH *DEPRESSED OUTER DARK* EDGES FACING RIGHT AND LEFT TOWARD POTENTIOMETER AND *FLAT DARK EDGES* FACING TOP AND BOTTOM. USE CASTLE TOOL TO TIGHTEN NUTS.

27) ALIGN THE 16MM RED PUSHBUTTON (PRS362) RACK 13 TO SNAP INTO CONTROL PANEL UNDER THE STOP INDICATION ORIENTED THE SAME WAY AS THE GREEN PUSHBUTTON.

28) WITH POTENTIOMETER STEM AWAY FROM YOU AND TERMINAL POSTS POINTING UP, UNITE THE MIDDLE AND LEFT POST (NEAREST THE CATCH TAB). SLIDE ¾" OF 3/16 BLACK INSULATION TUBING (PRI165) CAB 1 ONTO THE BROWN AND GRAY WIRES FROM BAG #2. SOLDER THE BROWN WIRE TO THE DOUBLE TERMINAL POSTS AND THE GRAY TO THE RIGHT POST. SLIDE THE INSULATION TUBING OVER THE POST AND SOLDER AND HEAT SHRINK IT.

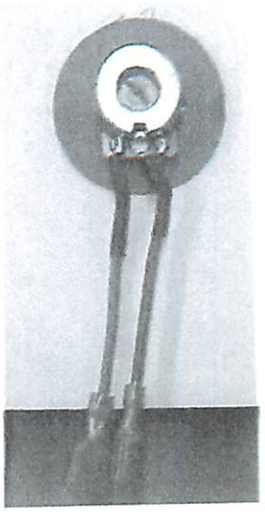
29) USE THE PAPER WASHER ON THE INSIDE

FAN WIRES, MOLEX MOTOR CONTROL AND TERMINAL BLOCK WIRE CONNECTIONS



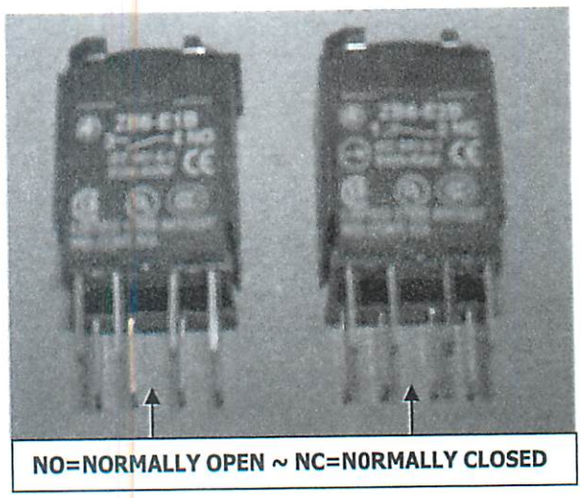




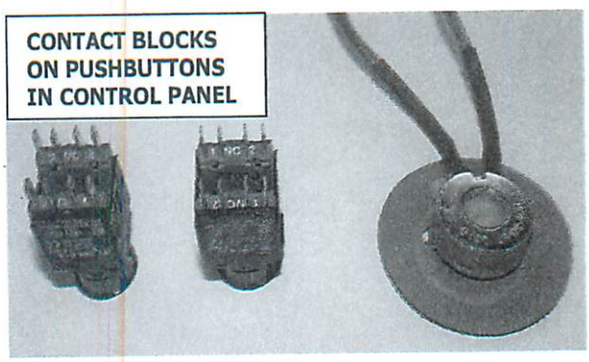


AND FIT THE STEM AND THE CATCH TAB INTO PANEL OPENINGS. SECURE THE OUTSIDE OF THE POTENTIOMETER TO THE PANEL WITH A TOOTHED WASHER AND HEX NUT. SECURE A MINARIK KNOB (PRM221A) AS08 ON THE STEM.

30) FROM RACK 13 FIT THE RED NORMALLY CLOSED NC CONTACT BLOCK (PRS373) WITH (8) TERMINAL POSTS ONTO THE RED PUSHBUTTON SWITCH BY THE POTENTIOMETER. FIT THE GREEN NORMALLY OPEN NO CONTACT BLOCK (PRS365) WITH (8) TERMINAL POSTS ONTO GREEN PUSHBUTTON SWITCH. POSTS SHOULD ORIENT AS PICTURED.



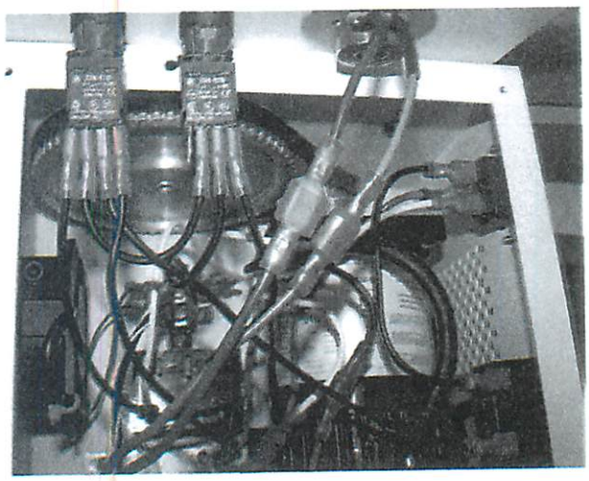
31) *IT IS CRITICAL BOTH CONTACT BLOCK CONNECTIONS ARE ALONG THE SAME LINE, ALIGNING WITH EACH OTHER.*



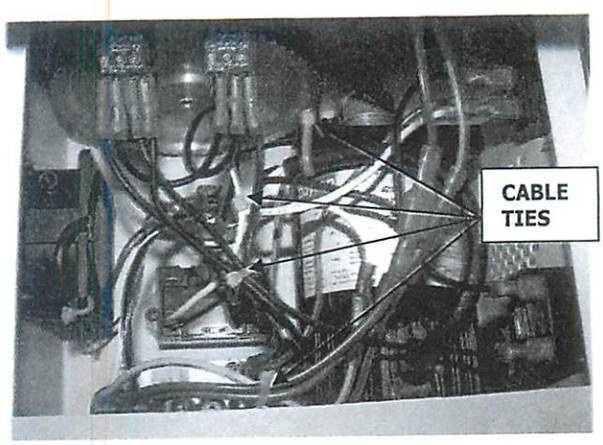
32) ONLY (7) OF THE *INNER TERMINAL POSTS* ON THE GREEN NO AND RED NC CONTACT BLOCKS ARE USED.

33) CONNECT THE BROWN MOLEX WIRE TO POTENTIOMETER BROWN AND THE GRAY MOLEX WIRE TO POTENTIOMETER GRAY.

34) FOLLOW NRTL WIRING DIAGRAM FOR 120V 30" AUTOCUTTER, PROCEEDING THIS SECTION. CONNECT 3" BLACK JUMPER WIRE BETWEEN OUTER-MIDDLE GREEN PUSHBUTTON POST AND INNER-MIDDLE RED PUSHBUTTON POST. CONNECT BLACK WIRE ON OUTER FUSE TO GREEN INNER-MIDDLE POST, RIGHT OF JUMPER. CONNECT BLACK WIRE ON RELAY #0 TO OUTER-GREEN POST AND RELAY #2 TO INNER GREEN POST.

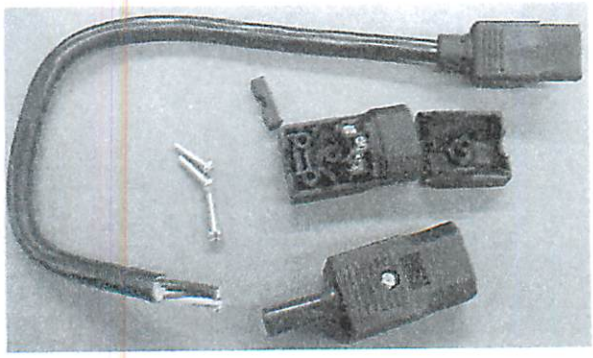


35) CONNECT BLACK WIRE ON 90 DEGREE MOTOR-SIDE TERMINAL BLOCK TO OUTER-MIDDLE RED PUSHBUTTON POST, NEXT TO JUMPER. CONNECT BLACK WIRE ON RELAY #4 TO OUTER RED PUSHBUTTON BY POTENTIOMETER.

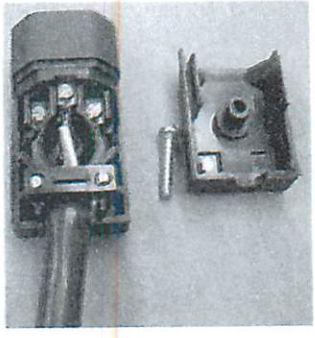


36) PLUG IN EXIT TABLE AND TEST. IF MOTOR IS HUMMING, YOU CAN TURN THE "MIN" POT TOTALLY DOWN. TIE WIRES AND CLOSE COVER. SECURE COVER WITH (4) 6-32 X ¼ PH.

37) PREPARE THE REMOVEABLE CORD (PRC118) LD05 BY SHORTENING CORD TO LEAVE 12" REMAINING FROM RECEPTACLE END. REMOVE SHEATHING FROM 1" OF END WIRES. LEAVE THE GREEN GROUND WIRE SLIGHTLY LONGER THAN THE OTHER TWO.

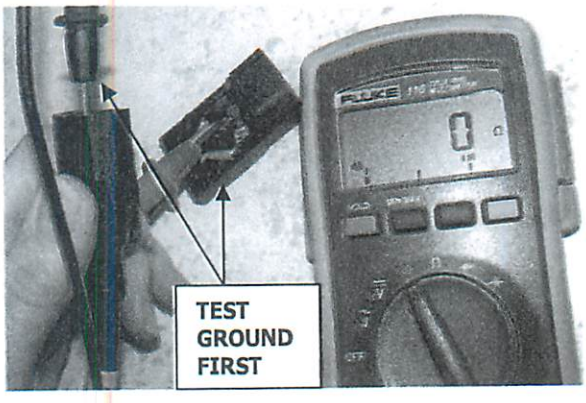


38) REMOVE THE (3) SCREWS FROM THE AC APPLIANCE PLUG MATE (PRR254) RACK 11 AND SEPARATE HALVES. RETAIN SCREWS AND CORD CATCH, DISCARD STRAIN RELIEF. LOOSEN (3) FH SCREWS TO EXPOSE WIRE INSERT OPENINGS BENEATH SCREWS.





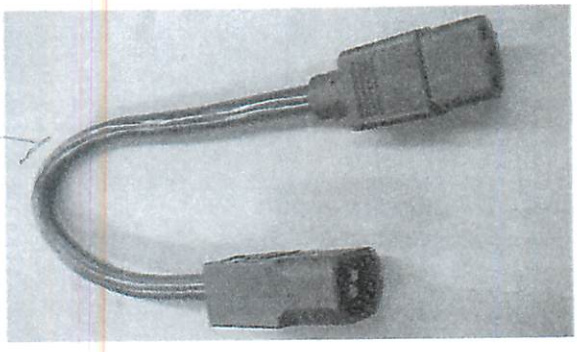
39) INSERT BLUE OPEN WIRE RIGHT OF neutral CENTER, INTO OPENING UNDER SCREW AND TIGHTEN FH SCREW ON WIRE. INSERT BROWN OPEN WIRE LEFT OF "line" CENTER AND TIGHTEN FH SCREW ON WIRE. INSERT GREEN/YELLOW GROUND WIRE INTO RAISED CENTER OPENING. ***LEAVE ROOM FOR CENTER COVER SCREW*** TO THREAD ON COVER.



40) USE A VOLT METER ON "BEEP" SETTING AND TEST CONTINUITY OF EACH WIRE CONNECTION. TEST GROUND FIRST.

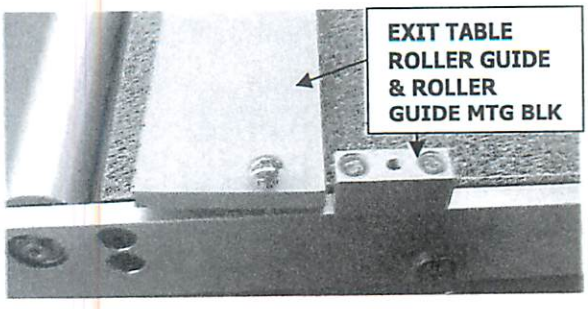
41) REPLACE CORD CATCH AND SECURE WITH (2) SCREWS. REPLACE COVER AND SECURE WITH REMAINING SCREW.

42) ATTACH (2) EXIT TABLE ROLLER GUIDE MOUNTING BLOCKS (C30 310.4) AS11 ONTO THE THREADS OF BOTH BARS. SECURE THE ROLLER GUIDE MOUNTING BLOCKS THROUGH COUNTERSINKS WITH (4) 10-32 X 1 ¼ FH.



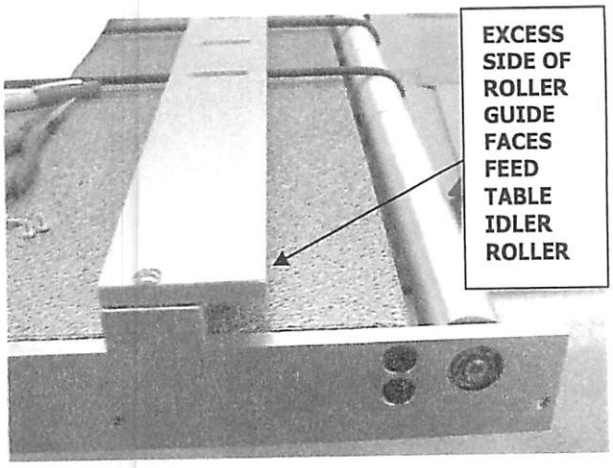
43) ALIGN THE LONGER WIDTH OF THE EXIT TABLE ROLLER GUIDE (C30 309.4) AS16 AWAY FROM THE CONTROL BOX. SECURE ROLLER GUIDE MOUNTING BLOCKS WITH (2) 10-32 X ¾ TH.

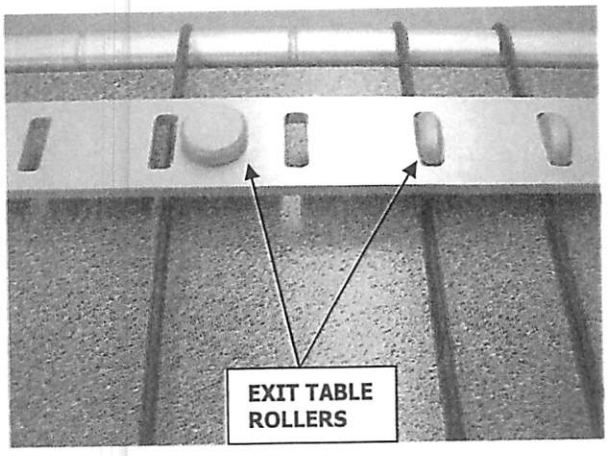
44) INSERT (4) EXIT TABLE ROLLERS (C30 311.4) RACK 11 INTO CHANNELS ON ROLLER GUIDE ABOVE O-RINGS.

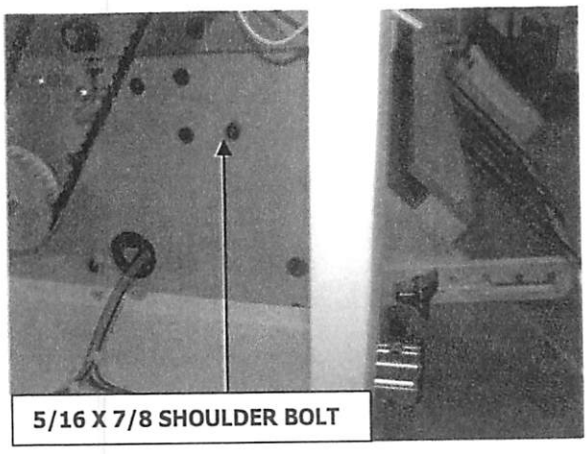


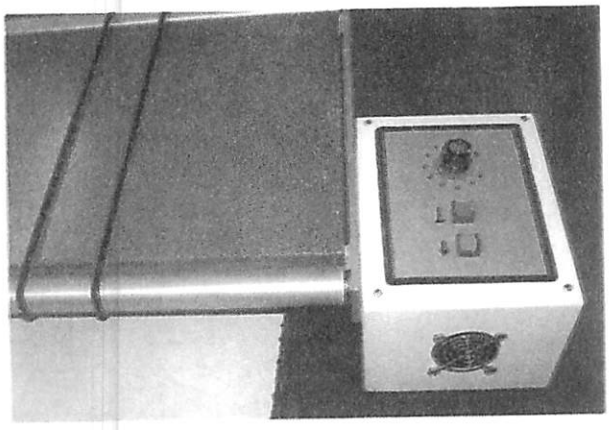
45) TO SECURE THE EXIT TABLE TO THE C30

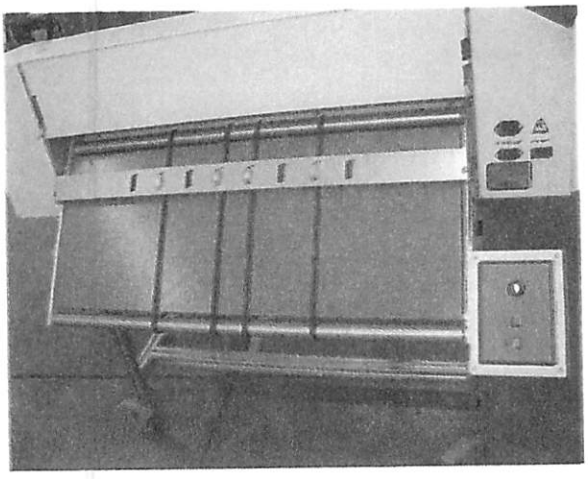
CHASSIS, PLACE EXIT TABLE SUPPORT BARS OUTWARD, RESTING ON STAND. SIT FROM BEHIND THE CHASSIS, HOLDING EXIT TABLE AND HAVE A SECOND PERSON ALIGN (2) 5/16 X 7/8 SHOULDER BOLTS THROUGH SIDE PANELS. ALIGN THE EXIT TABLE ANGLE BY MOVING ALONG THE EXIT TABLE SUPPORT BAR CHANNELS. SET HEIGHT BY MOVING RIGHT AND LEFT THREE PRONG KNOBS (PRK150) RACK 12 EACH HAVING A ¼ X 5/8 X 1/8 FLAT WASHER.

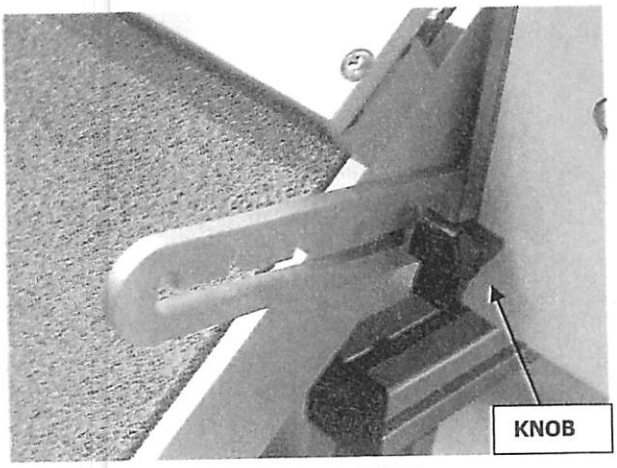


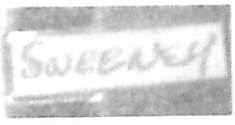












C30 AUTOCUTTER TESTING

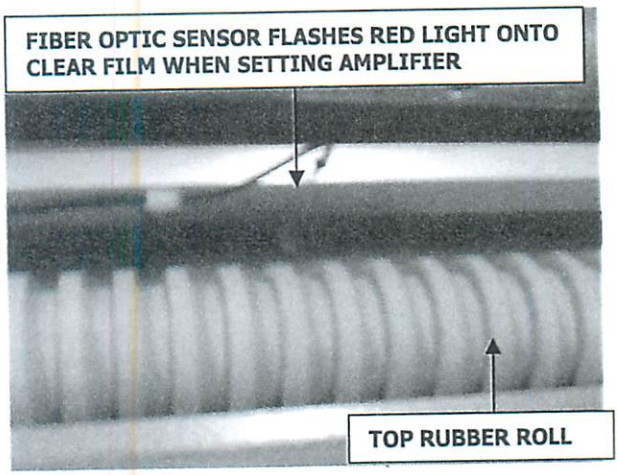
1) PREPARE TO TEST CUTTING MECHANISM BY PLUGGING THE C30 AUTOCUTTER INTO THE APPROPRIATE OUTLET AND TURNING KEY ON. TEST WITH DOORS OFF OR OPEN. ACTIVATE WITH EXTRA DOOR MAGNET (PRS352) ~~AS31~~ SNAPPED ONTO RIGHT AND LEFT HOUSING MAGNETS.

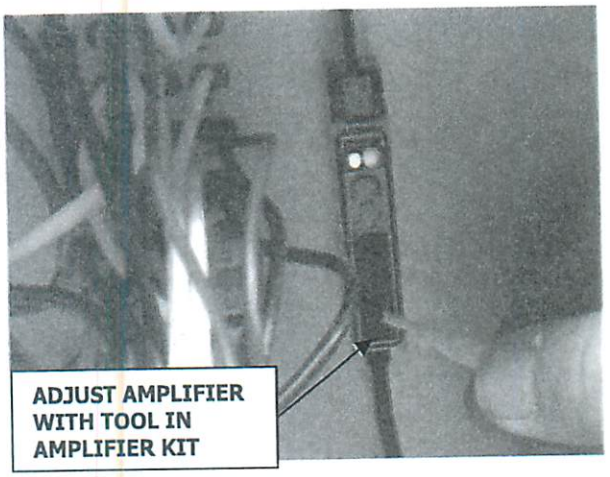
2) WITH SAFETY SHIELD *DOWN* AND TOP RUBBER ROLL "*UP*" THREAD FILM WEB UNDER DANCER BAR AND BETWEEN STRIPPERS. ALIGN ***CLEAR SECTION*** OF TEST FILM BETWEEN RUBBER ROLLS UNDER FIBER OPTIC SENSOR TO MEASURE FILM DENSITY. SECURE TEST FILM BY PUTTING TOP RUBBER ROLL "*DOWN*". TEST WITH (2) 1.7 MIL FILM LAYERS WITH A 1" LAMINATED CLEAR SECTION BETWEEN MATERIAL. THE THICKNESS OF EACH MIL FILM HAS DIFFERENT SENSOR SENSITIVITY.

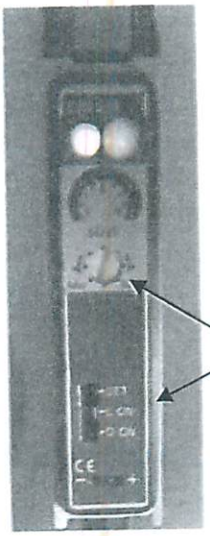
3) REMOVE THE FRONT COVER OF AMPLIFIER BY PULLING TOP SECTION OUTWARD AND DOWN. THE RUBBER GROMMET STAYS ON THE AMPLIFIER. USE TESTING TOOL TO SNAP THE BOTTOM SWITCH UPWARD TO THE "*SET*" POSITION.

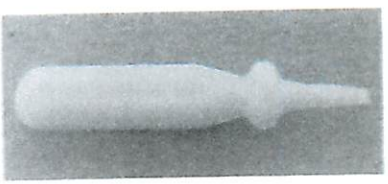
4) TO ADJUST THE C30 FIBER OPTIC SENSOR "EYE" USE THE WHITE PLASTIC TOOL INCLUDED IN THE OMRON AMPLIFIER PACKET, PICTURED WITH AMPLIFIER. A SMALL SCREWDRIVER MAY ALSO BE USED.

5) ROTATE THE SLOTTED ADJUSTMENT SCREW ***COUNTERCLOCKWISE*** UNTIL IT CLICKS. THE RED LIGHT WILL GO OUT. NOW TURN ADJUSTING SCREW SLOWLY ***CLOCKWISE***. THE GREEN LIGHT WILL FLASH AND GO OUT, THEN THE RED



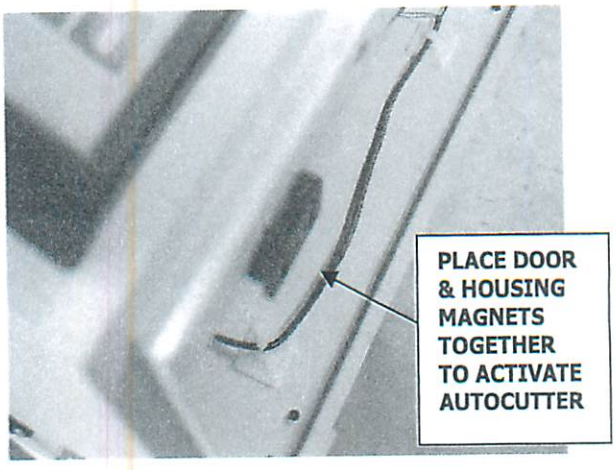






LIGHT WILL COME ON. CONTINUE *CLOCKWISE* TURNING UNTIL GREEN LIGHT COMES ON BRIGHT AND STABLE. AFTER GREEN AND RED LIGHTS ARE BOTH ON FULL BRIGHTNESS, STOP TURNING ADJUSTMENT SCREW, THEN TURN SCREW A FRACTION MORE.

6) RETURN AMPLIFIER SWITCH TO MIDDLE "-L ON" POSITION. THIS IS THE RUN POSITION. AMPLIFIER IS NOW SET FOR THE MIL FILM UNDER FIBER OPTIC SENSOR. REPLACE AMPLIFIER COVER.

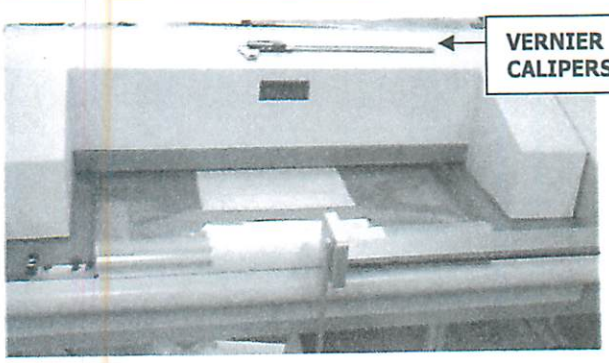


7) UNDERSTAND THE DISPLAY BOARD READING TERMS: FD (FEED MODE) CUTS TO A SPECIFIC LENGTH. THE RG (REGISTRATION MODE) SETS TRIMMING TO SENSED EDGE IE. FRONT (NOSE) AND REAR (TAIL). THE RF (REGISTRATION FEED) TRIMS BEFORE AND AFTER A SENSED EDGE AND CUTS TO A SPECIFIC LENGTH. THE PASSWORD IS "6457" WHEN CALLED FOR.



8) SEQUENCE FOR TEST PREPARATION: A) TURN ON KEY, WAIT FOR BOARD TO INITIALIZE. B) DEPRESS ESCAPE BUTTON ON LOWER LEFT UNTIL ZEROS READ ON DISPLAY BOARD. C) DEPRESS TAIL BUTTON WHICH WILL ASK FOR PASSWORD. D) KEY IN PASSWORD 6457 AND DEPRESS ENTER BUTTON ON LOWER RIGHT.

9) SET BATCH FOR (5) 1" STRIPS BY DEPRESSING BATCH BUTTON AND THEN FOLLOWING DISPLAY BOARD, IE. F2 FOR BATCH NUMBER , F3 FOR MECHANICAL AND F2 FOR RATIO. TEST CUT FOR ACCURACY. LIFT RUBBER ROLL WITH LIFTING LEVER AND ALIGN TEST FILM WITH LEFT SIDE GUIDE, LOWER ROLLS AND TEST CUT. RAISE ROLLS AND ALIGN FILM WITH RIGHT GUIDE. LOWER ROLL AND TEST ANOTHER (5) CUTS TO SEE IF BLADE CUTS ALL THE WAY ACROSS.





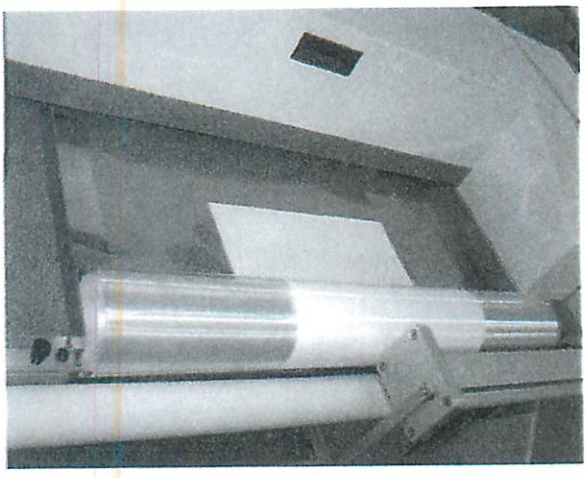
10) DEPRESS "ESCAPE" UNTIL ZEROS READ. DEPRESS RED "STOP" BUTTON. SET LENGTH BY DEPRESSING 6.301 "ENTER."

11) DEPRESS MODE SELECTOR TO READ WINDOW DISPLAY. F1-FD FOR FEED MODE, F2-RG FOR REGISTRATION MODE AND F3-RF FOR REGISTRATION FEED MODE. DEPRESS YOUR SELECTION. CHECK *SPEED* IN UPPER LEFT CORNER BELOW SPEED LEGEND. SPEED IS DISPLAYED FROM 0-150 FEET PER MINUTE OR, IF METRIC MODE 0-45 METERS PER MINUTE. TO CHANGE SPEED WHILE MACHINE IS STOPPED, 1) PRESS THE SPEED BUTTON 2) KEY IN YOUR SPEED ON NUMBER PAD (25) 3) PRESS ENTER BUTTON TO ACCEPT. TO INCREASE SPEED WHILE MACHINE IS RUNNING PRESS SPEED+ BUTTON, SPEED WILL INCREASE WITH EACH CUT, PRESS ENTER BUTTON WHEN ACCEPTABLE SPEED IS REACHED. TO DECREASE SPEED WHILE MACHINE IS RUNNING, PRESS SPEED- BUTTON. PRESS ENTER BUTTON AT ACCEPTABLE SPEED, THEN PRESS SAVE BUTTON.



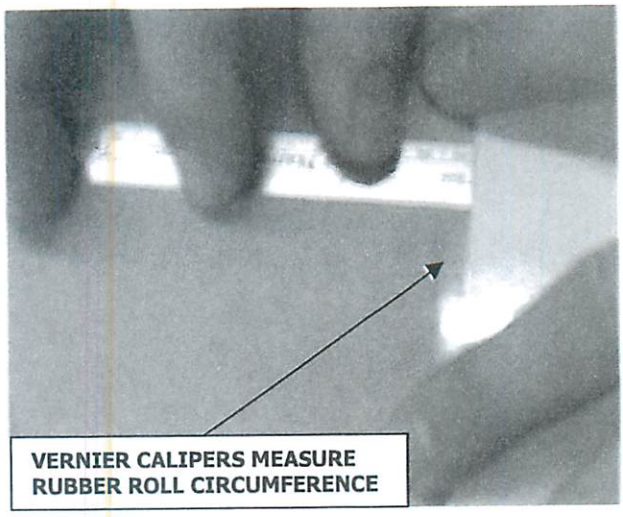
DISPLAY BOARD READING REGISTRATION

12) *LENGTH* IS ONLY DISPLAYED AND SET DURING FD OR RF MODES. LENGTH IS DISPLAYED IN UPPER MIDDLE SCREEN BELOW LENGTH LEGEND. ADJUSTMENTS ARE FROM 0-999 INCHES OR 0-9999 MILLIMETERS. SET RATIO TO CONFORM TO RUBBER ROLL CIRCUMFERENCE. THE RUBBER ROLL CIRCUMFERENCE FOR THE 30" AUTOCUTTER IS 6.287. TO CHANGE LENGTH WHILE MACHINE IS STOPPED 1) PRESS LENGTH BUTTON 2) KEY IN LENGTH ON NUMBER PAD. MEASURE (5) SAMPLES WITH VERNIER CALIPERS. 3) TO INCREASE LENGTH WHILE MACHINE IS RUNNING PRESS LGTH+ BUTTON OR DECREASE BY PRESSING LGTH- BUTTON. PRESS ENTER BUTTON TO ACCEPT AND THEN PRESS SAVE.



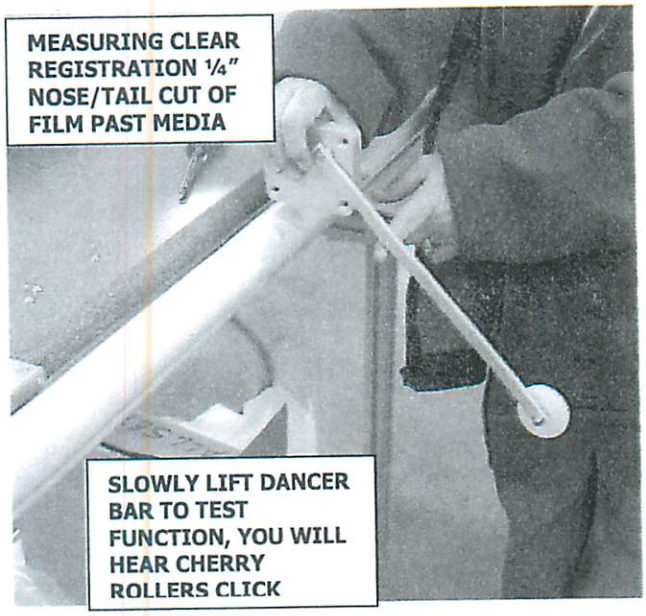
SETTING & MEASURING LENGTHS WITH LAMINATED "TEST" MEDIA ON 1.7 MIL FILM

13) *COUNT* IS DISPLAYED IN UPPER RIGHT CORNER BELOW COUNT LEGEND. COUNT REGISTERS FROM 0-999999. RESET COUNT TO ZERO BY PRESSING COUNT BUTTON, DISPLAY READS F1-ZERO AND F2-ADJUST, PRESS F1 TO RESET TO ZERO. ADJUST THE COUNT BY 1) PRESS THE COUNT BUTTON 2) PRESS F2 3) KEY IN ADJUSTED AMOUNT ON KEY PAD 4) PRESS ENTER BUTTON TO ACCEPT.

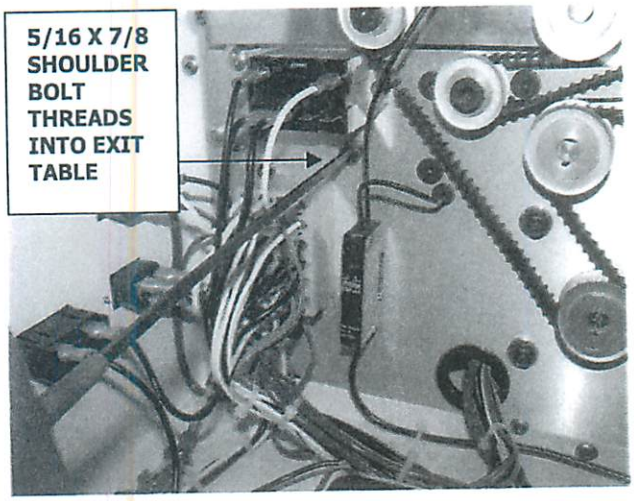


VERNIER CALIPERS MEASURE RUBBER ROLL CIRCUMFERENCE

14) *NOSE* SETTING IS DISPLAYED AND SET DURING RG MODE AND RF MODE. THE DISPLAY IS LOCATED ON LOWER LEFT SCREEN ABOVE NOSE LEGEND. TO CHANGE NOSE SETTING *WHILE MACHINE IS STOPPED* 1) PRESS NOSE BUTTON 2) SCREEN DISPLAYS F1/+/-. WHEN YOU PRESS F1 BUTTON GO TO THE NUMBER PAD AND KEY IN THE REQUIRED DISTANCE. WHEN YOU PRESS THE NOSE+ OR NOSE- BUTTON THE CURRENT SETTING WILL INCREASE OR DECREASE .01 INCHES EVERY KEYSTROKE 3) PRESS ENTER BUTTON TO ACCEPT. TO CHANGE NOSE SETTING WHILE MACHINE IS RUNNING PRESS NOSE BUTTON + OR -.



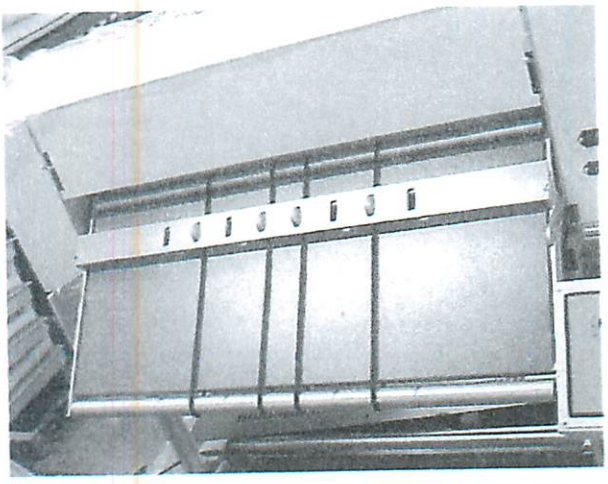
15) THE *TAIL* SETTING IS ONLY DISPLAYED AND SET DURING THE RG MODE. TAIL DISPLAY IS LOCATED ON LOWER RIGHT OF SCREEN ABOVE TAIL LEGEND. TO CHANGE TAIL SETTING WHILE MACHINE IS STOPPED 1) PRESS TAIL BUTTON 2) SCREEN DISPLAYS F1/+/-. WHEN YOU PRESS F1 BUTTON GO TO THE NUMBER PAD AND KEY IN THE REQUIRED DISTANCE. WHEN YOU PRESS TAIL+ OR TAIL- BUTTON THE CURRENT SETTING WILL INCREASE OR DECREASE .01 INCHES PER KEY STROKE. 3) PRESS ENTER BUTTON TO ACCEPT.



16) *BATCH* SETTING IS DISPLAYED ON LOWER RIGHT CORNER OF SCREEN ABOVE BATCH LEGEND. SETTING RANGES FROM 0-99999 AND MAY BE USED IN CONJUNCTION WITH ALL OTHER MODES. BATCH MODE MAY BE SET TO STOP OR PAUSE. TO CHANGE THE BATCH SETTING 1) PRESS BATCH BUTTON 2) DISPLAY READS F1-ON, F2-OFF OR F3-CANCEL. PRESS F1 TO CONTINUE. SCREEN WILL DISPLAY "ENTER BATCH" AND CURRENT BATCH AMOUNT IN LOWER LEFT CORNER. 3) PRESS ENTER BUTTON TO ACCEPT CURRENT BATCH AMOUNT OR INSERT NUMBER DESIRED ON KEYPAD AND PRESS ENTER BUTTON. SCREEN WILL DISPLAY BATCH WITH DWELL? F1-DWELL AND F2-STOP. CHECK BATCH FUNCTION AND ADJUST, THEN SAVE.



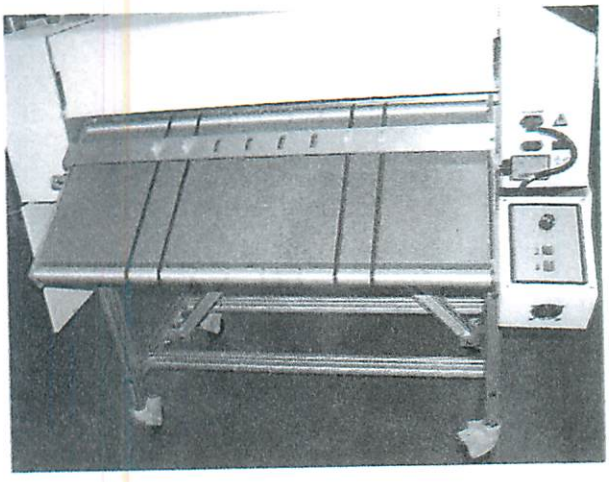
17) TEST DANCER BAR FUNCTION BY SLOWLY RAISING AND LOWERING DANCER BAR. AT ABOUT 45 DEGREES THE C30 SHOULD STOP CUTTING AND SHOULD RESUME CUTTING WHEN DANCER BAR IS LOWERED.



18) TEST (2) E-STOP SWITCHES AND DOOR MAGNETS, ONE AT A TIME. EACH TIME THE CUTTER STOPS, YOU WILL HAVE TO RESTART WITH GREEN BUTTON.

19) ATTACH EXIT TABLE. THIS IS EASIER WITH TWO PEOPLE. ONE CAN HOLD AND ALIGN THE FEED TABLE WHILE THE OTHER INSERTS A 5/16 X 7/8 SHOULDER BOLT THROUGH EACH SIDE PANEL, THREADED INTO THE EXIT TABLE SIDE BARS. PLACE (4) EXIT TABLE ROLLERS, ONE EACH IN THE EXIT TABLE ROLLER GUIDE OPENINGS ABOVE AN O-RING. PLUG THE EXIT TABLE INTO THE POWER OUTLET ON THE AUTOCUTTER. PLUG THE AUTOCUTTER INTO THE PROPER OUTLET. TURN ON KEY AND DEPRESS GREEN START BUTTON. ENGAGE THE EXIT TABLE BY DEPRESSING GREEN EXIT TABLE BUTTON. TEST FUNCTION OF ROLLER GUIDES. IF THEY ARE TOO THICK, THE O-RINGS WILL NOT RUN SMOOTHLY. TURN OFF AND UNPLUG BOTH POWER CORDS. CLOSE DOORS AND CLEAN MACHINE.

EXIT TABLE INSTALLED ON AUTOCUTTER WITH (4) ROLLERS OVER O-RINGS



20) ON REAR OF LEFT HOUSING ADHERE THE 110-120VAC 15AMP LABEL (LAB120) ~~CP01~~ CENTERED ABOVE THE POWER OUTLET. THIS WILL POWER THE EXIT TABLE.

A509



21) BELOW THE RECEPTACLE CENTER AND ADHERE THE 30" 110V AUTOCUTTER SERIAL # DECAL (LAB117) WHICH IS CLIPPED TO THE WORK JOB. ~~TO THE RIGHT OF THE SERIAL # DECAL ADHERE THE WHITE ETL COMPLIANCE LABEL WHICH ALSO~~ IS WITH WORK JOB.

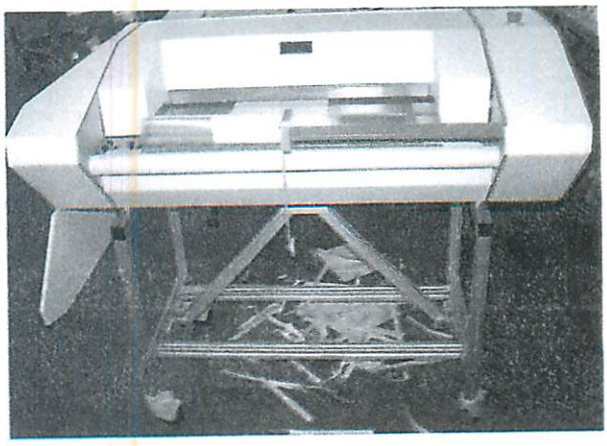
22) RIGHT OF THE POWER OUTLET, ADHERE THE YELLOW GENERAL DANGER LABEL (LAB52) ~~CP03~~.

A509

23) ABOVE THE 3AMP FUSE HOLDER CENTER AND ADHERE THE FA 350V 3AMP LABEL (LAB122) CP01.

24) ADHERE ANOTHER YELLOW GENERAL DANGER LABEL (LAB53) CP03 CENTERED UNDER THE PULL HANDLE ON THE FRONT OF THE SAFETY SHIELD.

25) UNDER THE GENERAL DANGER LABEL CENTER A *LARGE* YELLOW CUTTING OF FINGERS AND HAND/STRAIGHT BLADE LABEL (LAB54) CP04.



26) LIFT UP THE SAFETY SHIELD AND PLACE (2) *SMALL* YELLOW CUTTING OF FINGERS AND HAND/STRAIGHT BLADE LABELS (LAB53) CP04. FROM THE OUTER RIBS OF THE TOP RUBBER ROLL COUNT INWARD 8 RIBS AND ALIGN LABEL ABOVE ON BLADE HOLDER.



27) ON FEED TABLE PLACE (4) CASTERS (PRC210) AS31 EACH WITH A ½ X 13 FIN JAM NUT, A REMOVEABLE CORD (PRC118) LD08 AND EXIT TABLE CORD. BAG (4) EXIT TABLE ROLLERS, (2) 3 POINT KNOBS AND (2) ¼ X 5/8 X 1/8 FLAT WASHERS. ROTATE DANCER BAR UPWARD TO REST ON FEED TABLE, PROTECTING IT FROM DAMAGE. FILL OUT PAPERWORK.

SMALL "CUT" LABEL ADHERED TO TOP BLADE HOLDER, 8 RUBBER ROLL RIBS INWARD ON BOTH SIDES



On "Final Tech ..." in "OPTIONS" write "Ratio: 1.0000 to whatever cutting ratio you ended with, ie. 6.2925

NRTL C30 CUTTER 110V & 220V HIGH POT TESTING

1) TO COMPLY WITH 2/2009 U.S. ETL AND OUTSIDE CERTIFICATION THE 110V C30 AND THE 220V C30 MUST PASS A HIGH POT TEST FOR POWER LEAKAGE AND GROUNDING. THE PROCEDURES FOR THE HIGH POT TEST ARE AS FOLLOWS.

2) WITH HIGH POT TESTER POWER SWITCH IN "OFF" POSITION CONNECT <u>TESTER POWER/GROUND CORD</u> BETWEEN THE "INPUT" INLET ON TESTER AND A 110 VOLT POWER SOURCE. THE WHITE "TESTER GROUND" LAMP GLOWS AMBER IF GROUND IS SATISFACTORY. THIS INDICATES THE <u>TESTER</u> IS GROUNDED.

3) ***CLEAR THE AREA!! DO NOT TOUCH THE MACHINE OR THE CORD WHILE HIGH POT TESTING, AS SEVERE SHOCK MAY OCCUR IF MACHINE FAILS TEST.***

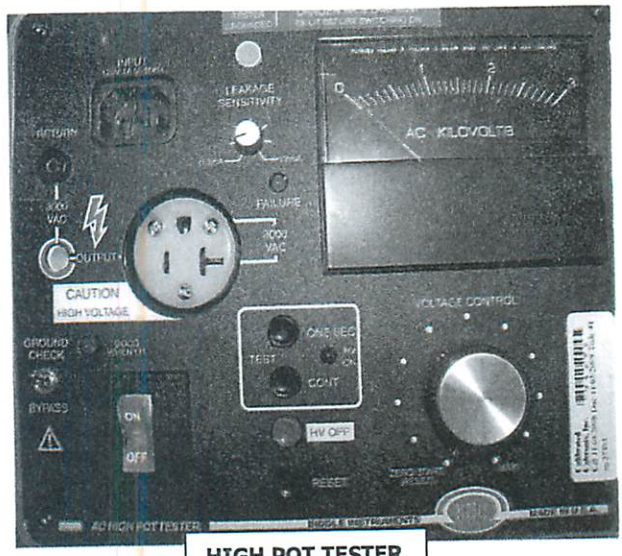
4) WITH "GROUND CHECK" SWITCH *UPWARD*, PLUG THE TESTER <u>MACHINE GROUND CORD</u> BETWEEN THE "RETURN" INLET ON TESTER AND THE SHAFT LOCATED BETWEEN THE FEED TABLE AND THE FRONT IDLER TUBE. CLAMP THE TOOTHED END OF THE <u>MACHINE GROUND CORD</u> ONTO THE SHAFT. THE SHAFT IS HELD BY SCREWS INTO THE SIDE PANEL AND THAT GENERALLY CONDUCTS A GOOD GROUND.

5) PLUG THE <u>C30 POWER CORD</u> BETWEEN THE C30 RECEPTACLE AND "OUTPUT" INLET ON THE HIGH POT.

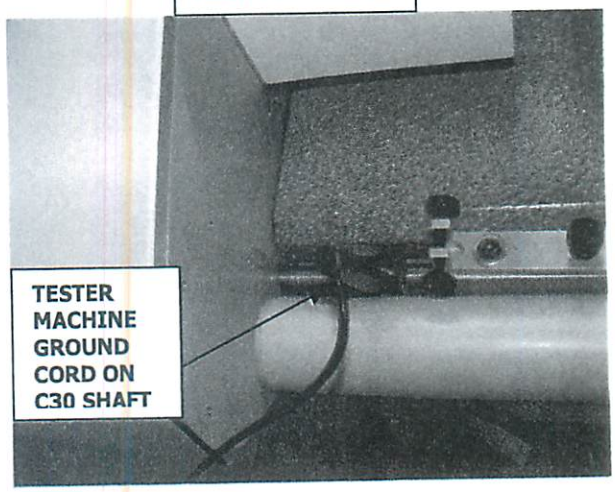
6) PRESS HIGH POT ROCKER SWITCH TO "ON" POSITION. THE GREEN "GOOD WHEN LIT" LIGHT GLOWS WHEN MACHINE IS GROUNDED.

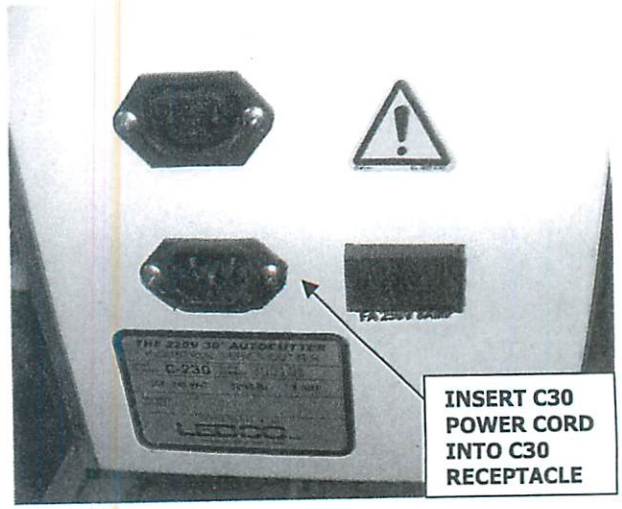
7) WITH "ZERO/START" ON "VOLTAGE CONTROL" DIAL, PRESS THE BLACK "RESET" BUTTON.

8) PRESS THE BLACK "CONT" BUTTON. THE



HIGH POT TESTER


TESTER MACHINE GROUND CORD ON C30 SHAFT



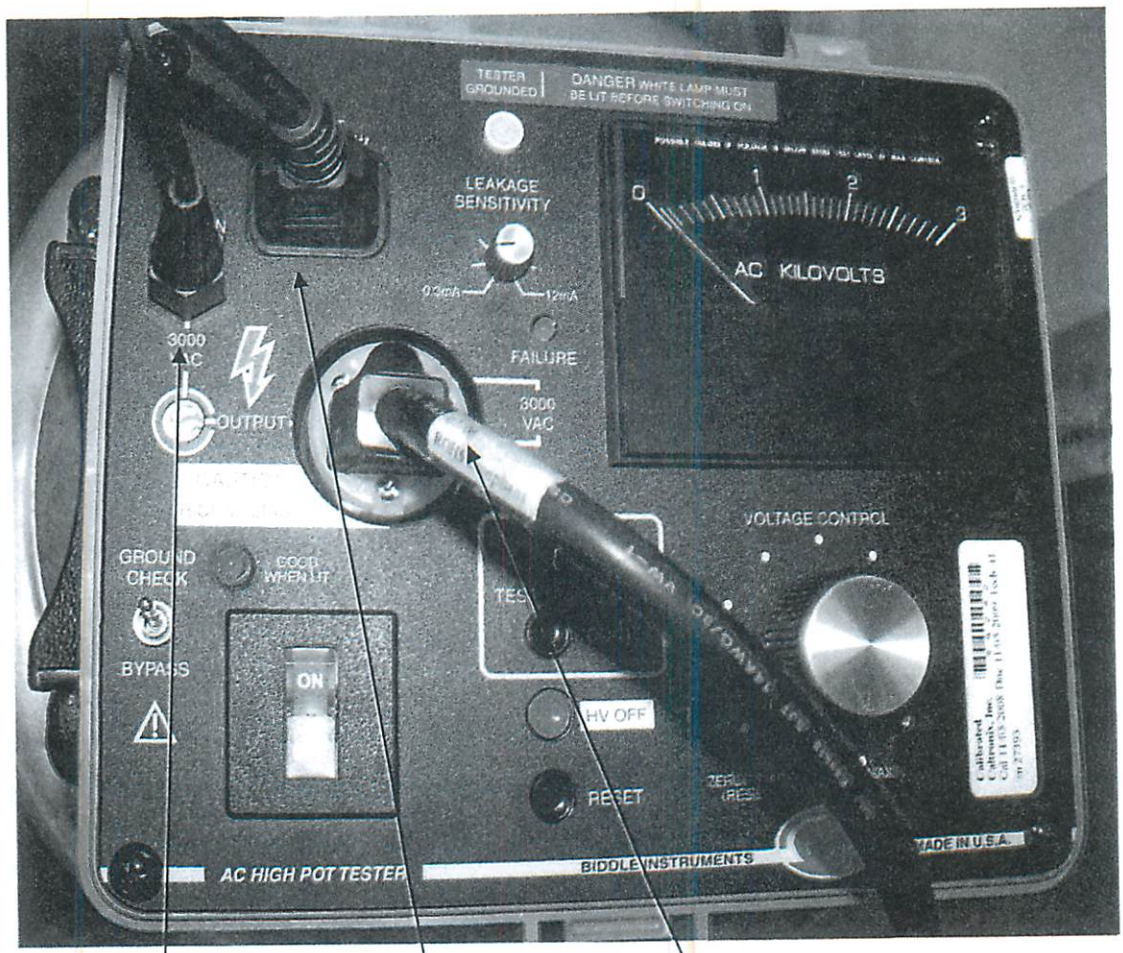
INSERT C30 POWER CORD INTO C30 RECEPTACLE

RED "HV" LIGHT COME ON.

9) WITH "VOLTAGE CONTROL" STILL AT ZERO/START, INCREASE AC KILOVOLT DIAL CLOCKWISE TO 1.6 AC KILOVOLTS ON THE REGISTER SCREEN. <u>MAINTAIN 1.6 AC KILOVOLTS FOR TWO SECONDS</u>. A *HIGH POT TEST FAILURE* REGISTERS WITH AN AMBER "FAILURE" LIGHT AND A "BEEP."

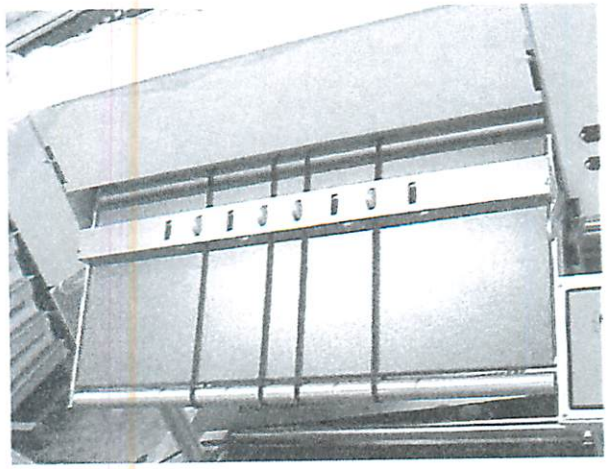
10) TO END THE HIGH POT TEST, RETURN THE "VOLTAGE CONTROL" DIAL TO "ZERO/START," PRESS THE "HV OFF" BUTTON, "HV ON" LIGHT GOES OUT.

11) TURN "OFF" THE HIGH POT TESTER ROCKER SWITCH, <u>UNPLUG "INPUT" POWER CORD FIRST</u>, THEN THE UNPLUG REMAINING CORDS.



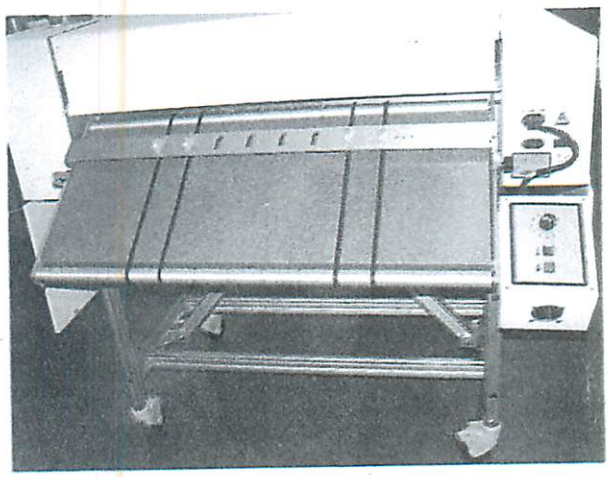
C30 GROUND, TESTER POWER/GROUND, C30 POWER CORD

ABOVE BATCH LEGEND. SETTING RANGES FROM 0-99999 AND MAY BE USED IN CONJUNCTION WITH ALL OTHER MODES. BATCH MODE MAY BE SET TO STOP OR PAUSE. TO CHANGE THE BATCH SETTING 1) PRESS BATCH BUTTON 2) DISPLAY READS F1-ON, F2-OFF OR F3-CANCEL. PRESS F1 TO CONTINUE. SCREEN WILL DISPLAY "ENTER BATCH" AND CURRENT BATCH AMOUNT IN LOWER LEFT CORNER. 3) PRESS ENTER BUTTON TO ACCEPT CURRENT BATCH AMOUNT OR INSERT NUMBER DESIRED ON KEYPAD AND PRESS ENTER BUTTON. SCREEN WILL DISPLAY BATCH WITH DWELL? F1-DWELL AND F2-STOP. CHECK BATCH FUNCTION AND ADJUST, THEN SAVE.



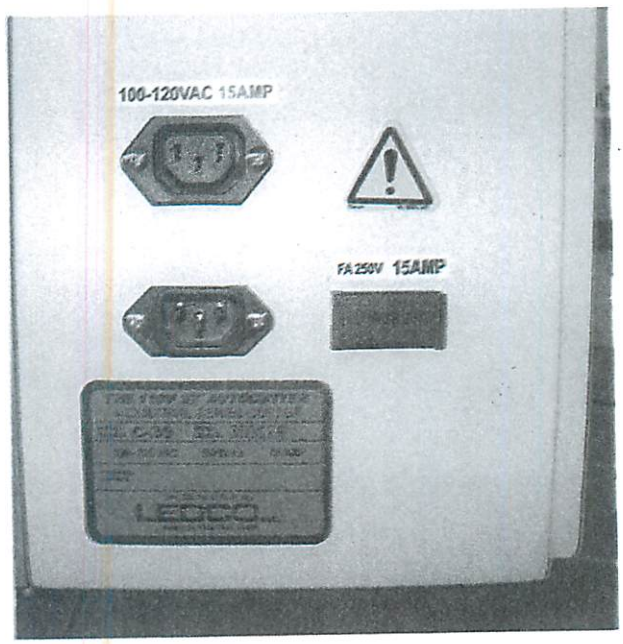
EXIT TABLE ROLLERS OVER O-RINGS

19) TEST FUNCTION OF ROLLER GUIDES. IF THEY ARE TOO THICK, THE O-RINGS WILL NOT RUN SMOOTHLY. CONTROL SPEED WITH POTENTIOMETER. TURN OFF AND UNPLUG BOTH POWER CORDS. CLOSE DOORS AND CLEAN MACHINE.



20) ON REAR OF LEFT HOUSING ADHERE THE 110-120VAC 15AMP LABEL (LAB120) AS09 CENTERED ABOVE THE POWER OUTLET. THIS WILL POWER THE EXIT TABLE.

21) BELOW THE POWER RECEPTACLE CENTER ADHERE THE 30" 110V AUTOCUTTER SERIAL # DECAL (LAB117) WHICH IS CLIPPED TO THE WORK JOB.



22) RIGHT OF THE POWER OUTLET, ADHERE THE YELLOW GENERAL DANGER LABEL (LAB52) AS09.

23) ABOVE THE 15 AMP FUSE HOLDER MAKE A LABEL BY CUTTING AND ADDING A FA 250V AND A 15 AMP LABEL FROM AS09.

24) ADHERE ANOTHER YELLOW GENERAL DANGER LABEL (LAB52) AS09 CENTERED UNDER THE PULL HANDLE ON THE FRONT OF THE SAFETY SHIELD.

25) UNDER THE GENERAL DANGER LABEL ON THE FRONT SAFETY SHIELD CENTER A *LARGE* YELLOW CUTTING OF FINGERS

AND HAND/STRAIGHT BLADE LABEL (LAB53) AS09.

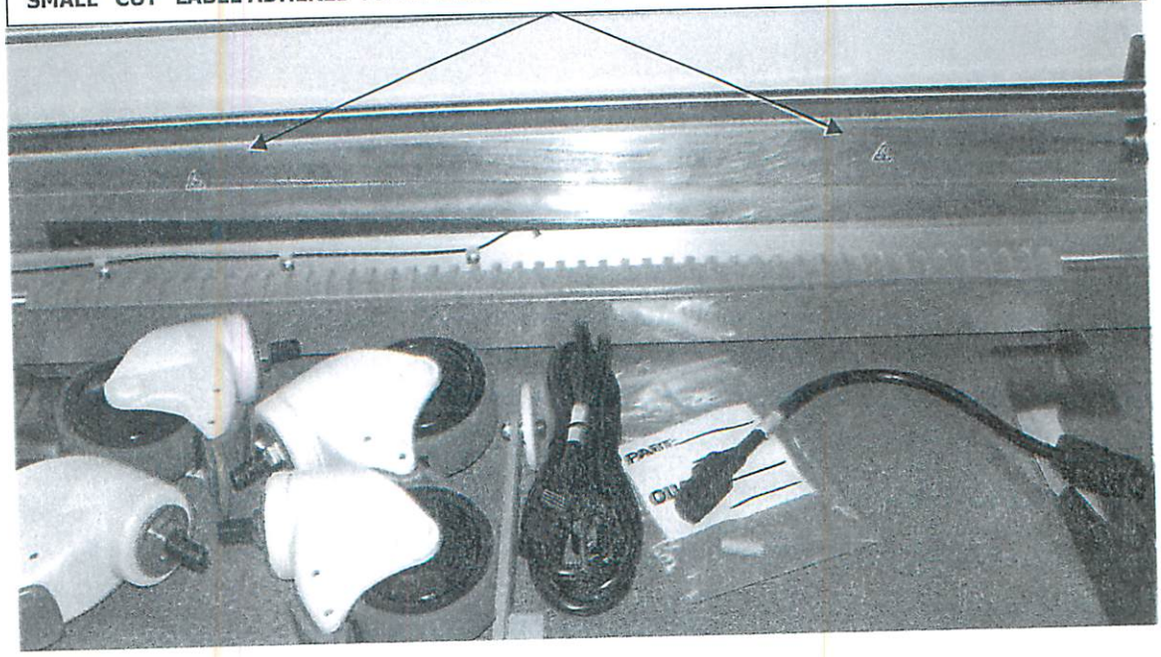


26) LIFT UP THE SAFETY SHIELD AND PLACE (2) *SMALL* YELLOW CUTTING OF FINGERS AND HAND/STRAIGHT BLADE LABELS (LAB54) AS09. FROM THE OUTER RIBS OF THE TOP RUBBER ROLL COUNT INWARD 8 RIBS AND ALIGN LABEL ABOVE ON BLADE HOLDER.

27) ON FEED TABLE PLACE (4) CASTERS (PRC210) AS14 EACH WITH A ½ X 13 HEX NUT, A REMOVEABLE CORD (PRC118) LD05 AND THE EXIT TABLE CORD. BAG THE (4) EXIT TABLE ROLLERS, (2) 3 POINT KNOBS AND (2) ¼ X 5/8 X 1/8 FLAT WASHERS. ROTATE DANCER BAR UPWARD TO REST ON FEED TABLE, PROTECTING IT FROM DAMAGE.

28) FILL OUT PAPERWORK. ADD IN OPTIONS SECTION OF FINAL TEST, "RATIO: 1.0000 TO WHATEVER CUTTING RATIO YOU ENDED WITH, IE. 6.2925."

SMALL "CUT" LABEL ADHERED TO TOP BLADE HOLDER, 8 RUBBER ROLL RIBS INWARD ON BOTH SIDES

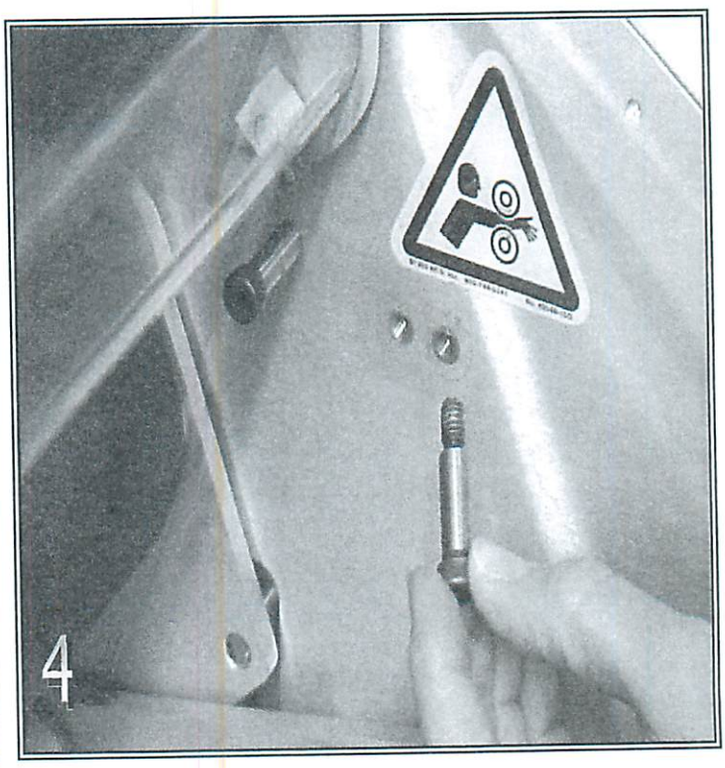


Procedure for replacing auto-feeder coupling stud with standard precision feed tray mounting shoulder bolt



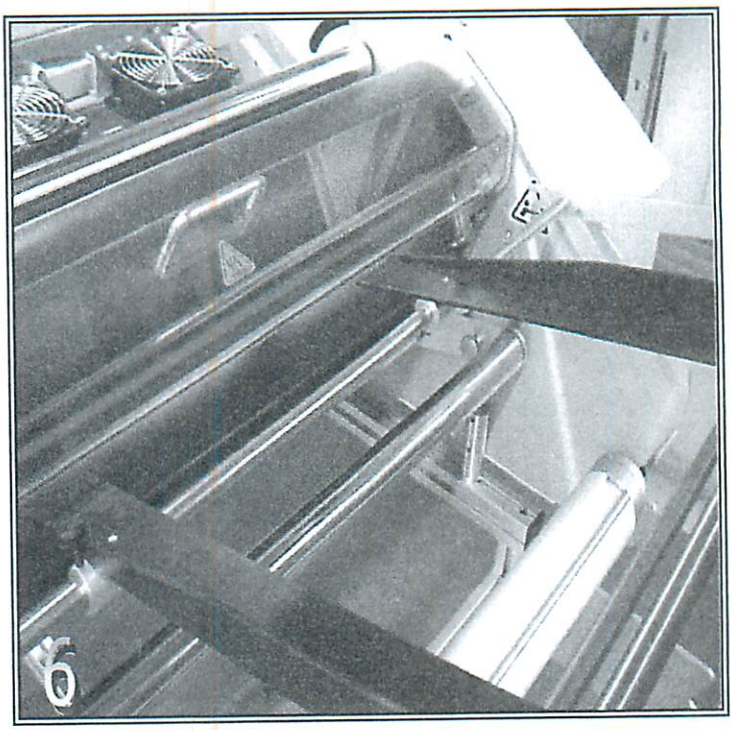






Procedure for replacing auto-feeder coupling stud with standard precision feed tray mounting shoulder bolt (cont.)









Ledco Corporation

Single Level Current Bill of Material

4.00.02 live

onents	Description	T	Quantity Per U/M U	Unit Cost / Extended Cost	Effectivity Dates From	To
				0.00000		
B	110V CUTTER w/TOUCHSCREEN			0.00000		
	#10 X 3/4 PH PHIL SMS	M	12.00000 EA U			
I12	10-32 ACORN NUT	M	1.00000 EA U			
E00	10-32 KEPS NUT	M	1.00000 EA U			
L00	10-32 X 1 1/2 SHCS	M	1.00000 EA U			
B24	1/4 X 3/8 SHOULDER BOLT	M	1.00000 EA U			
C06	1/4" FLAT WASHER, SAE 1NU48	M	2.00000 EA U			
KC01	1/4 ZINC WILLIAMS WASHER	M	1.00000 EA U			
LD02	1/4-20 HEX NUT 1WB19	M	2.00000 EA U			
DF00	1/4-20 X 3/4 BH SOCKET M/S	M	1.00000 EA U			
AA12	1/4-20 X 5/8 SHCS	M	1.00000 EA U			
PAA10	1/4-20 X 1-1/2 HEX BOLT 1XU86	M	8.00000 EA U			
PDA24	5/16-18 X 1 CARRIAGE BOLT 1VB94	M	8.00000 EA U			
G0A16	5/16 FLAT WASHER, SAE	M	8.00000 EA U			
KKC01	5/16-18 ACORN NUT	M	4.00000 EA U			
LDE00	5/16-24 X 1 BHCS	M	14.00000 EA U			
OAB16	5/16-18 X 2 SHCS	M	4.00000 EA U			
PAA32	3/8-24 X 1 SHCS	M	1.00000 EA U			
5PAB16	3/8 X 1 1/4 SOCKET SHOULDER SCREW	M	4.00000 EA U			
5IAC20	1/2-13 X 2-1/2 HEX BOLT Gr5 1xu48	M	8.00000 EA U			
0HDA40	1/2" FLAT WASHER, SAE 2DNX6			0.00000		
0KKC01		M	4.00000 EA U			
Revision: .190lol0	1/2-13 HEX NUT 1WB36	M	2.00000 EA U			
00LDF00	RUBBER ROLL 30" CUTTER	M	3.00000 EA U			
30 040.4	TOP RUBBER ROLL SPACER	M	1.00000 EA U			
25 045.4	TOP RUBBER ROLL PULLEY SPACER	M	1.00000 EA U			
30 046.4	BOTTOM RUBBER ROLL PULLEY SPACER	M	1.00000 EA U			
30 047.4	DRIVE IDLER MOUNTING BAR	M	1.00000 EA U			
30 055.4	RUBBER ROLL PIVOT ARM LEFT	M	1.00000 EA U			
C25 056.4L	RUBBER ROLL PIVOT ARM RIGHT	M	2.00000 EA U			
C25 056.4R	TOP CUT OFF PIVOT ARM DWG #C25 057.4-A	M	2.00000 EA U			
C25 057.4						
Revision: A	PIVOT ARM BLOCK USE DRWG #C25 058.4-A	M	1.00000 EA U			
C25 058.4						
Revision: A	SAFETY SHIELD	M	1.00000 EA U			
C30 074.4	LEFT SIDE PANEL WITH TOUCHSCREEN	M	1.00000 EA U			
C30 090.4LC	RIGHT SIDE PANEL	M	1.00000 EA U			
C30 090.4RC	BOTTOM HOUSING W/NRTL WIRING	M	1.00000 EA U			
C30 093.4A	BOTTOM HOUSING BACK DOOR	M	1.00000 EA U			
C30 093.4B	LEFT SIDE HOUSING W/TOUCHSCREEN	M	1.00000 EA U			
C30 094.4LB	RIGHT HOUSING W/TOUCHSCREEN, NRTL	M	1.00000 EA U			
C30 094.4RA	LEFT HOUSING DOOR W/NRTL WIRING	M	1.00000 EA U			
C30 095.4L	RIGHT HOUSING DOOR W/NRTL WIRING	M	1.00000 EA U			
C30 095.4R	BOTTOM STRIPPER	M	1.00000 EA U			
C30 096.4B	TOP STRIPPER USE DRWG #C30096.4T-A					07/02/07
C30 096.4T		M	1.00000 EA U			
Revision: A	TOP STRIPPER FINGER	M	2.00000 EA U			
C30 096.4TF	ADJUSTABLE FEED GUIDE BOTTOM BAR					
C30 097.4BB						

Ledco Corporation

ine 4.00.02 live

Single Level Current Bill of Material

5-R

Components	Description	T	Quantity Per U/M U	Unit Cost / Extended Cost	Effectivity Dates From	To
				0.00000		
110-B	110V CUTTER w/TOUCHSCREEN					
097.4CS	ADJUSTABLE FEED GUIDE CENTER SUPPORT	M	2.00000 EA U			
097.4L	ADJUSTABLE FEED GUIDE LEFT	M	1.00000 EA U			
097.4LTB	ADJUSTABLE FEED GUIDE TOP BAR LEFT	M	1.00000 EA U			
097.4R	ADJUSTABLE FEED GUIDE RIGHT	M	1.00000 EA U			
097.4RTB	ADJUSTABLE FEED GUIDE TOP BAR RIGHT	M	1.00000 EA U			
105.4	STATIONARY HINGE BLOCK	M	4.00000 EA U			
106.4	ROTATING HINGE BLOCK	M	4.00000 EA U			
110.4	BOTTOM CUT OFF BLADE MOUNTING BAR	M	1.00000 EA U			
Revision: C						
111.4	SPREADER BAR	M	3.00000 EA U			
112.4	FRONT IDLER TUBE	M	1.00000 EA U			
113.4	FRONT IDLER BEARING	M	2.00000 EA U			
115.4	TOP CUT OFF MOUNTING BAR #C30 115.4-C	M	1.00000 EA U			
Revision: C						
116.4	TP CUT OFF MNTNG PIVOT USE C25 116.4-A	M	2.00000 EA U			
Revision: A						
120.4	PRESSURE ROLL GUIDE	M	2.00000 EA U			
121.4	PRESSURE ROLL GUIDE BEARING	M	2.00000 EA U			
122.4	PRESSURE ROLLUSE DRW #C30 122.4 REV.A	M	1.00000 EA U			
Revision: A						
123.4	PRESSURE ROLL PRESSURE ADJUSTER	M	2.00000 EA U			
132.4	RUBBER ROLL LIFTING LEVER	M	2.00000 EA U			
133.4	CAM	M	2.00000 EA U			
134.4	RUBBER ROLL CAM SHAFT USE #C30 134.4-A	M	1.00000 EA U			
Revision: A						
135.4-B	C-30 MACHINE STAND W/BRACING	M	1.00000 EA U			
Revision: B						
201.4	POSITION SENSOR MOUNTING BAR	M	1.00000 EA U			
202.4	POSITION DISC	M	1.00000 EA U			
203.4	CAM SHAFT SUPPORT PLATE STANDOFF	M	4.00000 EA U			
204.4A	CAM SHAFT SUPPORT PLATE	M	1.00000 EA U			
213.4	PRESSURE BLOCK	M	2.00000 EA U			
216.4	TOP CUT OFF SPACER	M	2.00000 EA U			
Revision: A						
217.4	PRESSURE PLUNGER	M	2.00000 EA U			
218.4	PRESSURE ADJUSTMENT PLUNGER	M	2.00000 EA U			
250.4	GUILLOTINE CAM	M	2.00000 EA U			
251.4	GUILLOTINE CONNECTING BLOCK	M	2.00000 EA U			
252.4	CUT OFF CAM SHAFT SPACER	M	1.00000 EA U			
253.4A	CUT OFF CAM SHAFT (new style)	M	1.00000 EA U			
270.4	TOP SENSOR HOLDER	M	1.00000 EA U			
293.4	DANCER POTENTIOMETER MOUNTING BRACKET	M	1.00000 EA U			
294.4	DANCER MOUNTING SHAFT	M	1.00000 EA U			
295.4	DANCER STOP PLATE	M	1.00000 EA U			
288.4	DANCER MOUNTING BAR	M	1.00000 EA U			
Revision: A						
289.4A	DANCER BAR FOR TOUCHSCREEN CUTTER CURVED	M	1.00000 EA U			

Ledco Corporation

Single Level Current Bill of Material

.ine 4.00.02 live

.5-R

/Components	Description	T	Quantity Per	U/M	U	Unit Cost / Extended Cost	Effectivity Dates From	To
						0.00000		
110-B	110V CUTTER w/TOUCHSCREEN							
) 292.4	DANCER ROLLER	M	1.00000	EA	U			
0 300.4A	EXIT TABLE CONTROL BOX W/NRTL WIRING	M	1.00000	EA	U			
0 301.4A	EXIT TABLE CONTROL PANEL W/NRTL WIRING	M	1.00000	EA	U			
0 302.4	EXIT TABLE	M	1.00000	EA	U			
0 303.4D	EXIT TABLE DRIVE ROLLER	M	1.00000	EA	U			
.0 303.4I	EXIT TABLE IDLER ROLLER	M	2.00000	EA	U			
30 305.4	EXIT TABLE BRACE BAR	M	2.00000	EA	U			
30 306.4	EXIT TABLE SUPPORT BAR	M	1.00000	EA	U			
30 307.4	EXIT TABLE RIGHT SIDE BAR	M	1.00000	EA	U			
30 308.4	EXIT TABLE LEFT SIDE BAR	M	1.00000	EA	U			
30 309.4	EXIT TABLE ROLLER GUIDE	M	2.00000	EA	U			
30 310.4	EXIT TABLE ROLLER GUIDE MOUNTING BLOCK	M	4.00000	EA	U			
30 311.4	EXIT TABLE ROLLER	M	2.00000	EA	U			
Revision: A								
230 400.4	CUT OFF BLADE USE DRAWING C30 400.4-A	M	2.00000	EA	U			
H850 178.4	1/8 SQ X 1/4 LG STRAIGHT KEY	M	4.00000	EA	U			
I30 097.4	DOOR LATCH BRACKET	M	1.00000	EA	U			
LAB06	INTERNATIONAL GROUND SYMBOL LABEL	M	1.00000	EA	U			
LAB107A	LISTED AUTOCUTTER CONTROL DECAL	M	1.00000	EA	U			
LAB108A	LISTED AUTOCUTTER EXIT TABLE DECAL	M	2.00000	EA	U			
LAB52	GENERAL DANGER LABEL #IS6014-PC	M	1.00000	EA	U			
LAB53	CUTTING OF FINGERS OR HAND/STRAIGHT BLD	M	2.00000	EA	U			
LAB54	CUTTING OF FINGERS OR HAND/STRAIGHT BLD	M	1.00000	EA	U			
LAB117	30" 110V AUTOCUTTER SERIAL # DECAL	M	1.00000	EA	U			
LAB120	100-120VAC 15AMP LABEL NRTL LISTED	M	1.00000	EA	U			
PRB251	#322L050 KEVLAR TIMING BELT	M	1.00000	EA	U			
LAB121	100-120VAC 1.5AMP LABEL NRTL LISTED	M	1.00000	EA	U			
LAB122	FA 250V 3AMP LABEL NRTL LISTED	M	1.00000	EA	U			
LAB124	FA 250V 1.5AMP LABEL NRTL LISTED	M	4.00000	EA	U			
LC38 048.4	FEET MOUNTING SHAFT EXTENSION	M	4.00000	EA	U			
PML002	1/4 TURN LATCH SET (HOUSING COVER)	M	3.00000	EA	U			
PRB038	BRG BALL 8ZZ	M	3.00000	EA	U			
PRB040A	.377 ID x .503 OD x .609 L PRB040 WORKED	M	2.00000	EA	U			
PRB046	BRG FB683,3/8 X 1/2 X 3/8	M	2.00000	EA	U			
PRB059	BRG NYLINER 8L2FF	M	1.00000	EA	U			
PRC0306	#PDB241-E420P-103B0 BOURNS LIN POT 10K	M	1.00000	EA	U			
PRC0307	#JWS15024/A POWER SUPPLY 24VDC	M	1.00000	EA	U			
PRC0308	CUI/FSC-S15-5U POWER SUPPLY 5VDC	M	1.00000	EA	U			
PRC0309	PARKER SERVO MOTOR CMP0923D1E-200438	M	1.00000	EA	U			
PRC0310	COPLEY SERVO DRIVE 091-0006A XLT-230-36	M	1.00000	EA	U			
PRC0312	COPLEY FDBCK CBLE 091-0008A 4ft long	M	1.00000	EA	U			
PRC0313	PARKER P-1A1-04 4ft Servo Motor Cable	M	1.00000	EA	U			
PRC2000	DELTA TAU PC104 CONTROLLER	M	1.00000	EA	U			
PRC2005	CTC PA-05 PARKER 5" TOUCHSCREEN	M	1.00000	EA	U			
PRC2008	DT09 COMM CABLE	M	1.00000	EA	U			
PRC0323	85-264Vac in, 24Vdc 1.46A out, Power Sup	M	1.00000	EA	U			
PRF133	AXIAL FAN FOR EDUCATOR 120V	M	1.00000	EA	U			

Item/Components	Description	T	Quantity Per U/M U	Unit Cost / Extended Cost	Effectivity Dates From	To
300110-B	110V CUTTER w/TOUCHSCREEN			0.00000		
PRB062	SNAP BSHG SM .562HOLE//.375ID	M	1.00000 EA U			
PRB075	R6-ZZ ROLLER BEARING	M	12.00000 EA U			
PRB260	SNAP BSHG, HEYCO #2415	M	2.00000 EA U			
PRB101	#NBA-6-A ALINABL; SPHERICAL BEARING	M	2.00000 EA U			
PRB105	#Z-695 INSULATION GROMMET	M	2.00000 EA U			
PRF137	LITTELFUSE SLO-BLO 8 AMP #313 008	M	2.00000 EA U			
PRF142	SCHAFFNER FN670-10/06 POWER FILTER	M	1.00000 EA U			
PRB106	BALL BEARING,	M	2.00000 EA U			
PRB108	D300XL037 GOODYEAR DUAL POS DRIVE BELT	M	1.00000 EA U			
PRB111A	.377 ID x .503 OD x .484 L PRB111 WORKE	M	4.00000 EA U			
PRB202	3L3F- NYLINER BEARING 3/16" ID	M	4.00000 EA U			
PRB250	#A6B 3-083037 URETHANE KEVLAR TMG BELT	M	1.00000 EA U			
PRC117	CORD RECEPTACLE, PANEL MOUNT	M	2.00000 EA U			
PRC211	3/8"BORE SPLIT SHAFT COLLAR, 1L658	M	2.00000 EA U			
PRC118	REMOVEABLE CORD #504 (EDUCATOR & P4)	M	2.00000 EA U			
PRK167	1/4-20 SPI KNOB,	M	1.00000 EA U			
PRC250	EXTRUDED STAND END CAP 36414	M	4.00000 EA U			
PRC270	#E-50 ROTOR CLIP E RING	M	5.00000 EA U			
PRC271	#CCS12-S8-C CABLE CLAMP	M	8.00000 EA U			
PRM2108	IMS #MDM1FSD34C7 MOTOR/DRIVE WORKED	M	1.00000 EA U			
PRR098	#SH-31 EXTERNAL RETAINING RING	M	1.00000 EA U			
PRC273	#SH-196-STPA ROTOR CLIP SH RING	M	2.00000 EA U			
PRC274	#HO-315-STPA-S ROTOR CLIP HO RING	M	2.00000 EA U			
PRC275	#HO-87-STPA-S ROTOR CLIP HO RING	M	14.00000 EA U			
PRC276	#E3XNA11 PHOTOELECTRIC SWITCH	M	1.00000 EA U			
PRC277	#E32-TC200 OMRON FIBER OPTIC CABLES 2 PC	M	1.00000 EA U			
PRF120	FAN GUARD, SMALL 4YD87	M	1.00000 EA U			
PRF124	FUSE 314008 LITTELFUSE 8A	M	4.00000 EA U			
PRF126	FUSE HOLDER LITTELFUSE 354901GY	M	2.00000 EA U			
PRF128	LITTELFUSE 31201.5 1-1/2A	M	2.00000 EA U			
PRF143	115VAC MINI FAN	M	1.00000 EA U			
PRF144	WIRE FAN GRILL FOR PRF143	M	1.00000 EA U			
PRF145	#346877 LITTELFUSE FUSE HOLDER	M	1.00000 EA U			
PRS377	#EE-SX4009-P10 OPTO SENSOR SLOT TYPE 5mm	M	1.00000 EA U			
PRG002	RUBBER ROLL DRIVE PULLEY	M	2.00000 EA U			
PRG003	IDLER PULLEY	M	3.00000 EA U			
PRG019	CUT OFF DRIVEN PULLEY	M	1.00000 EA U			
PRG020	CUT OFF DRIVE TIMING BELT PULLEY	M	1.00000 EA U			
Revision: A						
PRG021	RUBBER ROLL DRIVE TIMING BELT PULLEY	M	1.00000 EA U			
PRT407	#09 18 510 6813 CONN PLUG 10 CONTACTS	M	1.00000 EA U			
PRT408	#8309-8000 SOCKET .12" 9 PIN CONNECTOR	M	1.00000 EA U			
PRW050	#135-2801-050 RIBBON CABLE 28AWG 50 COND	M	2.00000 FT U			
PRG004	#A6A 3-15DF03716 TIMING BELT PULLEY	M	1.00000 EA U			
PRG005	#A6A 3-72NF03712 TIMING BELT PULLEY	M	1.00000 EA U			
PRH150	#P2-42 POCKET PULL FLUSH HANDLE	M	1.00000 EA U			
PRK150	#DK-1217 THREE PRONG PLASTIC KNOB	M	2.00000 EA U			

	Description	T	Quantity Per	U/M	U	Unit Cost / Extended Cost	Effectivity Dates From	To
	110V CUTTER w/TOUCHSCREEN					0.00000		
	#303 WOODRUFF KEY	M	2.00000	EA	U			
	5/16-18 x 1" PLASTIC MOLDED THUMBSCREW	M	2.00000	EA	U			
PRM1995	PERMANENT MAGNET DC MOTOR 4Z141	M	1.00000	EA	U			
PRM219	MINARIK MM31701B, SPEED CONTROL	M	1.00000	EA	U			
PRM221A	MINARIK KNOB	M	1.00000	EA	U			
PRR150	#3A355 DPST-NO 120V COIL RELAY	M	2.00000	EA	U			
PRR225	LEVELER - FOOT	M	4.00000	EA	U			
PRR253	QUICK DISCONNECT AC OUTLET	M	1.00000	EA	U			
PRR254	AC APPLIANCE PLUG MATE	M	1.00000	EA	U			
PRR265	#E70452, AS568-452 EPR O-RING	M	4.00000	EA	U			
PRS003	#HWIK-2AF10 IDEC 2 POSITION KEY SWITCH	M	1.00000	EA	U			
PRS221	LEE SPRING #LC-026C-10-M	M	2.00000	EA	U			
PRS243	PRESSURE SPRING	M	2.00000	EA	U			
PRS352	PROXIMITY SWITCH MAGNET HAMLIN #57135-00	M	3.00000	EA	U			
PRS360	#59135-030 HAMLIN POSITION SENSOR	M	1.00000	EA	U			
PRS361	#4VW24 16MM GREEN PUSHBUTTON	M	2.00000	EA	U			
PRS362	#4VW25 16MM RED PUSHBUTTON	M	2.00000	EA	U			
PRS365	#4VW83 NO CONTACT BLOCKS	M	1.00000	EA	U			
PRS373	#4VW84 NC CONTACT BLOCKS	M	1.00000	EA	U			
PRS374	IDEC #XW1E-BV402M-R E-STOP SWITCH	M	2.00000	EA	U			
PRS375	IDEC #HWAV-27 YELLOW E-STOP WASHER	M	2.00000	EA	U			
PRT304	KULKA 2 COND. TERMINAL BLOCK 699-2	M	1.00000	EA	U			
PRT307	KULKA 45 TERMINAL KT47	M	2.00000	EA	U			
PRT308	KULKA TERMNL KT48	M	2.00000	EA	U			
PRW369	WIRING HARNESS 30 AUTOCUTTER TOUCHSCREEN	M	1.00000	EA	U			
PRW337	TEFLON WSH 1-3/16x1/2x.062	M	2.00000	EA	U			
XS87	30" AUTOCUTTER OPERATIONAL MANUAL	M	1.00000	EA	U			
xs51	STD SKID, 42 x 70"	M	1.00000	EA	U			
mro-363	2" x 4" x 8' HEM FIR STUD, KILN DRIED	M	3.00000	EA	U			
MRO-364	OSB BOARD, 7/16"X4'X8'	M	5.00000	EA	U			
.138BAB10	6-32 x 5/8 TORX FH SOCKET M/S	M	20.00000	EA	U			
PRW03	12 GA WHITE MTW	M	3.30769	EA	U			
PRW04	12 GA BLACK MTW	M	3.30769	FT	U			
PRW8	14 GA BLACK MTW	M	4.75000	FT	U			
PRW9	14 GA WHITE MTW	M	2.91666	FT	U			
PRW5	18 GA BLACK MTW	M	0.33333	FT	U			
PRW16	14 GA RED MTW	M	2.00000	FT	U			
PRT282	#10 FORK, VINYL INS., 12-10GA	M	4.00000	EA	U			
.500LDB13	1/2-13 FINISHED HEX JAM NUT	M	4.00000	EA	U			
PRX347	HD SUPPLY ROLL KEY	M	4.00000	EA	U		11/17/11	
PRT8293	.250x.032 VINYL INS. FM QC 12-10GA SPOOL	M	6.00000	EA	U		08/23/12	
PRT8302	.250x.032 VINYL FEMALE QC 22-18GA SPOOL	M	2.00000	EA	U		08/23/12	
PRT8330	.250x.032 NYLON F.I.M. QC 22-18GA SPOOL	M	2.00000	EA	U		08/23/12	

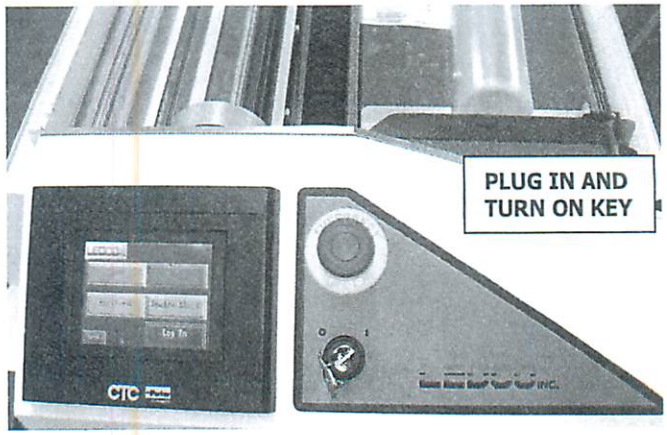
C30 AUTOCUTTER TESTING 2015

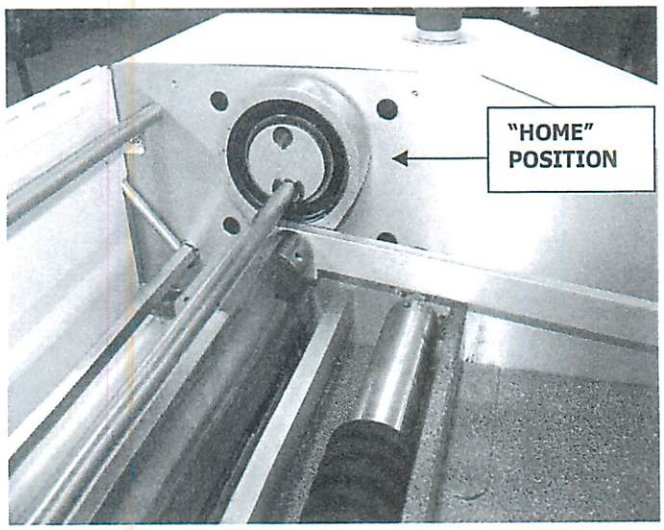
1) PREPARE TO TEST THE CUTTING MECHANISM BY FIRST CHECKING THAT THE 2 POSITION KEY IS IN THE 'O' OFF POSITION.

2) PLUG A 110 VOLT TEST CORD (PRC118) INTO THE C30 AUTOCUTTER RECEPTACLE AND INSERT THE OTHER END OF THE CORD INTO A 110V OUTLET.

3) TEST WITH THE DOORS OPEN. SNAP A TEMPORARY MAGNET (PRS352) ONTO THE RIGHT AND LEFT HOUSING PROXIMITY MAGNETS. USE MASKING TAPE TO SECURE, SO MAGNETS DO NOT FALL OFF WHILE TESTING, WHICH WOULD MAKE THE TOUCHSCREEN LOOSE ACTIVATION.

4) TURN THE 2 POSITION KEY TO THE 'I' ENGAGE POSITION. ALLOW TIME FOR THE TOUCHSCREEN TO INITIALIZE. THE TOUCHSCREEN WILL ENERGIZE CUTTER AND THE GUILLOTINE CONNECTING BLOCK WILL MOVE TO THE "HOME" POSITION.





C30-B CUTTER INITIAL PROGRAMMING SETUP

5) TURN KEY TO THE START POSITION TO ENERGIZE CUTTER. TOUCH SCREEN WILL ILLUMINATE, WAIT UNTIL MAIN MENU COMES UP BEFORE PROCEEDING, SEE (FIG. 1).

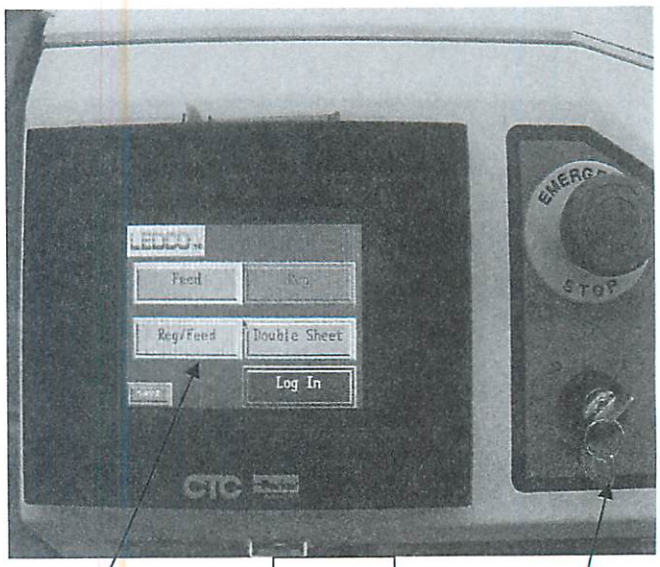


FIG. 1

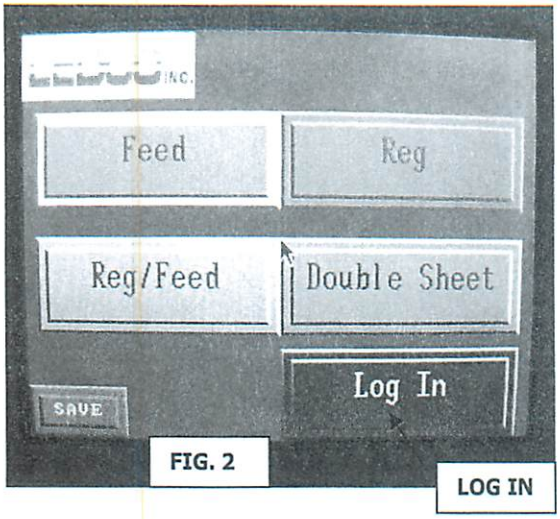
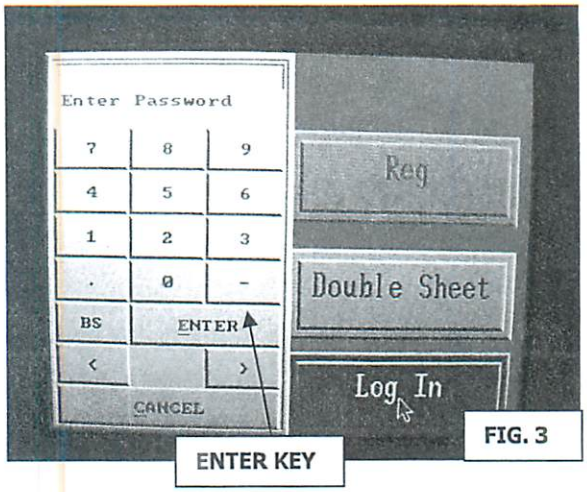


FIG. 2

LOG IN



ENTER KEY

FIG. 3

6) AT MAIN MENU PRESS "Log In" BUTTON (FIG.2). GRAY NUMBER PAD APPEARS. TYPE IN PASSWORD NUMBERS 6457 AND PRESS THE "ENTER" KEY, SEE (FIG. 3).

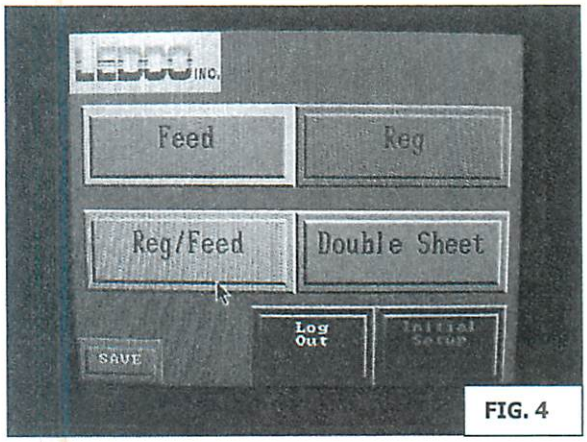
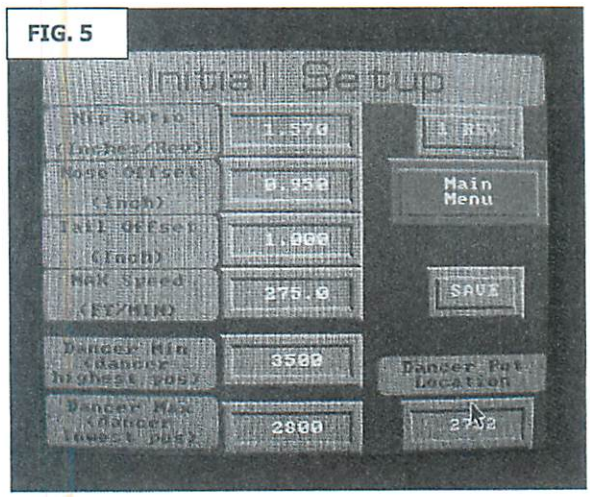


FIG. 4

7) PRESS "Initial Setup" BUTTON ON LOWER RIGHT SIDE OF SCREEN, SEE (FIG4). 4).

FIG. 5



8) WITH THE EXCEPTION OF THE DANCER POT SETTINGS INITIAL SETTINGS SHOULD BE SET TO NUMBERS SHOWN IN (FIG. 5) (NOTE: NOSE AND TAIL OFFSETS MAY HAVE TO CHANGE IF THEY DIFFER IN LENGTHS DURING SAMPLE RUNS). TO CHANGE NUMBER, PRESS BUTTON OF NUMBER YOU WANT TO CHANGE (FIG. 6) AND ENTER NUMBER YOU WANT THEN PRESS THE "ENTER" KEY, SEE (FIG. 7).

NIP RATIO: 1.570
NOSE OFFSET: 0.950
TAIL OFFSET: 1.000
MAX SPEED: 275.0

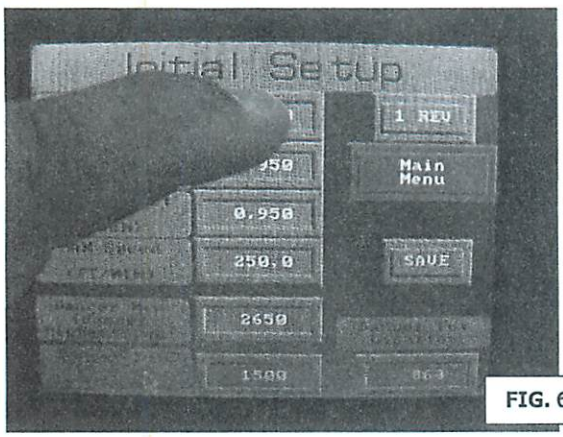
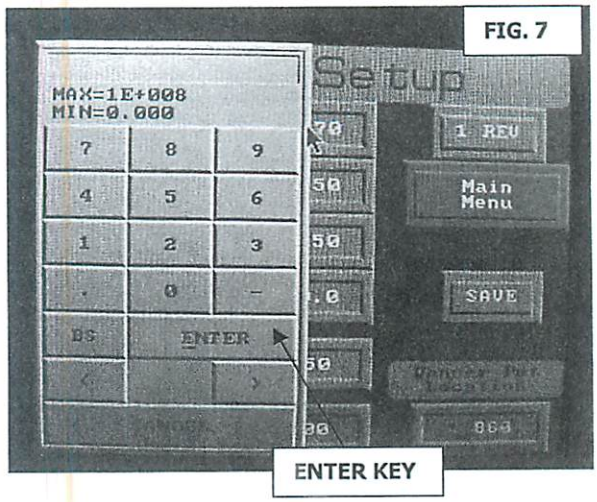


FIG. 6

FIG. 7



ENTER KEY

9) TO SET DANCER MAX POSITION (DANCER LOWEST POSITION): SET DANCER ARM AS SHOWN IN (FIG. 8), WHEN IN THIS POSITION MAKE NOTE OF THE DANCER POT LOCATION READING AND CHANGE DANCER MAX IN INITIAL SETUP TO THIS NUMBER.

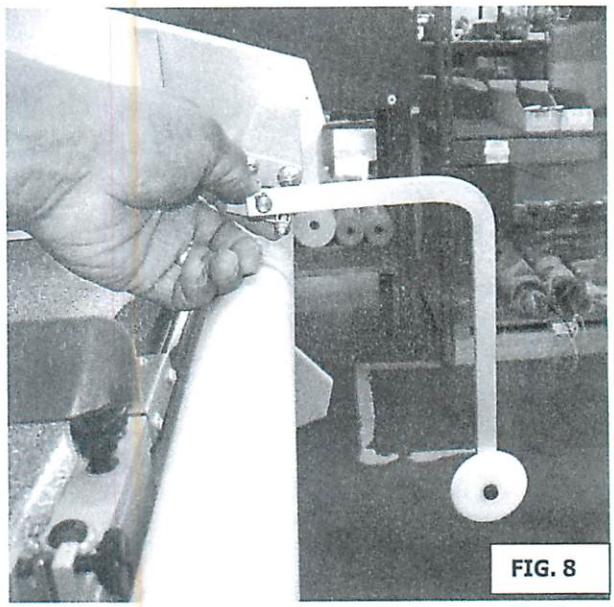


FIG. 8

10) TO SET DANCER MIN POSITION (DANCER HIGHEST POSITION): SET DANCER ARM AS SHOWN IN (FIG. 9), WHEN IN THIS POSITION MAKE NOTE OF THE DANCER POT LOCATION READING AND CHANGE DANCER MIN IN INITIAL SETUP TO THIS NUMBER.

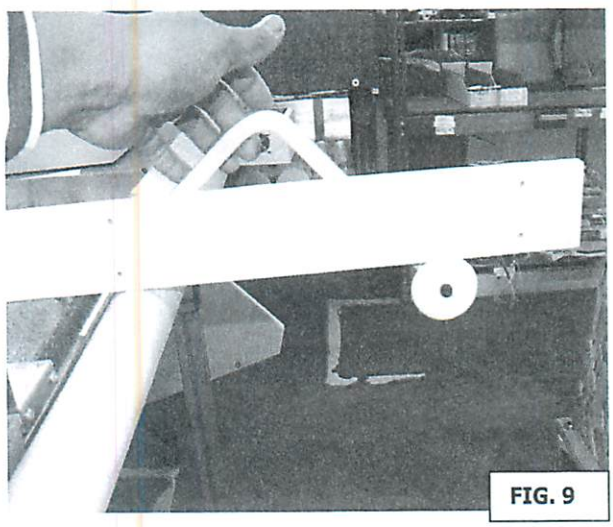


FIG. 9

11) PRESS SAVE BUTTON. SEE (FIG. 10) AND WAIT FOR PARAMETERS TO SAVE (FIG. 11)

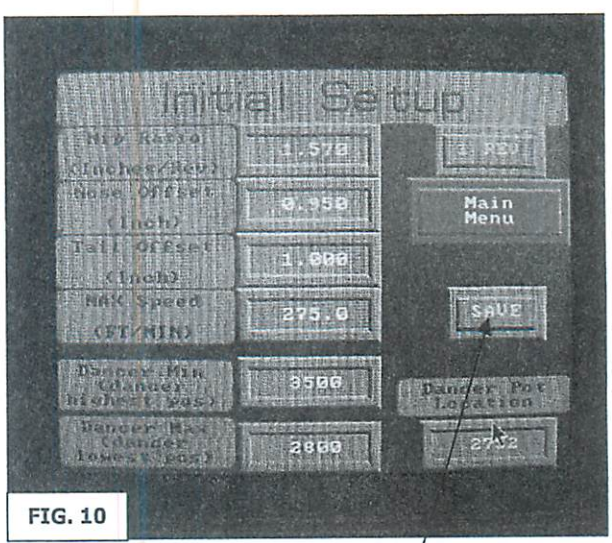


FIG. 10

SAVE

P1

P2

C24

B2

B1

C25