C30
AUTOCUTTER-B

ASSEMBLY
PROCEDURES

SEPTEMBER 2015

C30 AUTOCUTTER-B ASSEMBLY

TABLE OF CONTENTS

1) STAND

2) SIDE PANELS

3) BOTTOM HOUSING BACK DOOR & CUT OFF BLADE

4) CHASSIS

5) GUILLOTINE, CUT OFF CAM SHAFT

6) FEED GUIDE

7) DANCER BAR

8) HOUSINGS

9) DOORS

10) SAFETY SHIELD

11) WIRING

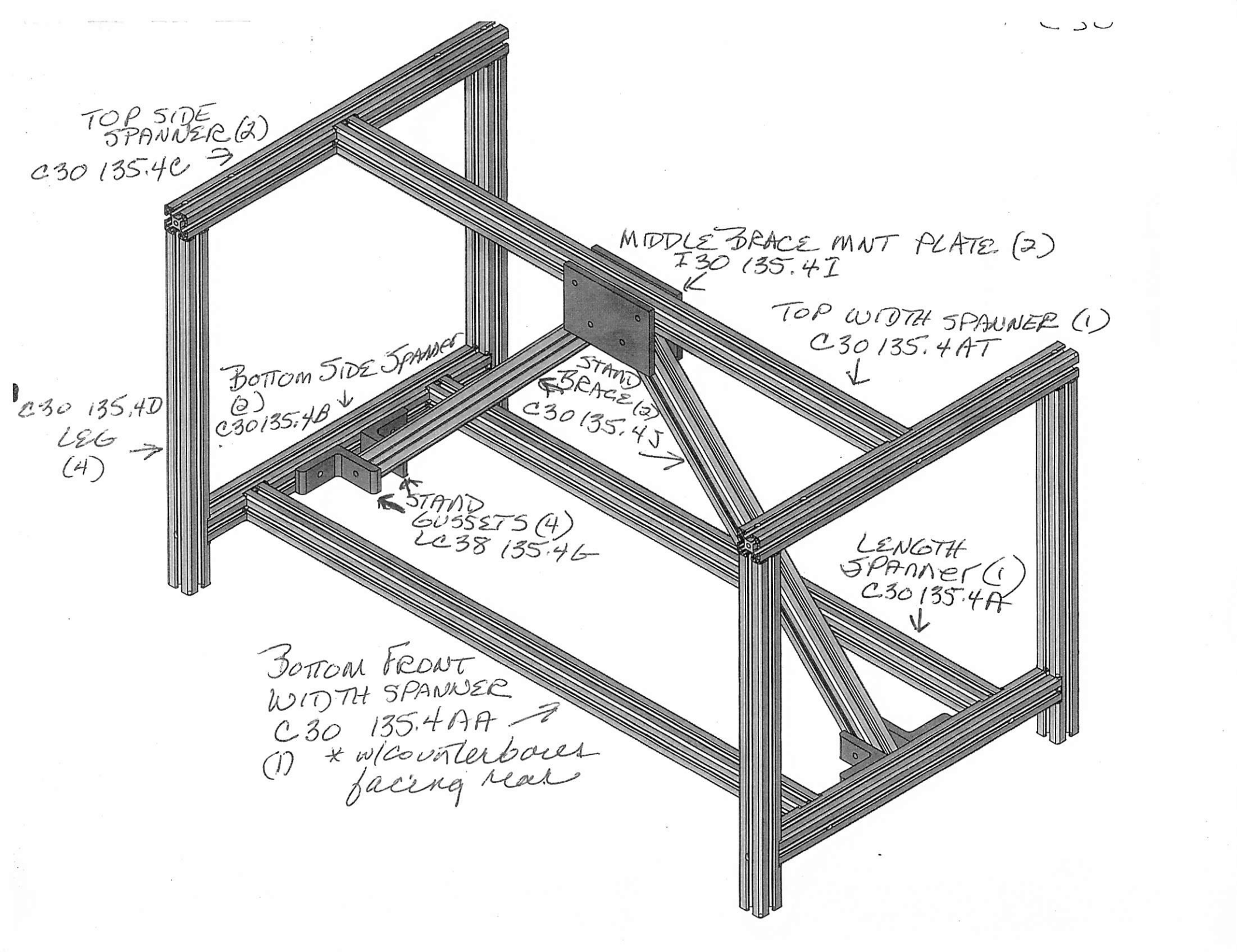
12) BOTTOM HOUSING BACK DOOR INSTALLATION

13) DOOR MAGNETS

14) STEPPER MOTOR (PRM853.4) SETTING PARAMETERS

15) EXIT TABLE

16) TESTING


TOP SIDE SPANNER (2)
C30 135.4C
MIDDLE BRACE MNT PLATE (2)
I30 135.4I
TOP WIDTH SPANNER (1)
C30 135.4AT
BOTTOM SIDE SPANNER (2)
C30135.4B
C30 135.4D
LEG (4)
STAND BRACE (2)
C30 135.4J
STAND GUSSETS (4)
C38 135.4G
LENGTH SPANNER (1)
C30 135.4A
BOTTOM FRONT WIDTH SPANNER
C30 135.4AA
(1) * w/counterbores facing rear

C30 AUTOCUTTER
STAND ASSEMBLY 2015

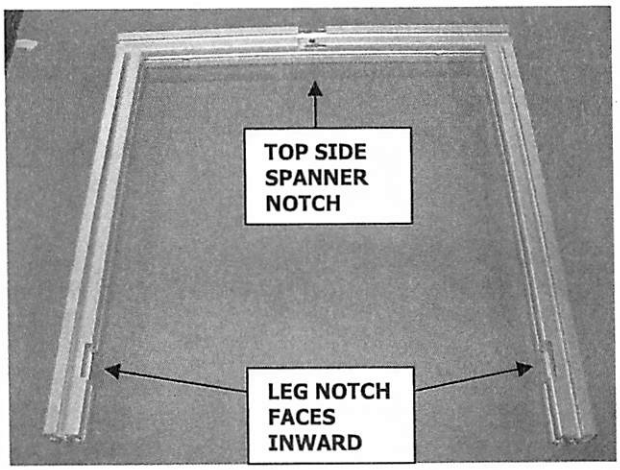
1) THE ASSEMBLY OF A STURDY, EXTRUDED STAND IS REQUIRED FOR THE C30 AUTOCUTTER. THE CHASSIS IS BUILT ON THE COMPLETED STAND WITH "IN HOUSE" CASTERS ATTACHED. THE C30 AUTOCUTTER IS SHIPPED ON THE STAND. PARTS ARE IN LOFT 1. STAND ASSEMBLY IS AS FOLLOWS.

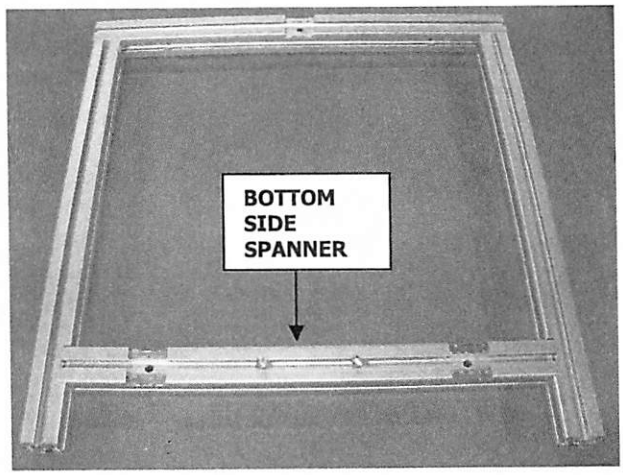
2) PLACE THE APPROPRIATE STAND PIECES ON A CLEAN WORKTABLE. THE TOTAL CONNECTIONS ARE MADE WITH THE FOLLOWING HARDWARE: (4) 5/16-18 X 1 CARRIAGE BOLTS (.312G0A16), (16) FLAT WASHERS SAE, (12) 5/16-18 ACORN NUTS, (4) 5/16-18 HEX NUTS, (10) 5/16-18 X 1 ½ SHCS, AND (6) 5/16-18 X 3 SHCS AS11 & AS12.

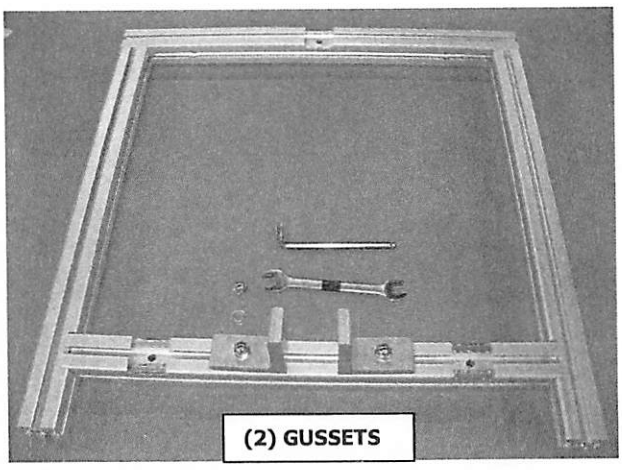
3) PLACE (2) TOP SIDE SPANNERS (C30 135.4C) ON A WORKTABLE WITH NOTCHES FACING INWARD AND THE FOUR COUNTERBORES UPWARD. SECURE A LEG (C30 135.4D) TO EACH END OF THE TOP SIDE SPANNERS, ALIGNED WITH THE LEG NOTCHES FACING EACH OTHER AT THE LOWER END. USE 5/16-18 X 1 ½ SHCS.

4) SECURE A BOTTOM SIDE SPANNER (C30 135.4B) BETWEEN THE LEGS WITH THE NOTCHES FACING INWARD, GOING THE SAME DIRECTION AS THE TOP SIDE SPANNER NOTCH. SECURE WITH 5/16-18 X 1 ½ SHCS.

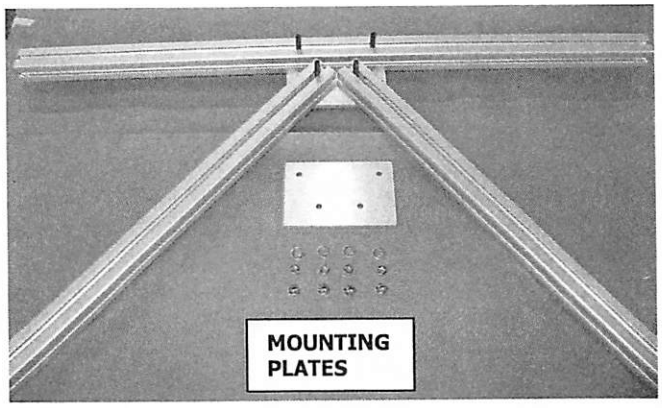
5) SECURE (2) STAND GUSSETS (LC38 135.4G) BY INSERTING A 5/16-18 X 1 CARRIAGE BOLT INTO THE BOTTOM SIDE SPANNER NOTCH, BREAK INWARD. ADD A 5/16 FLAT WASHER TO THE CARRIAGE BOLT THREADS AND SNUG A 5/16-18 ACORN NUT ONTO THREADS.

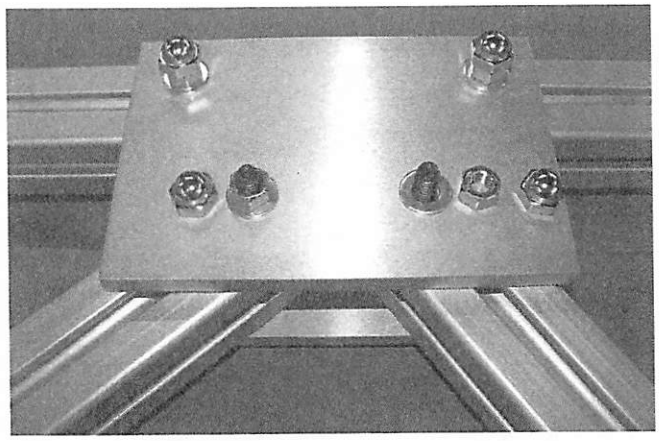






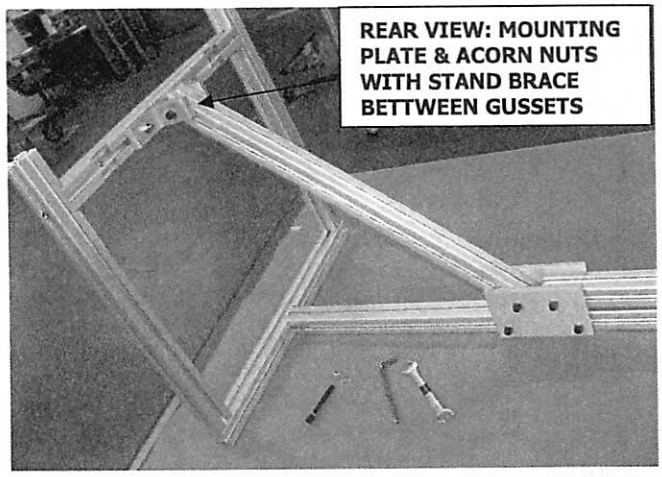
6) PLACE A 5/16 FLAT WASHER ON EACH OF (4) 5/16-18 X 3 SHCS. SET A MIDDLE BRACE MOUNTING PLATE (I30 135.4I) ON THE (4) SHCS. ALIGN A TOP WIDTH SPANNER (C30 135.4AT) WHICH HAS TWO HOLES IN THE CENTER TO ACCOMMODATE THE MOUNTING PLATE, HOLES ARE ORIENTED FRONT AND BACK, ON MORE DISTANT HOLES. PLACE (2) STAND BRACES (C30 135.4J) ON THE (2) CLOSER MOUNTING PLATE HOLES. PLACE ANOTHER MIDDLE BRACE MOUNTING PLATE ON THE SHCS THREADS AND LOOSELYSECURE WITH A 5/16 FLAT WASHER, 5/16-18 HEX NUT AND A 5/16-18 ACORN NUT. <u>THE ACORN NUTS WILL FACE THE FRONT OF THE MACHINE.</u>



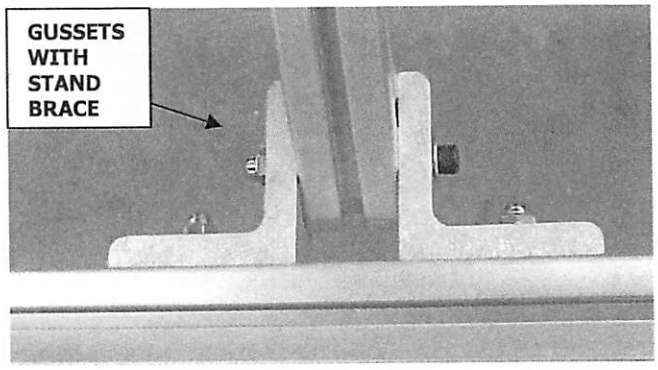


7) ROTATE THE TOP WIDTH SPANNER SO THE ACORNS ARE FACING THE FRONT AND THE STAND BRACES ARE UPWARD. SECURE THE RIGHT AND LEFT SIDE SPANNERS WITH LEGS, FITTING THEM IN THE NOTCHES. USE 5/16-18 X 1 ½ SHCS.

8) PLATE THE STAND BRACE BETWEEN THE GUSSETS AND INSERT A 5/16-18 X 3 SHCS WITH A 5/16 FLAT WASHER THROUGH THREW A GUSSET, STAND BRACE AND THE OTHER GUSSET. LOOSELY SECURE WITH A 5/16 FLAT WASHER AND 5/16 ACORN NUT. ***THE ACORN NUTS SHOULD FACE THE FRONT OF THE MACHINE, ALONG WITH THE MOUNTING BRACE ACORN NUTS.

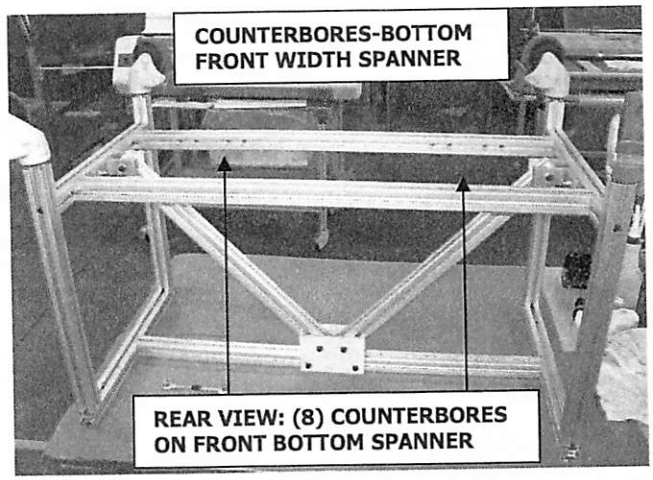


9) SECURE THE LENGTH SPANNER (C30 135.4A) BETWEEN THE REAR NOTCHES IN THE RIGHT AND LEFT BOTTOM SIDE SPANNERS. THE LENGH SPANNER WILL THEN ORIENT BEHIND THE MIDDLE BRACE MOUNTING PLATE, ON THE SIDE ***<u>WITHOUT THE ACORNS</u>***. USE 5/16-18 X 1 ½ SHCS TO SECURE LENGTH SPANNER BETWEEN BOTTOM SIDE SPANNERS.



10) THE BOTTOM FRONT WIDTH SPANNER (C30 135.4AA) 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.

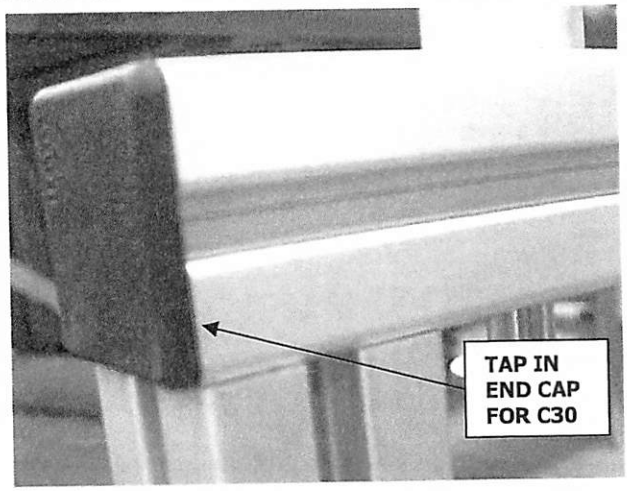


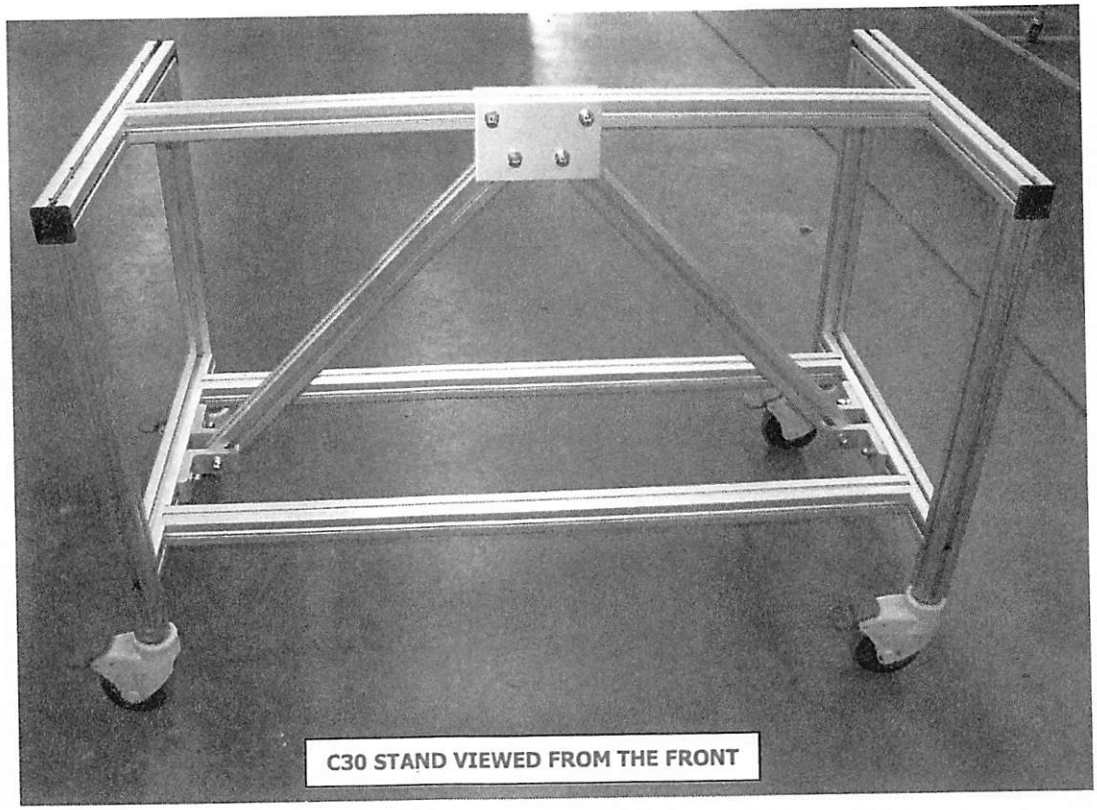
11) THREAD (4) "IN HOUSE" CASTERS ONTO THE ENDS OF THE LEGS. THESE WILL BE REMOVED AND STORED IN SHIPPING WHEN MACHINE IS CRATED. NEW CASTERS ARE SENT WITH THE C30 AUTOCUTTER.

12) TIGHTEN ALL CONNECTIONS, INCLUDING MOUNTING PLATE NUTS AND ACORNS AND GUSSET ACORNS.

13) SLIDE ASSEMBLED C30 STAND OFF WORK TABLE TO FLOOR AND ONTO CASTORS

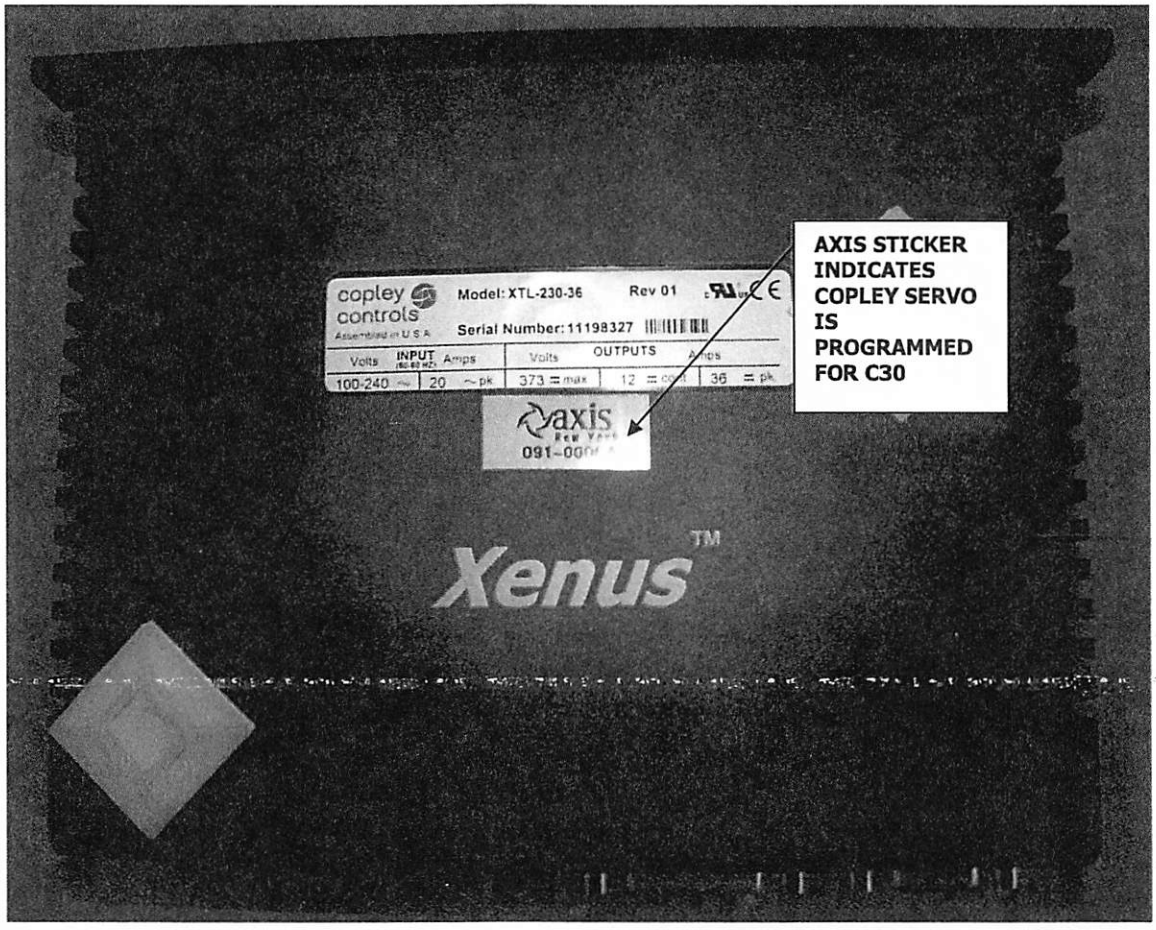
14) ALIGN AND TAP (4) EXTRUDED STAND END CAPS (PRC250) INTO THE EXPOSED ENDS OF THE TOP SIDE SPANNERS.



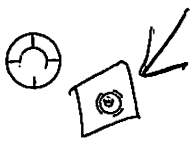


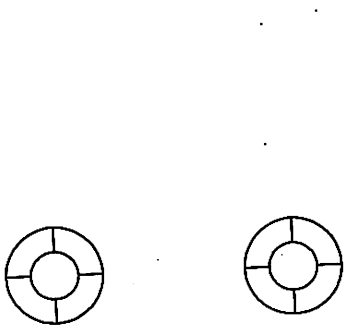
COPLEY SERVO DRIVE PROGRAMMED STICKER

1) **THE BLUE COPLEY SERVO DRIVE (PRC0310) SHOULD *ALWAYS* HAVE A WHITE/BLACK "AXIS" STICKER CENTERED BELOW THE MODEL STICKER. THIS "AXIS" STICKER INDICATES THAT THE COPLEY SERVO DRIVE HAS BEEN PROGRAMMED SPECIFICALLY FOR OUR C30 CUTTERS.**



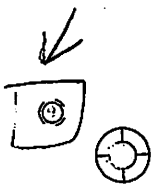
replacement





6-32

6-12-A



C30 AUTOCUTTER
SIDE PANEL ASSEMBLY 2015

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) ~~AS13~~ AS09, TWO EACH, ON THE BOTTOM LEFT SIDE PANEL WITH TOUCHSCREEN (C30 090.4LC) AS16 AND RIGHT SIDE PANEL (C30 090.4RC) AS17. USE (8) 5/16-18 X ¾ FHSH INSERTED FROM OUTER PANEL.

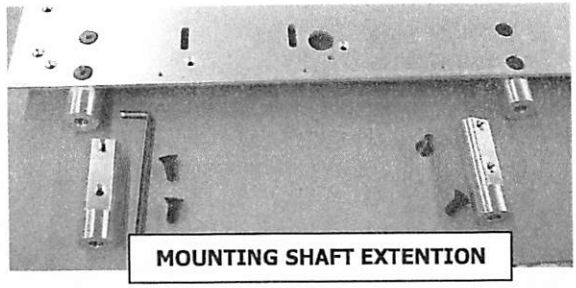
3) *LOOSELY* SECURE SIDE PANELS TO THE STAND, ACORNS TO FRONT, USING (4) ½-13 X 2 ½ HEX BOLTS (.500HDA40) AS13 EACH WITH A ½ FLAT WASHER.

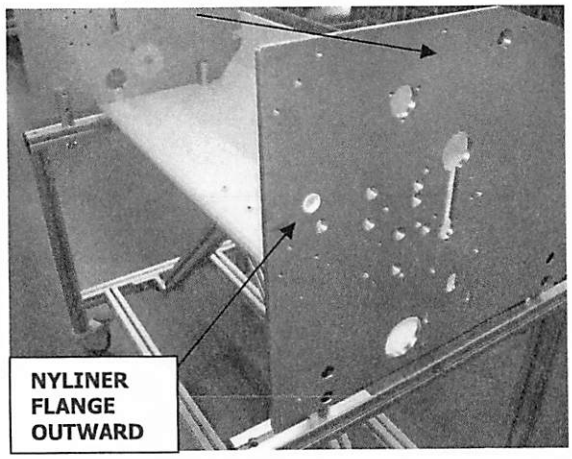
4) ATTACH THE BOTTOM HOUSING NRTL (C30 093.4A) AS16 BETWEEN SIDE PANELS THROUGH TABS, WITH LIP TO THE FRONT. USE (4) 10 X ¾ PH SMS.

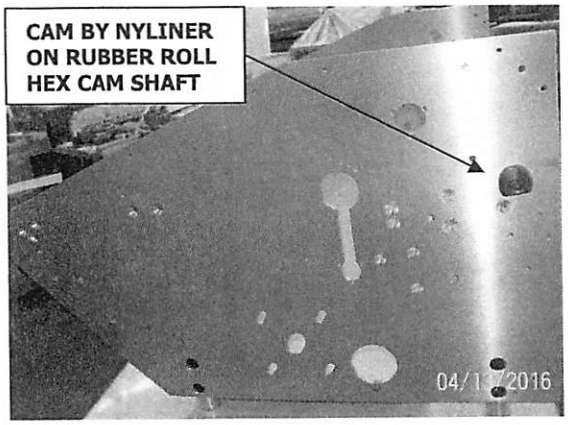
5) INSERT (2) WHITE BEARING NYLINERS (PRB059) RACK 21 <u>FLANGE OUTWARD</u>, FOR THE HEX RUBBER ROLL CAM SHAFT (C30 134.4) LOFT 2.

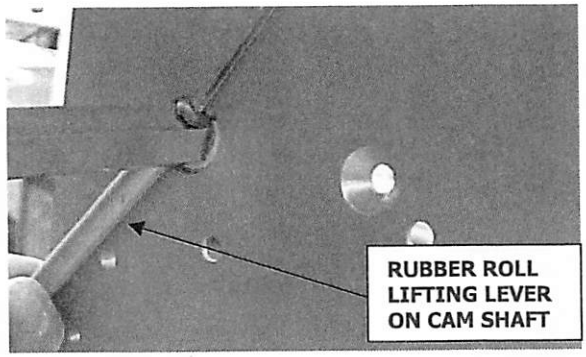
6) INSERT HEX CAM SHAFT, ORIENTED WITH INNER HOLES UPWARD/INWARD AND SECURED ON THE OUTER SIDE PANELS WITH (2) CAMS (C25 133.4) RACK 11. *CRITICAL THAT THE CAMS* ARE FLAT SIDE <u>DOWNWARD</u> AND SET SCREW UPWARD. SECURE CAMS TO SHAFT WITH (2) 10-32 X 3/8 SS.

7) THREAD (2) RUBBER ROLL LIFTING LEVERS (C25 132.4) AS11 ONTO THE RUBBER ROLL CAM SHAFT THROUGH THE INNER HOLES ON THE CAM SHAFT. USE (2) 10-32 X ¾ BHSH. CRITICAL: THE FLAT SIDE OF THE CAM SHOULD BE <u>DOWNWARD</u> AND LIFTING LEVER SHOULD BE <u>DOWNWARD</u>.

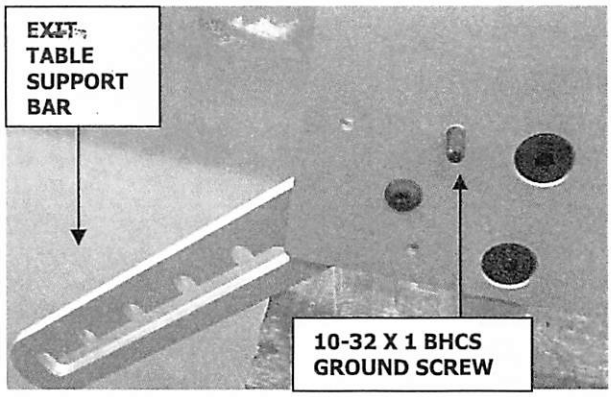




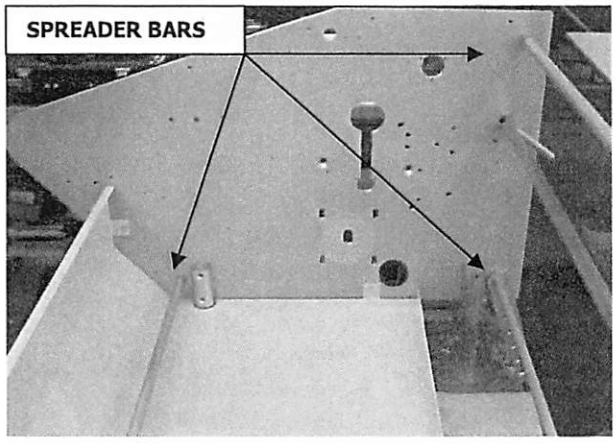




8) ***AFTER*** **THE RUBBER ROLL CAM SHAFT IS INSTALLED LOCATE (3) SPREADER BARS (C30 111.4) LOFT 2. ***** ***BEFORE*** **SECURING SPREADER BARS ADD (2) EXIT TABLE SUPPORT BARS (C30 306.4) RACK 11 ORIENTED WITH NOTCHED CHANNELS *UP*, FACING DOWN, ONTO THE REAR BOTTOM SPREADER BAR. THEN SECURE ALL THREE SPREADER BARS WITH (6) ¼-20 X ¾ BHSH.**



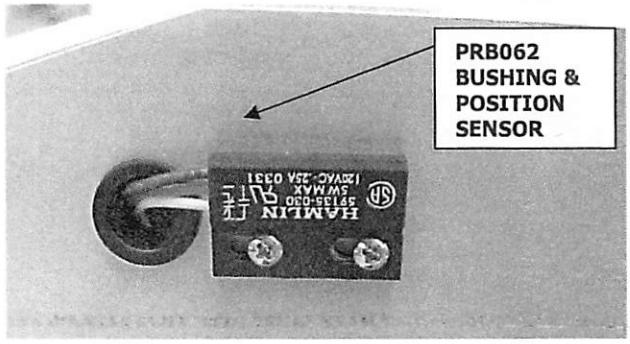
9) **THREAD A 10-32 X 1 BHCS WITH A #10 STAR WASHER FROM THE INNER REAR, LEFT PANEL, FOR GROUND WIRES. ON THE OUTER SIDE PANEL, ADD A #10 STAR WASHER. PLUS A INTERNATIONAL GROUND LABEL (LAB06) WB09.**



10) **USE A RATCHET TO TIGHTEN THE (4) FEET MOUNTING SHAFT EXTENSIONS TO THE STAND. THE RATCHET FITS THE (4) ½-13 X 2 ½ HEX BOLTS AND ½ FLAT WASHER SAE THAT WERE LOOSELY THREADED ON IN EARLIER ASSEMBLY.**

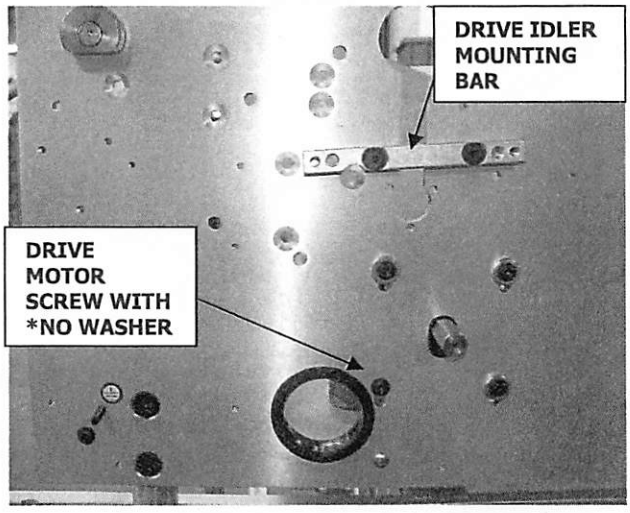
11) **ADD A SNAP BUSHING (PRB260) RACK 12 TO EACH SIDE PANEL, FLANGE OUT. NOTCH LEFT SIDE BY MOTOR CHANNEL.**

12) **INSERT A SNAP BUSHING (PRB062) AS09 ON THE UPPER LEFT SIDE PANEL, FLANGE INWARD FOR POSITION SENSOR MAGNET WIRES.**

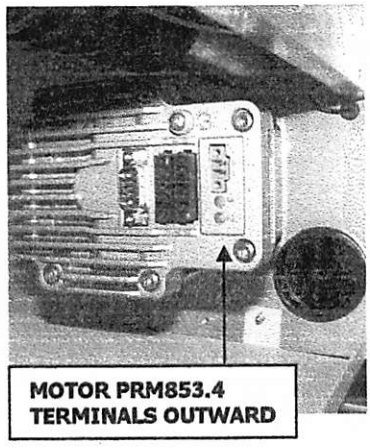


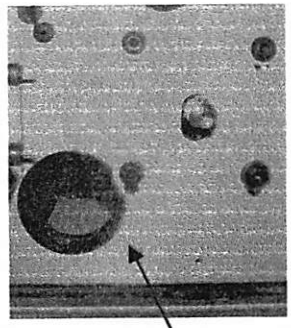
13) **SECURE THE HAMLIN POSITION SENSOR (PRS360) RACK 12 TO THE INNER LEFT SIDE PANEL. POSITION THE RED WIRE UPWARD AND SECURE WITH (2) 4-40 X 3/8 PHMS. INSERT WIRES THROUGH SNAP BUSHING. TRIM RED WIRE TO 1 ½" ON OUTER SIDE PANEL AND CLEAR CAP WITH A (PRT289). TRIM BLUE AND WHITE 6" AND CRIMP ON RED MALE CONNECTORS (PRT330).**

14) **SECURE THE DRIVE IDLER MOUNTING BAR (C30 055.4) RACK 11 TO THE OUTER LEFT SIDE PANEL THROUGH THE COUNTERSUNK HOLES INTO SIDE PANEL THREADS. USE (2) ¼-20 X ¾ FHSH. ORIENT THE BAR'S *NOTCH DOWNWARD TOWARD REAR.***



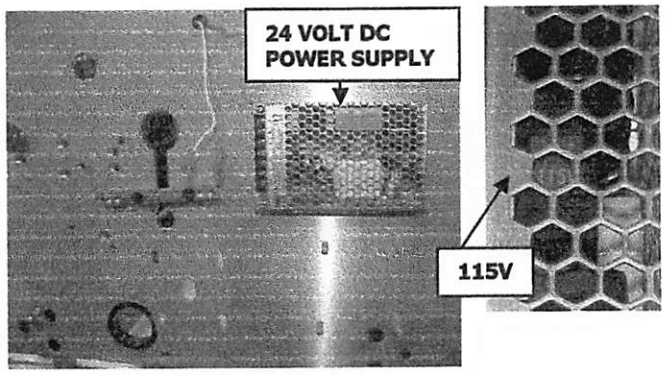
15) ATTACH THE MOTOR/DRIVE (PRM853.4) AS02 ***MACHINED AND TAPPED*** TO INNER LEFT SIDE PANEL. USE (4) 5/16-18 X 1 BHSH WITH (3) 5/16 FLAT WASHERS. ***NO WASHER BY TRIMMED SNAP BUSHING***. ***LOOSELY*** SECURE TO UPPER CHANNELS. PROGRAM MOTOR LATER.





16) SECURE THE LEFT SIDE PIVOT ARM BLOCK (C25 058.4) RACK 11 TO THE INNER FRONT SIDE PANEL USING (2) ¼-20 X ¾ FHSH THROUGH THE OUTER PANEL COUNTERSUNK OPENINGS.

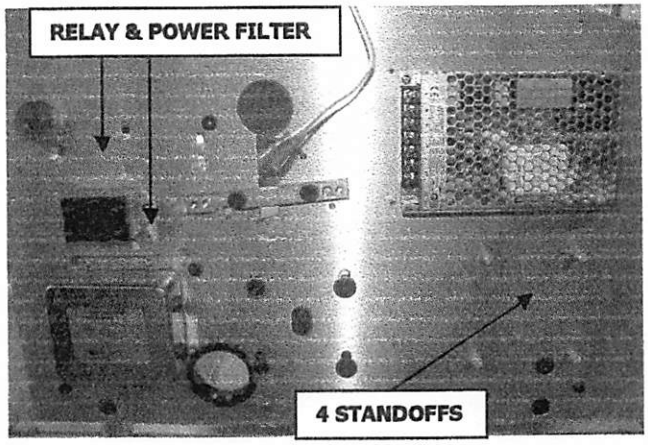
17) ON THE OUTER LEFT SIDE PANEL SECURE THE 2019 UPDATED POWER SUPPLY 24VDC (PRC0307) RACK 13, OVER THE SCREWS HOLDING THE PIVOT ARM BLOCK. ORIENT WITH TERMINALS TO THE LEFT/REAR. SECURE WITH (2) 6-32 X ¼ PHMS IN DIAGONAL CORNERS.



18) POWER SUPPLY MUST BE ON 115V.

19) BELOW THE 24VDC POWER SUPPLY, SECURE (4) HEX STANDOFF (LC25 010.4) LD09 USING (4) 4-40 X 3/8 FHMS THROUGH THE INNER COUNTERSINKS.

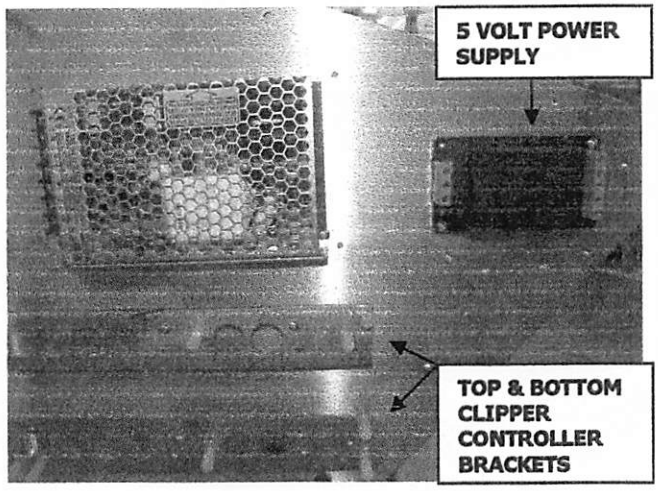
20) PREPARE TOP AND BOTTOM CLIPPER CONTROLLER BRACKETS (C30 414.4) RACK 12. ADD (5) HEX STANDOFFS (LC25 010.4) TO EACH, WITH TOP OUTER STANDOFFS DIAGONAL, BOTTOM OUTER STANDOFFS PARALLEL. USE 4-40 X 3/8 PHMS. SECURE BRACKETS TO SIDE PANEL STANDOFFS, 4-40 X 3/8 PHMS.



21) TO THE RIGHT/FRONT OF THE 24 V-DC POWER SUPPLY, SECURE A SMALLER, 5 V-DC POWER SUPPLY (PRC0325) RACK 24. USE (2) 6-32 X ½ RHMS, DIAGONAL.

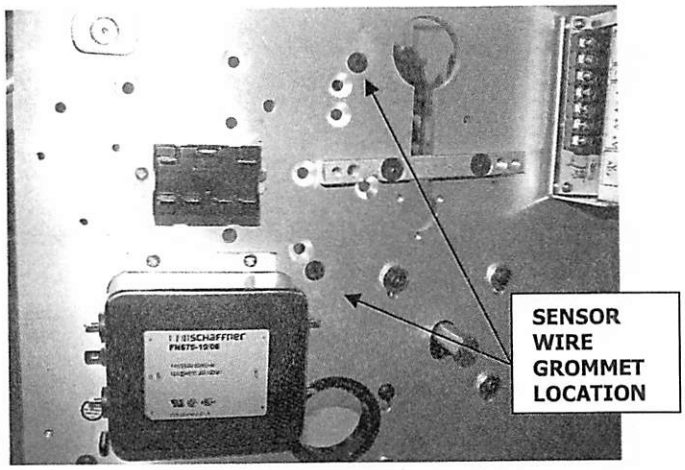
22) SECURE A 120 VAC COIL RELAY (PRR150) RACK 12. THE ***DOUBLE TERMINALS*** FACE ***UPWARD*** ON THE HORIZONTAL RELAY. LOCATE BEHIND DRIVE IDLER MOUNTING BAR, BELOW COUNTERSINKS. USE 8-32 X ¼ RHMS.

23) SECURE THE POWER FILTER (PRF142) AS08 BELOW THE RELAY. ORIENT THE POWER FILTER WITH THE (3)



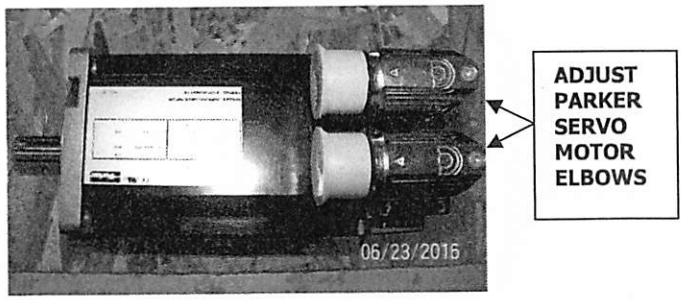
TERMINALS; LINE, POSITIVE AND GROUND TO THE REAR. USE (3) 8-32 X ¼ RHMS (2) ON TOP AND (1) BOTTOM.

24) FROM THE OUTER LEFT SIDE PANEL INSERT (2) RUBBER INSULATION GROMMETS (PRB105) RACK 12. GENTLY PUSH GROMMET THROUGH HOLES WITH A SMALL SCREWDRIVER.



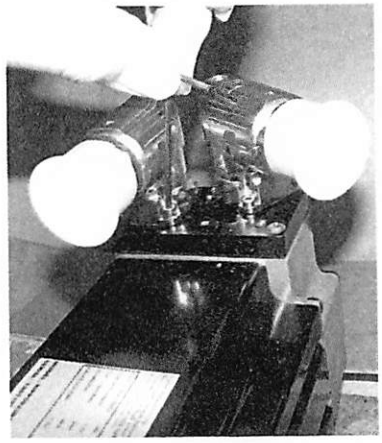
25) RE-ALIGN THE PARKER SERVO MOTOR (PRC0309) AS17 ELBOWS TO FACE AWAY FROM MOTOR. REMOVE THE (4) SCREWS WITH A 5/64 ALLEN WRENCH.

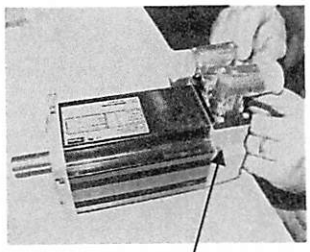
26) ON <u>RIGHT SIDE PANEL</u> INSERT PARKER SERVO MOTOR. ALIGN SERVO MOTOR ELBOWS <u>FACING THE FRONT</u>. USE (4) 5/16-24 X 1 BHSH EACH WITH A 5/16 FLAT WASHER. THE MOTOR KEYWAY FACES UPWARD. DO NOT OVER TIGHTEN, MOTOR ADJUSTMENT LATER.

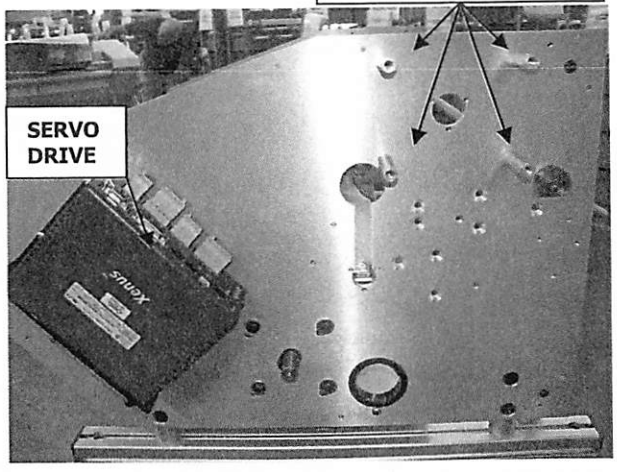


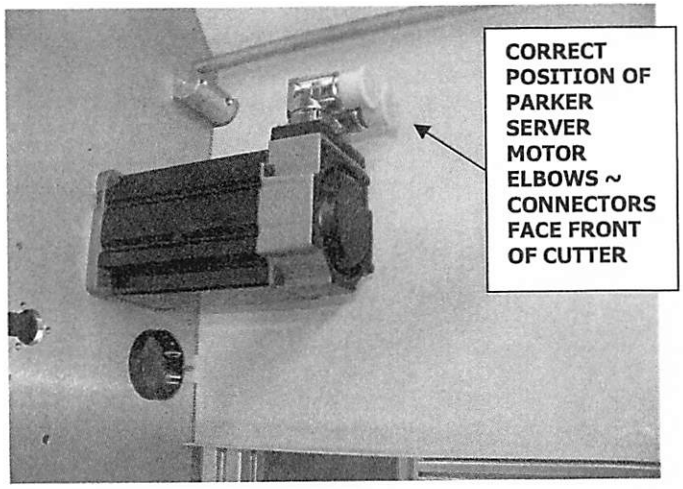
27) TO THE UPPER, REAR ATTACH (4) CAM SHAFT SUPPORT PLATE STANDOFFS (C30 203.4) RACK 13. USE (4) ¼-20 X ¾ FHSH THROUGH COUNTERSUNKS ON THE INNER RIGHT SIDE PANEL.

28) TO THE FRONT SECURE THE ANGLED BIG BLUE COPLEY SERVO DRIVE (PRC0310) AS17, CONNECTIONS UPWARD. USE (4) 6-32 X 3/8 THMS. * **REMOVE THIS PIECE WHEN ADDING THE RIGHT SIDE PIVOT ARM BLOCK OR ADD AFTER RIGHT PIVOT ARM.



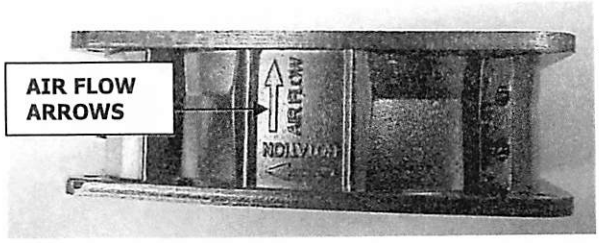




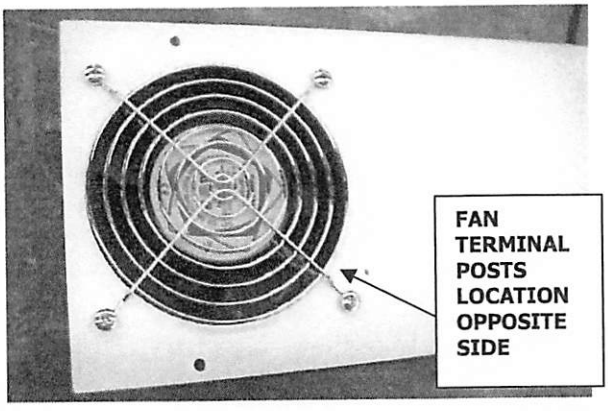


C30 AUTOCUTTER
BOTTOM HOUSING BACK DOOR & BOTTOM CUT OFF BLADE 2015

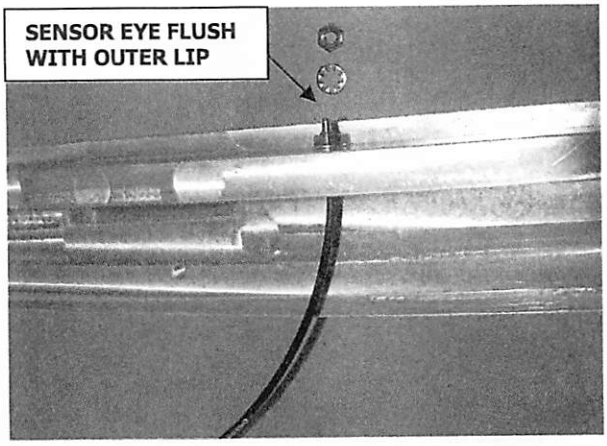
1) IN PREPARATION OF THE BOTTOM HOUSING BACK DOOR (C30 093.4B) AS16 FOR THE CHASSIS, SECURE THE AXIAL FAN FOR EDUCATOR *120VOLT* (PRF133) LD04 WITHOUT FAN CORD. FAN CORD IS IN WIRING HARNESS.



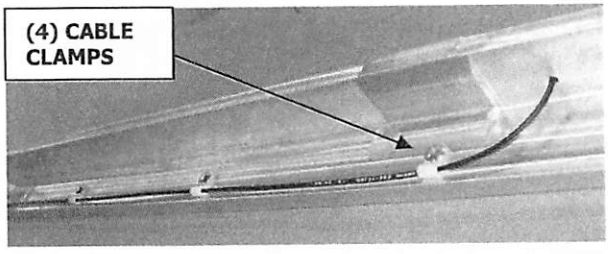
2) ORIENT THE FAN WITH TERMINAL POSTS TOWARD THE INSIDE OF THE BOTTOM HOUSING BACK DOOR AND THE FAN'S AIR FLOW OUTWARD (SEE ARROWS ON FAN). THE FAN CORD FACES INWARD AND DOWN ALONG LOWER EDGE AND WILL LOCATE BEHIND MOTOR. FROM THE OUTSIDE CONNECT THE SMALL FAN GUARD (PRF120) ~~AS07~~ THROUGH THE BACK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



3) PREPARE A BOTTOM CUT OFF BLADE MOUNTING BAR (C30 110.4) AS16. THREAD AN OMRON FIBER OPTIC CABLE (PRC277) RACK 12 FROM THE MIDDLE, INNER BREAK, INTO THE DEEPER SET SECTION OF THE BOTTOM CUT OFF BLADE MOUNTING BAR. THREAD THE FIBER OPTIC SENSOR THROUGH THE BAR UNTIL IT IS FLUSH WITH OUTER LIP. SECURE SENSOR EYE WITH WASHER AND NUT PROVIDED IN FIBER OPTIC PACK. THE CABLE IS DELICATE, USE CARE WHEN THREADING INTO 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 BEFORE SECURING.



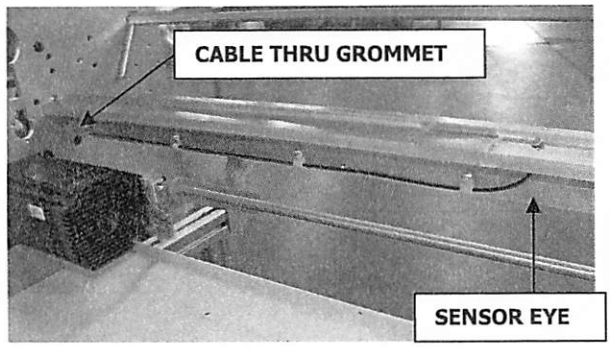
5) FEED CABLE END THROUGH *LOWER* RUBBER GROMMET IN LEFT SIDE PANEL. DO NOT BEND CABLE.

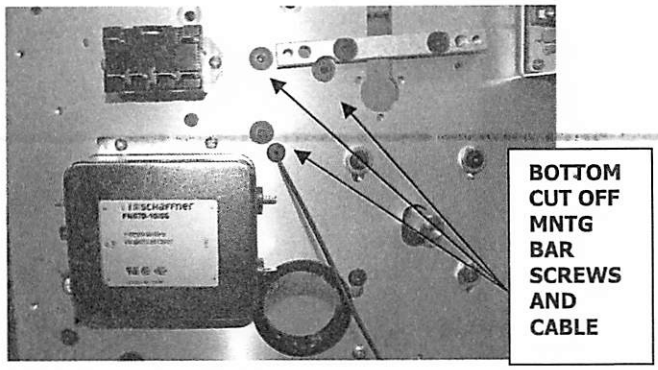
6) FROM THE REAR OF THE CUTTER SECURE THE BOTTOM CUT OFF BAR, WITH THE FIBER OPTIC CABLE DOWNWARD, EYE UPWARD AND IN FRONT BETWEEN THE SIDE PANELS. *THIS OPERATION IS EASIER WITH TWO PEOPLE*. LOOSELY START THE (2) VERTICAL ¼-20 X ¾ FHSH THROUGH THE OUTER COUNTERSUNK OPENINGS TO ALIGH THE MOUNTING BAR. START THE REMAINING ¼-20 X ¾ FHSH. TIGHTEN VERTICLE SCREWS FIRST AND THEN START THE THIRD SCREW.

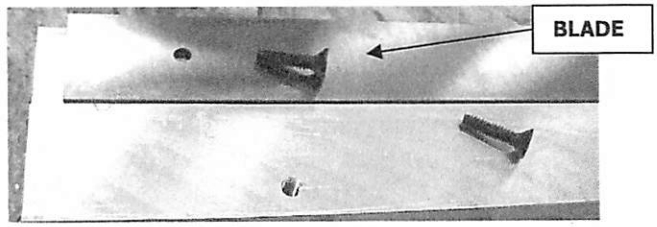
7) FROM REAR *VERY CAREFULLY* ALIGN A CUT OFF BLADE (C30 400.4) AS16 *WHICH IS SHARP ON BOTH SIDES*. ** HOLD WITH A RAG TO PROTECT YOUR HANDS. THE CUT OFF BLADE WILL BE CLOSER TO THE RIGHT SIDE PANEL, USE UPPER THREADS. LOOSELY START A 6-32 X 5/8 FL TORX (.138BAB10) ON THE END THREADS BY THE RIGHT SIDE PANEL. RAISE THE BLADE AND START THE MIDDLE THREADS. START ALL (9) THREADS. USE THE BLADE'S WEIGHT TO LEVEL THE CUTTING BLADE. WITH A TORK DRIVER, 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*.

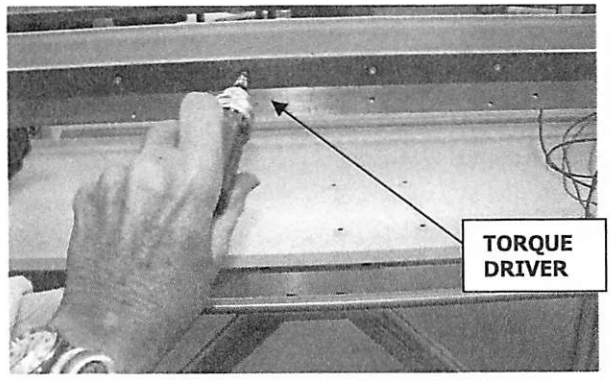
8) INSERT THE BOTTOM 30" CUTTER RUBBER ROLL (C30 040.4) AS16 BETWEEN SIDE PANELS WITH THE JOURNAL KEYWAY ON THE LEFT SIDE, THROUGH THE LEFT SIDE PANEL, *UNDER* THE DRIVE MOUNTING IDLER BAR. **BE MINDFUL OF THE BLADE!!

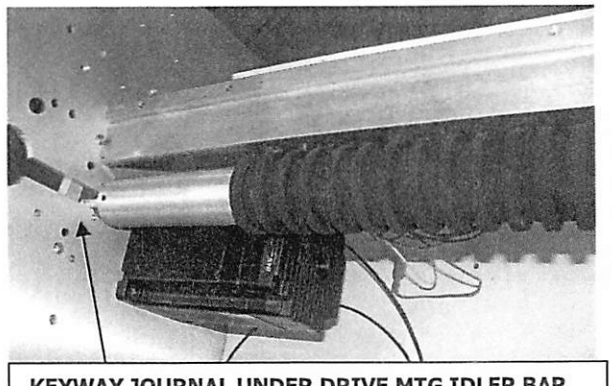
9) SECURE THE BOTTOM CUTTER RUBBER ROLL BY SLIDING A ROLLER BEARING (PRB075) RACK 12 ONTO EACH JOURNAL. THE RUBBER ROLL MUST SPIN VERY FREELY. IF IT DOES NOT, THE SHOULDER OF THE JOURNAL MAY BE TRIMMED INWARD, OR LOCTITE



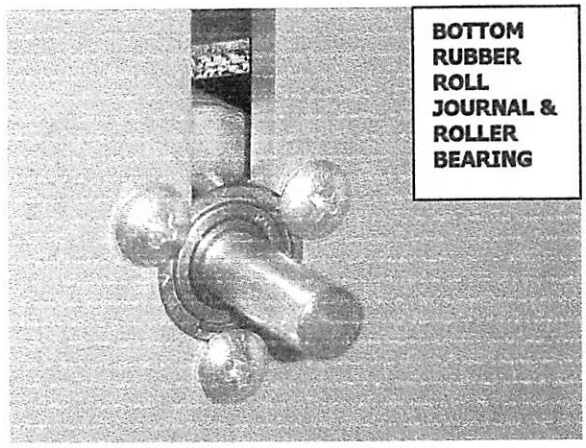




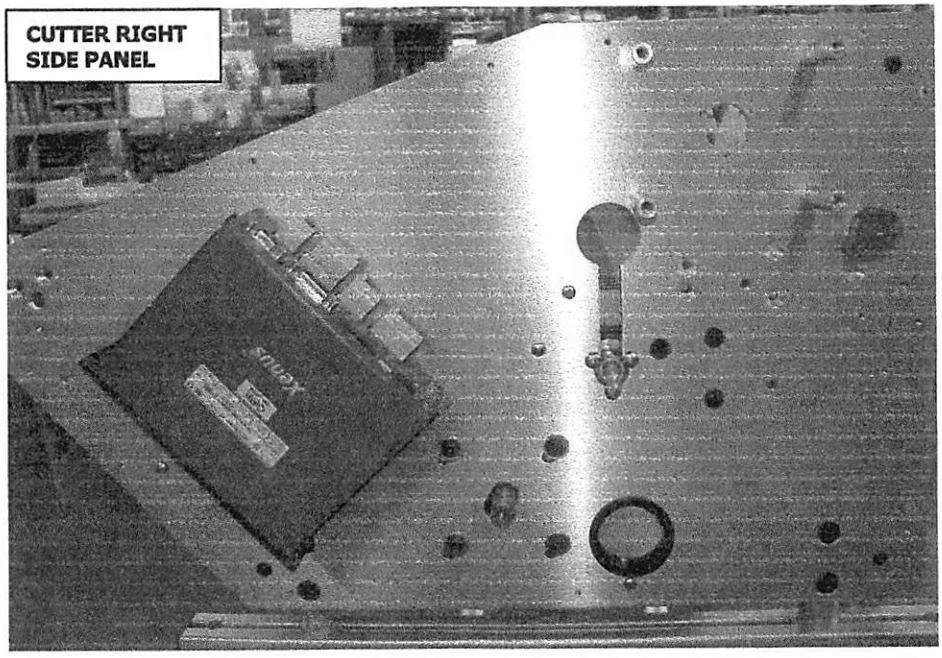




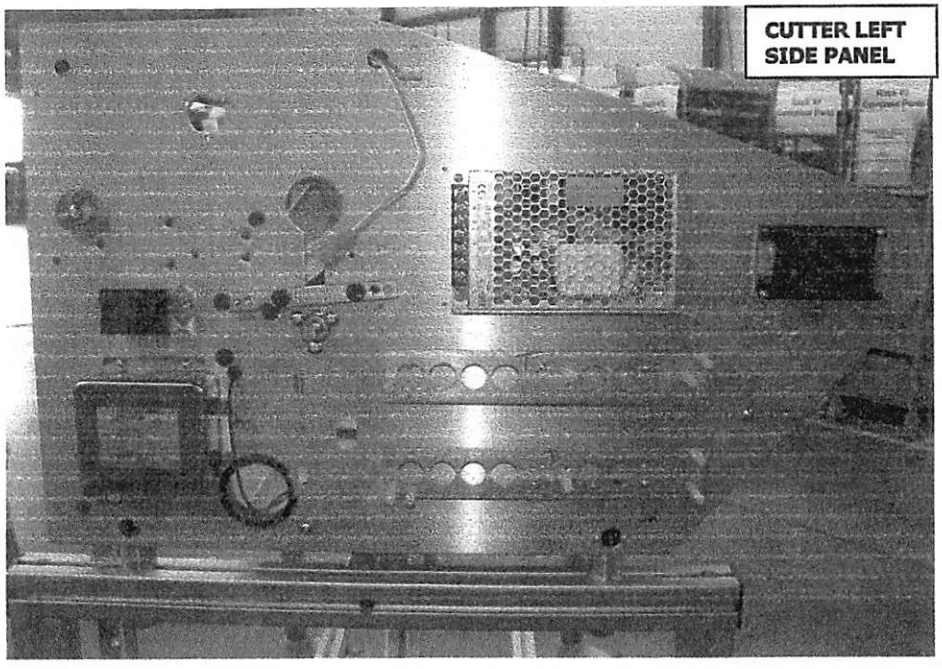
THE THREADS ON THE TRUSSHEADS HOLDING THE LEFT SIDE AND TIGHTEN UNTIL THE TRUSSHEAD JUST TOUCHES THE PANEL. SECURE THE ROLLER BEARINGS ON THE BOTTOM RUBBER ROLL BETWEEN SIDE PANELS WITH (3) 10-32 X ¼ THMS PER SIDE. SPIN RUBBER ROLL AGAIN TO VERIFY SMOOTHNESS.



BOTTOM RUBBER ROLL JOURNAL & ROLLER BEARING



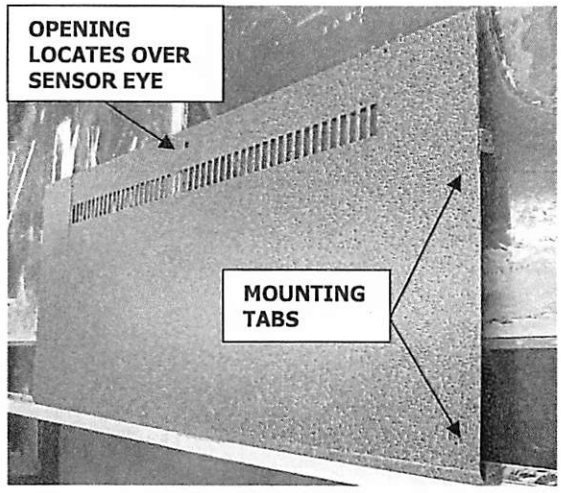
CUTTER RIGHT SIDE PANEL

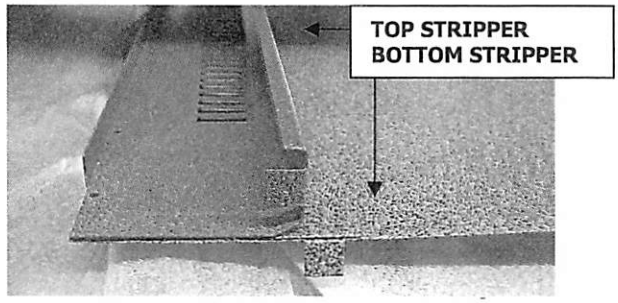


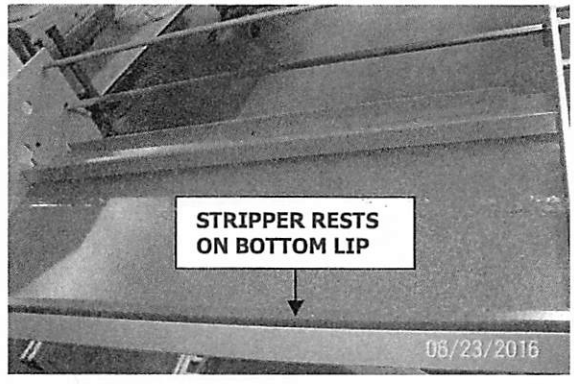
CUTTER LEFT SIDE PANEL

C30 AUTOCUTTER CHASSIS 2019

1) FROM THE CUTTER FRONT, ORIENT THE BOTTOM STRIPPER (C30 096.4B) AS16 WITH THE SLOTS TOWARD THE REAR. SLOTS FIT OVER BOTTOM RUBBER ROLL, AND THE FRONT LIP FACES DOWNWARD, RESTING *ON* BOTTOM COVER LIP EDGE. GENTLY TAP TABS INWARD SO THEY DO NOT SCRATCH SIDE PANELS. ***BE VERY CAREFUL OF REAR BLADE.*** PLACE BOTTOM STRIPPER OVER RUBBER ROLL. LOOK AT THE (3) HOLES ABOVE THE 6-32 THREADS ON THE BOTTOM CUT OFF BAR. THESE HOLES MUST LINE UP PERFECTLY OR BE RETAPPED WITH A HAND TAP NOT A DRILL. CONNECT THE REAR OF THE BOTTOM STRIPPER TO THE BOTTOM CUT OFF BAR THROUGH THE COUNTERSUNK HOLES IN BOTH. USE (3) 6-32 X 3/8 FHMS. ***SCREWS MUST BE FLUSH SO PAPER DOESN'T CATCH DURING RUN.*** IF THE SCREWS ARE NOT FLUSH, COUNTERSINK THE STRIPPER A BIT DEEPER AND THREAD SCREWS IN. CLEAN DEBRIS AWAY FROM BLADE WITH A RAG.

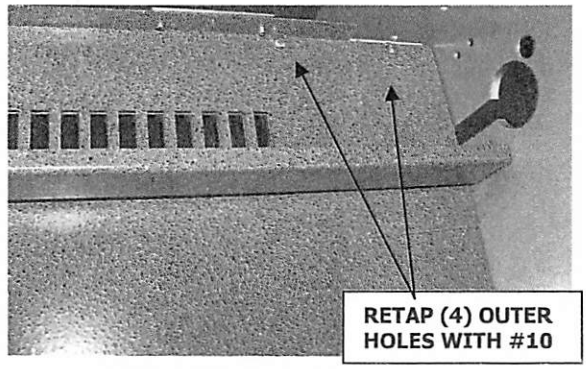






2) ATTACH THE BOTTOM STRIPPER TO THE RIGHT AND LEFT SIDE PANELS THROUGH THE TABS ON THE FRONT AND REAR SIDES. SECURE WITH (4) 10 X ¾ PH SMS. A DROP OF OIL ON SCREW POINT MAY HELP THREADING.

3) 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 RETAPPED



USING A #10 HAND TAP, NOT A DRILL. CONNECT THE SPRIPPERS TO THE BOTTOM CUT OFF BAR USING (4) 10-32 X ½ PHMS.

4) SECURE THE TOP STRIPPER TABS TO THE SIDE PANELS WITH (2) 10 X ¾ PH SMS *AFTER* THE TOP AND BOTTOM STRIPPERS ARE CONNECTED TO THE CUT OFF BAR. USE OIL ON SCREW THREADS.

5) ALIGN THE 3" TOP STRIPPER FINGER (C30 096.4TF) RACK 11 WITH REAR, OUTER EDGE OF THE TOP STRIPPER PLATE. COUNTERSINKS OUTWARD, ON CAM SIDE OF THE MACHINE. ALIGN THE BEVELED EDGE DOWNWARD AND UPPER EDGE EVEN WITH THE TOP STRIPPER, COUNTERSINKS OVER HOLES. HOLD 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).

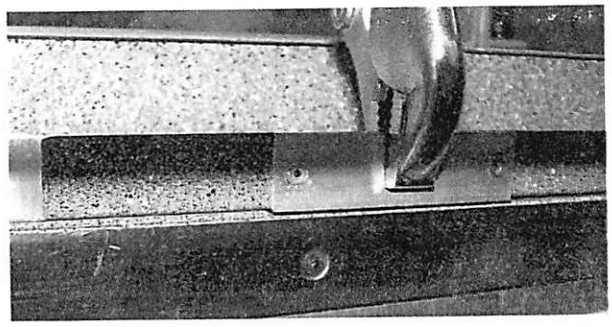
6) CONNECT (4) CABLE CLAMPS (PRC271) RACK 12 TO THE TOP SENSOR HOLDER (C30 270.4) AS16 ORIENTED WITH THE CABLE HOLDER LOOPS UPWARD, AND FIBER OPTIC CABLE THREAD, RIGHT OF CLAMPS. SECURE CABLE CLAMPS TO SENSOR HOLDER WITH (4) 8-32 X ¼ THMS, *SENSOR THREADS DOWNWARD.*

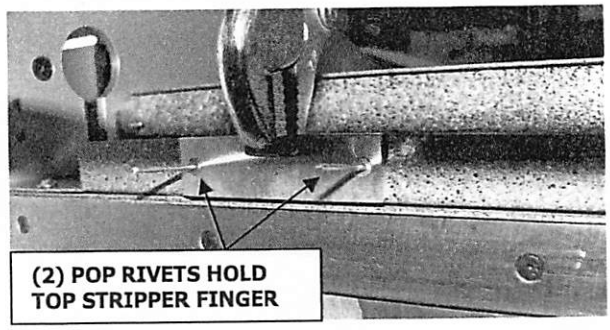
7) CONNECT TOP SENSOR ASSEMBLY BETWEEN SIDE PANELS. ORIENT CABLE CLAMP LOOPS UPWARD, BELOW RUBBER GROMMET. USE (4) ¼-20 X ¾ FHSH.

8) *COMPLETELY* 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.

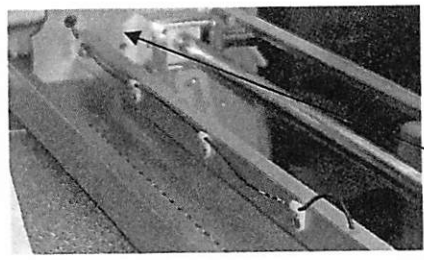
9) INSERT THE OPEN END OF THE FIBER OPTIC CABLE THROUGH THE CABLE CLAMP LOOPS AND THE RUBBER GROMMET IN THE LEFT SIDE PANEL.

10) ADD THE TOP 30" CUTTER RUBBER ROLL (C30 040.4) AS16 BETWEEN SIDE PANELS. ALIGN STRIPPER SLOTS, WITH

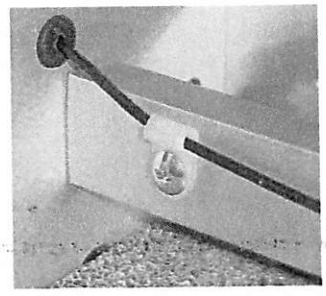


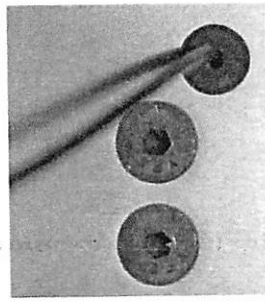


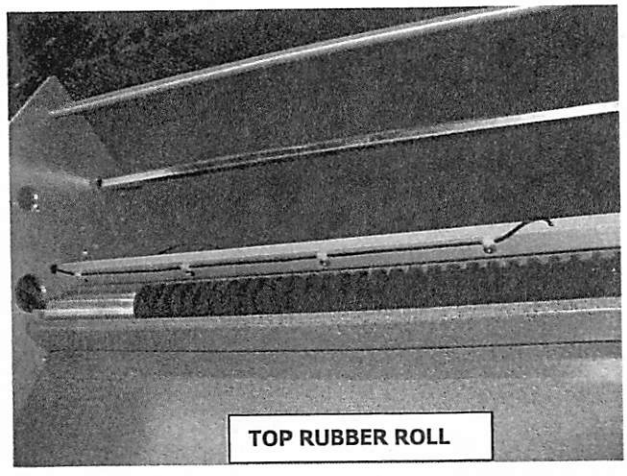
(2) POP RIVETS HOLD TOP STRIPPER FINGER



TOP SENSOR HOLDER & FIBER OPTIC CABLE IN CLAMPS & GROMMET







TOP RUBBER ROLL

THE JOURNAL KEYWAY ON LEFT SIDE.

11) ADD A TOP RUBBER ROLL SPACER (C25 045.4) RACK 11 ONTO BOTH ENDS OF THE JOURNAL, FITTING IN THE SIDE PANEL SLOTS.

12) SET A TEFLON WASHER (PRW337) RACK 8 ON THE *OUTER JOURNAL* ON SPACERS.

13) PREPARE A RUBBER ROLL PIVOT ARM LEFT (C25 056.4L) RACK 11 AND RUBBER ROLL PIVOT ARM RIGHT (C25 056.4R) RACK 11 AS FOLLOWS: ARBOR PRESS A ROLLER BEARING (PRB075) RACK 12 INTO THE RECESS OF BOTH PIVOT ARMS. SECURE EACH ROLLER BEARING WITH A ROTOR CLIP HO RING (PRC275) RACK 12. ARBOR PRESS (2) "WORKED" OILITE BEARINGS (PRB111A) RACK 12 INTO EACH PIVOT ARM, *MEASURED TO 1/16 ON THE INSIDE* (SIDE FACING SIDE PANEL) ON BOTH. THE INSIDE IS OPPOSITE THE ROTOR CLIP HO RING AND BEARING RECESS. SET ASIDE.

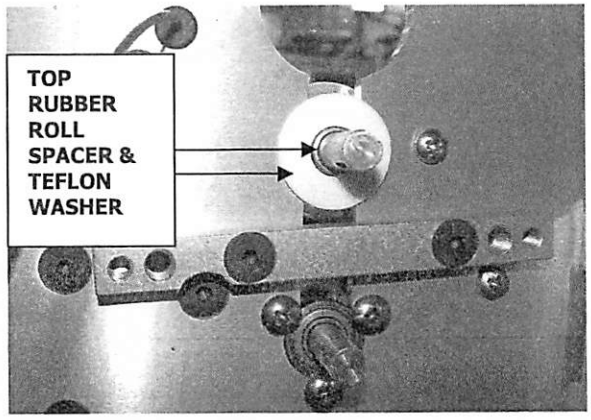
14) REMOVE BOTH SET SCREWS FROM (3) IDLER PULLEYS (PRG003) RACK 12 AND DISCARD. ARBOR PRESS A "WORKED" OILITE BEARING (PRB040A) RACK 12 INTO EACH PULLEY.

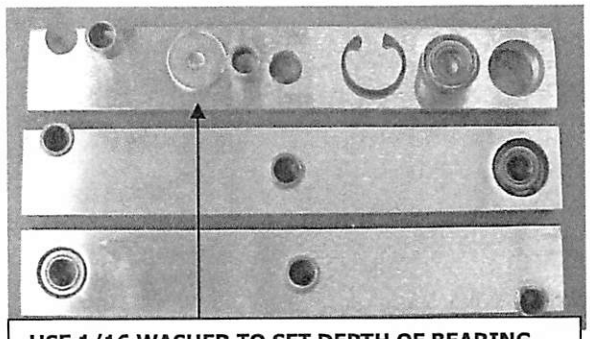
15) RETAIN 8 X 3/8 SET SCREW *ACROSS FROM THE KEYWAY* ON (3) RUBBER ROLL DRIVE PULLEYS (PRG002) RACK 12. REMOVE SET SCREW 90 DEGREES FROM KEYWAY AND DISCARD. SET ASIDE.

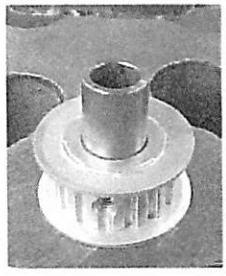
16) PREPARE (2) PRESSURE ROLL GUIDE (C25 120.4) RACK 11 ASSEMBLIES. FIRST, INSERT A ¼-28 X ½ SS INTO THE THREADED ENDS OF (2) PRESSURE ROLL GUIDES, *ONLY DOME SHOWS INSIDE*.

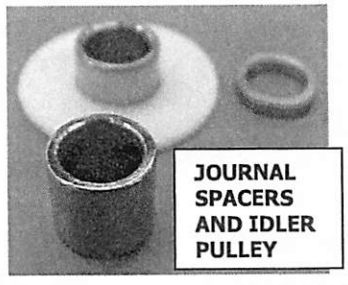
17) ARBOR PRESS (2) SPHERICAL BEARINGS (PRB101) RACK 12, ONE EACH INTO THE LARGER RECESS OF (2) WHITE TEFLON PRESSURE ROLL GUIDE BEARINGS (C25 121.4) RACK 11. *SPHERE ROLLS EASILY*.

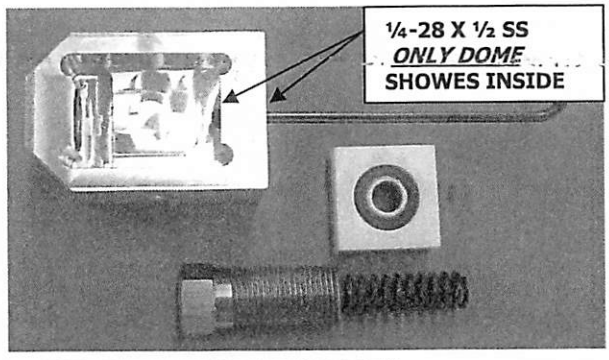
18) SET PRESSURE ROLL GUIDE BEARINGS INTO PRESSURE ROLL GUIDES, WITH

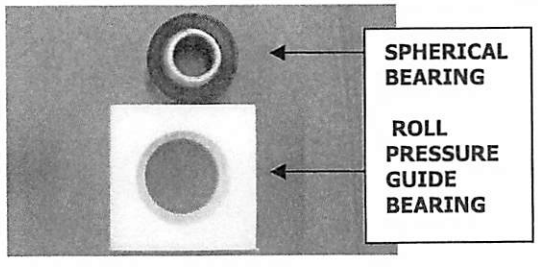












THE ENTIRE BEARING SHOWING OUTWARD. TEST BEARING MOVEMENT.

19) INSERT A BLACK PRESSURE SPRING (PRS243) RACK 2 INTO EACH OF (2) PRESSURE ROLL PRESSURE ADJUSTERS (C25 123.4) RACK 11.

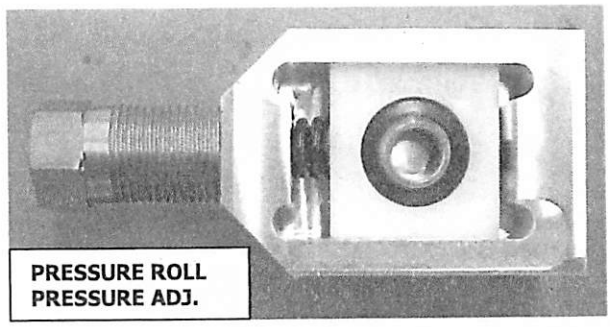
20) THREAD THE PRESSURE ROLL PRESSURE ADJUSTER WITH SPRING INTO THE END OF THE ROLL PRESSURE GUIDE AND GENTLY TIGHTEN ONTO THE TEFTON PRESSURE ROLL GUIDE BEARING. TOO MUCH FORCE CAN STRIP THREADS. THE PRESSURE ADJUSTER THREADS SHOULD JUST BE SHOWING ON INSIDE OF ROLL PRESSURE GUIDE. SNUG SET SCREW.

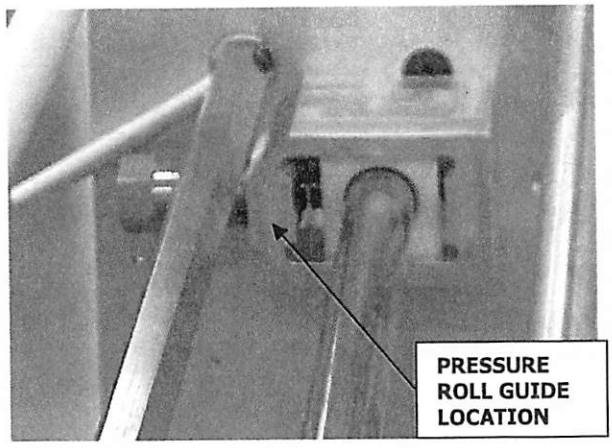
21) TEST THE ENDS OF A PRESSURE ROLL SHAFT (C30 122.4) LOFT 2 BY FITTING THEM INTO THE SPHERICAL BEARINGS OF THE PRESSURE ROLL GUIDE ASSEMBLIES. THE SHAFT SHOULD SPIN FREELY IN THE BEARINGS.

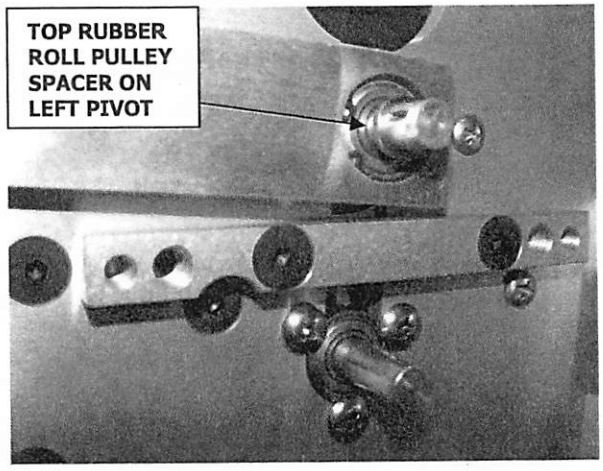
22) WITH THE PRESSURE ROLL SHAFT IN ONE OF THE SPHERICAL BEARINGS, CONNECT THAT PRESSURE ROLL GUIDE TO THE INNER SIDE PANEL, PLACING THE PRESSURE ROLL PRESSURE ADJUSTER UNDER THE RUBBER ROLL CAM SHAFT. USE (3) ¼-20 X ¾ FHSH. THEN SLIDE THE OTHER END OF THE PRESSURE ROLL SHAFT INTO THE OTHER SPHERICAL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

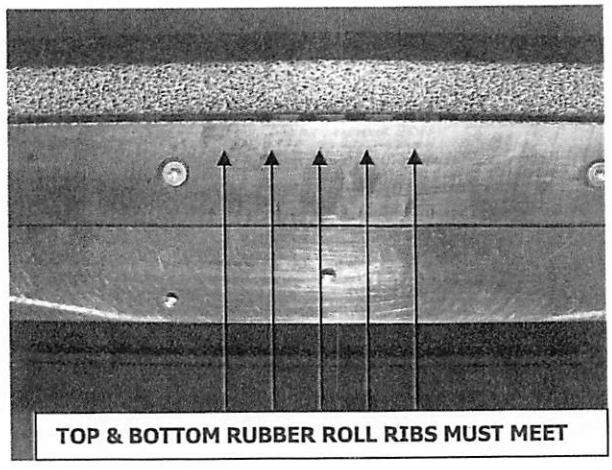
23) SLIDE THE ROLLER BEARING ON RIGHT AND LEFT PIVOT ARM ASSEMBLIES OVER THE TOP RUBBER ROLL JOURNAL, FLUSH WITH TEFLON WASHER, *RETAINING RINGS OUTWARD*. ORIENT THE REAR OILITE BEARING FACING UPWARD AND THE FLAT SIDE OF THE CAM RESTING ON THE OILITE BEARING.

24) ****WHEN TIGHTENING RUBBER ROLLS BETWEEN SIDE PANELS, IT IS CRITICAL THAT RIBS OF RUBBER ROLLS REMAIN 'DEAD NUTS' CENTERED FROM MIDDLE OUTWARD ON EACH OTHER! IF THEY ARE OFF, THE PAPER WILL SKEW.









25) ON <u>BOTH</u> LEFT AND RIGHT SIDES PLACE A THIN TOP RUBBER ROLL PULLEY SPACER (C30 046.4) RACK 11 ONTO THE <u>TOP RUBBER ROLL JOURNAL</u>, BY OUTER PIVOT ARM ROLLER BEARING.

26) ON <u>LEFT SIDE ONLY</u> PLACE A BOTTOM RUBBER ROLL PULLY SPACER (C30 047.4) RACK 11 ON BOTTOM RUBBER ROLL JOURNAL.

27) TAP (2) #303 WOODRUFF KEYS (PRK155) RACK 12 INTO THE TOP AND BOTTOM LEFT SIDE RUBBER ROLL JOURNAL KEYWAYS. YOU MAY NEED TO SAND KEYS.

28) SECURE THE TOP RUBBER ROLL DRIVE PULLEY (PRG002) OVER KEY, FLUSH WITH THIN SPACER BY OUTER PIVOT ARM BEARING, TIGHTEN ON JOURNAL.

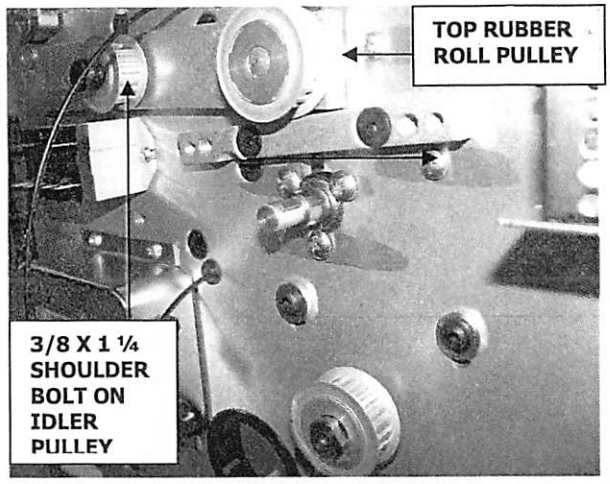
29) SECURE THE BOTTOM RUBBER ROLL DRIVE PULLEY (PRG002) OVER KEY, FLUSH WITH BOTTOM ROLL SPACER.

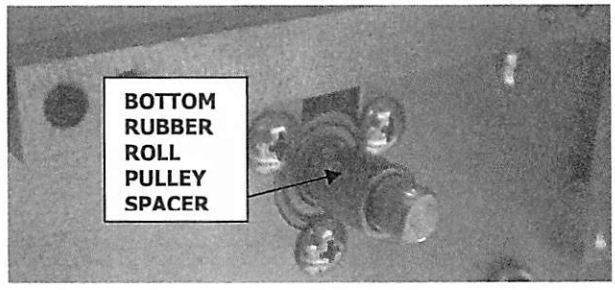
30) PLACE A 3/8 X 1¼ SHOULDER BOLT INTO AN IDLER PULLEY (PRG003). REAM WITH .3780 IF NECESSARY. **THE SIDE WITH EXCESS OILITE BEARING ALWAYS GOES <u>INWARD</u>. SECURE *<u>LEFT PIVOT ARM</u>* TO LEFT SIDE PANEL <u>THROUGH THE CENTER OILITE BUSHING</u>.

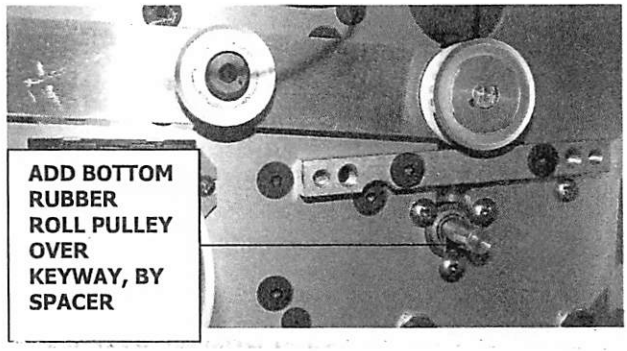
Reamer .3800

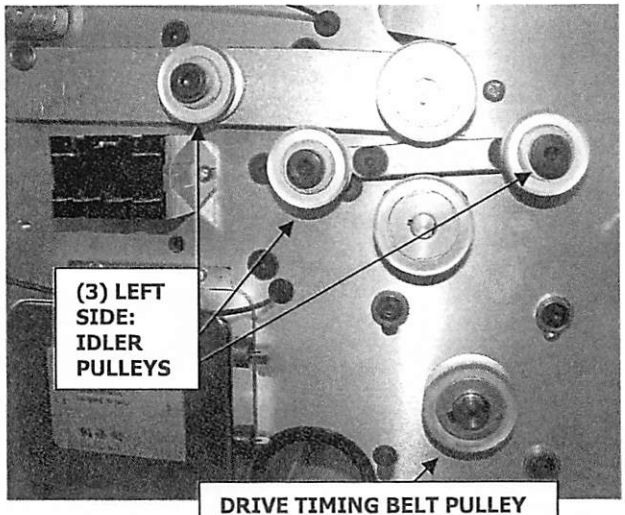
31) WITH THE HUB INWARD, SLIDE A RUBBER ROLL DRIVE TIMING BELT PULLEY (PRG021) RACK 13, *<u>WITH (2) SET SCREWS</u>*, OVER METRIC 5MM X 5MM MOTOR/DRIVE <u>KEY</u> (PRK192) AS02. MEASURE SPACE BETWEEN THE SIDE PANEL AND <u>OUTER EDGE OF THE HUB</u> ON THE RUBBER ROLL DRIVE TIMING BELT PULLEY USING A BOTTOM RUBBER ROLL PULLEY SPACER (C30 047.4) RACK 11 *<u>AS A GUIDE</u>*. TIGHTEN BOTH OF THE PULLEY SET SCREWS ON MOTOR SHAFT. *<u>REMOVE THE SPACER USED AS DISTANCE GUIDE</u>*.

32) ON THE LEFT SIDE INSERT A 3/8 X 5/8 SHOULDER BOLT THROUGH IDLER PULLEY (PRG003), SO THE THICKER SIDE OF THE OILITE BEARING IS INWARD



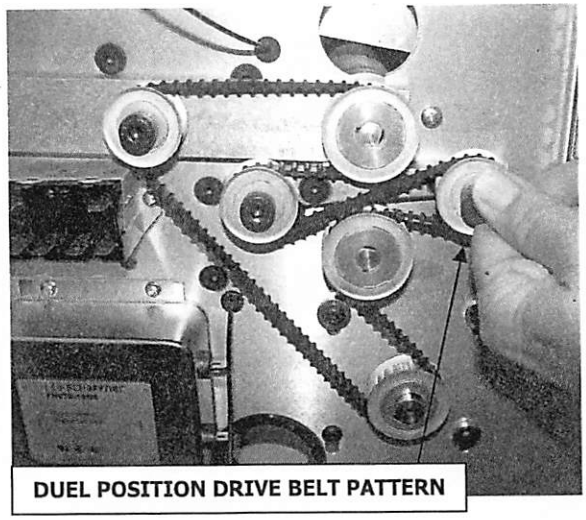






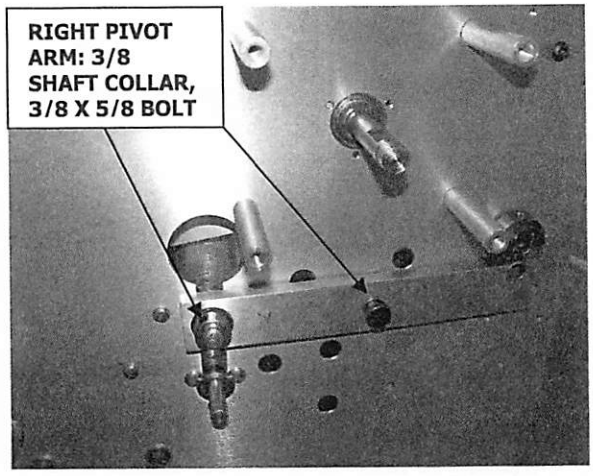
TOWARD DRIVE IDLER MOUNTING BAR. SECURE THE IDLER PULLEY TO THE DRIVE IDLER MOUNTING BAR ON REAR THREADS, ABOVE THE NOTCH ON BAR.

33) INSERT A 3/8 X 5/8 SHOULDER BOLT THROUGH ANOTHER IDLER PULLEY, WITH THE THICKER OILITE BEARING INWARD AND THREAD *LOOSELY* INTO THE FRONT DRIVE IDLER MOUNTING BAR THREADS. FOLLOW DIAGRAM AND WIND THE DUEL POSITION DRIVE BELT (PRB108) RACK 12 AROUND PULLEYS AND TIGHTEN USING THE 3/8 X 5/8 SHOULDER BOLT ON THE THIRD IDLER PULLEY. ADJUST BELT TENSION BY WEIGHT OF LOWERED STEPPER MOTOR. <u>THIS BELT SHOULD BE QUITE TIGHT</u>.



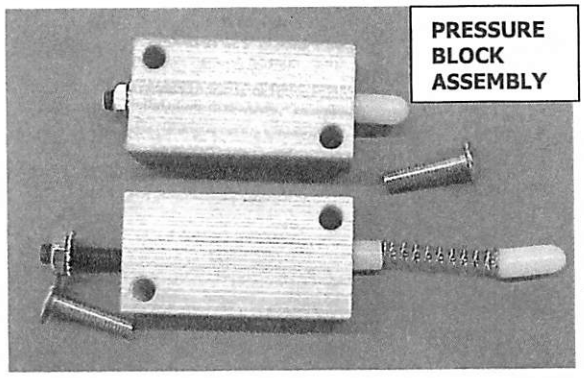
DUEL POSITION DRIVE BELT PATTERN

34) SECURE THE RIGHT SIDE TOP RUBBER ROLL JOURNAL TO THE PIVOT ARM *WITH THE THIN SPACER BETWEEN THEM.* SNUG A 3/8 BORE SHAFT COLLAR (PRC095) LD03 OVER JOURNAL. HOLD PIVOT ARM FLAT WITH SIDE PANEL AND TIGHTEN SHAFT COLLAR.

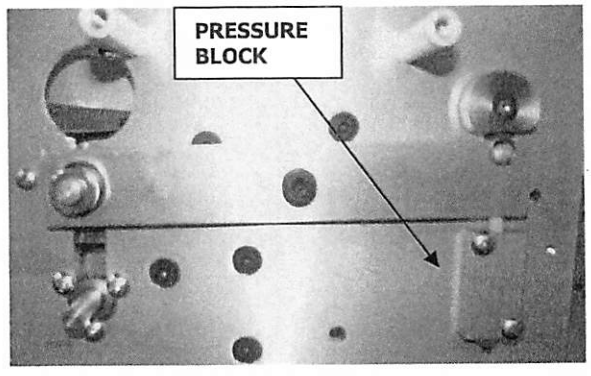


35) SECURE THE RIGHT PIVOT ARM TO THE RIGHT SIDE PANEL USING A 3/8 X 5/8 SHOULDER BOLT THROUGH THE MIDDLE OILITE BEARING.

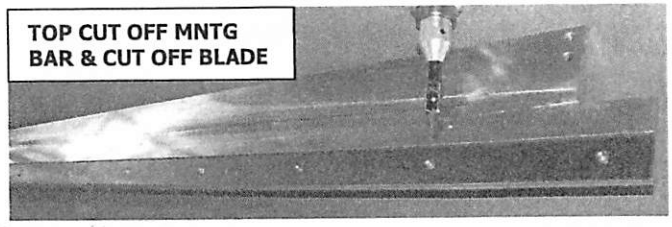
36) ASSEMBLE (2) PRESSURE BLOCKS (C25 213.4) RACK 11. FIRST THREAD A #10 KEPS HEX NUT ONTO A 10-32 X ¾ SET SCREW. LEAVE ABOUT THREE THREADS SHOWING ON SET SCREW END. INSERT INTO PRESSURE BLOCK END THREADS AND TIGHTEN KEPS WITH WRENCH. INSERT THE SMALLER WHITE PRESSURE ADJUSTMENT PLUNGER (C25 218.4) RACK 11 INTO THE OTHER END OF PRESSURE BLOCK. THEN INSERT A LEE SPRING (PRS221) RACK 12 AND A WHITE PRESSURE PLUNGER (C25 217.4) RACK 11.



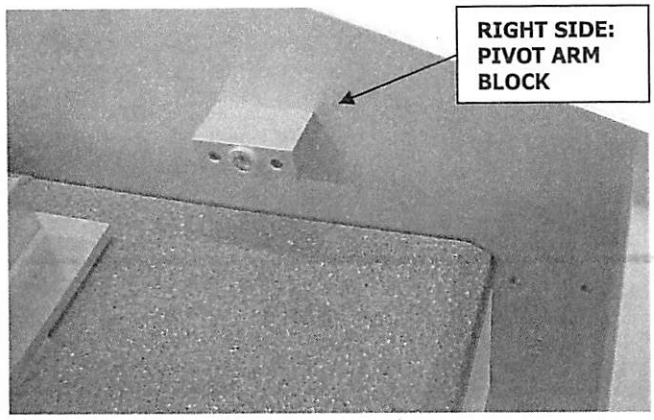
37) THE PRESSURE BLOCKS ARE SECURED TO THE SIDE PANELS WITH PRESSURE PLUNGER TOUCHING THE REAR OF PIVOT ARMS. USE (2) 10-32 X ¾ THMS ON EACH SIDE PRESSURE BLOCK.



38) FROM AS16 PREPARE THE TOP CUT OFF MOUNTING BAR (C30 115.4) BY ATTACHING THE CUT OFF BLADE (C30 400.4) ALONG FLAT SIDE INTO RECESS OF THE MOUNTING BAR USE (9) 6-32 X 5/8 FTORX AND A TORQUE SCREWDRIVER. ***BOTH EDGES OF THE BLADE ARE VERY SHARP***. SET ASIDE.

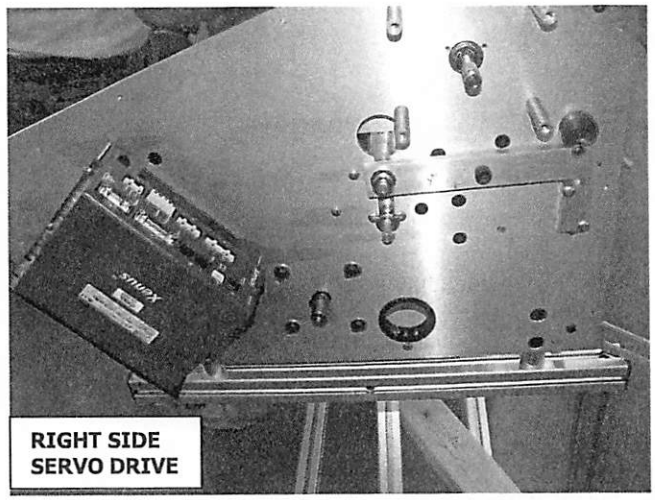


39) SECURE THE RIGHT SIDE PIVOT ARM BLOCK (C25 058.4) RACK 11 USING (2) ¼-20 X ¾ FHSH THROUGH OUTER SIDE PANEL COUNTERSINKS, OPPOSITE LEFT SIDE PIVOT ARM BLOCK.



40) ****AT THIS POINT, REFER TO C30 AUTOCUTTER GUILLOTINE, CUT OFF CAM SHAFT SECTION. COMPLETE THE CAM SHAFT SECTION ASSEMBLY AND INSTALL THE CUT OFF CAM SHAFT. THIS MUST BE DONE BEFORE THE TOP CUTTER BLADE ASSEMBLY IS SECURED.

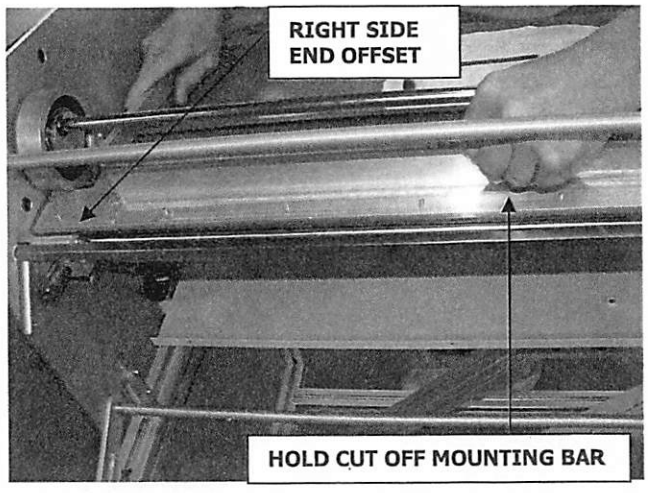
41) THE BIG BLUE COPLEY SERVO DRIVE (PRC0310) AS17 CAN BE SECURED TO THE RIGHT SIDE PANE, AT AN ANGLE WITH THE TERMINAL CONNECTIONS FACING UPWARD AND INWARD, ON THE OUTER SIDE PANEL. THE SERVO DRIVE SECURES OVER THE FLATHEAD SCREWS HOLDING THE RIGHT PIVOT ARM BLOCK. USE (4) 6-32 X 3/8 THMS TO SECURE THE SERVO DRIVE.



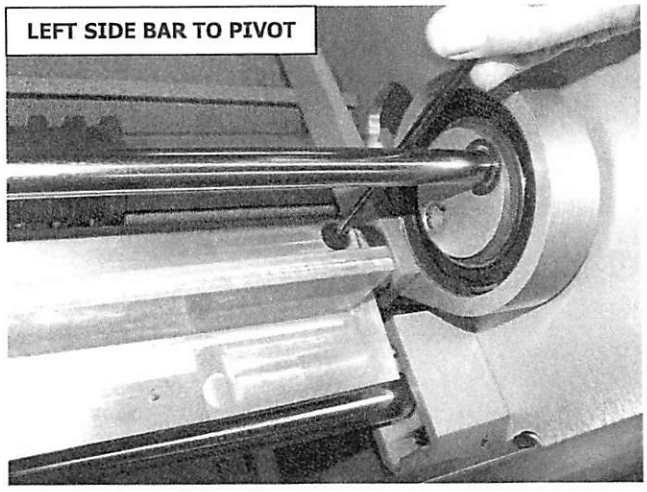
42) PREPARE TO INSTALL THE TOP CUT OFF MOUNTING BAR AND BLADE ASSEMBLY. IT IS SAFER AND HELPFUL TO ***USE TWO PEOPLE FOR THIS PROCESS***.

43) FROM THE CUTTER FRONT, PLACE AND ORIENT THE TOP CUT OFF MOUNTING BAR/BLADE ASSEMBLY UNDER THE CAMS ALIGNING THE MOUNTING BAR END OFFSET TOWARD THE RIGHT SIDE PANEL AND THE BLADE TO THE REAR.

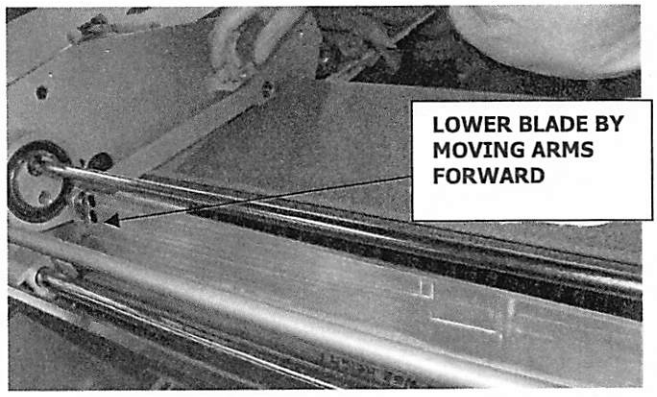
44) ALIGN AND HOLD THE MOUNTING BAR WITH RAISED CENTER PIECE. CAREFULLY LINE UP THE COUNTERSUNK OPENINGS ON TOP MOUNTING BAR WITH THREADS ON THE FLAT SIDE OF THE TOP CUT OFF MOUNTING PIVOTS. USE (4) ¼-20 X ¾ FHSH, STARTING THE

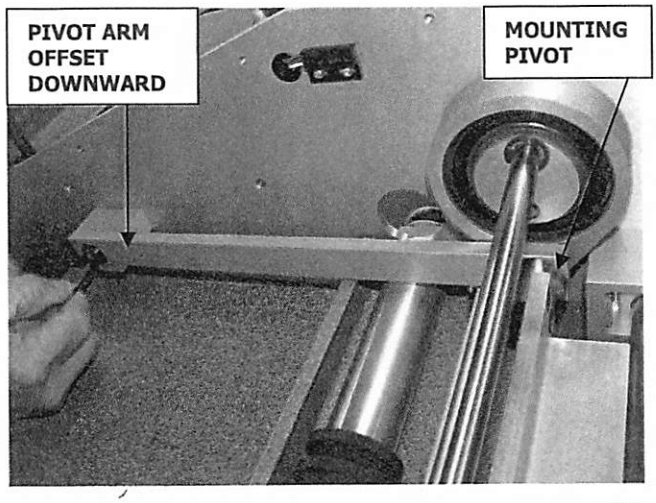


THREADS OF ONE ON EACH SIDE, THEN, TIGHTENING ALL FOUR SCREWS. TO LINE UP THE COUNTERSINKS WITH THE MOUNTING PIVOTS, MOVE PIVOTS BACK OR FORTH.

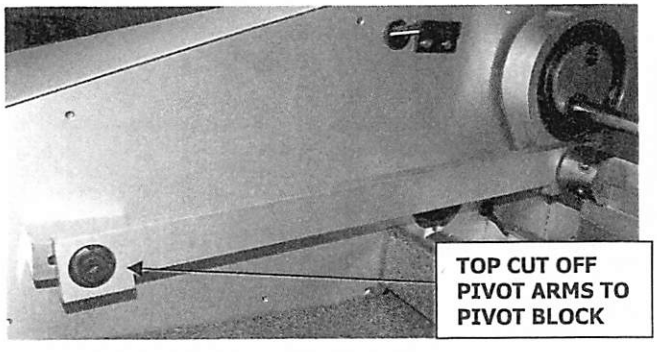


45) TO LOWER THE TOP CUT OFF BLADE, PLACING IT IN THE CUT OFF POSITION, MOVE THE RIGHT AND LEFT SIDES OF THE MOUNTING BAR ASSEMBLY FORWARD BY ADJUSTING PIVOT ARMS AND ROTATING CAMS AND DROPPING THE BLADE. BOTH SIDE CAMS MUST BE IDENTICAL. THE TOP CUT OFF BLADE IS LOCATED DOWNWARD AND BEHIND THE BOTTOM CUT OFF BLADE.

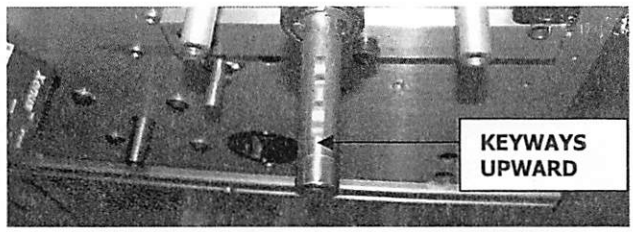




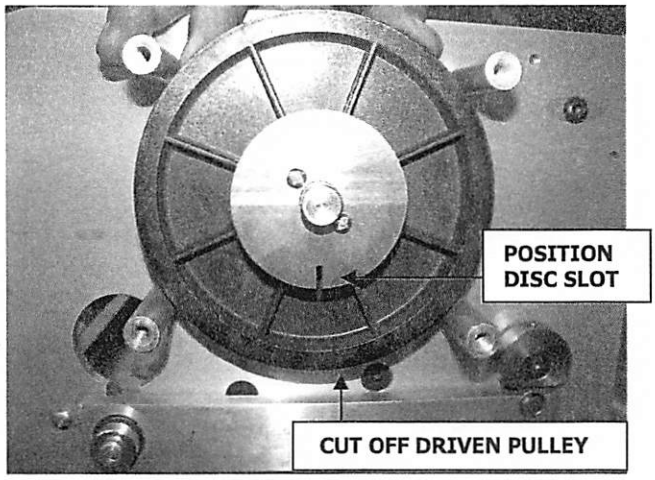
46) CONNECT THE ROLLER BALL BEARINGS IN THE FRONT END OF THE TOP CUT OFF PIVOT ARMS TO RIGHT AND LEFT SIDE PIVOT ARM BLOCKS USING A 3/8 X 3/8 SHOULDER BOLT THROUGH THE ROLLER BEARING IN THE TOP CUT OFF PIVOT ARM INTO THE PIVOT ARM BLOCK THREADS.



47) ON THE RIGHT SIDE OF THE CUTTER, BALANCE THE GUILLOTINE CAMS SO THE CUT OFF CAM SHAFT KEYWAYS ARE UPWARD. THIS MAY TAKE TWO PEOPLE. TAP (2) #3 WOODRUFF KEYS (MI03KEY) AS02 INTO THE KEYWAYS.

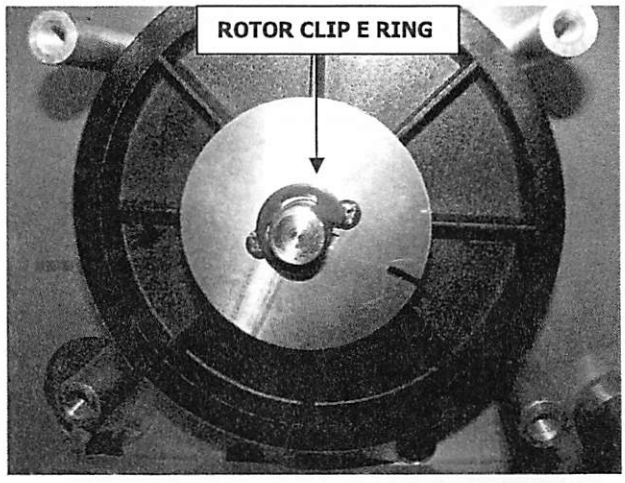


48) WITH A DROP OF LOCTITE ADDED TO THE (2) SET SCREWS IN THE HUB, SLIDE THE LARGE CUT OFF DRIVEN PULLEY (PRG019) RACK 13 OVER CUT OFF CAM SHAFT KEYS, ORIENTED WITH THE PULLEY *HUB AND SET SCREWS FACING OUTWARD, AWAY FROM RIGHT PANEL*. SLIDE DRIVEN PULLY ON JUST PAST OUTER SNAP RING GROOVE. DO NOT TIGHTEN PULLEY YET.



49) SLIDE A POSITION DISC (C30 202.4) RACK 13 OVER THE CUT OFF CAM SHAFT, SNUG TO CUT OFF DRIVEN PULLEY HUB. ORIENT OUTER SLOT ON THE POSITION DISC ***OPPOSITE*** KEYWAYS, WITH BLADE UP KEYWAY UP. THE OUTER SLOT IS FOR TIMING. SECURE THE POSITION DISC TO HUB OF CUT OFF DRIVEN PULLEY WITH (2) 6-32 X ¼ PHMS.

50) SECURE THE END OF THE CUT OFF CAM SHAFT WITH A ROTOR CLIP E RING (PRC270) RACK 12.

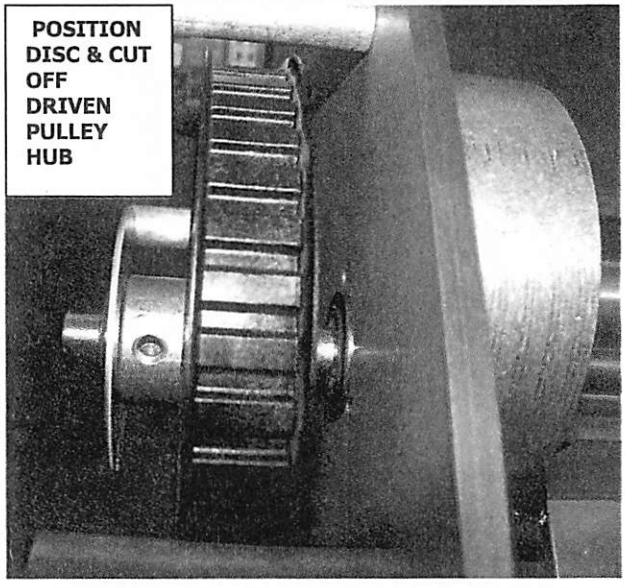


51) SLIDE THE POSITION DISC AND CUT OFF DRIVEN PULLY SNUG TO ROTOR CLIP E RING. THE HEADS OF THE 6-32 SCREWS ACT AS A SPACER BETWEEN ROTOR CLIP E RING AND POSITION DISC.

52) TIGHTEN THE (2) SET SCREWS ON HUB OF THE CUT OFF DRIVEN PULLEY ORIENTED TO THE FLAT OF THE CUT OFF CAM SHAFT.

53) THREAD THE TIMING BELT 322L050 (PRB251) RACK 12 ONTO THE TEETH OF THE CUT OFF DRIVEN PULLEY. THE BELT GOES INSIDE THE (3) SPACERS; THE TOP TWO AND THE REAR.

54) WITH THE PULLEY *HUB FACING INWARD*, PLACE THE TIMING BELT ON THE CUT OFF DRIVE TIMING BELT PULLEY (PRG020) RACK 13. SLIDE THE



CUT OFF DRIVE TIMING BELT PULLY ONTO THE MOTOR JOURNAL, OVER THE MOTOR KEY. **IF MOTOR DOES NOT HAVE A KEY IN THE KEYWAY, USE A 5MM X 5MM X 20MM METRIC KEY (PRK192) AS02.

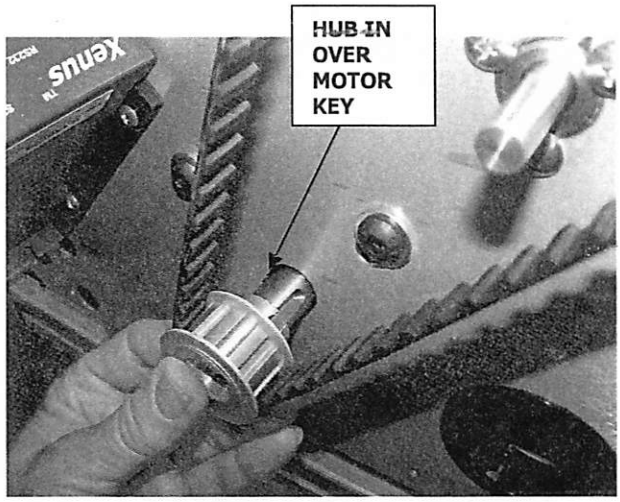
55) MEASURE THE DISTANCE FROM THE SIDE PANEL TO THE TIMING BELT ON THE LARGE CUT OFF DRIVEN PULLEY AND MEASURE THE DISTANCE FROM THE SIDE PANEL TO THE TIMING BELT ON THE CUT OFF DRIVE PULLEY. WHEN THE DISTANCE IS EQUIL, TIGHTEN THE (2) 8-32 X 3/16 SET SCREWS ON THE DRIVE PULLEY HUB. DO NOT OVER TIGHTEN AND STRIP THREADS.

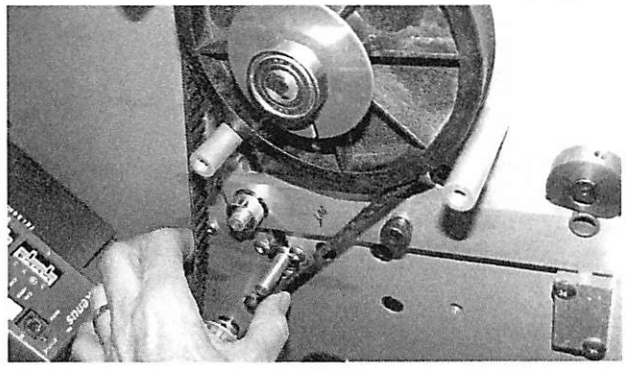
56) THE TENSION ON THIS BELT IS LOOSER THAN THE LEFT SIDE, ABOUT ½" ON EITHER SIDE OF CENTER.

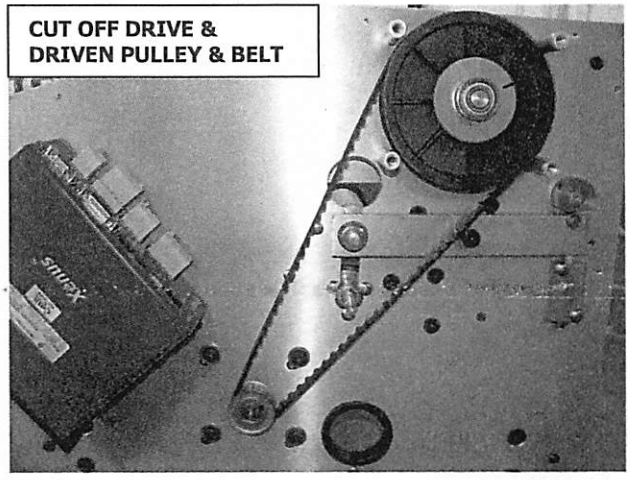
57) SLIDE A BALL BEARING (PRB038) RACK 21 ONTO END OF CUT OFF CAM SHAFT.

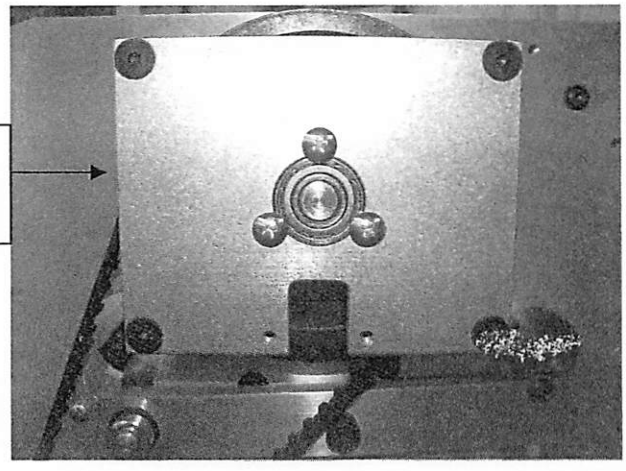
58) ALIGN A CAM SHAFT SUPPORT PLATE (C30 204.4A) RACK 11 ORIENTED WITH THE CUT OUT NOTCH DOWNWARD AND NOTCH COUNTERBORE INWARD. SLIDE THE CAM SHAFT SUPPORT PLATE OVER THE ROLLER BEARING ON CUT OFF CAM SHAFT. LOOSELY SECURE BALL BEARING WITH (3) 10-32 X ¼ THMS ON OUTER CAM SHAFT SUPPORT PLATE.

59) WITH THE CAM SHAFT SUPPORT PLATE NOTCH DOWNWARD START (4) ¼-20 X ¾ FHSH INTO THE (4) CAM SHAFT SUPPORT STANDOFFS. AFTER ALL FOUR ARE STARTED, TIGHTEN ALL OF THE FLATHEADS AND THEN TIGHTEN THE (3) TRUSSHEADS HOLDING THE ROLLER BALL BEARING.



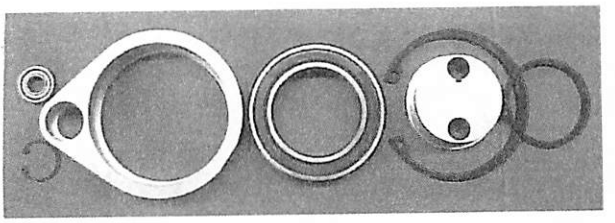




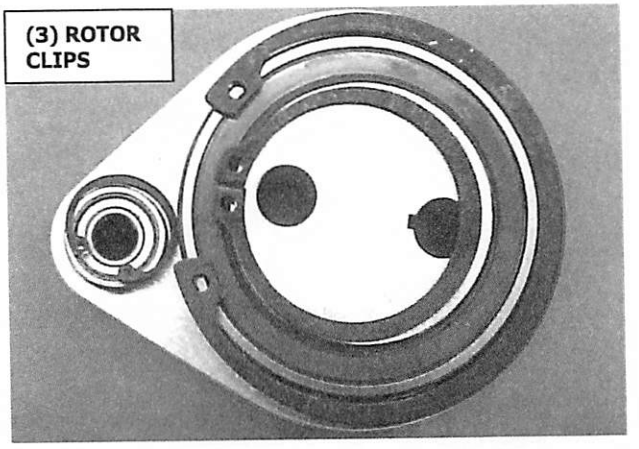


C30 AUTOCUTTER
GUILLOTINE, CUT OFF CAM SHAFT 2016

1) MAKE (2) GUILLOTINE CONNECTING BLOCK ASSEMBLIES: PRESS A R6ZZ 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 USING SNAP RING PLIERS.

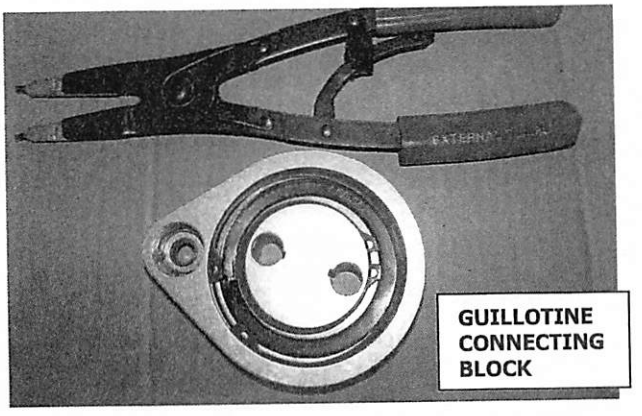


2) FROM RACK 12 PRESS A 6000 SERIES BALL BEARING (PRB106) INTO THE LARGER COUNTERBORED OPENING OF THE GUILLOTINE CONNECTING BLOCK. SECURE BEARING WITH A ROTOR CLIP HO RING (PRC274). USE HEAVY SNAP RING PLIERS WB09.

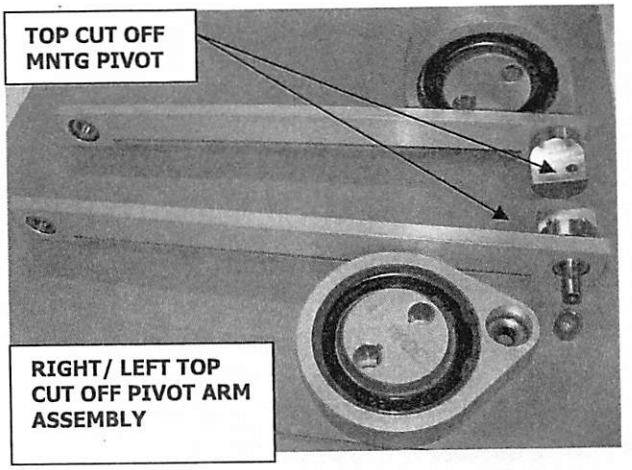


3) PRESS A GUILLOTINE CAM (C30 250.4) RACK 11 INTO A 6000 SERIES BALL BEARING, ***ALL (3) ROTOR CLIPS ARE ON THE SAME SIDE***. SECURE GUILLOTINE CAM WITH ROTOR CLIP SH RING (PRC273) RACK 12. EARLY CAMS HAD (1) KEYWAY, CURRENT CAMS HAVE (2) KEYWAYS.

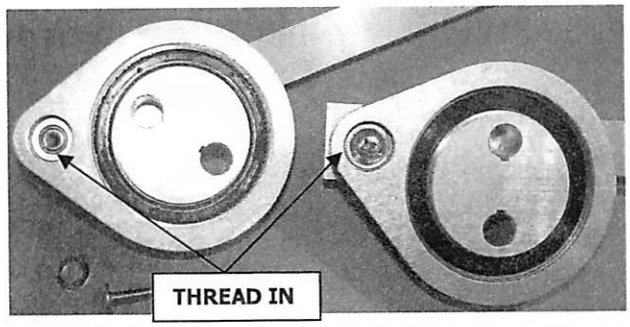
2) PREPARE A RIGHT AND LEFT TOP CUT OFF PIVOT ARM ASSEMBLY: ARBOR PRESS (4) ROLLER BEARING (PRB075) RACK 12 INTO THE RECESSED ENDS OF (2) TOP CUT OFF PIVOT ARMS (C25 057.4) RACK 11. SECURE THE BEARINGS WITH (4) ROTOR CLIP HO RINGS (PRC275) RACK 12.

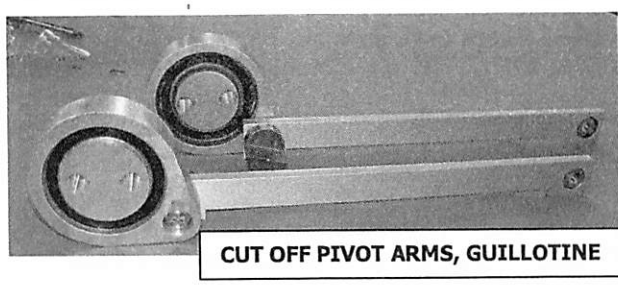


4) ORIENT THE OFFSET ENDS OF THE TOP CUT OFF PIVOT ARMS DOWNWARD ON A WORKTABLE, WITH THE ***ROTOR CLIP RINGS FACING INWARD***, TOWARD EACH OTHER. FROM THE INSIDE, INSERT THE SHAFT OF A TOP CUT OFF MOUNTING PIVOT (C25 116.4) RACK 11 THROUGH THE BALL BEARINGS OF THE RIGHT AND LEFT TOP CUT OFF PIVOT ARMS.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



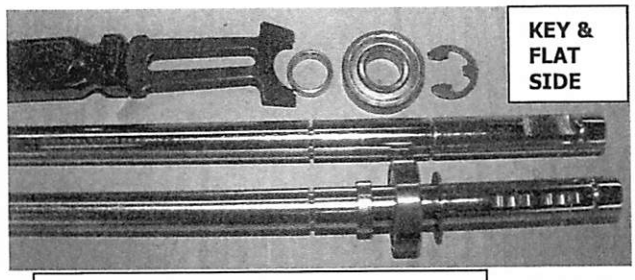
WITH THE ROTOR RINGS FACING INWARD. FROM THE OUTSIDE OF THE GUILLOTINE MOUNTING BLOCKS ADD A ¼ FLAT WASHER SAE AND SECURE THIS ASSEMBLY WITH A ¼-20 X ½ THMS INTO THE CUT OFF MOUNTING PIVOT SHAFT THREADS. THE SCREW WILL TIGHTEN THE ROLLER BEARING.





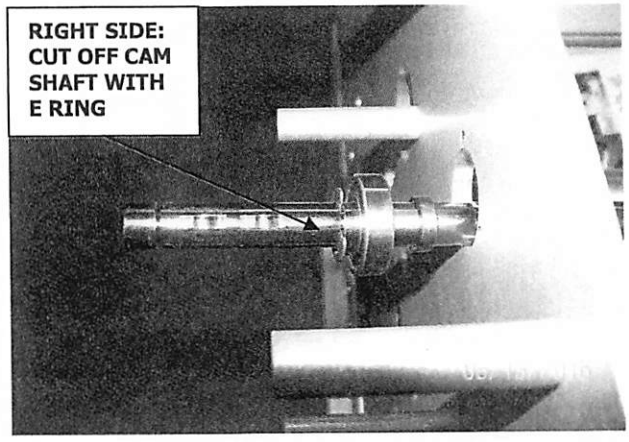
CUT OFF PIVOT ARMS, GUILLOTINE

5) BEFORE INSTALLATION, TEST THE R8ZZ BALL BEARING (PRB038) RACK 21 OVER THE 'NEW STYLE' CUT OFF CAM SHAFT (C30 253.4A) LOFT 2 TO SEE IF SHAFT NEEDS SANDING. IF SANDING IS REQUIRED WORK FROM THE END, PAST THE (3) SNAP RING GROOVES/RIGHT SIDE AND FLAT SECTION. SLIDE THE BALL BEARING PAST THE KEYWAYS. TEST BALL BEARING OVER THE OPPOSITE/LEFT SIDE END OF THE SHAFT, WHICH HAS (2) SNAP RING GROOVES AND KEYWAYS.



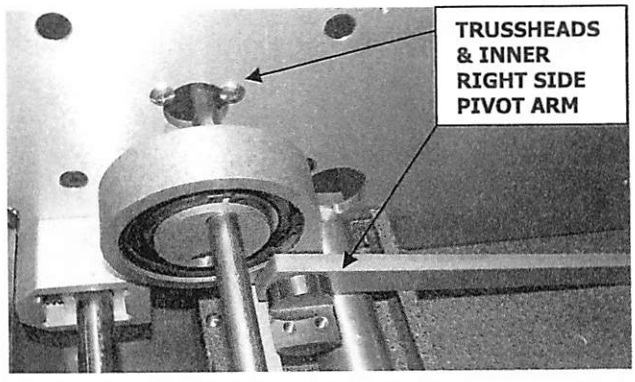
CAM SHAFT, SPACER, PRB038, E RING

6) SECURE A ROTOR CLIP E RING (PRC270) RACK 12 TO THE CENTER SNAP RING GROOVE OF A CUT OFF CAM SHAFT, FOR THE RIGHT SIDE OF THE CUTTER, WITH DOUBLE KEYWAYS. SLIDE A BALL BEARING (PRB038) DOWN THE LONG END OF THE CAM SHAFT BY SNAP RING. THEN ADD A CAM SHAFT SPACER (C25 252.4) RACK 11 BESIDE BALL BEARING.



7) TIGHTEN (3) 10-32 X ¼ THMS SCREWS WITH THE HEADS ON THE INNER RIGHT SIDE PANEL TO HOLD THE ROLLER BALL BEARING IN SIDE PANEL. LOOSELY THREAD (3) 10-32 X ¼ THMS OPPOSITE THESE ON THE INNER LEFT SIDE PANEL.

8) *FROM THE OUTER RIGHT SIDE PANEL* INSERT THE CUT OFF CAM SHAFT, LESS THAN *HALFWAY* ACROSS CUTTER. **BE SURE THERE IS A CUT OFF CAM SHAFT



SPACER BY BEARING. SLIDE THE RIGHT SIDE GUILLOTINE CAM WITH KEYWAYS ONTO THE CAM SHAFT. THE CUT OFF CAM SHAFT SPACER IS BETWEEN BEARING AND GUILLOTINE CAM. CUT OFF PIVOT ARMS FACE THE FRONT WITH OFFSET DOWN. THREADS ON TOP CUT OFF MOUNTING PIVOTS FACE UPWARD AND INWARD, UNDER THE SHAFT.

9) SLIDE ON THE LEFT SIDE GUILLOTINE CAM ASSEMBLY BY KEYWAYS, ARMS FORWARD, MOUNTING PIVOTS UPWARD AND INWARD UNDER SHAFT. INSERT CAM SHAFT THROUGH LEFT SIDE PANEL.

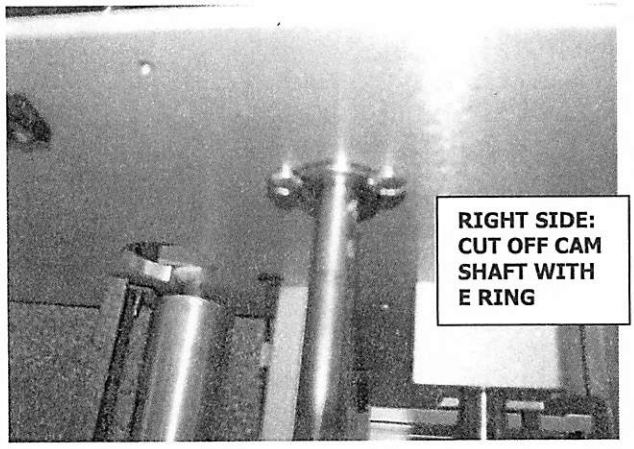
10) SNUG RIGHT SIDE BEARING INTO SIDE PANEL.

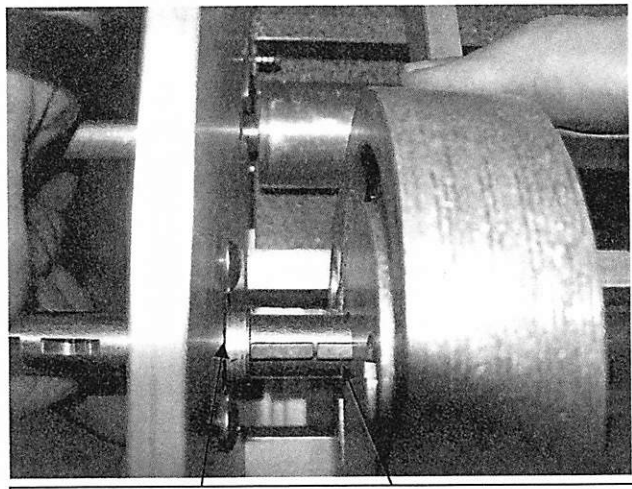
11) ON LEFT SIDE CAM SHAFT ADD ANOTHER CAM SHAFT SPACER AND BALL BEARING, SPACER INWARD. TIGHTEN (3) THMS.

12) WITH KEYWAYS UPWARD, TAP IN (4) #3 WOODRUFF KEYS (MI03KEY) AS02. ALIGN RIGHT SIDE GUILLOTINE CAM KEYWAY OVER KEYS AND SNUG TO SPACER. SECURE THE INNER CAM WITH ANOTHER ROTOR CLIP E RING.

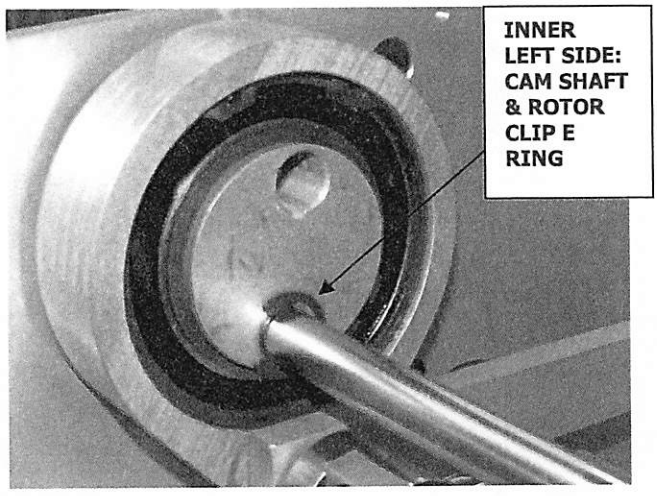
13) FROM OUTER LEFT SIDE SECURE A ROTOR CLIP E RING, THEN SNUG BALL BEARING INTO LEFT SIDE PANEL BY TIGHTENING TRUSSHEADS.

14) WITH CAM SHAFT SPACER ON INNER SIDE PANEL, SLIDE LEFT GUILLOTINE CAM KEYWAY OVER KEYS. SECURE ON INNER CAM WITH ROTOR CLIP E RING.





CUT OFF CAM SHAFT SPACER, (2) KEYS ON RIGHT SIDE





C30 AUTOCUTTER
SAFETY SHIELD 2015

1) BEFORE INSERTING THE SAFETY SHIELD (C30 074.4) AS16 TAP THE (4) CONNECTING TABS INWARD WITH A RUBBER MALLOT.

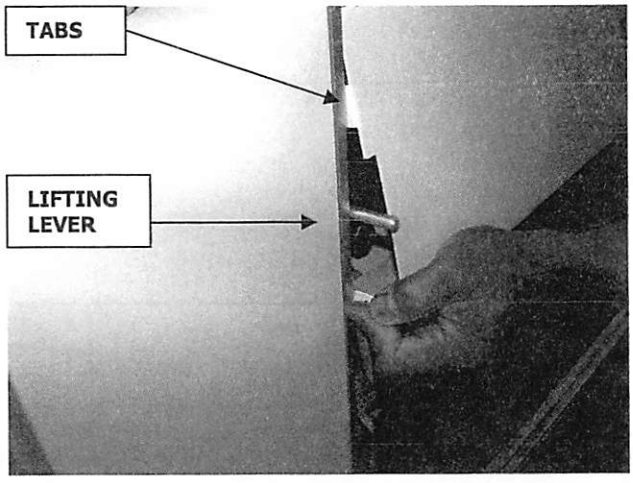
2) RAISE THE RUBBER ROLL LIFTING LEVERS TO ABOUT HALF WAY OPEN, SO THE LEVERS WILL FIT INTO THE CHANNELS IN THE REAR SECTION OF THE SAFETY SHIELD.

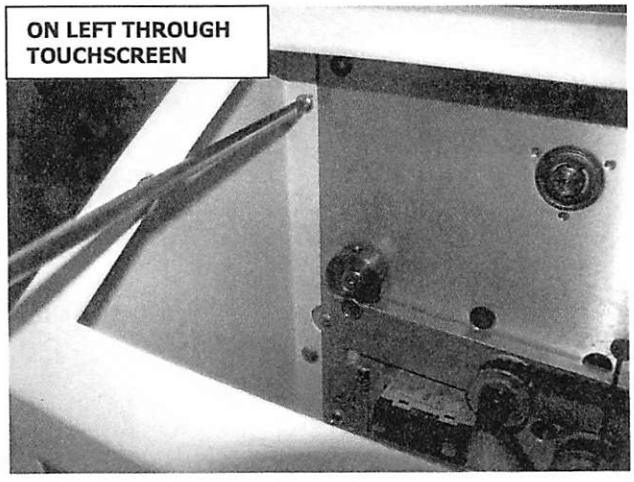
3) FROM THE REAR OF THE CUTTER, WHILE HOLDING THE SAFETY SHIELD IN THE OPEN POSITION, PLACE THE SAFETY SHIELD OVER THE GUILLOTINE ASSEMBLY. THIS MUST GO IN STRAIGHT TO AVOID SCRATCHING THE INNER SIDE PANELS.

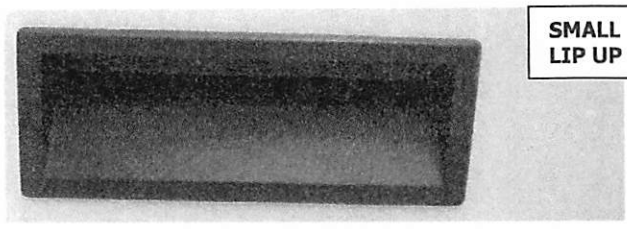
4) ALIGN THE TABS WITH THE REAR SIDE PANEL OPENINGS AND CONNECT THE SAFETY SHIELD MOUNTING TABS BETWEEN SIDE PANELS USING (4) 10 X ¾ PH SMS. OIL CAN BE PLACED ON THE SCREW THREADS TO HELP THREADING. THE HOLES ARE LOCATED IN TOP REAR SIDE PANEL OPENINGS AND BEHIND THE PIVOT ARMS.

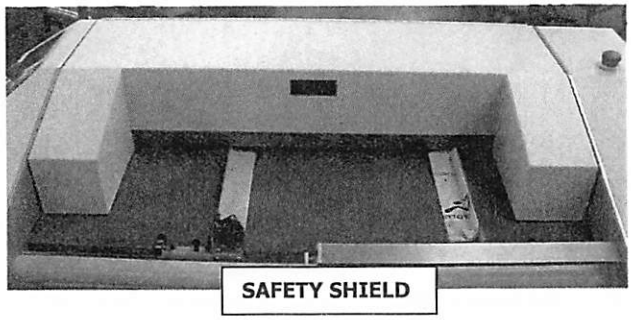
5) LOWER THE SAFETY SHIELD ONTO THE BOTTOM STRIPPER. SNAP THE POCKET PULL FLUSH HANDLE (PRH150) RACK 12 INTO THE CUT OUT OPENING OF THE FRONT, CENTER ON THE SAFETY SHIELD, AFTER YOU ALIGN THE POCKET PULL FLUSH HANDLE WITH THE SMALLER LIP UPWARD.

6) LIFT THE SAFETY SHIELD COVER AND COUNTERSINK (2) LEFT SIDE HOLES





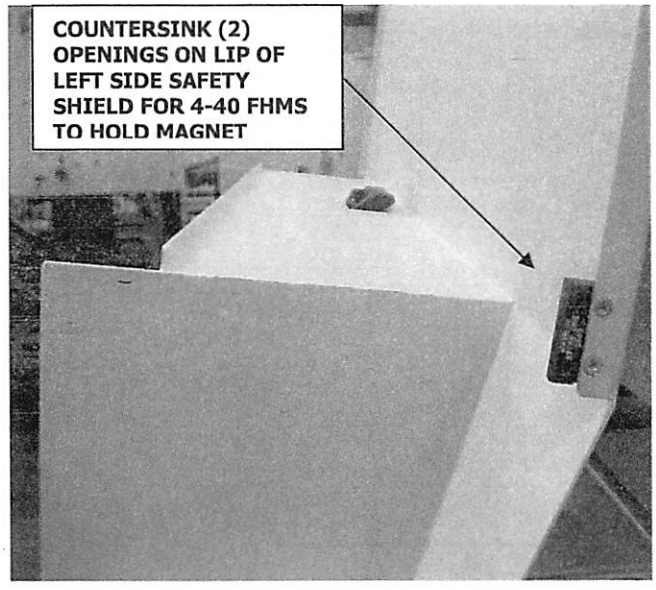


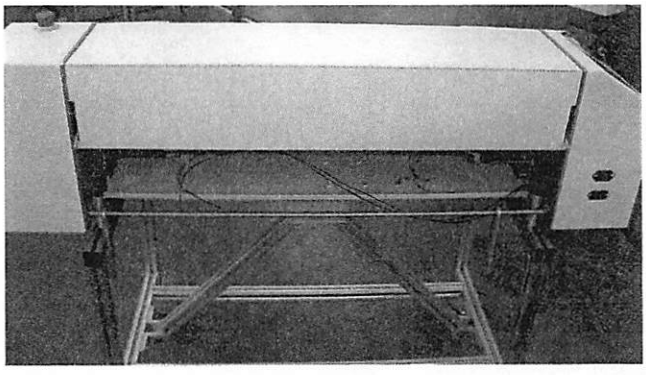


FROM THE OUTER LIP TO ACCOMMODATE 4-40 FHMS.

7) SECURE A PROXIMITY MAGNET (PRS352) RACK 1 TO THE COUNTERSUNK SAFETY SHIELD LIP. USE (2) 4-40 X 3/8 FHMS AND (2) 4-40 HEX NUTS. DON'T OVER TIGHTEN.

8) CLOSE THE SAFETY SHIELD COVER TO CHECK PROXIMITY MAGNET ALIGNMENT WITH POSITION SENSOR ON INNER SIDE PANEL. BE CERTAIN NOTHING SCRATCHES SIDE PANELS WHEN SAFETY SHIELD OPENS OR CLOSES.

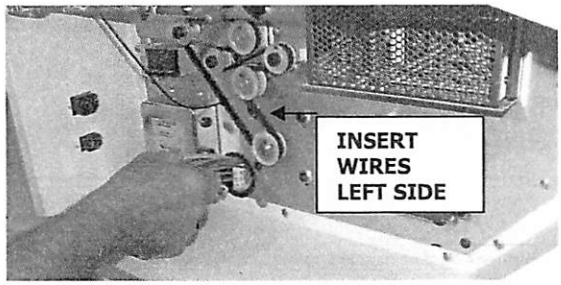




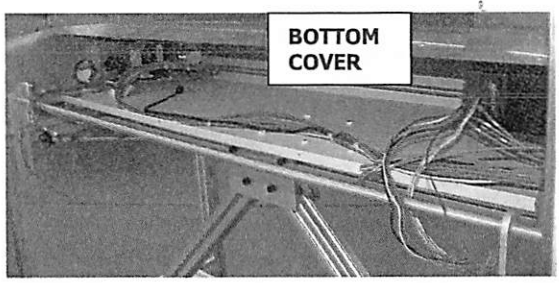
REAR OF SAFETY SHIELD

C30 AUTOCUTTER WIRING 2017

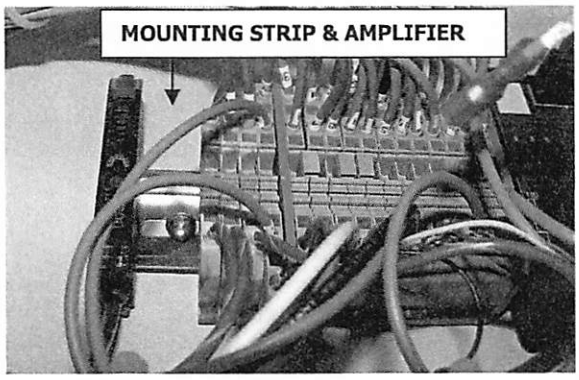
1) OPEN AND REMOVE WIRING HARNESS BAG FOR 30" AUTOCUTTER (PRW369) AS12. SEVERAL COMPONENTS ARE ALREADY WIRED AND ATTACHED TO THE HARNESS. BE GENTLE SO NONE OF THE CONNECTIONS BECOME LOOSE. SET THE SMALL BAG #1 ASIDE.



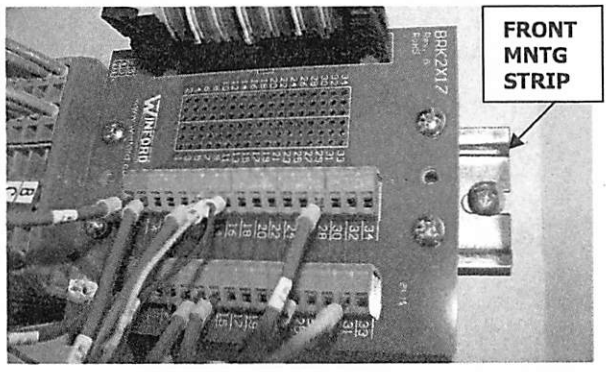
2) FROM THE LEFT CUTTER SIDE, INSERT THE LONGER WIRES THROUGH SNAP BUSHING. WIRE CONNECTIONS FOR THE LEFT SIDE MOTOR WIRES LAY ON THE BOTTOM COVER. THE WIRED PLUGS, BROWN/GRAY/RED SET AND YELLOW/ORANGE/GRAY SET OF POTENTIOMETER WIRES WILL EXIT THE RIGHT SIDE PANEL. ORIENT (3) BUNDLES UP SIDE PANEL, RIGHT OF PULLEYS, BEHIND MOUNTING BRACKETS: #23, 24 & 30-34; 28, 29; 15, 16 & 14, 17 & 19.



3) TO SECURE THE WINFORD BREAK OUT BOARD WITH WIRED TERMINALS LOCATED ON THE 'DINRAIL' MOUNTING STRIP IN THE HARNESS. FIRST, ORIENT WITH THE RIBBON CABLE INWARD, TOWARD SIDE PANEL.

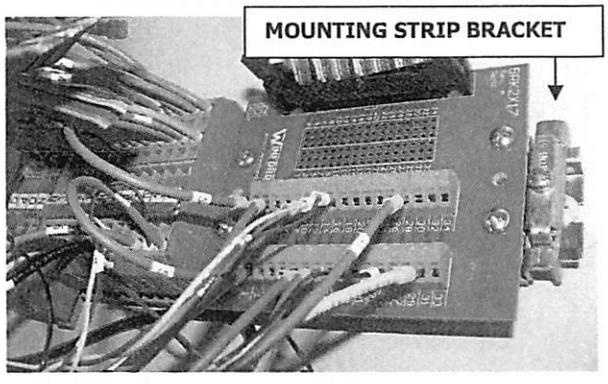


4) REMOVE THE END MOUNTING BRACKETS ON THE MOUNTING STRIP AND SLIDE BRACKETS OFF. THE BRACKETS HOLD THE COMPONENTS ON THE MOUNTING STRIP TOGETHER. SLIDE THE REAR AMPLIFFIER OUTWARD TO EXPOSE SLOTS IN MOUNTING STRIP. ***START*** THE THREADS OF AN 8-32 X ¼ THMS THROUGH THE MOUNTING STRIP CHANNEL INTO BOTTOM HOUSING.

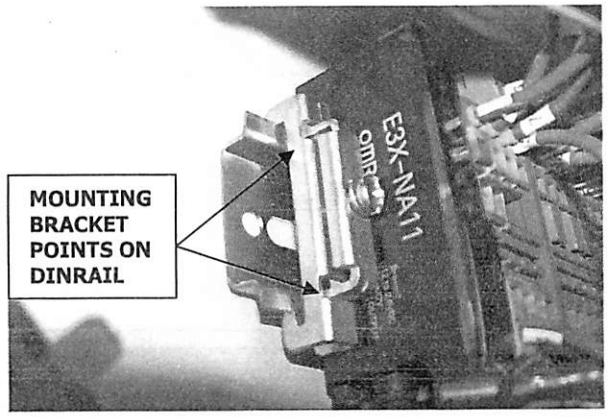


5) ALIGN AND SECURE THE FRONT OF THE MOUNTING STRIP FIRST, WITH AN 8-32 X ¼ THMS IN THE CHANNEL. THEN, TIGHTEN THE REAR 8-32 X ¼ THMS.

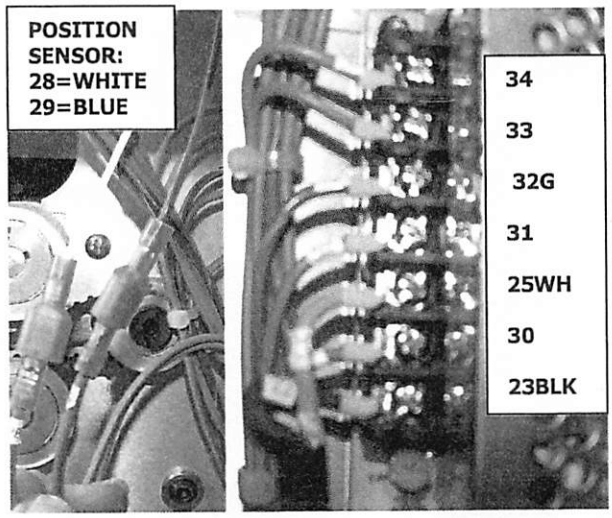
6) SLIDE THE AMPLIFIER OVER THE TRUSSHEAD, NEXT TO THE GROUND WIRE COMPONENTS.



7) REPLACE BOTH MOUNTING STRIP BRACKETS, ALIGNING POINTS ON UPPER SECTION OF BRACKET WITH THE RAIL ON THE MOUNTING STRIP. TIGHTEN THE BRACKET SCREW ON BOTH ENDS, NEXT TO THE COMPONENTS.

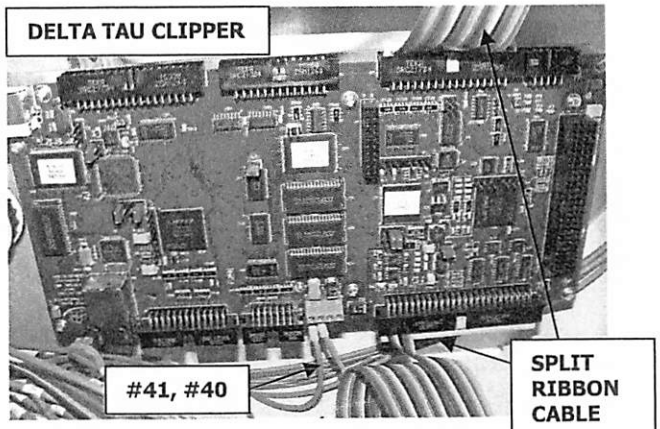


8) FOLLOW THE PRW369 C30 110V WITH SERVO WIRING DIAGRAM. WIRE 24V DC POWER SUPPLY, FROM TOP TO THE BOTTOM. THE HARNESS WIRES ARE NUMBERED TO MATCH THE WIRING DIAGRAM LOCATION. LOOSEN SCREWS ON CLAMP TERMINALS AND INSTERT THE FERRULE TERMINAL UNDER THE CLAMP AND TIGHTEN SCREW. FROM TOP TO BOTTOM THE NUMBERS ARE: #34, #33, #32, WHICH IS A GREEN WIRE, #31, #25 WHICH IS WHITE #30, #23 WHICH IS BLACK. ALL WIRES ***EXCEPT*** #25, #23 & #32 ARE BROWN.

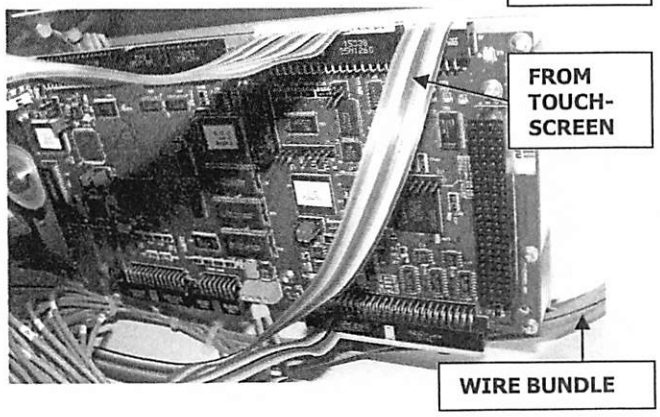


9) CONNECT THE BROWN WIRES WITH RED FEMALE ENDS TO THE POSITION SENSOR WIRES: #28 BROWN WIRE CONNECTS WITH THE WHITE POSITION SENSOR WIRE AND #29 BROWN WIRE CONNECTS WITH THE BLUE POSITION SENSOR WIRE.

10) CONNECT FERRULE ENDS ON WIRING HARNESS WITH THE GREEN TERMINAL BLOCK ON THE DELTA TAU CLIPPER CONTROLLER. IT IS EASIER TO REMOVE THE CONTROLLER FROM THE SIDE PANEL FIRST. LOOSEN THE FIRST TWO SMALL CAPTIVE SCREWS, FROM THE LEFT/REAR. INSERT THE BROWN #41 WIRE INTO THE OUTER/REAR OPENING. INSERT BROWN #40 INTO THE NEXT OPENING. TIGHTEN THE SMALL CAPTIVE SCREWS ON THE FERRULE TERMINALS.



11) LAY THE REMAINDER OF WIRE BUNDLE THAT JUST SECURED TO THE GREEN TERMINALS TOWARD THE FRONT. OVER THAT BUNDLE, INSERT THE RIBBON CABLE WITH SMALLER SPLIT SECTION OF RIBBON TO ***LOWER FRONT*** OF THE DELTA TAU CLIPPER. ALIGN KEY WITH KEY SLOT IN FRONT AND PRESS IN TERMINALS. CONNECT LARGER SECTION OF THE RIBBON CABLE TO ***UPPER FRONT***



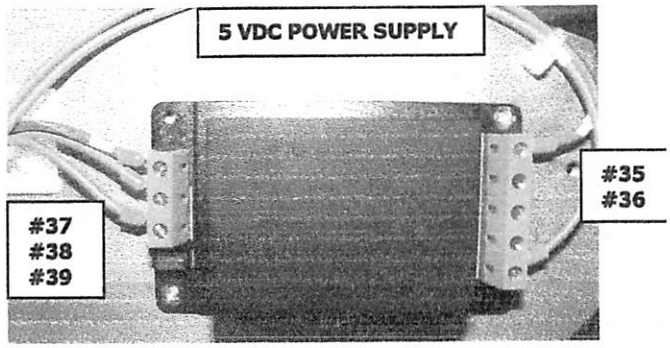
OF THE CONTROLLER, FITTING THE KEY IN THE KEY SLOT.

12) IN THE FRONT SECTION OF THE CUTTER IS THE 5 VOLT POWER SUPPLY. LOOSEN THE SCREWS ON (5) TERMINALS. SECURE THE FERRULE TERMINALS IN THE REAR FIRST, WORKING FROM THE TOP POST DOWNWARD. THE GREEN WIRE #37 IS FIRST, #38 WIRE IS IN THE MIDDLE TERMINAL AND #39 WIRE IS ON THE LOWER POST. TIGHTEN THE CAPTIVE SCREWS. RUN THE REMAINING (2) BROWN WIRES OVER THE TOP OF THE 5 VOLT POWER SUPPLY. CONNECT TO THE TOP #35 WIRE AND THE BOTTOM #36 WIRE. MIDDLE (3) ARE EMPTY.

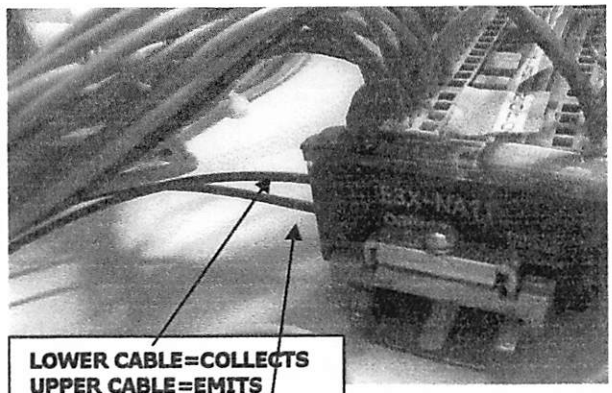
13) THE SENSOR EYE AMPLIFIER IS LOCATED ON THE REAR MOUNTING STRIP. OPEN THE COVER BY DISCONNECTING THE SNAP UNDERNEATH IT, LOCATED INWARD. OPEN THE SENSOR CONNECTION HOLES IN THE REAR OF THE AMPLIFIER BY PULLING UP THE PLASTIC TAB. MEASURE THE FIBER OPTIC CABLE CONFORMING TO THE PATH ON THE WIRING DIAGRAM. THE CABLES WILL PRESS CLIP TO THE POWER FILTER, THEN RUNNING UNDER THE WIRING HARNESS TO THE AMPLIFIER.

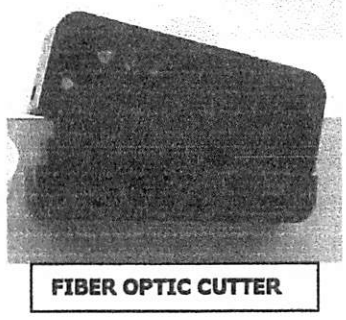
14) CUT F/O CABLE WITH TOOL SUPPLIED. USE ANY OF THE THREE LARGER HOLES TO CUT THE FIBER OPTIC CABLE BUT USE EACH HOLE ONLY ONCE. INSERT THE <u>UPPER FIBER OPTIC CABLE</u> INTO THE LOWER LIGHT "EMIT ARROW" AMPLIFER OPENING. INSERT <u>LOWER FIBER OPTIC CABLE</u> INTO THE UPPER LIGHT "COLLECT ARROW" AMPLIFIER OPENING. PUSH BOTH CABLES IN SNUGLY AND SNAP THE LOCKING TAB CLOSED. REPLACE COVER ON AMPLIFIER.

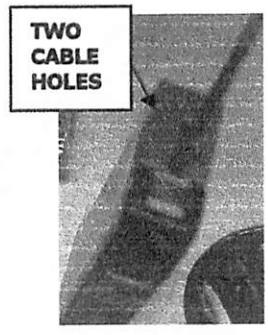
15) PRESS CLIP AND TIE THE FIBER OPTIC CABLES TO THE POWER FILTER. RUN CABLES UNDER HARNESS CONNECTIONS FOR RELAY AND RECEPTICLES.











16) CONNECT REAR RELAY WITH FULLY INSULATED WIRES FROM HARNESS: RELAY #1 WITH BROWN WIRE #10, RELAY #0 WITH BROWN WIRE #9, RELAY #2 WITH BLACK WIRE #7 AND RELAY #4 WITH BLACK WIRE #8. RELAY #6 AND #8 ARE NOT USED.

17) CONNECT THE BROWN WIRES TO THE QUICK DISCONNECT PLUG: THE INNER 'L' TERMINAL POST INDICATION ON THE PLUG RECEIVES #13 BROWN WIRE AND THE OUTER 'N' TERMINAL POST INDICATION ON THE PLUG RECEIVES #11 BROWN WIRE.

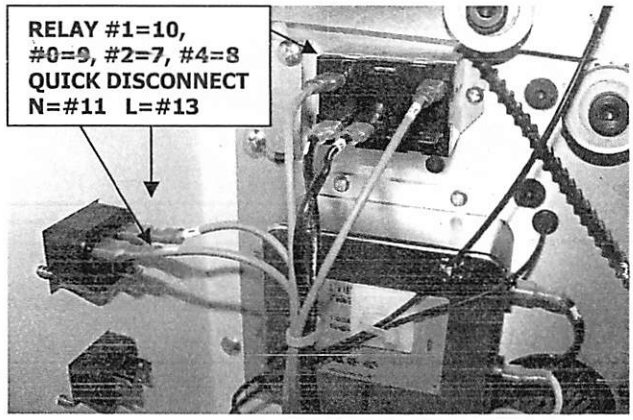
18) WIRE THE IN/OUT POWER SUPPLY LOCATED IN THE REAR LEFT HOUSING. LOOSEN THE SCREWS HOLDING THE CLAMP TERMINALS AND SECURE THE FERRULE ENDS AS FOLLOWS WIRING FROM INNER SCREW OUTWARD: INNERMOST #48, NEXT #47, #46 IS GREEN WIRE, FOLLOWED BY #45 AND #16 IS THE OUTERMOST WIRE.

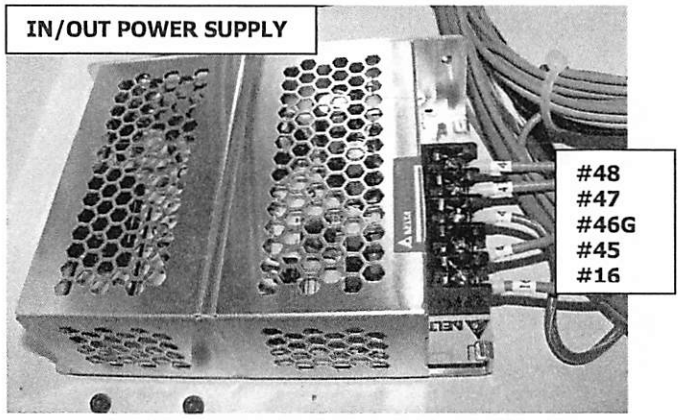
19) FROM BAG WIRES CONNECT THE GREEN GROUND #12 TO QUICK DISCONNECT LOWER TERMINAL POST. CONNECT THE GREEN GROUND #3 WIRE TO LOWER POWER CORD RECEPTACLE. CONNECT 5" GREEN GROUND #68 TO POWER FILTER.

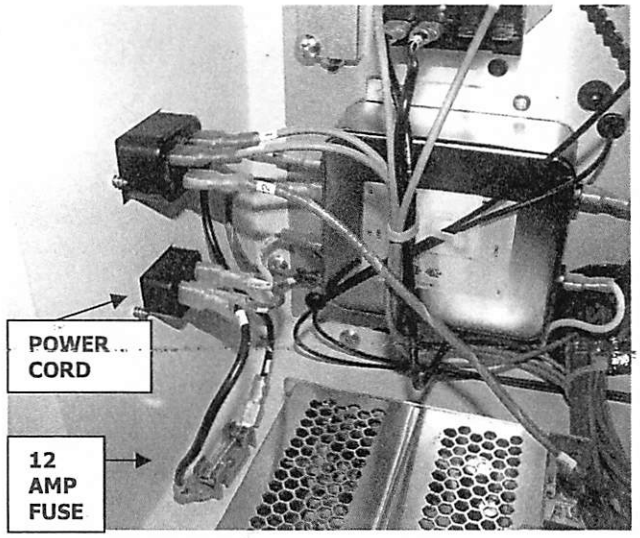
20) CONNECT 7" BLACK WIRE #4 BETWEEN INNER 12 AMP FUSE POST AND UPPER POWER FILTER <u>LINE</u> 'P' POST. FROM HARNESS, <u>LOAD</u> 'P' BLACK WIRE #6 AND 'N' WHITE WIRE #5. CONNECT 4" BLACK #2 BETWEEN OUTER 12 AMP FUSE POST AND OUTER RECEPTACLE 'L' POST.

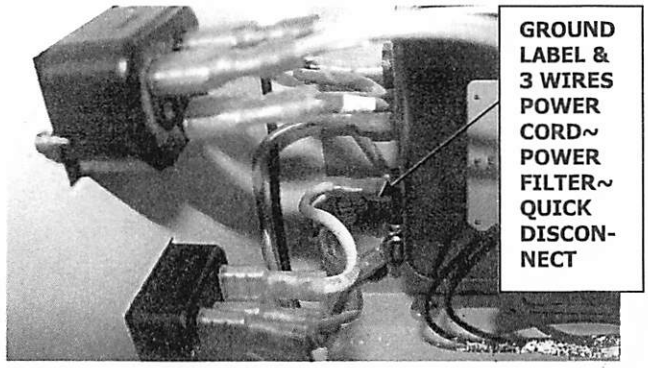
21) CONNECT 3 ½" WHITE #1 BETWEEN 'N' POST ON POWER FILTER <u>LINE</u> SIDE AND INNER 'N' RECEPTACLE POST.

22) PLACE A #10 STAR WASHER ON THE GROUND SCREW BY THE LOWER REAR POWER FILTER. SECURE THE GREEN GROUND POWER CORD RECEPTACLE WIRE WITH A #10 HEX NUT. ADD THE GREEN GROUND QUICK DISCONNECT WIRE, GREEN GROUND POWER FILTER WIRE AND ANOTHER #10 HEX NUT.

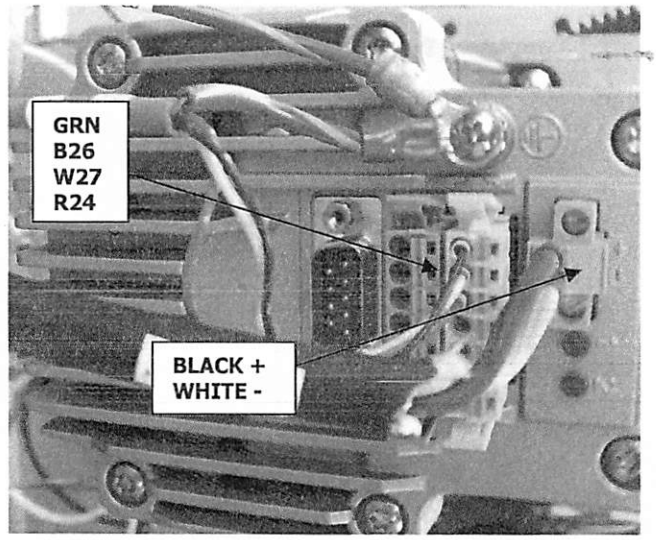




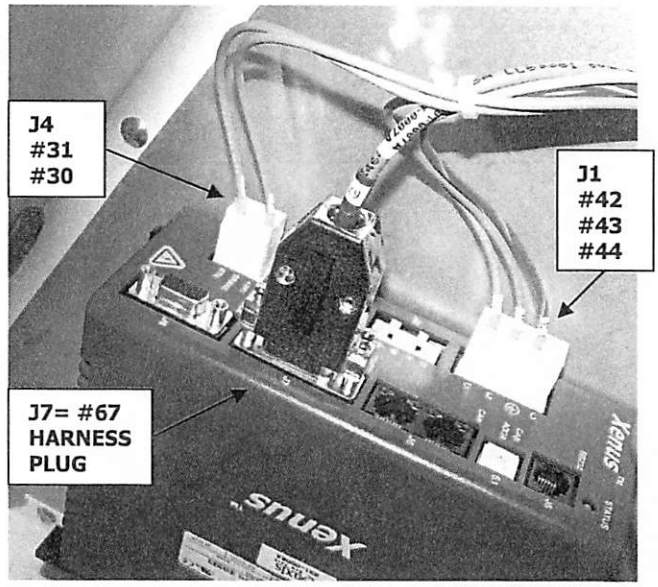




23) CONNECT LEXIUM STEPPER MOTOR WIRES FROM REAR HOUSING. BLACK CABLE CONNECTS TO THE GREEN TERMINAL BLOCK: WHITE- WIRE #25 INTO – TERMINAL AND BLACK+ WIRE #23 INTO+ TERMINAL. GRAY CABLE CONNECTS IN YELLOW TERMINAL BLOCK (PUSH IN): BLACK #26 INTO OUTER, TOP TERMINAL, WHITE #27 NEXT AND RED #24 NEXT TO WHITE. CONNECT (2) GREEN GROUND WIRES; #69 AND GRAY CABLE GREEN SHEATHED GROUND WIRE WITH A RED #6 RING (PRT296). SNAP IN GRAY TERMINAL, IT IS NOT WIRED.



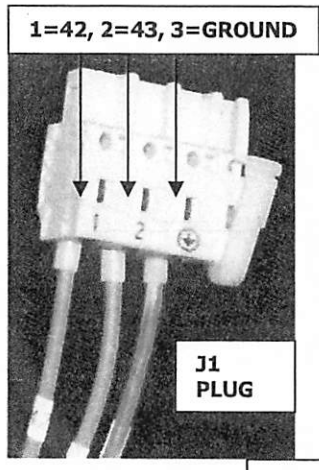
24) ON RIGHT SIDE ALIGN KEYS ON BLUE COPLEY SERVO AND CONNECT HARNESS PLUG TERMINALS. THE INNER, UPPER J4 TERMINAL SERVES A (2) WIRE PLUG CONNECTION WITH #31 OUTWARD AND #30 INWARD. THE INNER, LOWER J1 TERMINAL SERVES THE (3) WIRE PLUG CONNECTION WITH BROWN #42, #43 AND GREEN #44 OUTWARD.

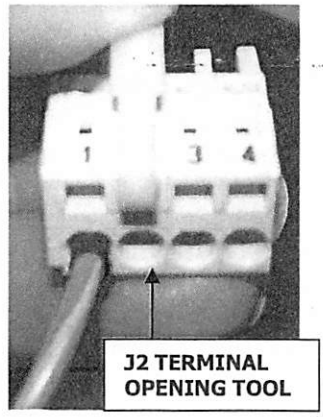


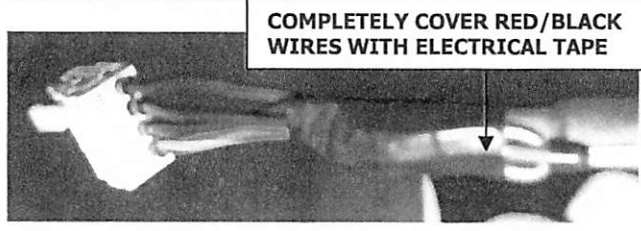
25) ALIGN THE TERMINALS ON THE #67 HARNESS PLUG WITH THE OUTER J7 RECEIVER ON THE BLUE SERVO MOTOR. INSERT #67 WIRE INTO J7 SERVO. DO NOT TIGHTEN THE SCREWS ON THIS PLUG YET.

26) FROM RACK 13 TAKE THE YELLOW COPLEY FEEDBACK CABLE (PRC0312) AND THE YELLOW PARKER P-1A1-05 SERVO MOTOR CABLE (PRC0313) TO THE WORK STATION.

27) THE (6) FERRULE FASTENERS ON THE WIRE ENDS OF THE YELLOW PARKER P-1A1-05 SERVO MOTOR CABLE ARE CONNECTED TO A (4) POST TERMINAL PLUG WHICH WILL INSERT INTO J2 TERMINAL ON THE BLUE COPLEY SERVO. WIRE THE TERMINAL PLUG AS FOLLOWS. USE AN OPENER TOOL TO ALLOW INSERTING FERRULE. ALIGH KEY ON TERMINAL AND INSERT THE GREEN CABLE WIRE INTO THE UPPER LOCATION #1. CONTINUE FROM LOCATION #1 GREEN GROUND WIRE INSERTING (3) BLACK NUMBERED WIRES: WIRE #3 IS NEXT TO THE GREEN GROUND WIRE, WIRE #2 IS THE MIDDLE BLACK WIRE

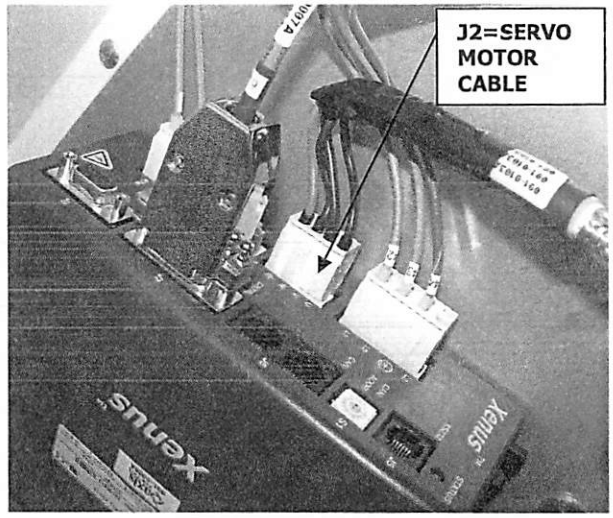






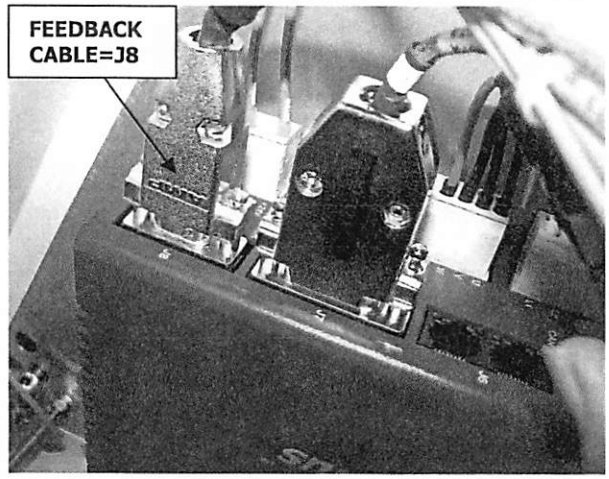
AND THE LOWER OUTSIDE BLACK WIRE IS WIRE #1. THERE ARE (2) RED/BLACK WIRES WITH FERRULES THAT ARE NOT CONNECTED. BEND THESE WIRES WITH THE FERRULES FACING AWAY FROM EACH OTHER AND THEN SECURE TO THE CABLE WITH BLACK ELECTRICAL TAPE.

28) INSERT THE WIRED TERMINAL PLUG ON THE SERVER MOTOR CABLE INTO THE INNER J2 RECEIVER, ORIENTED WITH THE GREEN GROUND WIRE UPWARD.



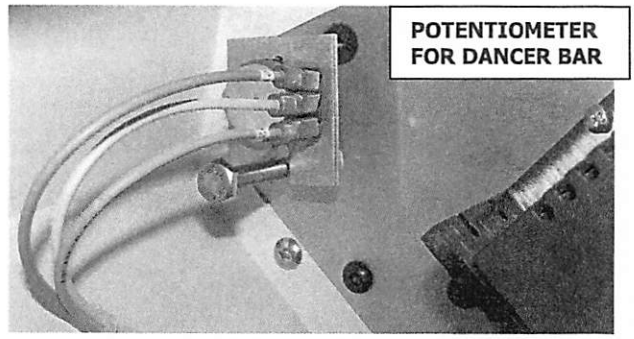
29) CONNECT THE YELLOW COPLEY FEEDBACK CABLE (PRC0312) TO THE J8 RECEIVER ON THE UPPER, OUTER BLUE SERVO MOTOR. ALIGN THE TERMINALS AND INSERT FEEDBACK CABLE PLUG INTO J8 SERVO MOTOR RECEIVER.

30) USE A SMALL SCREWDRIVER TO SNUG THE (4) SMALL SCREWS ON THE J7 AND J8 SERVO MOTOR LOCATIONS.

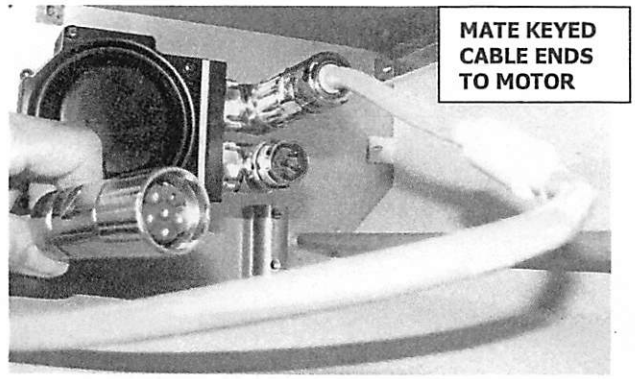


31) IN THE FRONT ON THE RIGHT SIDE PANEL IS THE POTENTIOMETER USED FOR THE DANCER BAR. WIRE THE POTENTIOMETER POSTS FROM THE RIGHT SIDE HARNESS WITH THE UPPER TERMINAL POST #21=GRAY WIRE, THE MIDDLE TERMINAL POST #20=YELLOW WIRE, AND THE LOWER TERMINAL POST #22=ORANGE WIRE.

32) INSERT BOTH YELLOW CABLES THROUGH THE SNAP BUSHING IN THE RIGHT SIDE PANEL. THE CABLES CONNECT TO THE RIGHT SIDE DRIVE MOTOR.



33) REMOVE THE PROTECTIVE PLASTIC COVERINGS FROM THE PULLEY DRIVE MOTOR CABLE PLUG RECEIVERS. LOCATE THE KEY ON EACH OF THE YELLOW CABLE PLUGS AND MATE THAT WITH THE LIKE MOTOR END. MATCH THE CERAMIC ENDS AND THE REDDISH PLASTIC ENDS. THE CABELS ONLY FIT ONE WAY. AFTER THE CABLE SNAPS INTO THE MOTOR RECEIVER, FINGER THREAD THE CABLE CONNECTING THREADS ONTO THE MOTOR THREADS.



34) FROM RACK 13 SNAP THE DARK PLASTIC TOOTH ON THE OPTO SENSOR SLOT TYPE

(PRS377) INTO THE CHANNEL ON THE END OF A POSITION SENSOR MOUNTING BAR (C30 201.4). ALIGN THE SENSOR SLOT TYPE HOLE OVER THE THREADS ON THE POSITION SENSOR MOUNTING BAR AND SECURE THE TWO PIECES TOGETHER WITH AN 8-32 X ½ PHMS.

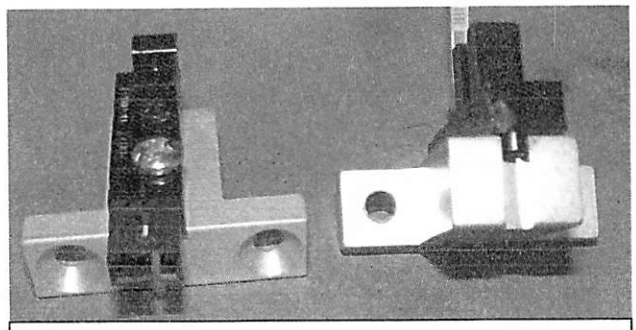
35) ALIGN THE CAM SHAFT POSITION DISC BETWEEN THE CHANNEL ON THE INNER SENSOR SLOT TYPE AND SECURE THE POSITION SENSOR MOUNTING BAR TO THE CAM SHAFT SUPPORT PLATE THROUGH THE COUNTERSUNK HOLES. USE (2) 10-32 X 3/8 FHUCMS.

36) FROM RIGHT SIDE WIRING HARNESS, CONNECT THE THIN BLACK #57 WIRE, THIN WHITE #64 WIRE AND THIN RED #63 WIRE THAT ARE PRE-WIRED TO THE SENSOR SLOT TYPE TERMINALS. THE BLACK WIRE IS ON THE LEFT/FRONT, THE WHITE WIRE IS IN THE MIDDLE AND RED WIRE IS RIGHT/REAR.

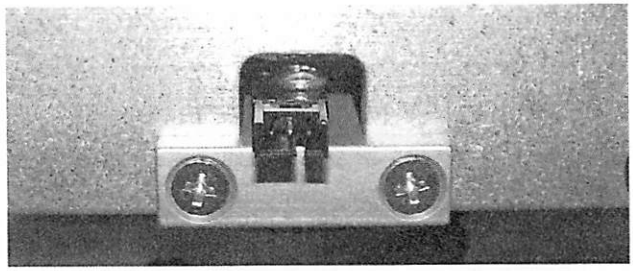
37) CONNECT THE RIGHT SIDE REMAINING HARNESS WIRES TO THE RIGHT SIDE EMERGENCY SWITCH. LOOSEN THE (2) SCREWS FACING THE REAR ON THE EMERGENCY SWITCH AND INSERT THE FERRULE ENDS; ONE RED WIRE FROM THE MAGNET IN THE HOUSING AND THE BROWN #10 WIRE.

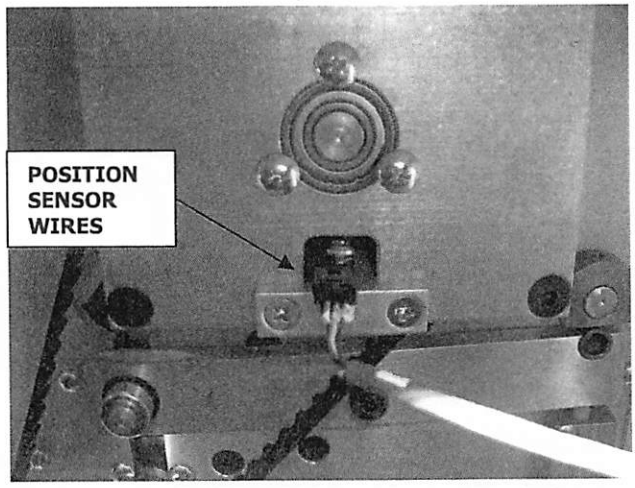
38) ON THE UPPER, REAR <u>LEFT SIDE</u> HOUSING LIP SECURE THE PROXIMITY SWITCH MAGNET WITH RED WIRES LOCATED IN THE SMALL BAG 1. USE (2) 4-40 X 3/8 PHMS ON THE OUTER HOUSING, HOLDING THE PROXIMITY MAGNET TO THE INNER HOUSING LIP WITH (2) 4-40 HEX NUTS. BOTH OF THE RED WIRES HAVE FERRULE CONNECTORS ON THEM. THE WIRES ARE DIFFERENT LENGTHS.

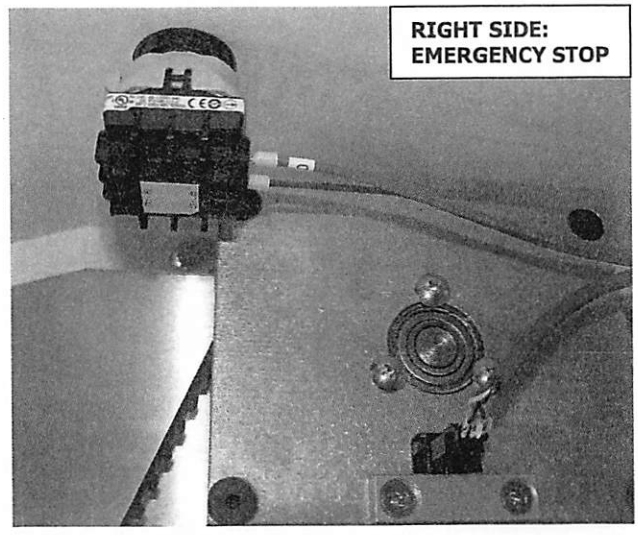
39) LOOSEN THE (2) REAR SCREWS ON THE LEFT SIDE EMERGENCY STOP SWITCH. CONNECT THE LONGER RED PROXIMITY MAGNET WIRE WITH THE FERRULE UNDER AN EMERGENCY STOP SCREW. CONNECT THE #14 BROWN HARNESS WIRE UNDER THE SECOND SCREW. BOTH SCREWS ARE ON THE SAME SIDE.



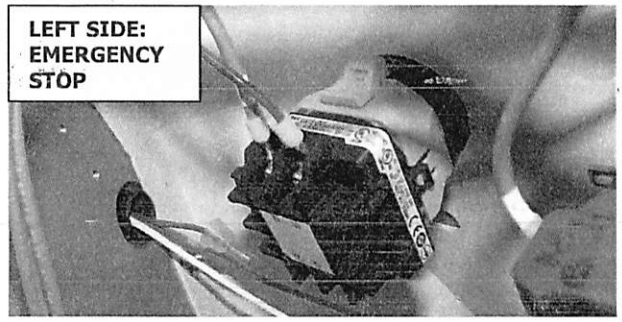
POSITION SENSOR MNTG BAR & SENSOR SLOT TYPE





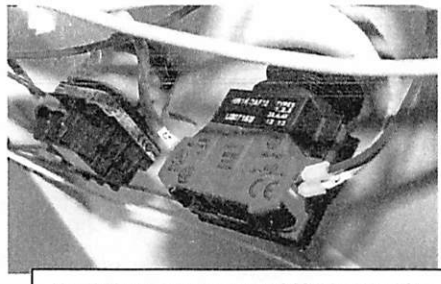


40) WIRE THE 2 POSITION KEY SWITCH. THE LOCKING TAB ON THIS SWITCH FACES UPWARD. LOOSEN THE UPPER SCREW AND INSERT #15 BROWN HARNESS WIRE. LOOSEN THE LOWER SCREW AND INSERT BOTH THE #16 BROWN HARNESS WIRE AND THE SHORTER RED WIRE FROM THE PROXIMITY MAGNET IN THE HOUSING.

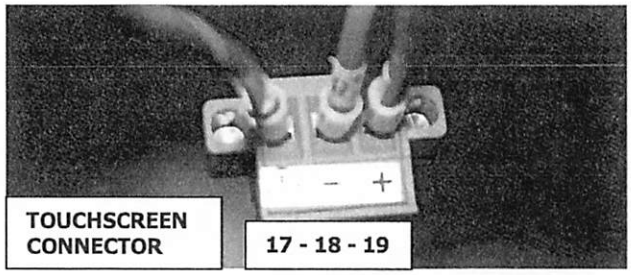


41) FROM LDW3 TAKE A PARKER 5" TOUCHSCREEN (PRC2005) AND A RIBBON COMM CABLE (PRC2008) TO THE WORK STATION.

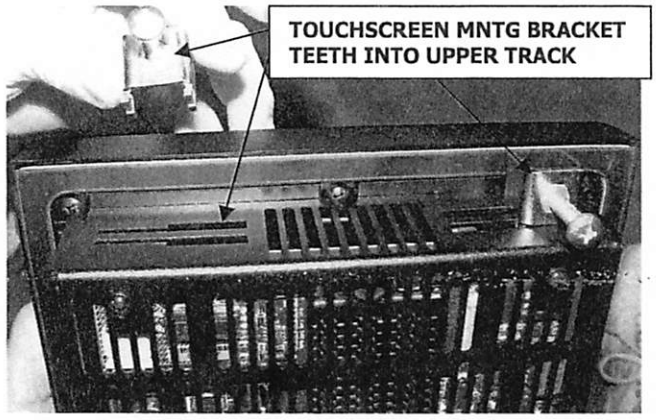




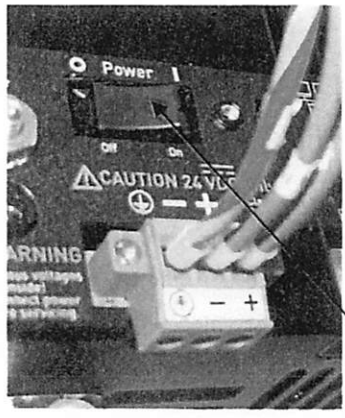
42) FROM THE TOUCHSCREEN HARDWARE BAG, REMOVE THE GREEN SCREW TERMINAL. WIRE THE GREEN TERMINAL BY INSERTING THE FERRULE CONNECTORS FROM THE HARNESS AS FOLLOWS: #17 GREEN GROUND WIRE FERRULE INTO THE GROUND POSITION, TIGHTEN SCREW. #18 BROWN WIRE FERRULE INTO THE – NEGATIVE MIDDLE POSITION, TIGHTEN SCREW AND #19 BROWN WIRE FERRULE INTO THE + POSITIVE POSITION AND TIGHTEN SCREW. TEST TIGHTNESS. SET THIS ASIDE UNTIL THE TOUCHSCREEN UNIT IS IN THE HOUSING.

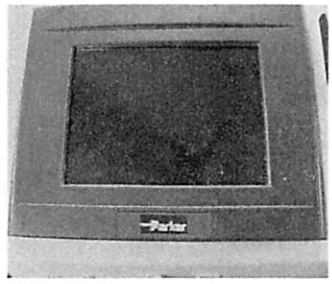


43) MOUNT THE TOUCHSCREEN UNIT TO THE HOUSING THROUGH THE REAR OPENING. FROM THE TOUCHSCREEN HARDWARE BAG, INSERT THE (4) 10-32 X 1 PHMS INTO THE (4) MOUNTING BRACKETS OR USE 1 ¼ FHMS. THE BRACKETS HAVE (2) SETS OF TEETH WHICH WILL ALIGN WITH THE TRACKS ALONG THE RECESSED SIDE OF THE TOUCHSCHEEN. SLIDE <u>ONLY</u> THE (2) UPPER MOUNTING BRACKETS ONTO THE TRACKS, FULLY INWARD AND FINGER TIGHTEN MOST OF THE SCREW THREADS. <u>SWITCH "POWER" TO "I"</u>.



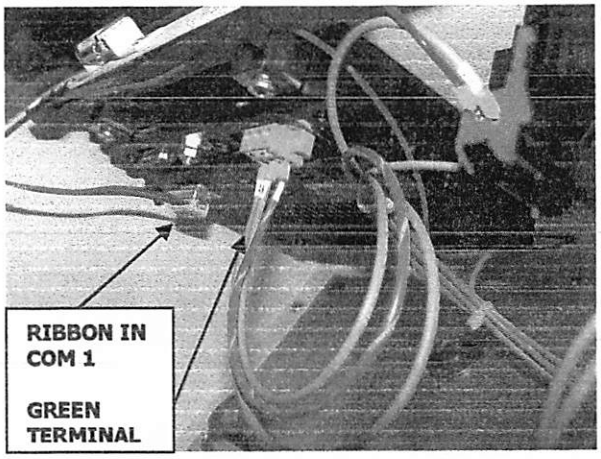
44) TILT THE TOUCHSCREEN UPWARD AND INSERT INTO THE LEFT HOUSING. ALIGN THE BOTTOM (2) MOUNTING BRACKETS WITH SCREWS ONTO THE TRACKS AND SLIDE FULLY INWARD. TIGHTEN ALL (4) SCREWS UNTIL SNUG.





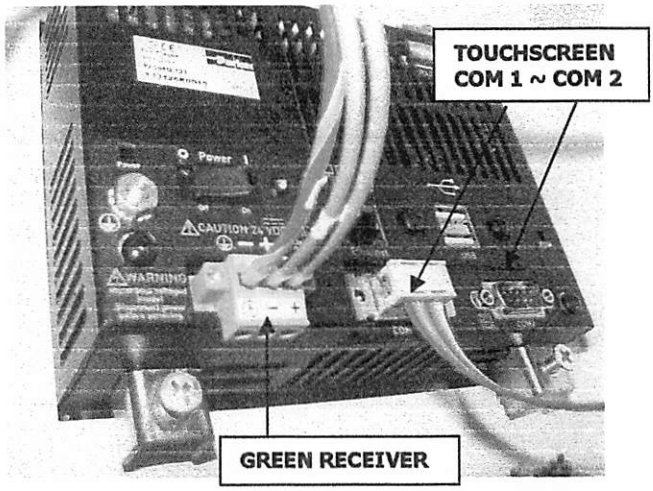
45) PLUG THE GREEN, WIRED TERMINAL INTO THE GREEN RECEIVER ON THE TOUCHSCREEN. THIS WILL ONLY FIT IN ONE WAY. SNUG THE TWO END SCREWS ON THE GREEN TERMINAL TO THE TOUCHSCREEN.

46) CONNECT THE METAL END OF RIBBON CABLE (PRC2008) LDW3 FOR THE TOUCHSCREEN ALIGNING SHAPE WITH THE INNER, 'COM 1' RECEPTICLE, LOCATED CLOSEST TO THE GREEN RECEPTACLE. THE SHORTER SIDE OF THE PLUG IS *DOWNWARD*.

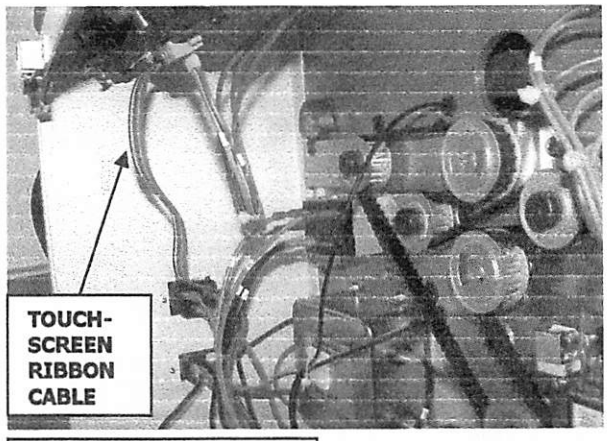


47) CONTINUE RIBBON CABLE DOWN THE HOUSING, BEHIND THE 12 AMP FUSE AND BEHIND THE POWER SUPPLY. GENTLY SLIDE THE RIBBON UNDER THE HARNESS BUNDLE AND CONTINUE TO THE DELTA TAU CLIPPER CONTROLLER ON THE SIDE PANEL. ALIGN THE KEY ON THE RIBBON CABLE AND INSERT INTO THE CONTROLLER RECEPTICLE LOCATED IN THE UPPER, FRONT CORNER, ABOVE THE THICKER RIBBON CABLE.

48) TIE AND PRESS CLIP THE PORTION OF THE WIRE HARNESS ALONG THE REAR OF THE 24 VOLT POWER SUPPLY ON THE SIDE PANEL. MOVE THE WIRES AWAY FROM THE PULLEYS AND BELT. DO NOT PUT STRESS ON THE FERRULE CONNECTORS.

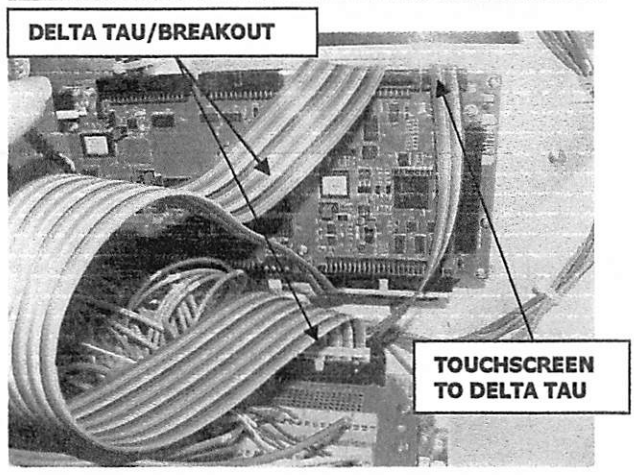


49) TIE AND PRESS CLIP THE LARGE BUNDLE OF WIRES ON THE BREAKOUT BOARD. TUCK THESE WIRES BETWEEN THE BREAKOUT BOARD AND THE OUTER HOUSING LIP. BE CAREFUL NOT TO LOOSEN ANY OF THE CONNECTING TERMINALS.



50) TIE AND PRESS CLIP ANY WIRES THAT ARE NOT NEATLY ARRANGED. DO NOT STRESS OR BEND RIBBON CABLES, FIBER OPTIC CABLES OR THE THIN WIRES WITH FERRULES.

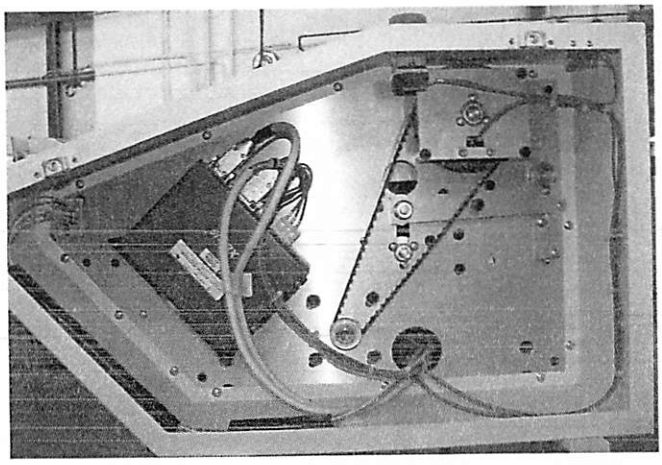
51) NOTE THE SPLIT RIBBON CABLE FROM THE (2) DELTA TAU LOCATIONS THAT CONNECT TO THE BREAKOUT BOARD.

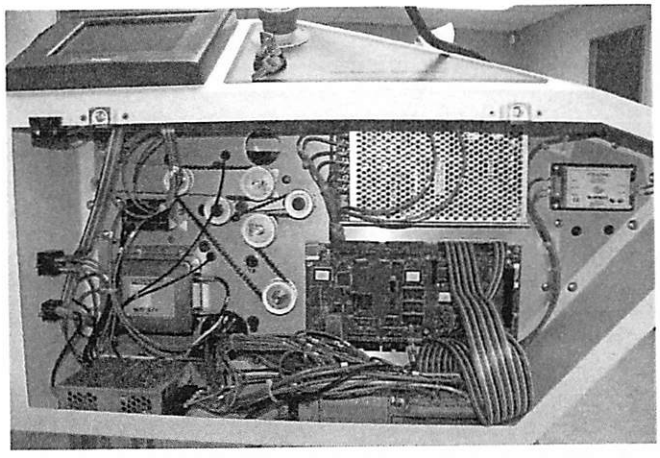


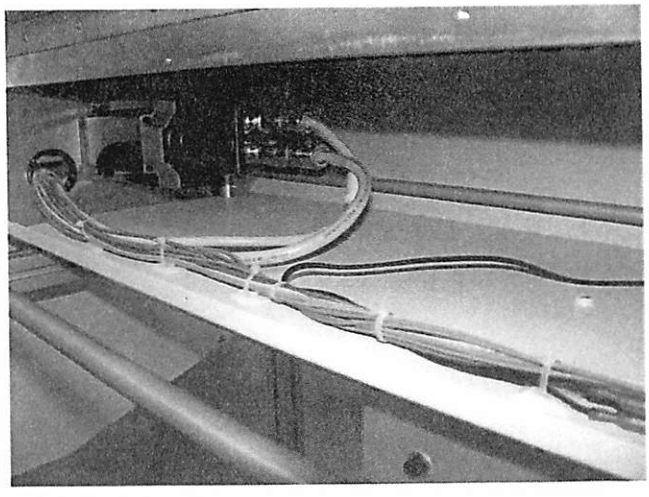
52) NOTE THE TIES ON THE RIGHT SIDE PANEL, INCLUDING THE YELLOW SERVO CABLES AND THEIR PATH TO THE SNAP BUSHING, AWAY FROM THE PULLEY. PICTURED.

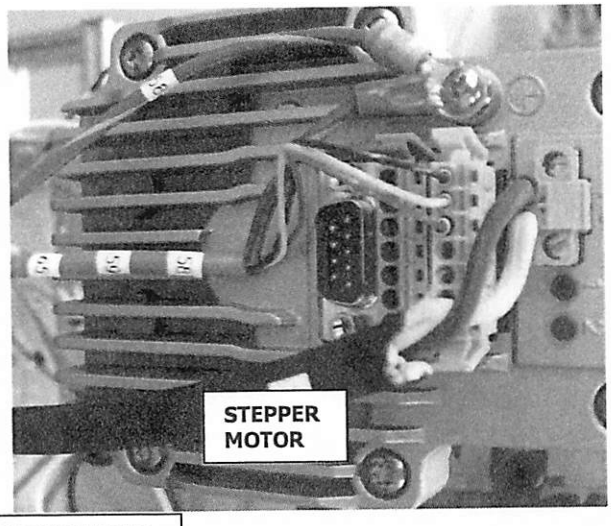
53) NOTE THE TIE PATH ON THE LEFT SIDE PANEL TO AVOID PULLEY. PICTURED.

54) NOTE THE (2) PICTURS OF THE WIRE PATHES FOR THE BOTTOM HOUSING. PICTURED.





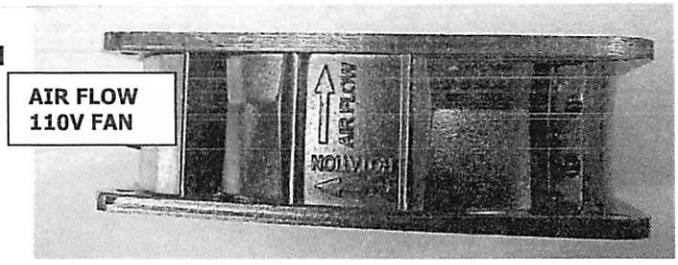




BOTTOM HOUSING WIRES

C30 AUTOCUTTER
BOTTOM HOUSING BACK DOOR INSTALLATION

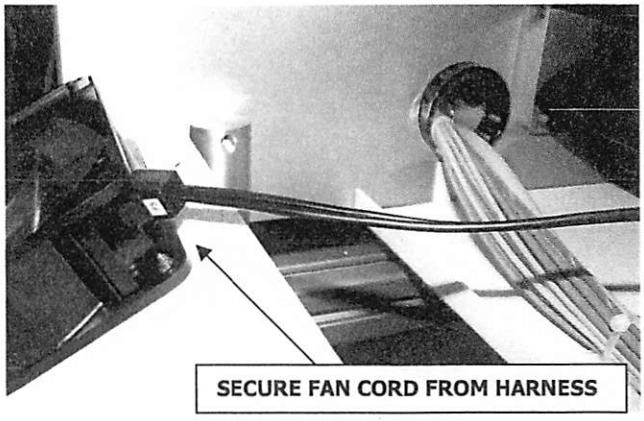
1) IN PREPARATION OF THE BOTTOM HOUSING BACK DOOR INSTALLATION ON THE CUTTER, HAVE CABLE TIES AVAILABLE, WITH A CABLE TIE NIPPER. A SCREWDRIVER AND (4) 8 X 3/8 PH SMS AND (4) 8-32 X 3/8 PHMS SHOULD BE ACCESSIBLE.



2) LOCK THE CASTORS ON THE CUTTER.

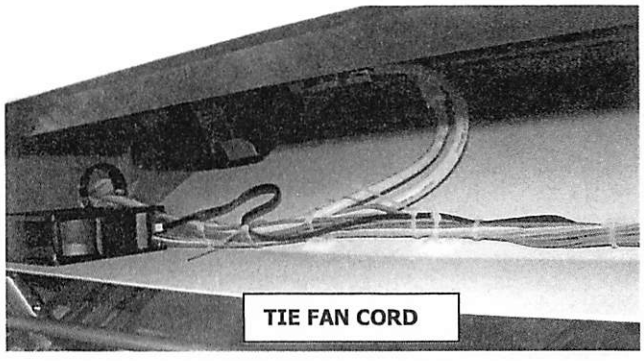
3) FROM THE REAR OF THE CUTTER, HOLD THE BOTTOM HOUSING BACK DOOR WITH THE FAN ON THE LEFT, WHICH WILL BE FACING THE RIGHT SIDE PANEL.

4) CONNECT THE FAN CORD WHICH IS IN THE HARNESS BUNDLE IN THE BOTTOM HOUSING ONTO THE FAN TERMINALS.



5) CABLE TIE THE FAN CORD TO THE HARNESS BUNDLE. THE EXCESS CORD CAN REMAIN BY THE FAN SO NO TENSION WILL STRESS THE TERMINAL POSTS.

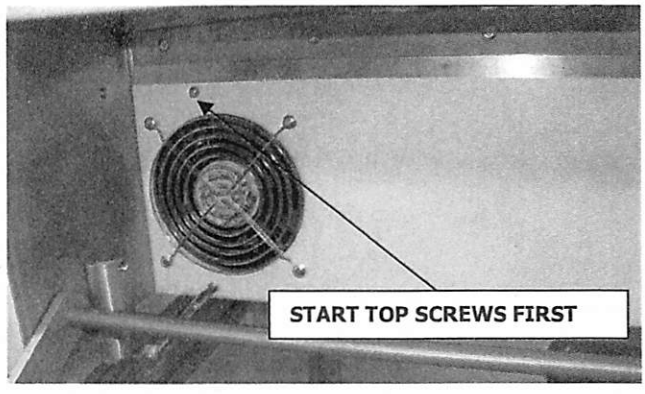
6) THE BOTTOM HOUSING BACK DOOR SECURES ON THE *OUTER* LIP PORTION OF THE BOTTOM COVER.



7) SECURE THE ASSEMBLED BOTTOM HOUSING BACK DOOR, WITH THE AXIAL FAN LOCATED BEHIND THE MOTOR.

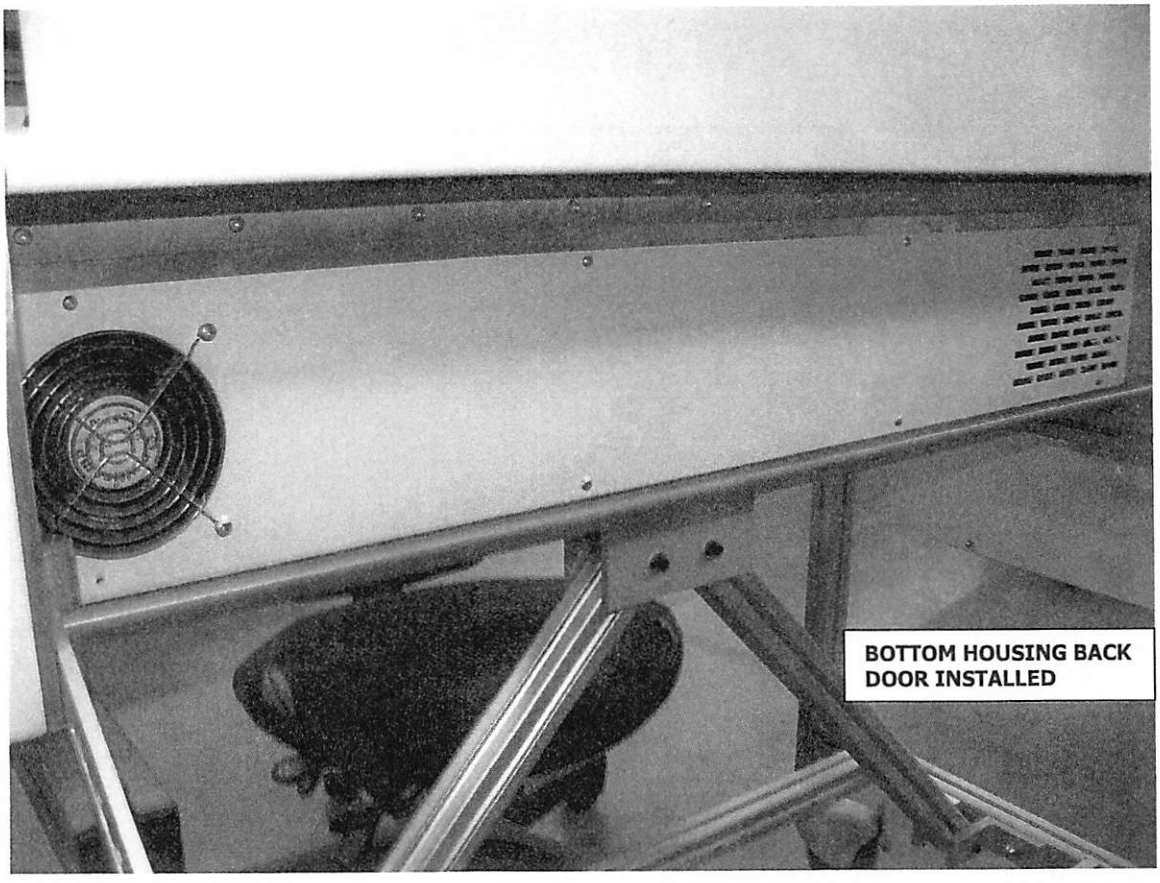
8) ALIGN THE (8) HOLES FIRST AND BEGIN THE THREADS OF THE TOP SCREWS INTO THE STATIONARY BOTTOM CUT OFF BLADE MOUNTING BAR FIRST. USE THE (4) 8-32 X 3/8 RHMS.

9) USE (4) 8 X 3/8 PH SMS TO CONNECT THE BOTTOM HOUSING BACK DOOR TO THE BOTTOM HOUSING LIP, WITH THE LIP INWARD. LIFT THE DOOR AS YOU ARE TIGHTENING THE SCREWS, SO YOU



CAN SEE THE UPPER DOOR HOLES ALIGN WITH THE THREADS ON THE CUT OFF MOUNTING BAR.

10) THE WIRE BUNDLE IN THE BOTTOM HOUSING SHOULD NOT BE TOUCHED BY ANY OF THE SCREWS.



BOTTOM HOUSING BACK DOOR INSTALLED

C30 AUTOCUTTER
DOOR MAGNETS 2015

1) THE C30 AUTOCUTTER HAS A RIGHT AND LEFT SIDE PROXIMITY SWITCH MAGNET (PRS352) RACK 1 GLUED TO THE INNER DOOR WHICH WILL LINE UP WITH THE OUTER HOUSING PROXIMITY SWITCH MAGNET. WHEN THE DOOR IS CLOSED THE MAGNETS ENGAGE THE INTERLOCKING SAFETY SYSTEM IS IN PLACE.

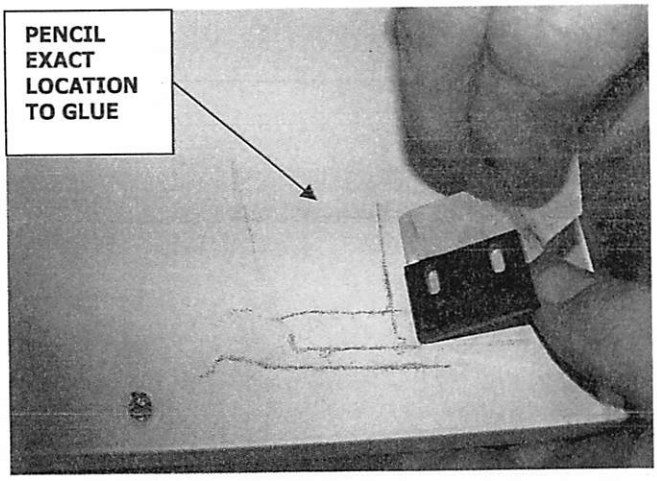
2) AFTER THE BACK HOUSING DOOR IS INSTALLED, AND THE TOUCHSCREEN HAS BEEN INITIALIZED SECURE THE HOUSING DOOR MAGNETS.

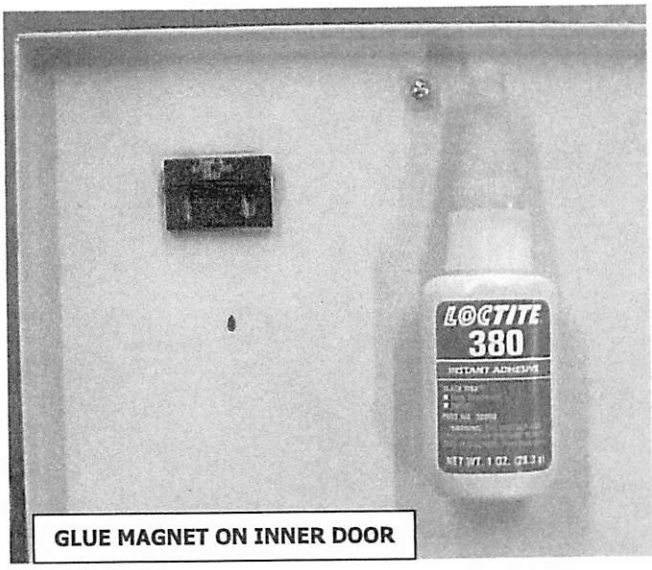
3) TEMPORARY MAGNETS CAN BE USED ON THE HOUSINGS TO ENGAGE THE BACK DOOR FAN. LISTEN TO THE SOUND OF THE FAN RUNNING TO HELP LOCATE DOOR MAGNET POSITION.

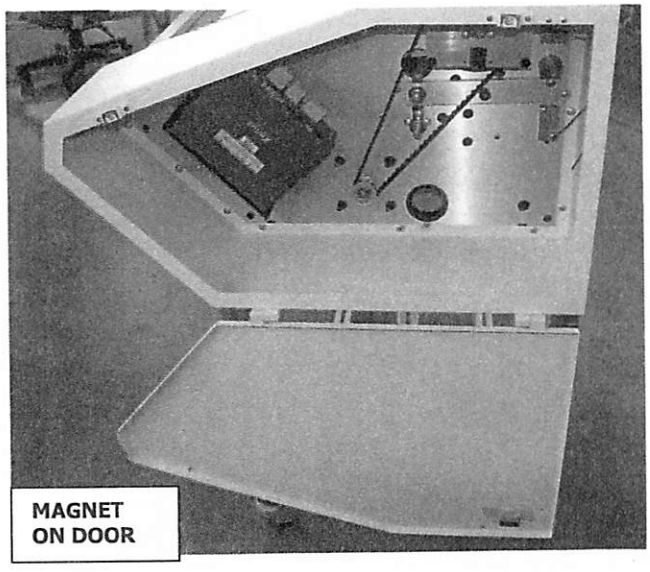
4) BY EYE, ALIGN THE HOUSING MAGNET WITH THE LOCATION OF THE HOUSING DOOR MAGNET. USE MASKING TAPE TO HOLD THE MAGNET ON THE DOOR WHEN YOU CLOSE THE DOOR TO LISTEN FOR FAN IGNITION. ORIENT THE MAGNET ON THE DOOR SO THE THICKER PORTION OF THE MAGNET IS ALIGNED WITH THE THICKER PORTION ON THE HOUSING. CLOSE AND OPEN THE DOOR TO TEST MAGNET FIT. MARK MAGNET LOCATION WITH A PENCIL.

5) LIFT THE ADHESIVE TAPE AND CAREFULLY GLUE THE MAGNET TO THE INNER DOOR. USE BLACK LOCTITE 380 GLUE. USE ONLY A SMALL AMOUNT.

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

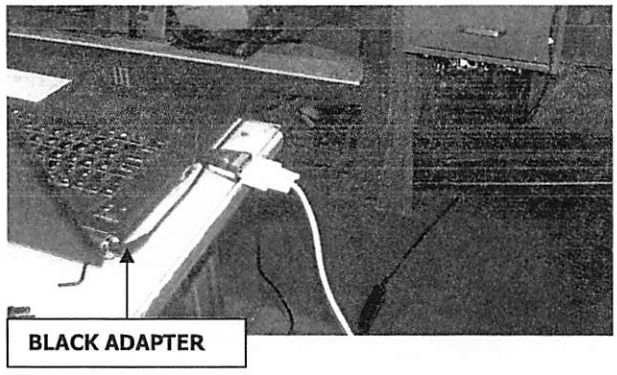




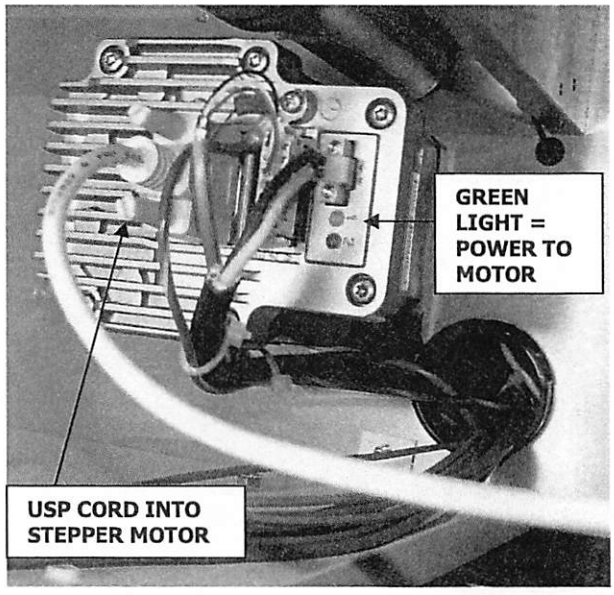


C30 STEPPER MOTOR (PRM853.4) SETTING PARAMETERS

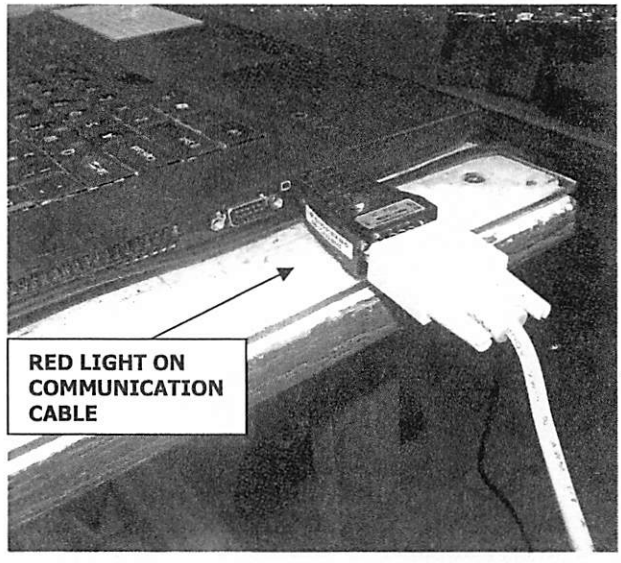
1) THE C30 STEPPER MOTOR MUST BE PROGRAMMED TO SET FEEDING PARAMETERS. TO PROGRAM THE STEPPER MOTOR USE THE SONY LAPTOP KEPT IN THE MAIN OFFICE. THE LAPTOP HAS A BATTERY OR YOU CAN USE THE BLACK ADAPTER CORD WITH LAPTOP CONNECTING BETWEEN LAPTOP AND POWER SOURCE. THE ASSEMBLY DESK TOP COMPUTER IS ALSO SET TO PROGRAM. TO COMMUNICATE USE THE GRAY USBRS-45/422 COMMUNICATION CABLE BETWEEN LAPTOP AND STEPPER MOTOR. PLUG GRAY CABLE, BLACK ADAPTER INTO THE LEFT SIDE LAPTOP.



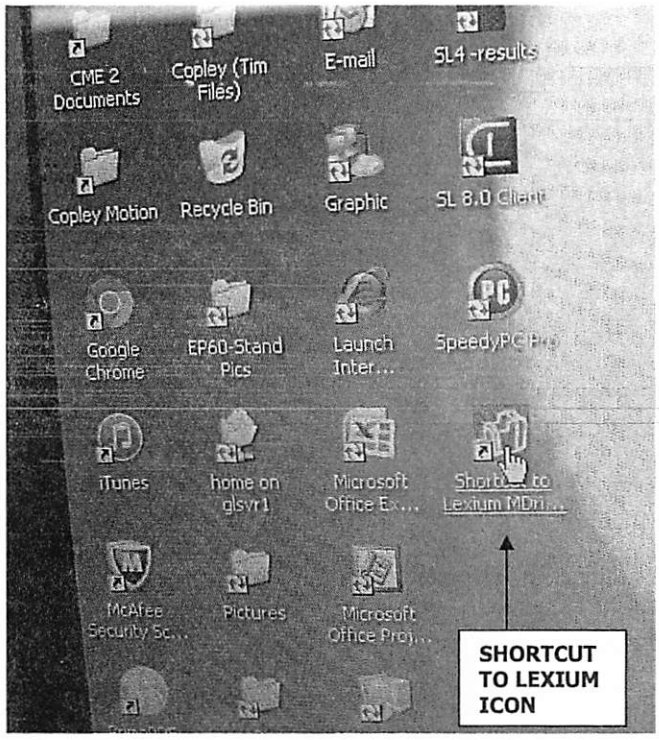
2) THE C30 MUST BE PLUGGED INTO A 110V POWER SOURCE AND THE POWER MUST BE ENGAGED WITH C30 KEY. *<u>GREEN LIGHT ON MOTOR INDICATES POWER</u>. CONNECT THE GRAY USB COMMUNICATION CORD BETWEEN THE LAPTOP AND THE CUTTING MOTOR. THE TERMINAL PLUG FITS IN ONLY ONE WAY. WHEN PLUGGING CABLE INTO THE MOTOR, YOU CAN SECURE BY TIGHTENING THE (2) COVERED SCREWS.



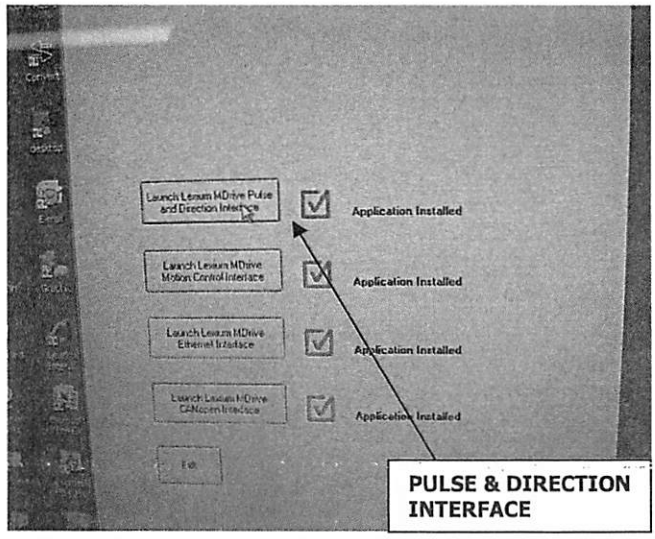
3) WITH THE LAPTOP OPENED AND COMMUNICATION CABLE INSERTED, A RED LIGHT SHOWS ON THE CONNECTED CABLE INDICATING THAT THERE IS COMMUNICATION CAPABILITY BETWEEN LAPTOP AND STEPPER MOTOR. THE RED LIGHT REMAINS CONSTANT.



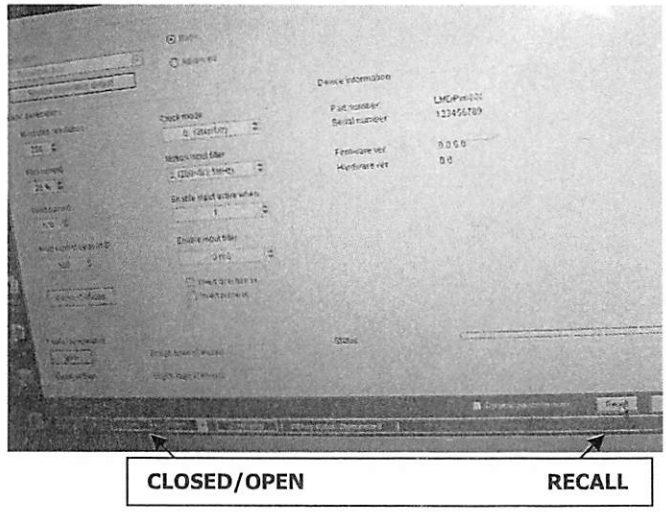
4) **WHEN THE LAPTOP MENU SCREEN ICONS ARE DISPLAYED, DOUBLE LEFT CLICK ON THE 'SHORTCUT TO LEXIUM' ICON TO LAUNCH "LEXIUM MDRIVE SOFTWARE SUITE."**



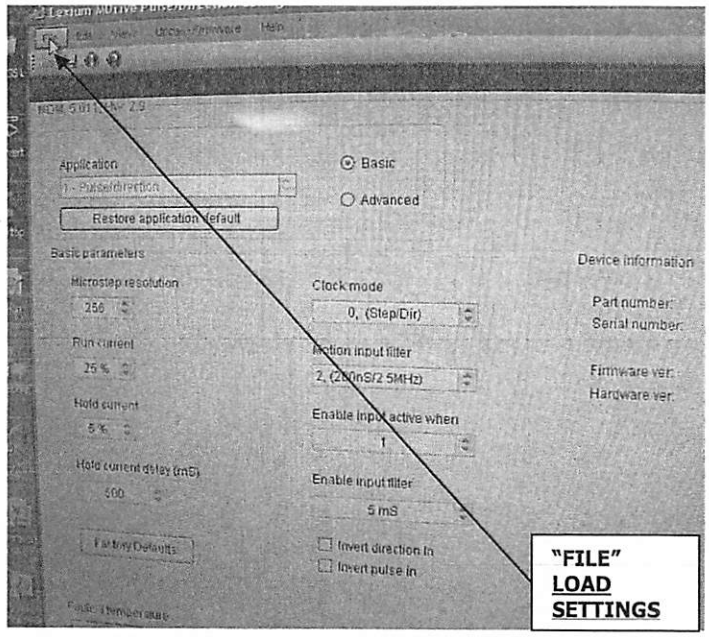
5) **WHEN THE "LEXIUM MDRIVE SOFTWARE SUITE" SCREEN APPEARS, SELECT THE "LAUNCH LEXIUM MDRIVE PULSE AND DIRECTION INTERFACE" BOX AND LEFT CLICK.**



6) **NOW THE "LEXIUM MDRIVE PULSE/DIRECTION CONFIGURATION UTILITY" SCREEN OPENS. PROCEED TO LOWER LEFT CORNER OF THIS SCREEN AND LEFT CLICK ON "CLOSED" BOX TO OPEN IT. MOVE CURSER TO LOWER RIGHT OF SCREEN, LEFT CLICK ON "RECALL" BOX. THE COMMUNICATION CABLE WILL BE FLASHING YELLOW TO INDICATE INFORMATION RETRIVAL.**

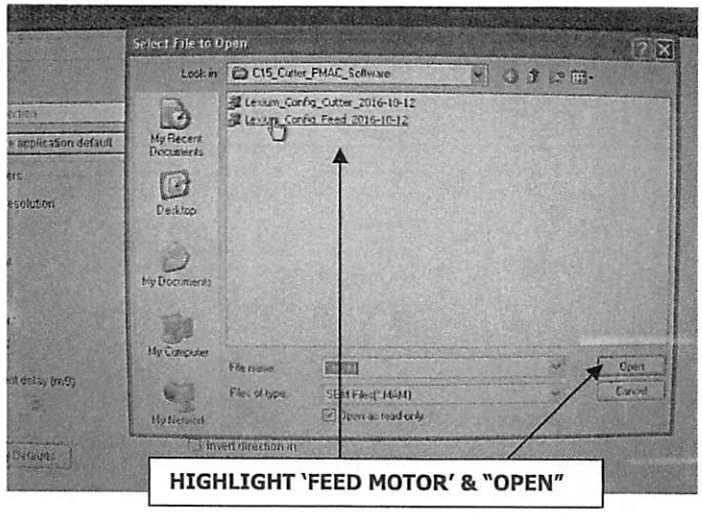


7) ONCE "RECALL" HAS RUN FAULTS / TEMPERATURE INFORMATION OF MOTOR SHOULD BE DISPLAYED IN LOWER LEFT. THESE READINGS ARE DIRECTLY FROM THE MOTOR. THE YELLOW FLASHING LIGHT FOR COMMUNICATION SHOULD STOP FLASHING AND INFORMATION APPEARS ON THE SCREEN.

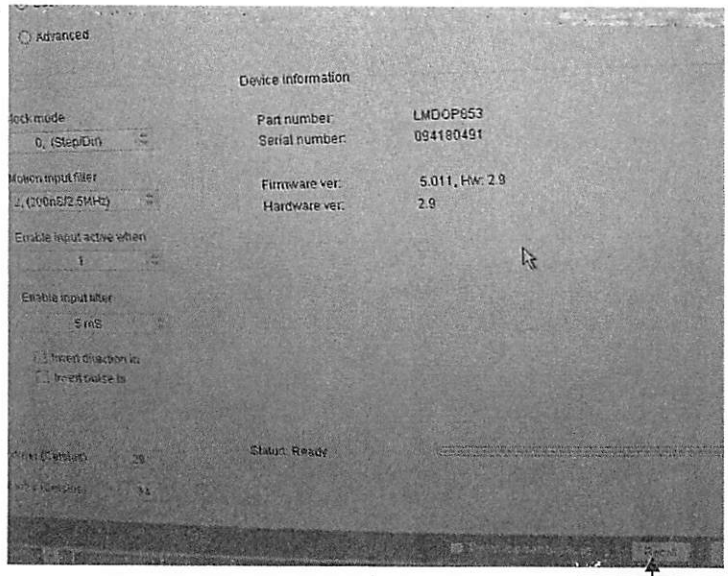


8) AT THE UPPER LEFT CORNER OF THE SCREEN, SELECT "FILE" AND LEFT CLICK. FROM THE PULL DOWN MENU SELECT "LOAD SETTINGS" WITH A LEFT CLICK.

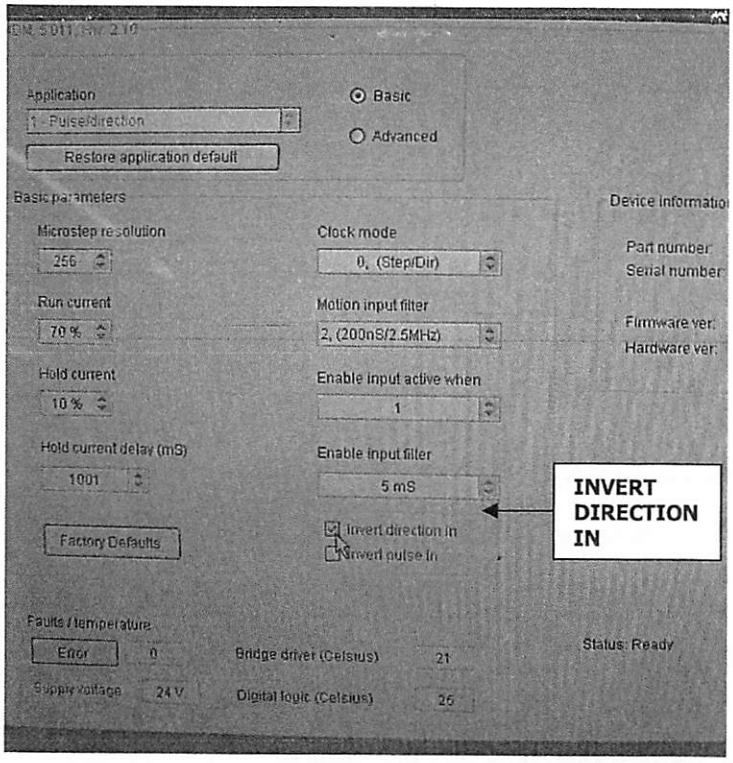
9) A SECOND SCREEN "SELECT FILE TO OPEN" APPEARS ON TOP OF THE SCREEN DISPLAYED. SELECT AND HIGHLIGHT STEPPER MOTOR TO BE PROGRAMMED (FEED MOTOR) AND MOVE CURSER TO "OPEN" BOX ON LOWER RIGHT. LEFT CLICK "OPEN".



10) THE SMALL SCREEN DISAPPEARS. AT THE LOWER RIGHT IN GREEN SECTION LEFT CLICK THE "RECALL" BOX.



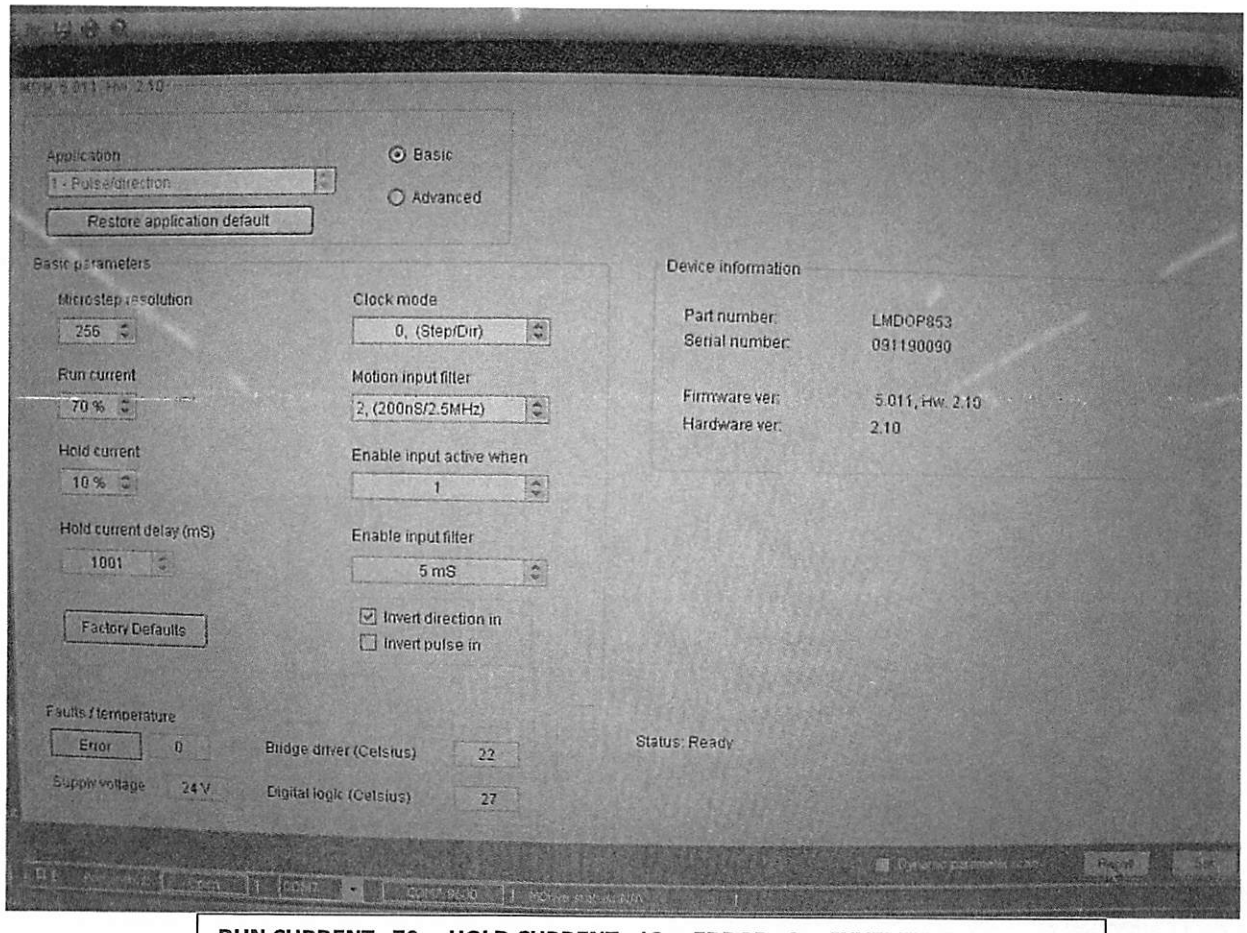
~~11)~~ **PLACE CURSER ON "INVERT DIRECTION IN" BOX AND LEFT CLICK CURSER.**



12) JUST RIGHT OF LOWER RIGHT THE "RECALL" BOX IS THE "SET" BOX. LEFT CLICK ON "SET" BOX TO SAVE NEW INFORMATION.

13) EXIT OUT ON RED 'X' TOP RIGHT.

14) CONFIRM PROGRAM LOADED SUCCESSFUL BY REPEATING STEPS FROM THE BEGINNING.



RUN CURRENT=70 ~ HOLD CURRENT=10 ~ ERROR=0 ~ INVERTED DIRECTION

C30 AUTOCUTTER EXIT TABLE 2015

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

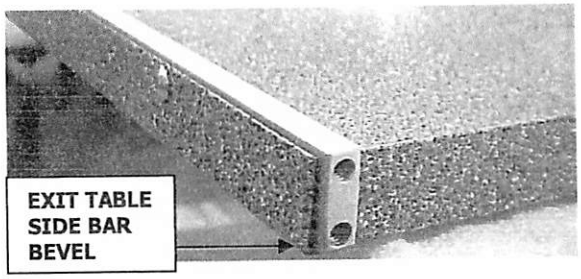
2) CONNECT (2) EXIT TABLE BRACE BARS (C30 305.4) AS16 TO THE *INNER* FRONT AND REAR EDGE OF THE EXIT TABLE, BETWEEN SLOT IN LIPS, WITH *BEVELED EDGE OF THE BRACE BAR BY EXIT TABLE BREAK.* SECURE BRACE BARS WITH (6) 10-32 x 3/8 THMS. BRACE BARS EXTEND PAST THE EXIT TABLE WIDTH.

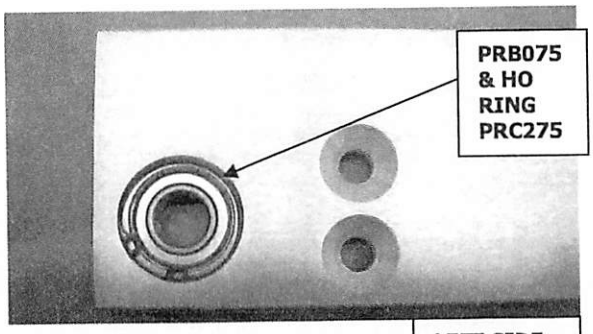
3) ARBOR PRESS (2) ROLLER BEARINGS (PRB075) RACK 12 *EACH* COMPLETELY INTO THE RECESSES OF AN EXIT TABLE RIGHT SIDE BAR (C30 307.4) AS17 AND EXIT TABLE LEFT SIDE BAR (C30 308.4) AS17. THE LEFT SIDE BAR HAS A SLOT UNDER THE BEARING. SECURE ALL ROLLER BEARINGS WITH A ROTOR CLIP HO RING (PRC275) RACK 12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

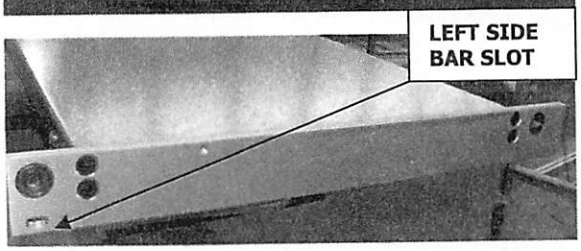
4) PLACE THE EXIT TABLE UPRIGHT ON THE WORKTABLE. ATTACH THE EXIT TABLE LEFT SIDE BAR *ONLY* TO THE EXIT TABLE BRACE BARS THROUGH THE (4) OUTER COUNTERSUNK HOLES. USE (4) ¼-20 X ¾ FHSH. THE SIDE BAR EXTENDS FURTHER PAST THE EXIT TABLE ON THE FRONT END THAN THE BACK END. THIS END CONNECTS TO THE CUTTER. THE *SLOT IS DOWNWARD* AND THE *THREADED EDGE FACES UPWARD* IN THE UPRIGHT POSITION.

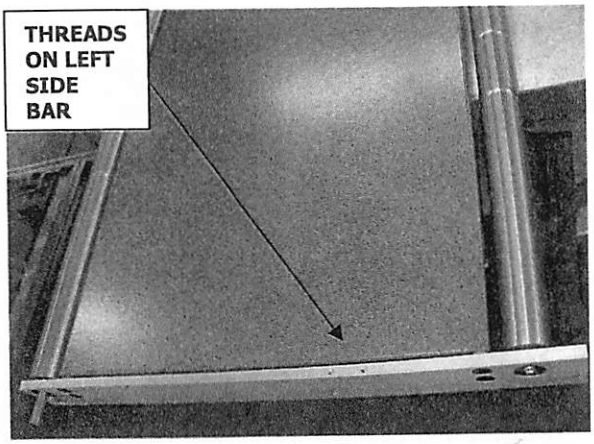
5) INSERT THE LONGER SHAFT END OF THE EXIT TABLE DRIVE ROLLER (C30 303.4D) AS16 INTO THE ROLLER BEARING ON THE EXIT TABLE LEFT SIDE BAR THAT IS CLOSER TO THE EXIT TABLE AND HAS A *CHANNEL OPENING* LOCATED ALONG THE EDGE OF THE BAR FOR THE CONTROL BOX.

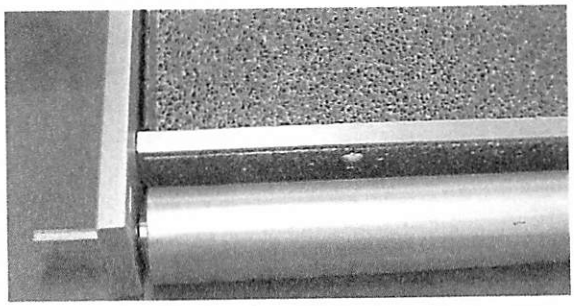
6) INSERT THE SHAFT OF THE EXIT TABLE IDLER ROLLER (C30 303.4I) AS16 INTO THE ROLLER BEARING IN THE FRONT OF THE EXIT TABLE LEFT SIDE BAR. SLIDE











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.

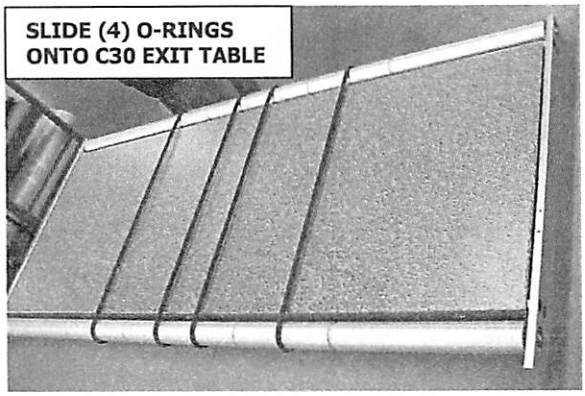
7) SLIDE (4) O-RINGS (PRR265) RACK 12 OVER THE END OF THE EXIT TABLE ASSEMBLY AND FIT THE O-RINGS INTO THE CENTER TWO DRIVE AND IDLER ROLLER GROOVES, SKIP A GROOVE ON EITHER SIDE AND FIT THE REMAINING TWO O-RINGS INTO THE NEXT PAIR OF GROOVES. THE O-RINGS CAN BE MOVED FROM GROOVE PAIRS TO ACCOMMODATE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

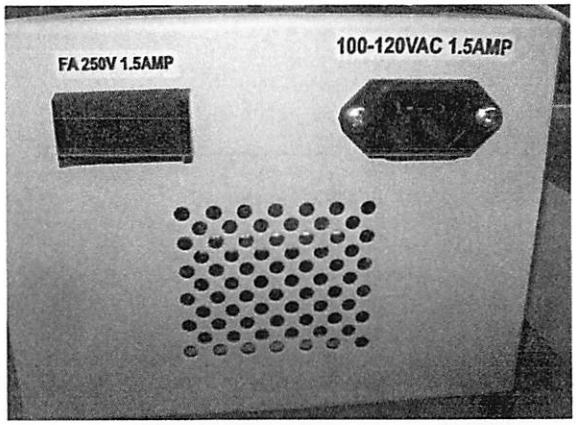
8) INSERT A CORD RECEPTACLE, PANEL MOUNT (PRC117) AS09 INTO EXIT TABLE CONTROL BOX (C30 300.4A) AS16, WITH SINGLE TERMINAL POST CLOSEST TO THE PERFORATIONS (DOWN POSITION). USE (2) 6 X 3/8 TH SMS TO SECURE. ADHERE 110-120VAC 1.5AMP LABEL (LAB121) AS08 ABOVE RECEPTACLE.

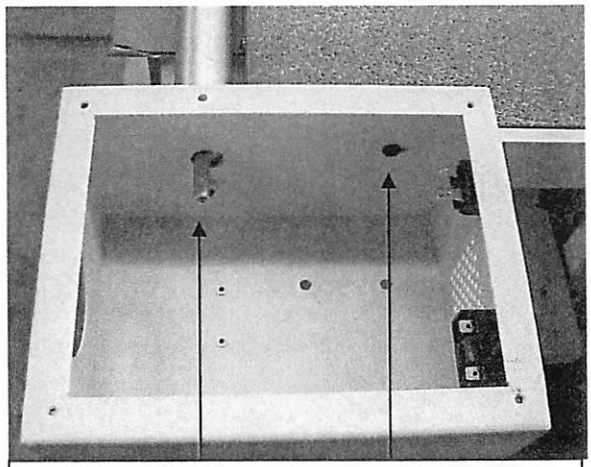
9) INSERT (2) 1.5 AMP FUSES (PRF128) AS09 INTO A FUSE HOLDER (PRF145) RACK 12. THE SECOND 1.5 AMP FUSE IS A SPARE. SNAP FUSE HOLDER IN BOX. ADHERE AN FA 250V 1.5 AMP LABEL (LAB124) AS08 ABOVE FUSE HOLDER.

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.***

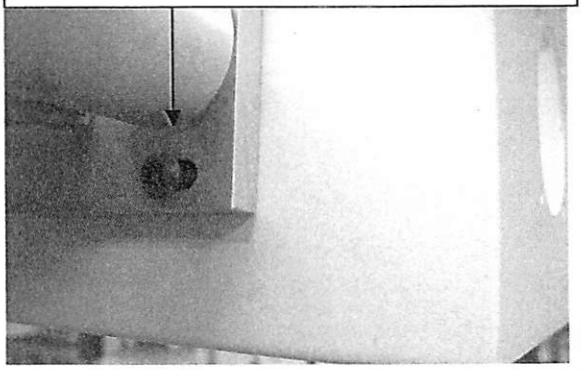
11) FROM RACK 12 INDICATE SET SCREW LOCATION OPPOSITE HUB ON TIMING BELT PULLEY (PRG005). PLACE A URETHANE KEVLAR TIMING BELT



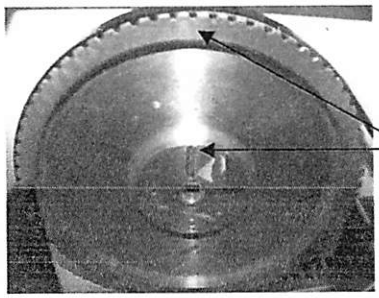




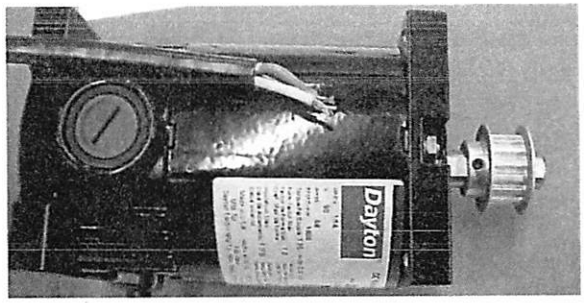
¼-20 X ¾ BHSH IN CHANNEL & ¼-20 X ½ BHSH



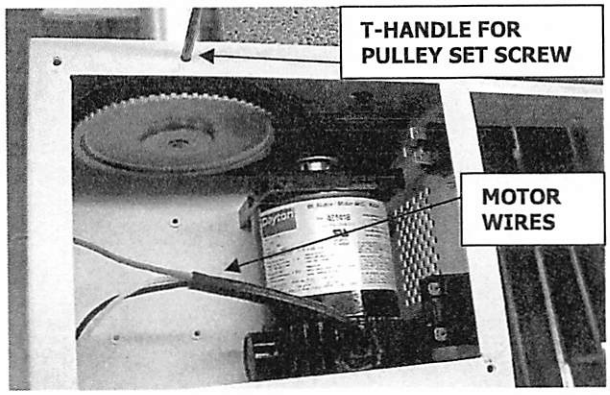
(PRB250) ONTO PULLY TEETH. ALIGN ***HUB OF TIMING BELT PULLEY INWARD*** AND LOOSELY SNUG THE SET SCREW ON THE FLAT OF DRIVE ROLLER JOURNAL, ***FULLY INWARD***. USE A T-HANDLE ALLEN WRENCH THROUGH OPENING IN THE CONTROL BOX LIP TO REACH THE SET SCREW. THE SECOND SET SCREW IN THE TIMING BELT PULLEY IS SNUGGED ON THE ROUND OF THE DRIVE JOURNAL.



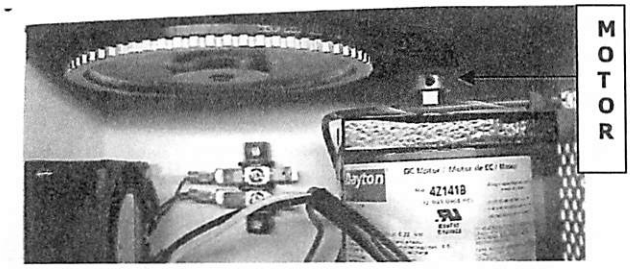
12) REMOVE ONE OF THE SET SCREWS ON THE TIMING BELT PULLEY (PRG004) RACK 12. PLACE THE TIMING BELT PULLEY ON THE SHAFT OF THE PERMANENT MAGNET DC MOTOR 4Z141B (PRM1995) AS02, WITH ***PULLEY HUB INWARD***. LOOSELY SNUG PULLEY ONTO FLAT OF MOTOR SHAFT SO THE PULLEY DOESN'T SPIN ON THE SHAFT, BUT CAN STILL 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.

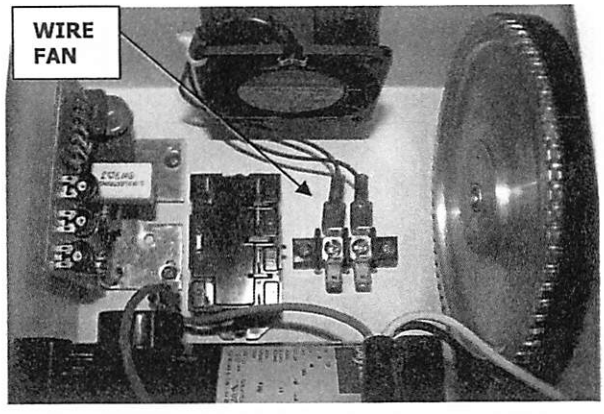


14) WITH MOTOR SHAFT FACING INWARD TOWARD EXIT TABLE, SECURE THE MOTOR TO THE EXIT TABLE CONTROL BOX WITH (4) ¼-20 X ½ BHSH.



15) FROM AS08 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 AS08 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) RACK 12. CONNECT FEMALE END OF #70 GREEN/YELLOW GROUND WIRE TO THE SINGLE TERMINAL POST ON THE RECEPTACLE.

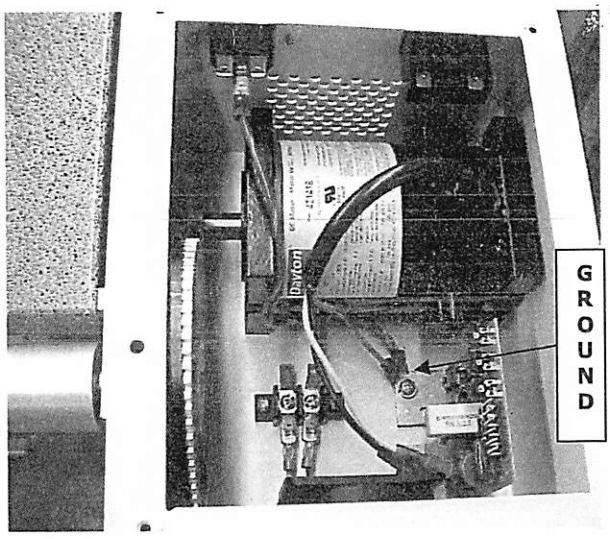
18) REMOVE THE MOLEX WIRE CONNECTION ON THE MINARIK SPEED CONTROL BOARD (PRM219) AS07. GIVE THE MOLEX UNIT TO THE WIRING DIVISION FOR FUTURE USE. CONNECT THE SPEED CONTROL BOARD BRACKET TO THE CONTROL BOX USING (1) 6-32 X ¼ PHMS ON THE FAN SIDE. SECURE THE MOTOR SIDE OF BRACKET WITH A 6-32 X ½ RHMS ***AFTER*** A #8 STAR WASHER, THE GREEN GROUND MOTOR WIRE AND 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, ORIENT THE (4) TERMINAL POSTS BESIDE THE TERMINAL BLOCK. USE (2) 6-32 x ¼ PHMS.

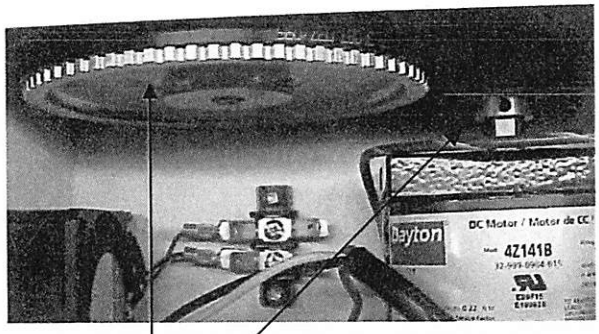
20) ALIGN PULLEY ON MOTOR SHAFT WITH PULLEY ON DRIVE ROLLER SO THE PULLEY BELT HAS AN EVEN TRACK. THEN SECURE SET SCREWS.

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

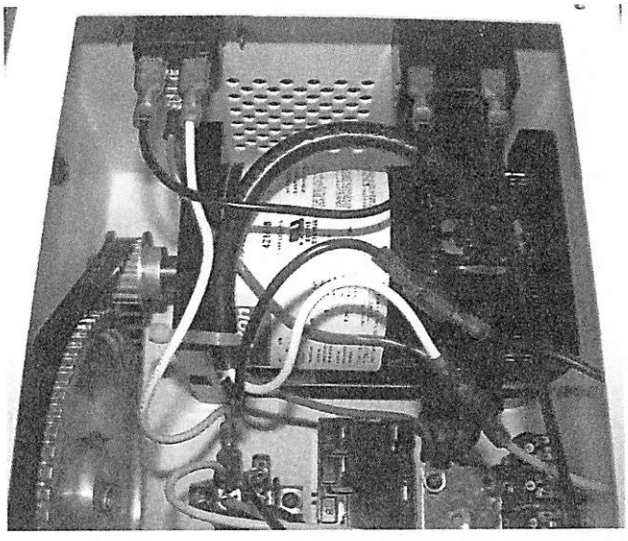
22) FROM WIRING BAG #2 CONNECT THE MOLEX WIRES ONTO THE SPEED BOARD, WITH ***BLUE WIRE CLOSEST TO THE MOTOR***. CONNECT THE BLACK MOTOR WIRE TO THE MOLEX BLUE WIRE AND THE WHITE MOTOR WIRE TO THE MOLEX YELLOW WIRE. THE WHITE MOLEX WIRE CONNECTS TO POSITIVE 90 DEGREE TERMINAL BY PULLEY, ABOVE FAN WIRE.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



23) CONNECT THE 5" SHORT BLACK WIRE BETWEEN PANEL-SIDE RECEPTACLE 'L' POST AND INNER FUSE POST. CONNECT LONGER 8 ½" 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 6 ½" WHITE WIRE BETWEEN FUSE-SIDE 'N' RECEPTACLE POST AND POSITIVE 45 DEGREE POST ON TERMINAL BLOCK. CONNECT A 6 ½" 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) AS16. CENTER AND ADHERE AN EXIT TABLE DECAL (LAB108A) RACK 13 ONTO EXIT CONTROL PANEL.

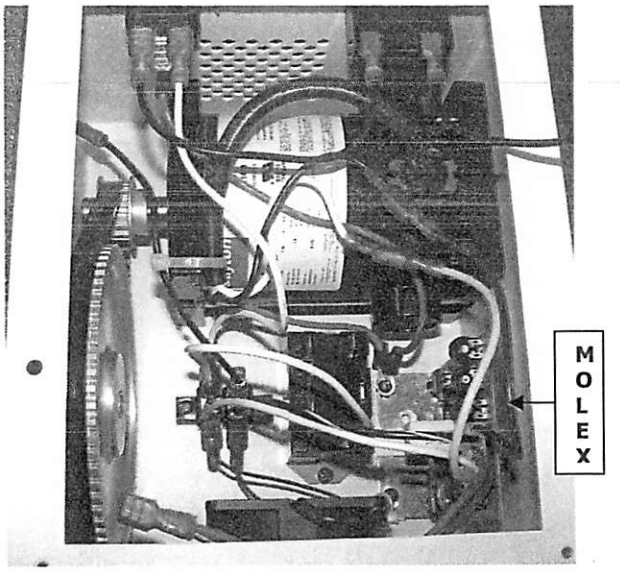
26) ALIGN THE 16MM GREEN PUSHBUTTON (PRS361) RACK 13 TO SNAP INTO CONTROL PANEL UNDER THE ARROW INDICATION WITH *STRAIGHT, COLOR OUTER* EDGES FACING RIGHT AND LEFT TOWARD POTENTIOMETER AND *CURVED COLOR EDGES* FACING TOP, BOTTOM. USE CASTLE TOOL TO TIGHTEN NUTS.

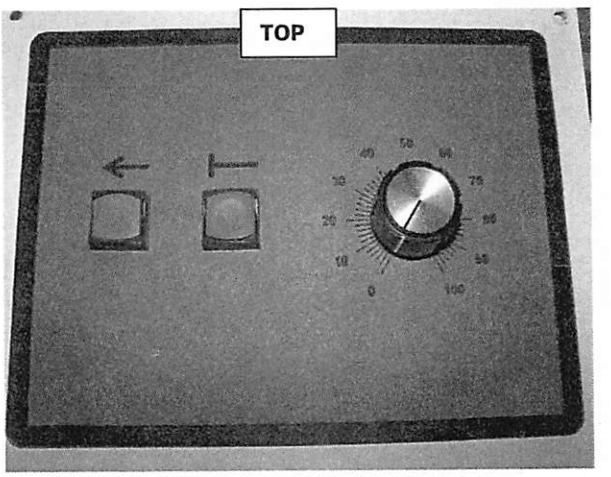
27) ALIGN THE 16MM RED PUSHBUTTON (PRS362) RACK 13 TO SNAP INTO CONTROL PANEL UNDER THE STOP INDICATION ORIENTED THE SAME WAY AS THE GREEN PUSHBUTTON.

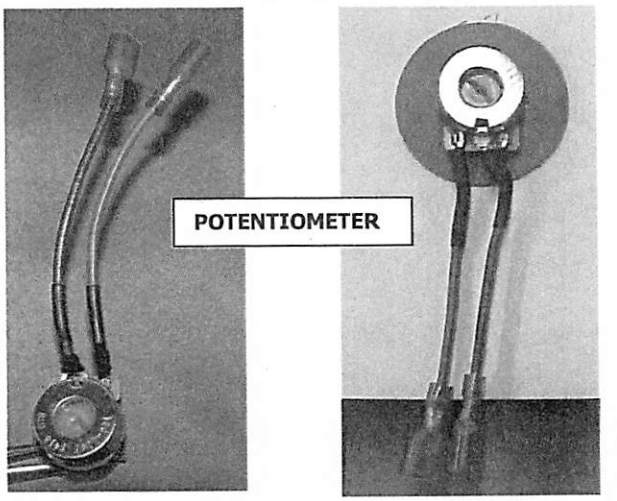
28) WITH POTENTIOMETER STEM AWAY FROM YOU AND TERMINAL POSTS POINTING UP, UNITE THE MIDDLE AND LEFT POST (NEAREST THE CATCH TAB). SLIDE ¾" OF 3/16 BLACK INSULATION TUBING (PRI165) CAB 1 ONTO THE BROWN AND GRAY WIRES FROM BAG #2. SOLDER THE BROWN WIRE TO THE DOUBLE TERMINAL POSTS AND THE GRAY TO THE RIGHT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

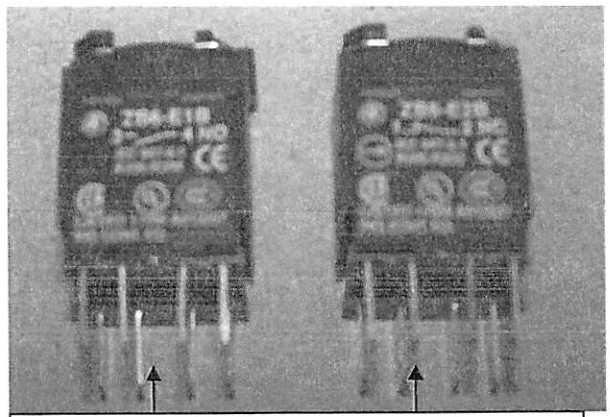






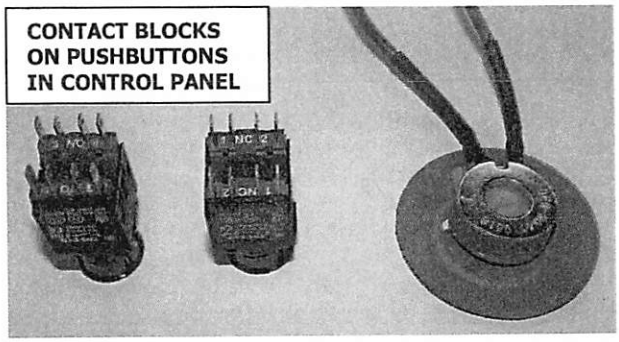
AND FIT THE STEM AND THE CATCH TAB INTO PANEL OPENINGS. SECURE THE OUTSIDE OF THE POTENTIOMETER TO THE PANEL WITH A TOOTHED WASHER AND HEX NUT. SECURE A MINARIK KNOB (PRM221A) AS08 ON THE STEM.

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.



NO=NORMALLY OPEN ~ NC=NORMALLY CLOSED

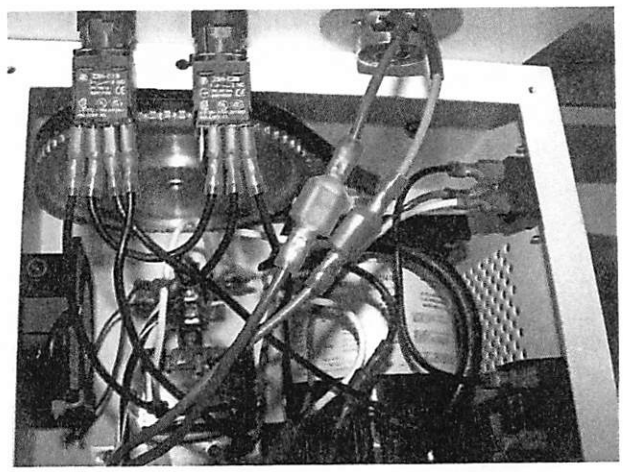
31) ***IT IS CRITICAL BOTH CONTACT BLOCK CONNECTIONS ARE ALONG THE SAME LINE, ALIGNING WITH EACH OTHER.***



CONTACT BLOCKS ON PUSHBUTTONS IN CONTROL PANEL

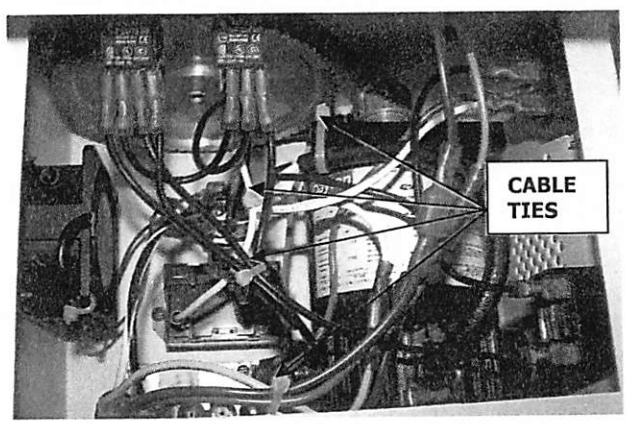
32) ONLY (7) OF THE ***INNER TERMINAL POSTS*** ON THE GREEN NO AND RED NC CONTACT BLOCKS ARE USED.

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 6" BLACK WIRES ON RELAY #0 TO OUTER-GREEN POST AND RELAY #2 TO INNER GREEN POST.

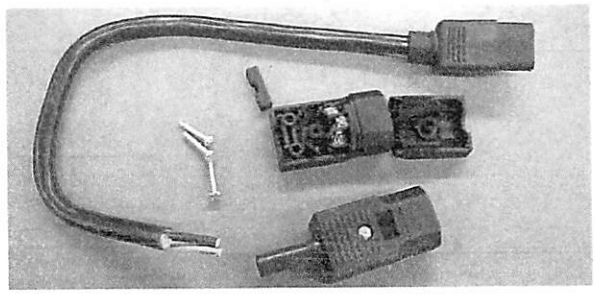
35) CONNECT BLACK WIRE ON 90 DEGREE MOTOR-SIDE TERMINAL BLOCK TO OUTER-MIDDLE RED PUSHBUTTON POST, NEXT TO JUMPER. CONNECT BLACK WIRE ON RELAY #4 TO OUTER RED PUSHBUTTON BY POTENTIOMETER.



CABLE TIES

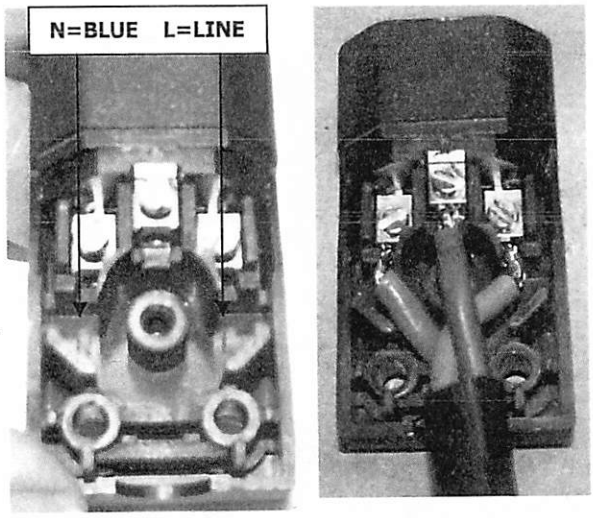
36) PLUG IN EXIT TABLE AND TEST. IF MOTOR IS HUMMING, YOU CAN TURN THE "MIN" POT TOTALLY DOWN. TIE WIRES AND CLOSE COVER. SECURE COVER WITH (4) 6-32 X ¼ PHMS.

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.

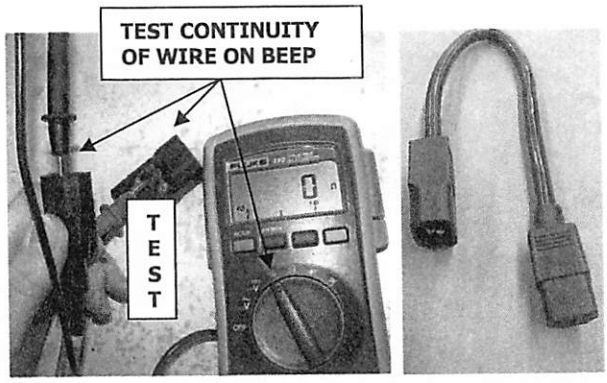
39) INSERT BLUE 'N' OPEN WIRE LEFT OF CENTER, INTO OPENING UNDER SCREW AND TIGHTEN SCREW ON WIRE. INSERT BROWN 'L' OPEN WIRE RIGHT OF CENTER AND TIGHTEN SCREW ON WIRE. INSERT GREEN/YELLOW GROUND WIRE INTO RAISED CENTER OPENING. ***LEAVE ROOM FOR CENTER COVER SCREW*** TO THREAD ON COVER.



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

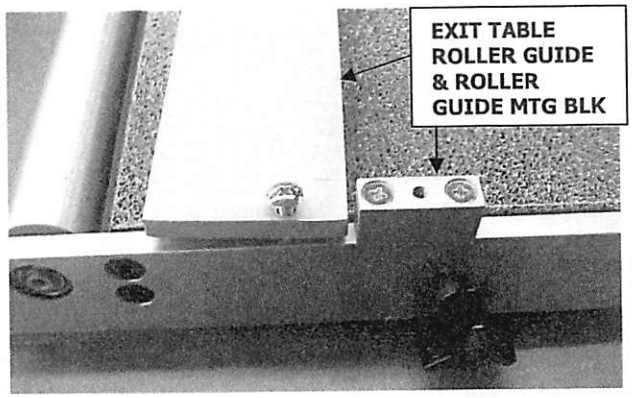
41) REPLACE CORD CATCH AND SECURE WITH (2) SCREWS. REPLACE COVER AND SECURE WITH REMAINING SCREW.

42) ATTACH (2) EXIT TABLE ROLLER GUIDE MOUNTING BLOCKS (C30 310.4) RACK 11 ONTO THE THREADS OF BOTH BARS. SECURE THE ROLLER GUIDE MOUNTING BLOCKS THROUGH COUNTERSINKS WITH (4) 10-32 X 1 ¼ FHMS.



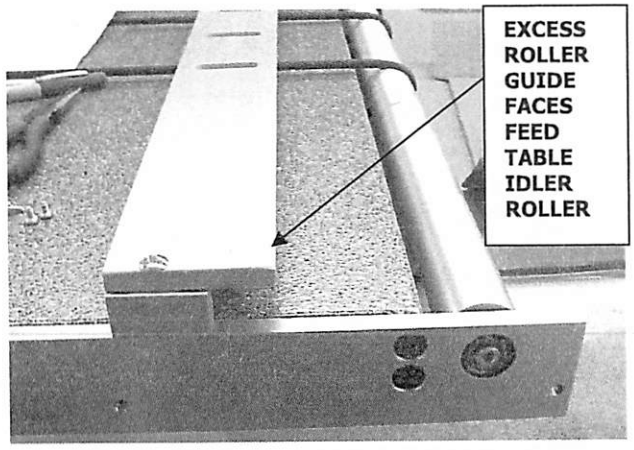
43) ALIGN THE LONGER WIDTH OF THE EXIT TABLE ROLLER GUIDE (C30 309.4) AS16 AWAY FROM THE CONTROL BOX. SECURE TO ROLLER GUIDE MOUNTING BLOCKS WITH (2) 10-32 X ¾ THMS.

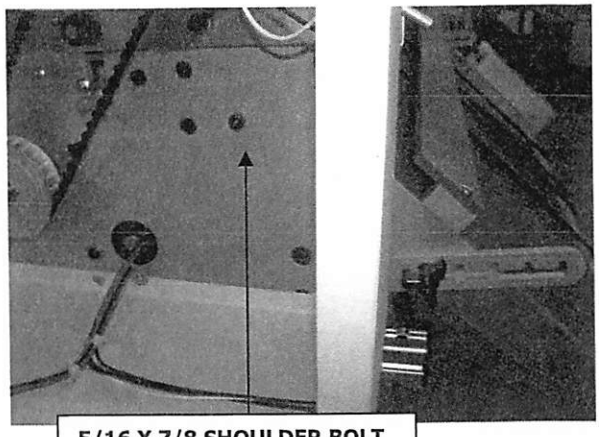
44) INSERT (4) EXIT TABLE ROLLERS (C30 311.4) RACK 11 INTO CHANNELS ON ROLLER GUIDE ABOVE O-RINGS.

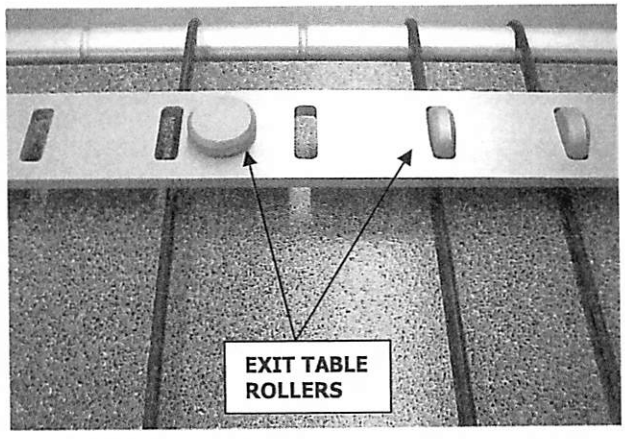


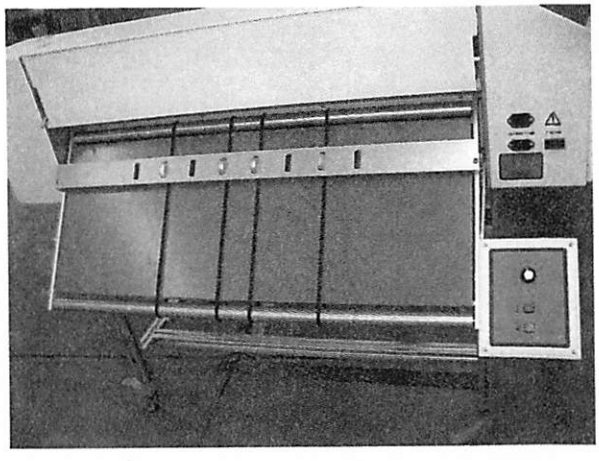
45) TO SECURE THE EXIT TABLE TO THE C30

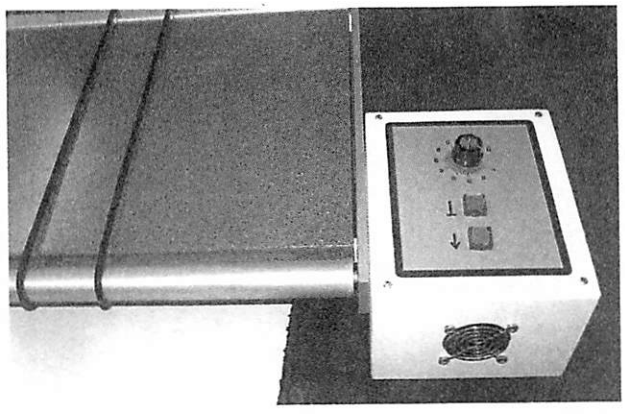
CHASSIS, PLACE EXIT TABLE SUPPORT BARS OUTWARD, RESTING ON STAND. SIT FROM BEHIND THE CHASSIS, HOLDING EXIT TABLE AND HAVE A SECOND PERSON ALIGN (2) 5/16 X 7/8 SHOULDER BOLTS THROUGH SIDE PANELS. ALIGN THE EXIT TABLE ANGLE BY MOVING ALONG THE EXIT TABLE SUPPORT BAR CHANNELS. SET HEIGHT BY MOVING RIGHT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



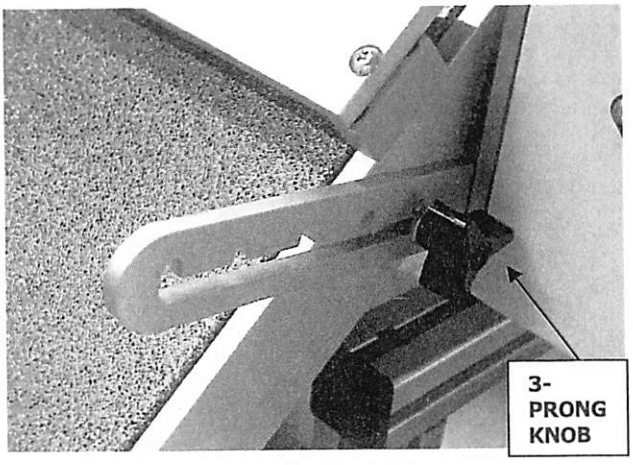

5/16 X 7/8 SHOULDER BOLT











C30 AUTOCUTTER-B
HIGH POT TESTING 2019

1) THE C30-B MUST PASS A HIGH POT TEST FOR POWER LEAKAGE AND GROUNDING. THE PROCEDURES ARE AS FOLLOWS.

2) ROLL THE HIGH POT CART TO THE C30-B. THE TESTER GROUND CORD MUST REACH THE OUTER LEFT SIDE PANEL AND THE TAN POWER STRIP CORD MUST REACH A 110 POWER SOURCE. THE POWER STRIP SWITCH SHOULD BE '*OFF*.' THE POWER STRIP RED LIGHT COMES ON WHEN THE POWER IS SWITCHED ON. PLUG INTO POWER SOURCE.

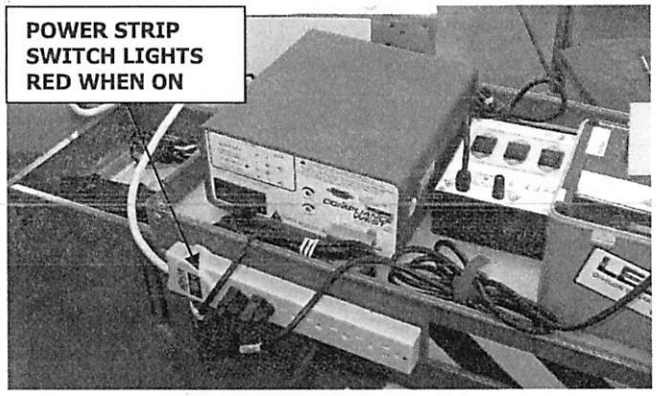
3) ***CLEAR THE AREA! DO NOT TOUCH THE MACHINE OR THE CORD WHILE HIGH POT TESTING, AS SEVERE SHOCK MAY OCCUR IF MACHINE FAILS TESTING.***

4) WITH 'GROUND CHECK' SWITCH *UPWARD*, PLUG TESTER MACHINE GROUND CORD BETWEEN THE 'RETURN' INLET ON THE TESTER AND CLAMP ONTO THE ¼-20 HEX HEAD BOLT STABILIZING THE POTENTIOMETER ON THE LEFT SIDE PANEL, BEHIND THE BLUE COPLEY SERVO MOTOR.

5) PLUG THE C30-B 110V POWER CORD BETWEEN THE TESTER 'OUTPUT' INLET AND THE C30-B RECEPTACLE.

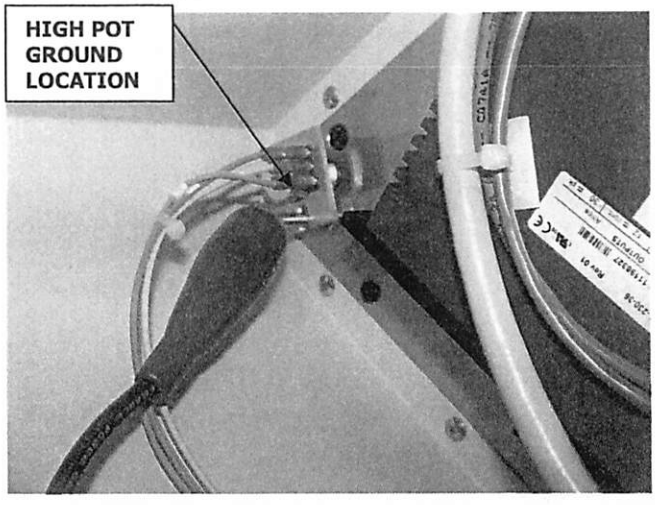
6) PRESS POWER STRIP ON – RED LIGHT APPLEARS. PRESS TESTER ROCKER SWITCH ON – GREEN SWITCH LIGHT APPEARS. IF GROUND IS GOOD, GREEN 'GOOD WHEN LIT' LIGHT GLOWS.

7) WITH 'ZERO/START' ON 'VOLTAGE CONTROL' DIAL, PRESS THE BLACK 'RESET' BUTTON. THEN PRESS THE BLACK 'CONT' BUTTON THE RED 'HV' LIGHT COMES ON.





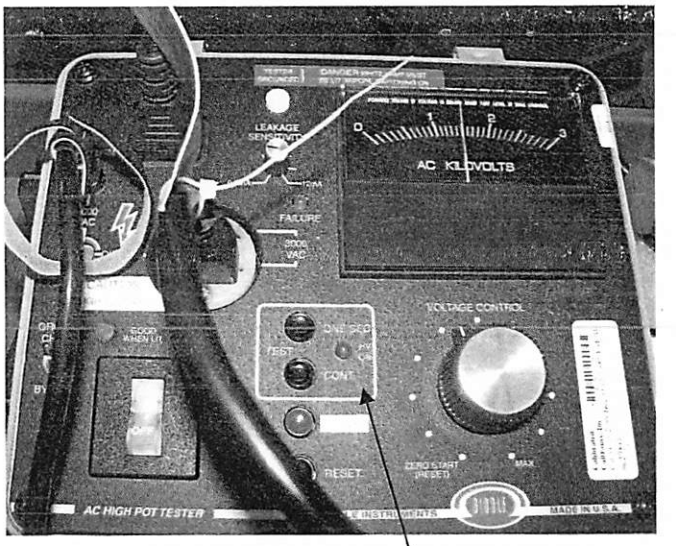
HIGH POT/OFF: POWER CORD TO C30-B



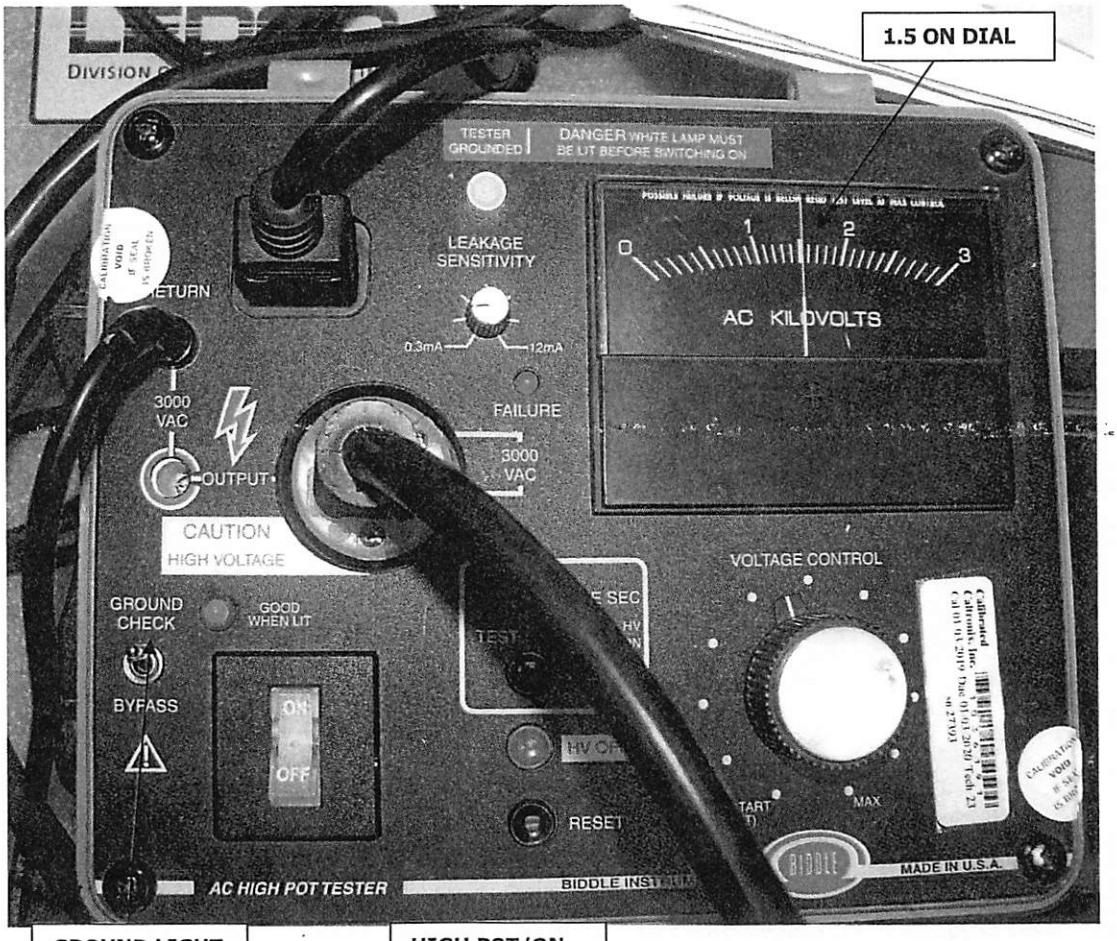
8) **WITH 'VOLTAGE CONTROL' STILL AT ZERO/START, INCREASE AC KILOVOLT DIAL CLOCKWISE TO 1.5 AC KILOVOLTS ON THE REGISTER SCREEN. <u>MAINTAIN 1.5 AC KILOVOLTS FOR TWO SECONDS</u>. A HIGH POT FAILURE GEGISTERS WITH AN AMBER 'FAILURE' LIGHT AND A 'BEEP' SOUND.**

9) **TO END THE HIGHT POT TEST, RETURN THE 'VOLTAGE CONTROL' DIAL TO 'ZERO/START' AND PRESS THE RED 'HV OFF' BUTTON. THE RED 'HV ON' LIGHT GOES OUT.**

10) **TURN 'OFF' THE HIGH POT TESTER ROCKER SWITCH AND POWER STRIP. UNPLUG 'INPUT' POWER CORD FIRST, THE UNPLUG REMAINING CORDS.**



RED 'HV ON' LIGHT



GROUND LIGHT **HIGH POT/ON**

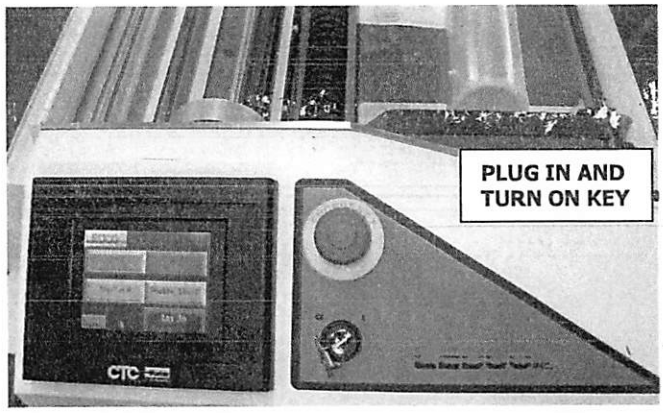
C30-B TESTING UPDATED 2019

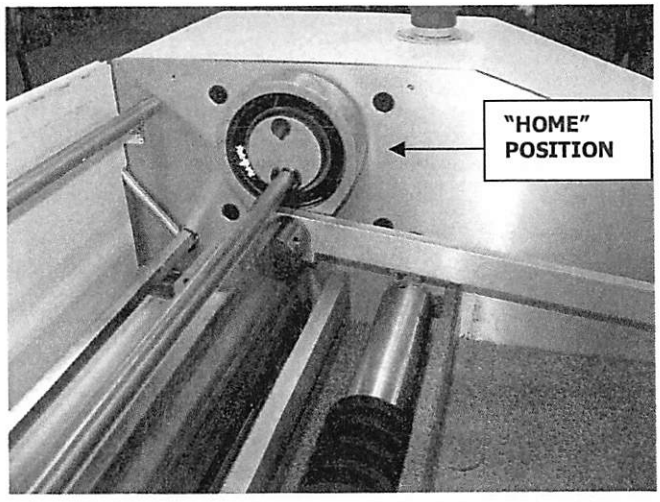
1) PREPARE TO TEST THE CUTTING MECHANISM BY FIRST CHECKING THAT THE 2 POSITION KEY IS IN THE 'O' OFF POSITION.

2) PLUG A 110 VOLT TEST CORD (PRC118) LD05 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) RACK 1 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 LOSE 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) WITH KEY IN THE START POSITION TO ENERGIZE CUTTER, TOUCH SCREEN WILL ILLUMINATE, WAIT UNTIL MAIN MENU COMES UP BEFORE PROCEEDING, SEE (FIG. 1).

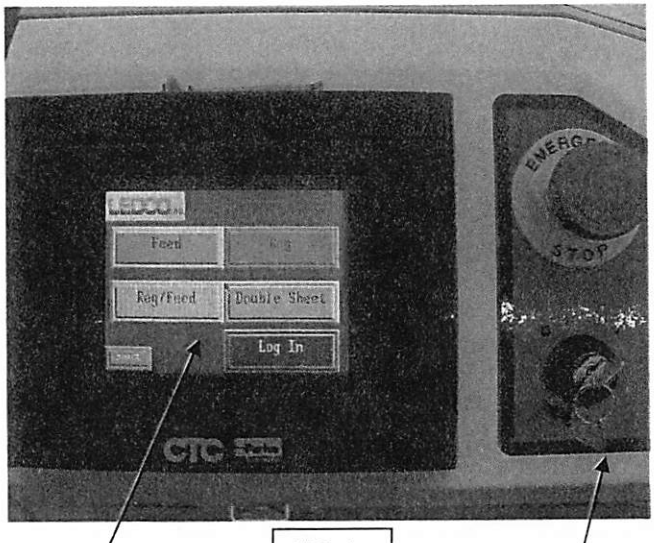
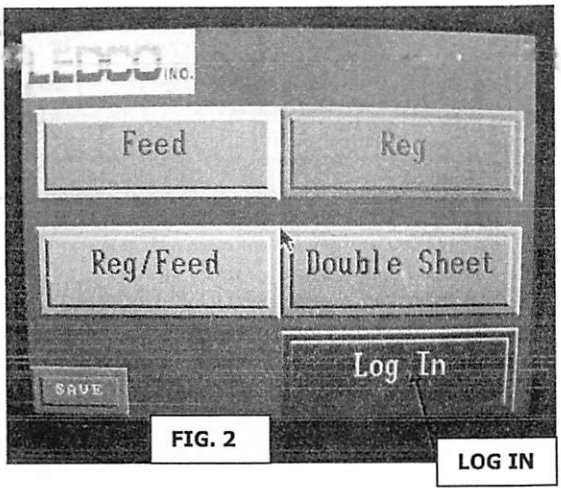
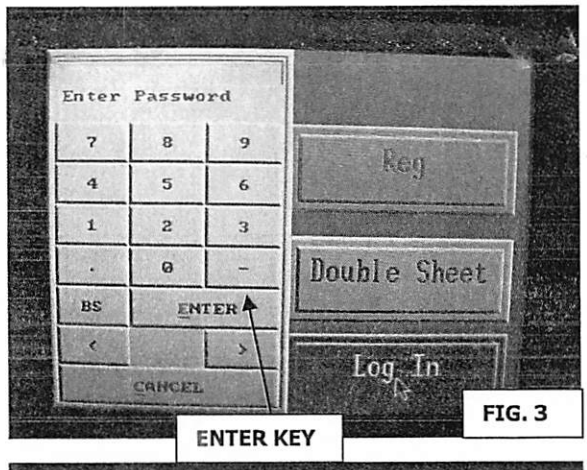
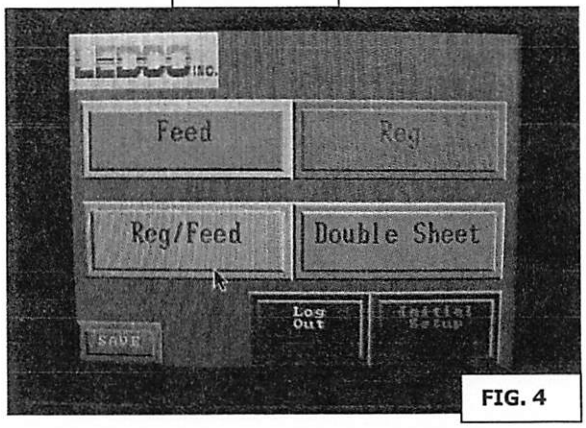


FIG. 1







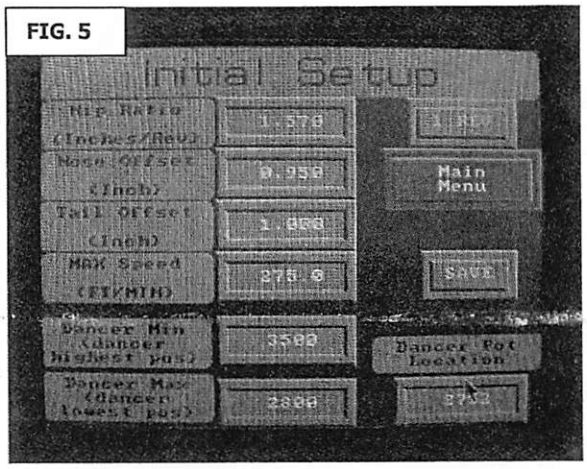
6) AT MAIN MENU PRESS "Log In" BUTTON (FIG.2). GRAY NUMBER PAD APPEARS. TYPE IN PASSWORD NUMBERS 6457 AND PRESS THE "ENTER" KEY, SEE (FIG. 3).

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

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 (ZERO OUT OF BOX) 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. 5



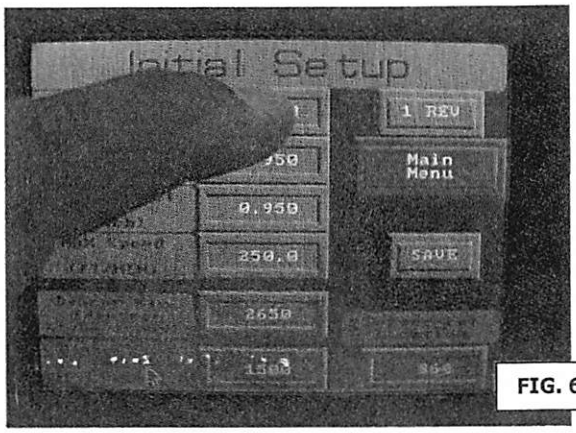
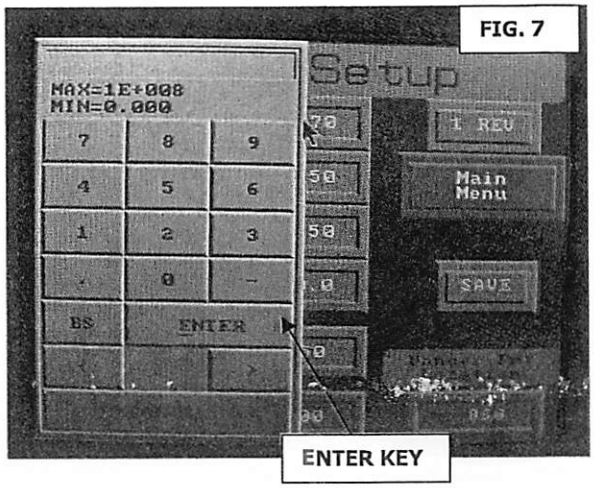


FIG. 7



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.

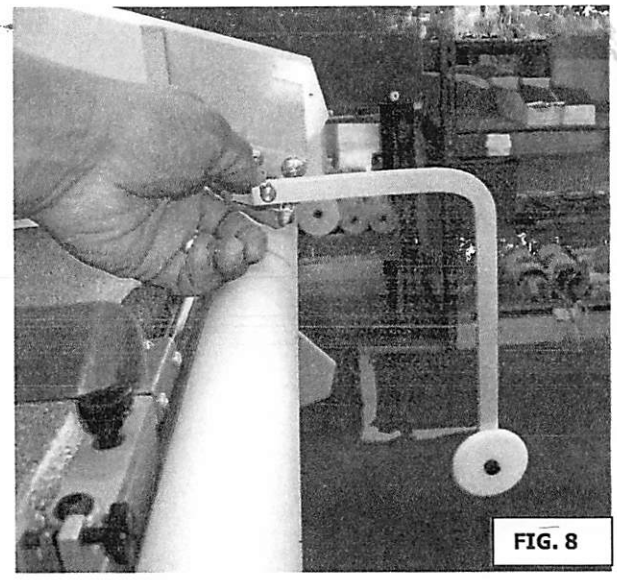


FIG. 8

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.

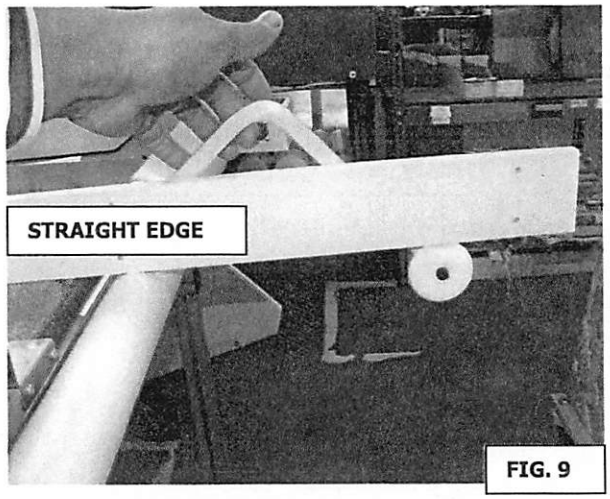


FIG. 9

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

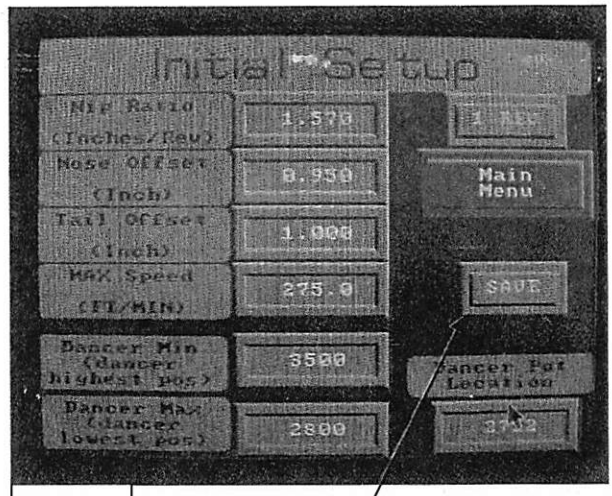


FIG. 10

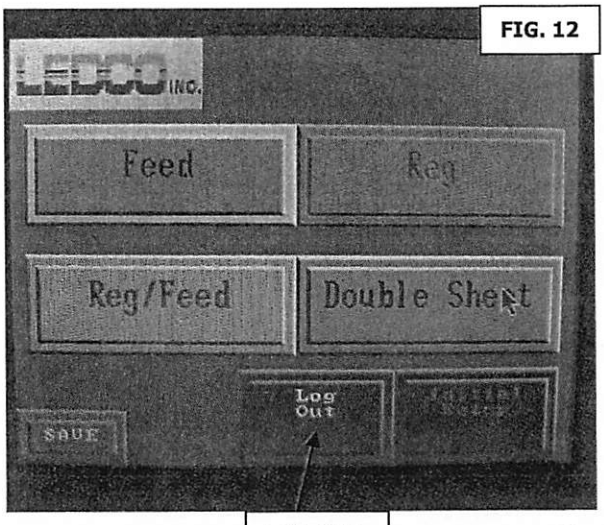
SAVE

12) PRESS LOG OUT (FIG. 12) TO COMPLETE CUTTER INITIAL SETUP PROGRAMMING PROCESS AND RETURN TO CUTTER MAIN MENU.



FIG. 11

FIG. 12

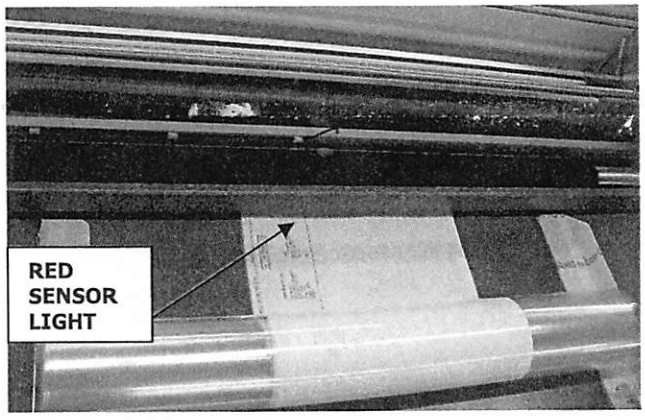


LOG OUT

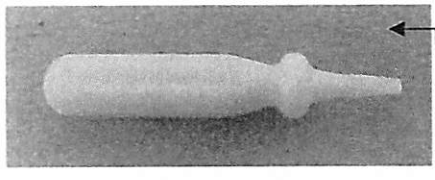
13) THE TOUCHSCREEN IS NOW PROGRAMMED. TEST WITH DOORS OFF OR OPEN.

14) UNDERSTAND THE TOUCHSCREEN TERMS: FEED (FEED MODE) CUTS TO A SPECIFIC LENGTH. THE REG/FEED (REGISTRATION MODE) SETS TRIMMING TO A SENSED EDGE IE. FRONT (NOSE) AND REAR (TAIL). THE NOSE OFFSET AND TAIL OFFSET TRIMS BEFORE AND AFTER A SENSED EDGE AND CUTS TO A SPECIFIC LENGTH. THE PASSWORD IS "6457" WHEN CALLED FOR.

15) WITH THE SAFETY SHIELD IN THE *UP* POSITION AND THE TOP RUBBER ROLL ALSO "*UP*" THREAD FILM WEB WITH LAMINATE CENTERED, BETWEEN STRIPPERS. ALIGN THE ***CLEAR SECTION*** OF TEST FILM BETWEEN RUBBER ROLLS UNDER THE RED FIBER OPTIC SENSOR LIGHT TO MEASURE FILM DENSITY. SECURE TEST FILM BETWEEN FEED GUIDES BY PUTTING TOP RUBBER ROLL "*DOWN*". CLOSE THE SAFETY SHIELD TO RUN. 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.



RED SENSOR LIGHT



AMPLIFIER ADJUSTMENT TOOL IN AMPLIFIER KIT

16) TO ADJUST THE C30 FIBER OPTIC SENSOR "EYE" USE THE WHITE PLASTIC TOOL INCLUDED IN PACKET. A SMALL SCREWDRIVER MAY ALSO BE USED.

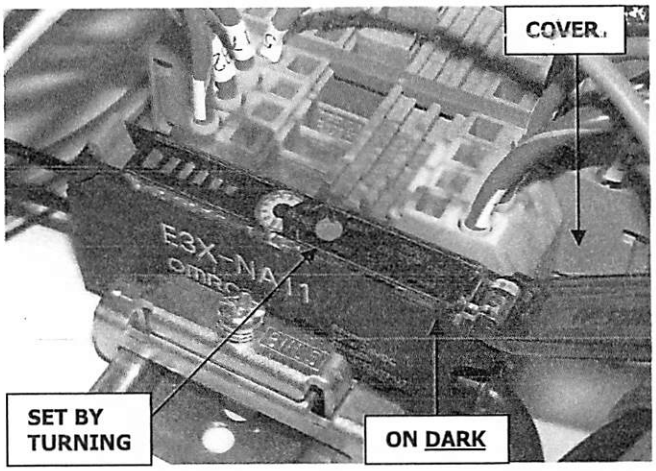
17) OPEN AMPLIFIER COVER. <u>SET SWITCH AT 'D' FOR 'DARK'.</u> USE ADJUSTMENT TOOL TO ROTATE ORANGE ADJUSTING SCREW ***<u>COUNTERCLOCKWISE</u>*** UNTIL IT CLICKS. THE GREEN LIGHTS GO OUT, RED LIGHT WILL REMAIN ON.

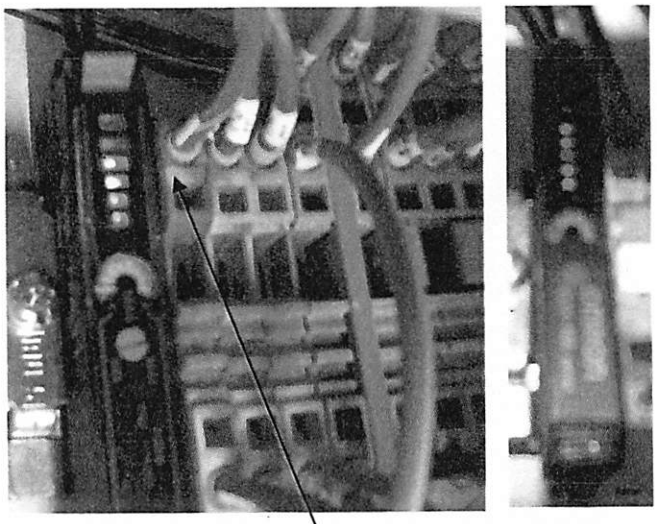
18) TURN THE ADJUSTING SCREW ***<u>SLOWLY CLOCKWISE</u>***. THE OUTER (2) GREEN LIGHTS WILL APPEAR. RED LIGHTS GO OUT. THEN RED LIGHT RETURNS. STOP TURNING WHEN THE FIRST GREEN LIGHT INWARD OF THE RED LIGHT APPEARS. CONTINUE SLOW *CLOCKWISE* TURNING UNTIL TWO INNER GREEN LIGHTS ARE BRIGHT AND STABLE.

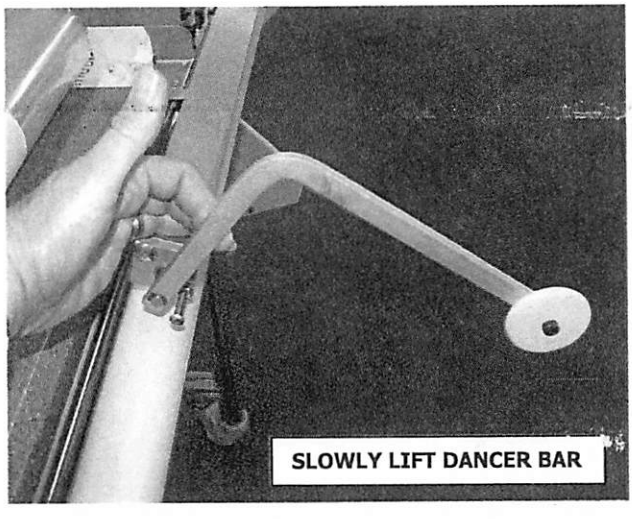
19) CLOSE THE AMPLIFIER COVER. THE AMPLIFIER IS IN THE RUN POSITION. AMPLIFIER IS NOW SET FOR THE MIL FILM UNDER FIBER OPTIC SENSOR.

20) CHECK FUNCTION OF (2) EMERGENCY STOPS. REMOVE THE TEMPERORY DOOR MAGNETS. SECURE DOORS WITH ¼ TURN SCREWS, ALIGNING WITH HOUSING MAGNETS FUNCTION PROPERLY. OPEN DOORS AND REPLACE EXTRA MAGNETS. OPEN AND CLOSE SAFETY SHIELD TO CHECK SHIELD POSITION MAGNET FUNCTION.

21) DEPRESS THE "START" BUTTON ON THE TOUCHSCREEN TO BEGIN CUTTING ACTION, AFTER SETTING 'BATCH' FOR (5) 1" STRIPS. A REGULATED CUTTING SOUND BEGINS. TEST THE DANCER BAR FUNCTION BY *SLOWLY* RAISING AND LOWERING DANCER BAR. AT ABOUT 45 DEGREES THE C30 SHOULD STOP CUTTING AND SHOULD RESUME CUTTING WHEN THE DANCER BAR IS LOWERED.







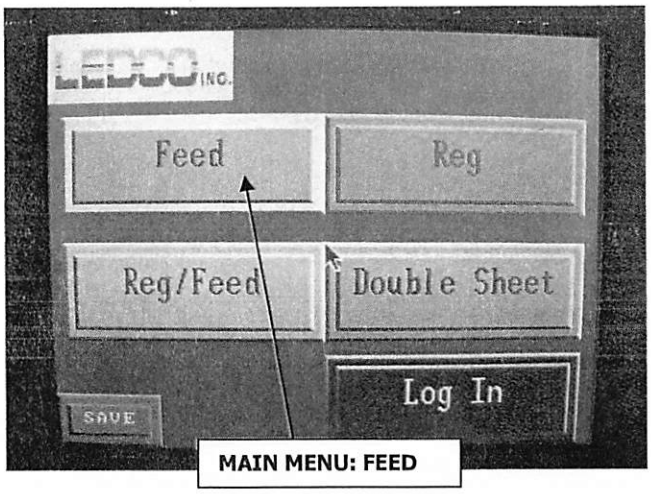
22) TO <u>TEST THE DISTANCE CUTTING</u>, SET THE 'FEED' MODE. DEPRESS THE MENU 'FEED' BUTTON. SCREEN CHANGES.

23) IN THE NEW SCREEN SET TO MEASURE IN 'INCHES' BY DEPRESSING 'ENGLISH/METRIC' BUTTON, IF SCREEN IS NOT ALREADY IN 'ENGLISH.' WHEN IN 'ENGLISH' THE 'LENGTH (IN)' READS IN INCHES. DEPRESS '+' OR '-' FOR INCREASE OR DECREASE IN INCHES. TEST WITH 'BATCH OFF' AND NO DWELL. SET TO MEASURE QUANTITY CUT BEFORE STOPPING. SET FOR QUANTITY OF 'FIVE.' DEPRESS 'SAVE.' FOR NEXT SETTING DEPRESS 'MAIN MENU.'

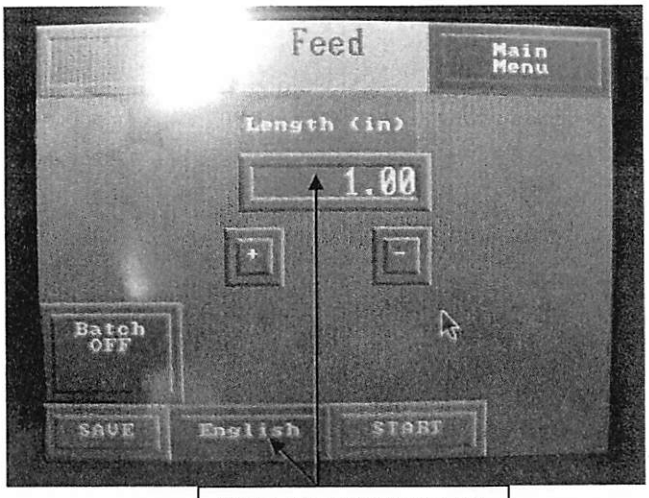
24) DEPRESS THE 'REG/FEED' REGISTRATION MODE KEY. THE NEW SCREEN APPEARS. SET 'NOSE (IN)' AND 'LENGTH (IN)' TO .25 WHICH IS ¼ INCH MEANING THE CLEAR LAMINATE BORDER SPACE NOSE AND TAIL ON THE LAMINATE. NO DWELL.

25) DEPRESS 'BATCH' WITH NO DWELL. THE 'DWELL' IS TIME HALTED BETWEEN CUTS. DEPRESS THE 'SAVE' BUTTON OR THESE NEW SETTINGS WILL BE LOST AFTER THE CUTTER TUIRNS OFF. DEPRESS MAIN MENU.

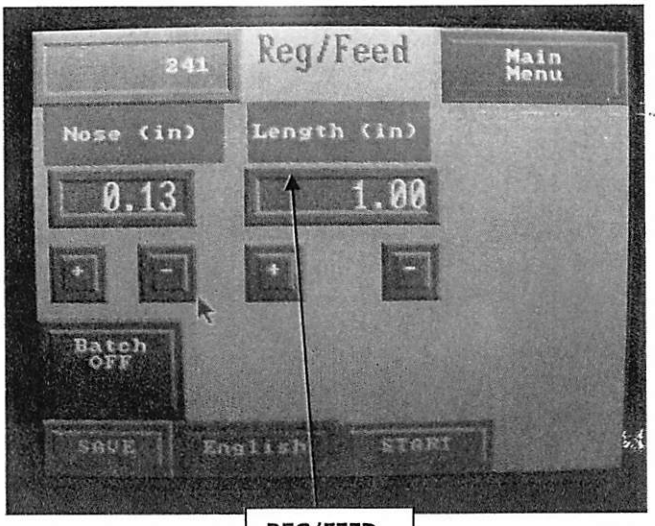
26) SET THE 'NOSE OFFSET' AND THE 'TAIL OFFSET' TO 1.000.



MAIN MENU: FEED

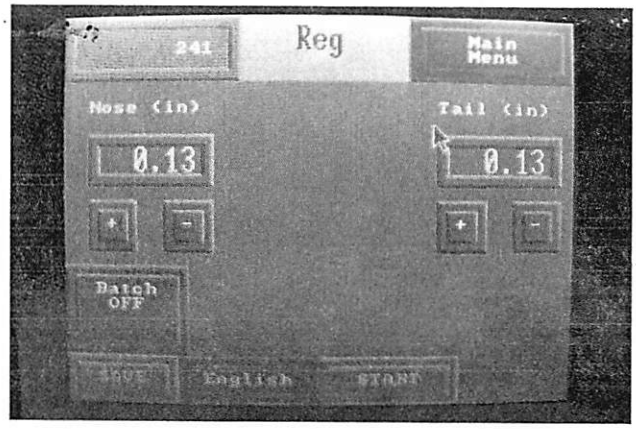


FEED: ENGLISH/METRIC

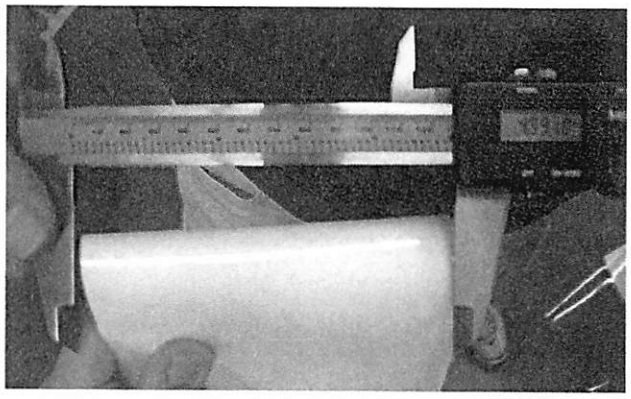


REG/FEED

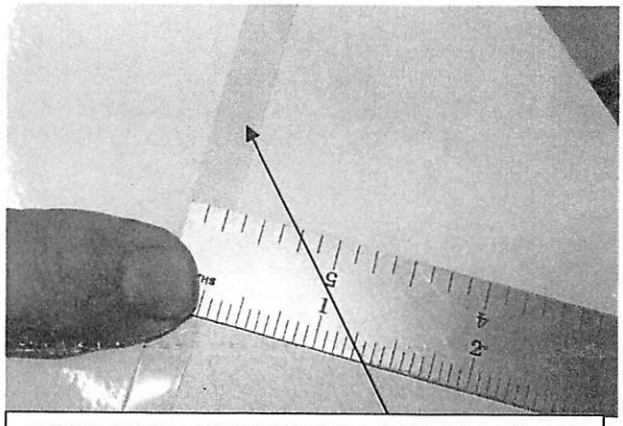
27) USE VERNIER CALIPERS TO MEASURE THE (5) CUT STRIPS WHICH HAVE BEEN CUT TO FIVE INCHE LENGTHS. ONE PERSON HOLDS THE FIVE STRIPS TIGHTLY TOGETHER, A SECOND PERSON MEASURES STRIPS WITH THE VERNIER CALIPER. THE DIFFERENCE SHOULD BE NO MORE THAN .003 AFTER TWO MEASUREMENTS ARE TAKEN.



28) USE A STRAIGHT EDGE RULER TO MEASURE THE NOSE/TAIL CUT TO ¼ INCH. **THE RUBBER ROLL CIRCUMFERENCE FOR THE 30" AUTOCUTTER IS 6.287.



29) *NOSE* SETTING IS DISPLAYED AND SET DURING REG MODE. THE DISPLAY IS LOCATED ON LOWER LEFT SCREEN ABOVE NOSE LEGEND. TO CHANGE NOSE SETTING 1) PRESS NOSE BUTTON 2) SCREEN DISPLAYS WHEN YOU PRESS 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 -.



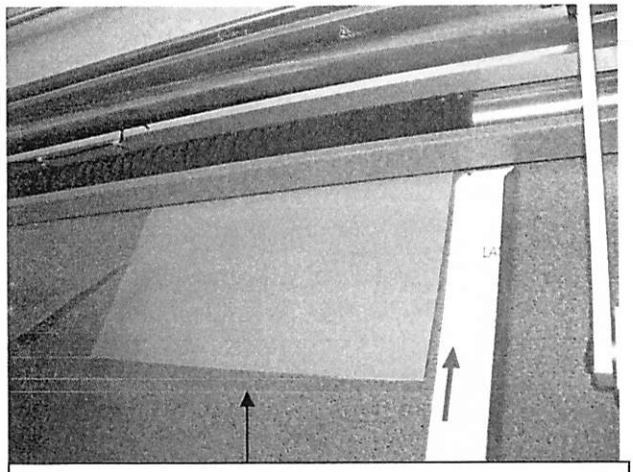
¼" NOSE/TAIL CUT ON CLEAR 1.7 MIL PAST MEDIA

30) THE *TAIL* SETTING IS ONLY DISPLAYED AND SET DURING THE REG/FEED MODE. TAIL DISPLAY IS LOCATED ON LOWER RIGHT OF SCREEN ABOVE TAIL LEGEND. TO CHANGE TAIL SETTING WHILE MACHINE IS STOPPED GO TO THE NUMBER PAD AND KEY IN THE REQUIRED DISTANCE. WHEN YOU PRESS TAIL+ OR TAIL- BUTTON THE



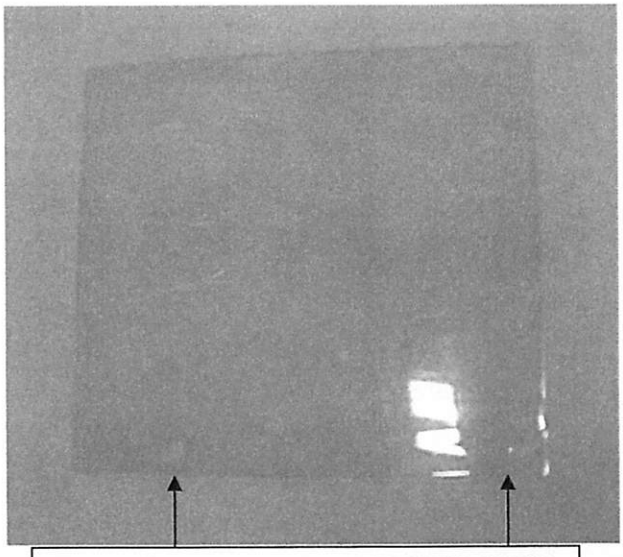
CUT LAMINATE STRIPS

31) AFTER SUCCESSFULLY TESTING AND MEASURING THE 1.7 MIL FILM, TEST THE CUT ON A 10 MIL LAMINATED PIECE OF 'FRESH/UNUSED' FIBERBOARD. THE FIBERBOARD MUST SLIP EASILY BETWEEN THE BOTTOM AND TOP STRIPPER ON THE CUTTER, LEAVING NO SCUFF MARKS. ***** IF THE FIBERBOARD DOES NOT EASILY INSERT BETWEEN THE STIPPERS, (2) SHIMS MUST BE ADDED. CONTINUE TO 32) FOR THIS PROCEDURE.



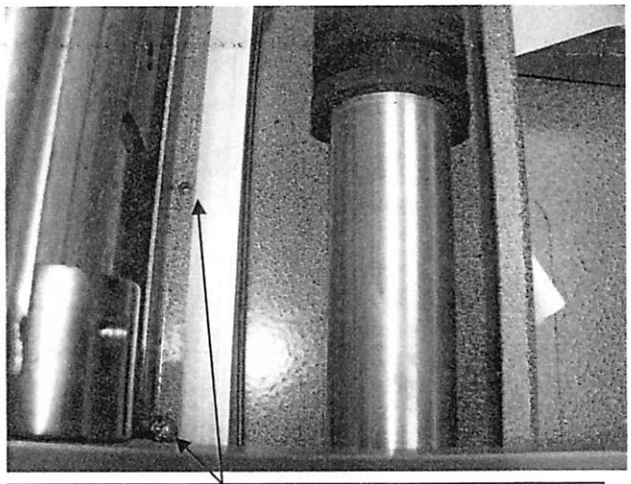
FIBERBOARD ON 10 MIL FILM BETWEEN STRIPPERS

32) USE THE TEMPLATE IN ENGINEERING AND CUT (2) PIECES OF 4" X 4¼" 10 MIL FILM. THE TEMPLATE (2) HAS HOLES MEASURED TO FIT THE SCREWS HOLES CONNECTING THE TOP AND BOTTOM STRIPPER ON BOTH SIDES. ADD THE TEMPLATE TO ONE SIDE AT A TIME. REMOVE THE (2) SCREWS HOLDING THE TOP AND BOTTOM STRIPPERS TOGETHER, SLIDE THE TEMPLATE BETWEEN THE STRIPPERS AND ALIGN THE HOLES IN THE LAMINATE WITH THE STRIPPER HOLES. REPLACE THE SCREWS, SNUG BUT NOT TOO TIGHT. REPEAT THIS PROCEDURE ON THE OTHER SIDE OF THE CUTTER. GENERALLY THE REASON THE STRIPPERE ARE TOO CLOSE TO EACH OTHER IS THE TOP STIPPER ITSELF IS SOMEWHAT OUT OF SPECIFICATIONS. AFTER BOTH TEMPLATES ARE SECURED, THE FIBERBOARD SHOULD EASILY SLIDE BETWEEN STRIPPERS.



4" X 4¼" 10 MIL SHIM WITH PUNCHED HOLES

33) 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 UNITS.

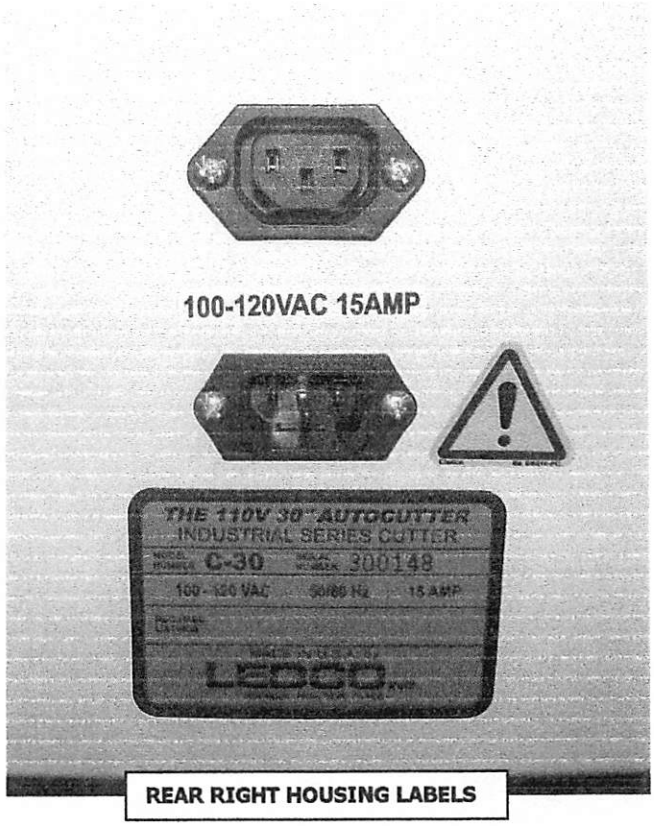


ALIGN TEMPLATE HOLES WITH STRIPPER THREADS

34) ON RIGHT REAR HOUSING ADHERE THE 110-120VAC 15AMP LABEL (LAB120) AS08 CENTERED BETWEEN THE POWER RECEPTACLES. THE LABLE REPRESENTS COMBINED POWER AND EXIT TABLE.

35) BELOW THE POWER RECEPTACLE CENTER AND ADHERE THE 30" 110V AUTOCUTTER SERIAL # DECAL (LAB117) WHICH IS WITH THE WORK JOB.

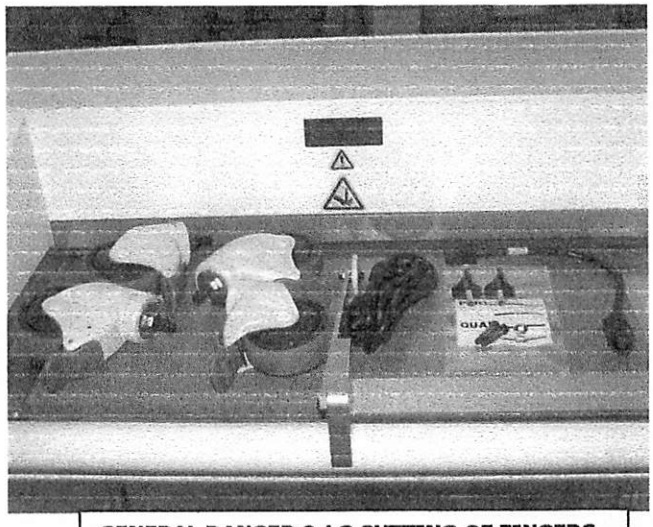
36) RIGHT OF THE POWER OUTLET, ADHERE THE YELLOW GENERAL DANGER LABEL (LAB52) AS08.



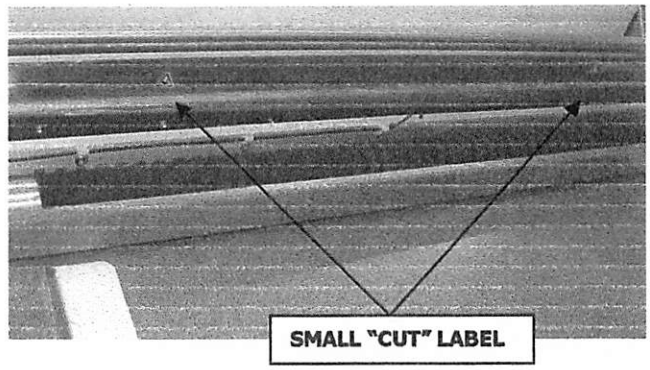
REAR RIGHT HOUSING LABELS

37) ADHERE ANOTHER YELLOW GENERAL DANGER LABEL (LAB52) AS08 CENTERED UNDER THE PULL HANDLE ON THE FRONT OF THE SAFETY SHIELD.

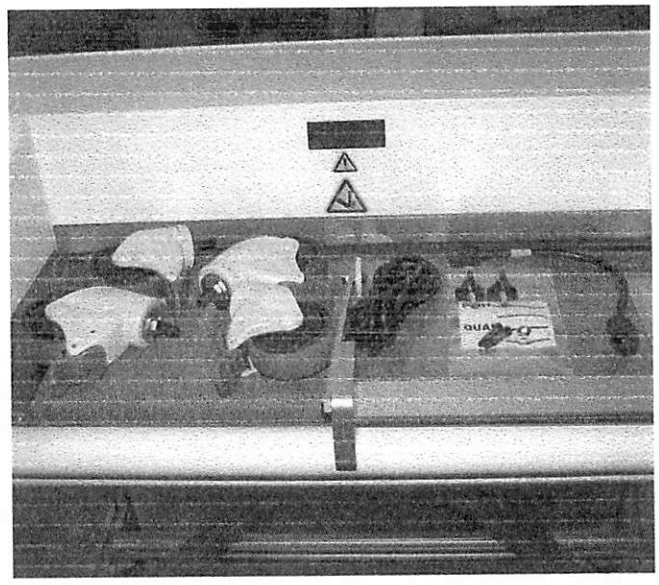
38) UNDER THE GENERAL DANGER LABEL ON THE FRONT SAFETY SHIELD, CENTER A *LARGE* YELLOW CUTTING OF FINGERS AND HAND/STRAIGHT BLADE LABEL (LAB53) AS08.


GENERAL DANGER & LG CUTTING OF FINGERS

39) LIFT UP THE SAFETY SHIELD. PLACE (2) *SMALL* YELLOW CUTTING OF FINGERS AND HAND/STRAIGHT BLADE LABELS (LAB54) AS08. FROM OUTER TOP RUBBER ROLL RIBS COUNT INWARD 8 RIBS AND ALIGN LABEL ABOVE ON BLADE HOLDER.


SMALL "CUT" LABEL

40) **<u>ALIGN AND SLIGHTLY SCORE AT THE HOUSING BEND</u> BEFORE ADHERING ABOVE THE TOUCHSCREEN THE GRAY/RED/BLACK C15/C30 WARNING LABEL (LAB157) RACK 12. THE 3M MULTIPURPOSE SPRAY ADHESIVE CAN IMPROVE ADHESION.



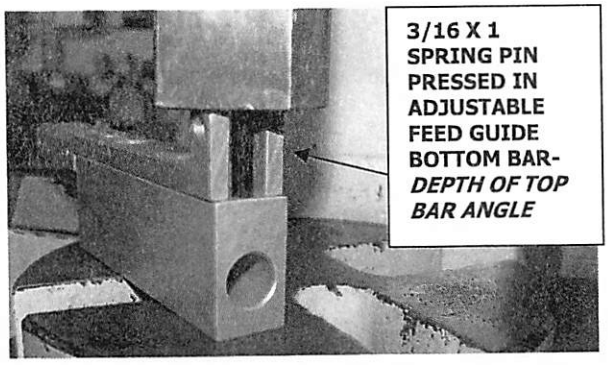
41) PLACE ON FEED TABLE: (4) CASTERS (PRC210) AS05 EACH WITH A ½ USS FLAT WASH AND ½ X 13 HEX NUT, A REMOVEABLE CORD (PRC118) LD05 AND EXIT TABLE CORD. BAG (4) EXIT TABLE ROLLERS, (2) THREE POINT KNOBS AND (2) ¼ X 5/8 X 1/8 FLAT WASHERS. ROTATE DANCER BAR UPWARD TO REST ON FEED TABLE, FOR PROTECTION.

42) FILL OUT PAPERWORK.

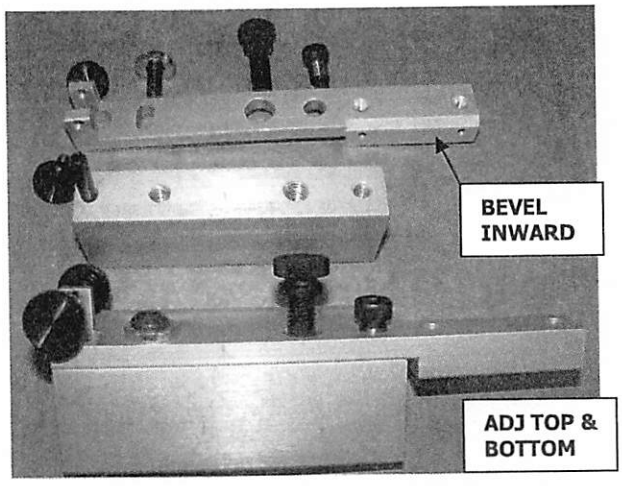


C30 AUTOCUTTER
FEED GUIDE ASSEMBLY 2015

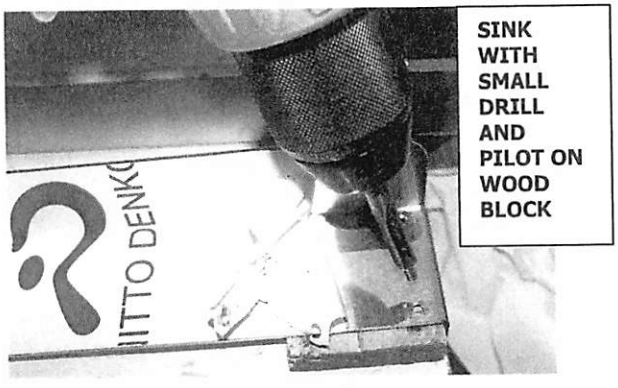
1) FROM RACK 11 PREPARE THE RIGHT AND LEFT FEED GUIDE ASSEMBLY AS FOLLOWS: ARBOR PRESS A 3/16 X 1" SPRING PIN, ***WITH THE SPRING PIN OPENING FACING INWARD, PRESSED INTO THE *UNTHREADED* END OPENING OF (2) ADJUSTABLE FEED GUIDE BOTTOM BARS (C30 097.4BB). MEASURE THE DEPTH OF THE SPRING PIN TO BE FLUSH 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 OF THE ADJUSTABLE FEED GUIDE TOP BARS FACES THE FRONT OF CUTTER.

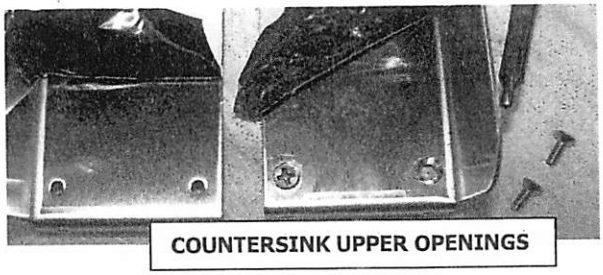


2) SNUG A ¼ X 5/8 X 1/8 FLAT WASHER AND A ¼-20 X ¾ BHSH THROUGH THE TOP BARS INTO THE BOTTOM BAR THREADS BY SPRING PIN. TIGHTEN A 5/16 X 3/8 SHOULDER BOLT INTO THE THREADS BY BEVELED END OF THE TWO TOP BARS TO CONNECT THEM. THREAD A 5/16-18 X 1" PLASTIC MOLDED THUMBSCREW (PRK184) AS09 INTO BOTH FEED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



3) PEEL BACK THE PROTECTIVE COVERING ON AN ADJUSTABLE FEED GUIDE LEFT (C30 097.4L) RACK 11 AND AN ADJUSTABLE FEED GUIDE RIGHT (C30 097.4R) RACK 11 TO EXPOSE THE FRONT AND TOP HOLES. PLACE THE BREAK OF THE ADJUSTABLE FEED GUIDE OVER A WOOD FIXTURE AND USE A SMALL #6 COUNTERSINK WITH PILOT TO OPEN THE (2) TOP HOLES ON BOTH ADJUSTABLE FEED GUIDES. TEST THE DEPTH OF THE COUNTERSINKING WITH A 6-32 FLATHEAD. THE HEAD MUST REST JUST BELOW THE ADJUSTABLE FEED GUIDE SO





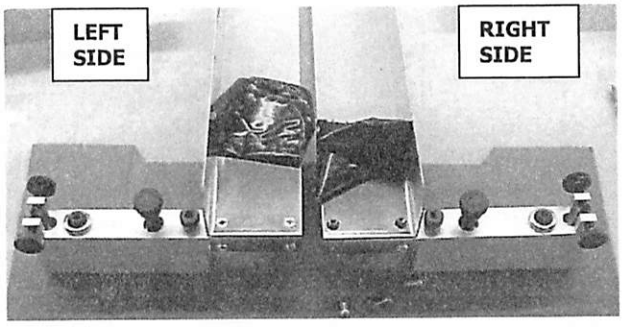
PAPER DOESN'T CATCH, BUT NOT SO DEEP IT FALLS THROUGH THE HOLE.

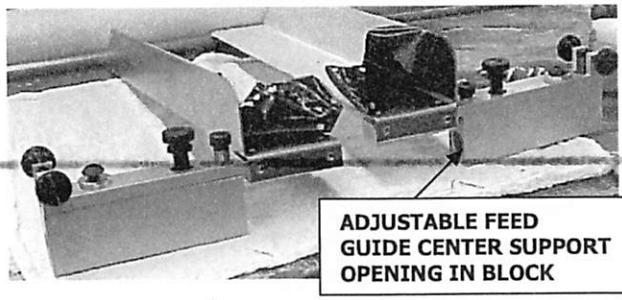
4) SECURE THE ADJUSTABLE FEED GUIDES TO THE COUNTERSUNK ADJUSTABLE FEED GUIDE TOPS, USING (2) 6-32 X ¼ PHMS IN FRONT AND (2) 6-32 X 3/8 FHMS ON TOP IN COUNTERSUNK HOLES. SCREWS MUST BE FLUSH OR DEEPER. ALIGN THE BEVELED SECTION TO THE FRONT, UNDER THE ADJUSTBLE FEED GUIDE AND THE KNOBS TO THE OUTSIDE.

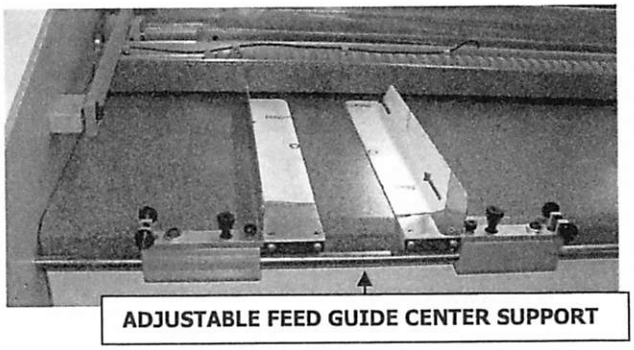
5) INSERT AN ADJUSTABLE FEED GUIDE CENTER SUPPORT (C30 097.4CS) LOFT 2 THROUGH THE OPENINGS IN THE ADJUSTABLE FEED GUIDE BOTTOM BARS. CONNECT TO THE SIDE PANELS UNDER THE BOTTOM STRIPPER USING (2) ¼-20 X ¾ BHSH. THE FEED GUIDES WILL LAY ON THE BOTTOM STRIPPER.

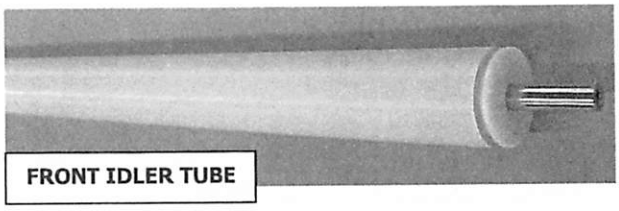
6) TAP IN (2) WHITE FRONT IDLER BEARINGS (C30 413.4) RACK 11, ONE EACH INTO BOTH ENDS OF THE PAINTED FRONT IDLER TUBE (C30 412.4) AS16.

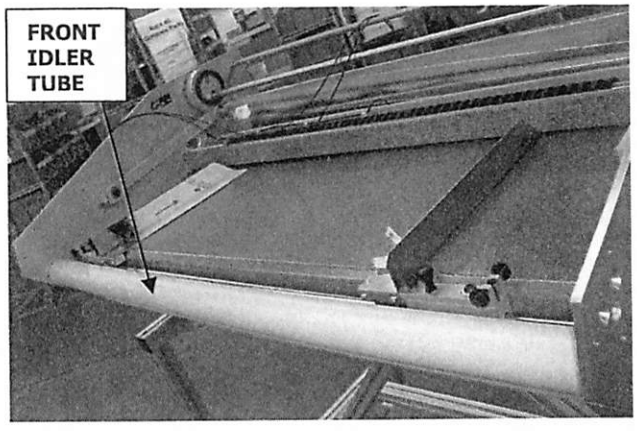
7) INSERT AN ADJUSTABLE FEED GUIDE CENTER SUPPORT (C30 097.4CS) LOFT 2 THROUGH THE FRONT IDLER BEARINGS. CONNECT THE IDLER TUBE ASSEMBLY BETWEEN THE SIDE PANELS, BELOW AND IN FRONT OF THE BOTTOM STRIPPER. USE A ¼-20 X ¾ BHSH ON OUTER SIDE PANELS.







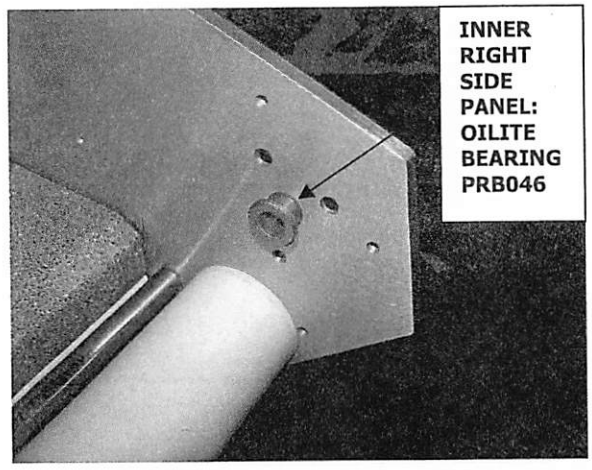




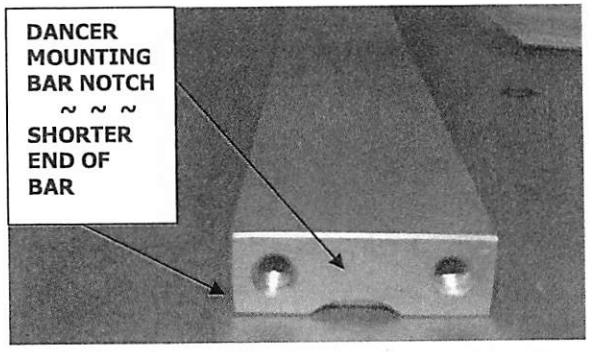
C30 AUTOCUTTER
DANCER BAR ASSEMBLY 2017

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 HEIGHT THE FAILSAFE ENGAGES.

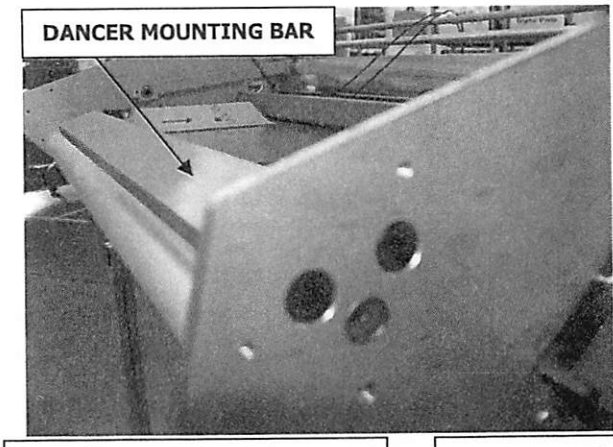
2) TAP AN OILITE BEARING (PRB046) RACK 21 INTO THE INNER FRONT OF RIGHT SIDE PANEL, LOCATED ABOVE FRONT IDLER TUBE, WITH THE OILITE BEARING *FRANGE INWARD* ON IDLER TUBE SIDE. REAM WITH .3800.



3) LOOK AT THE TAPPED ENDS OF A DANCER MOUNTING BAR (C30 288.4) AS17. THERE IS A NOTCH BETWEEN THE THREADS THAT WILL FIT OVER THE OILITE BEARING FLANGE IN SIDE PANEL. THE TWO ENDS OF THE DANCER MOUNTING BAR ***ARE NOT UNIVERSAL*** AND ONLY ONE SIDE FITS THE SIDE PANEL OILITE BEARING FLANGE PROPERLY.

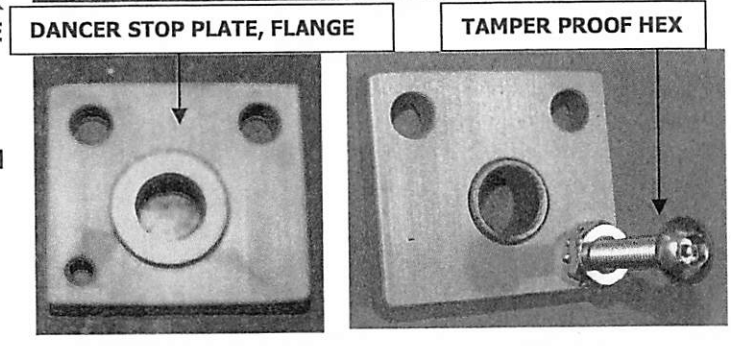


4) ALIGN THE DANCER MOUNTING BAR TO THE INNER RIGHT SIDE PANEL AND SECURE WITH (2) 1/4-20 X ¾ FHSH.



5) ARBOR PRESS ANOTHER OILITE BEARING (PRB046) RACK 21 INTO A DANCER STOP PLATE (C30 295.4) RACK 11 ORIENT FLANGE ON THE SIDE WITH (2) LARGER HOLES UPWARD AND THE SMALLER, THREADED OPENING TO THE LOWER LEFT. REAM WITH .3800.

6) START A 10-32 KEPS HEX NUT UP THE THREADS OF A 10-32 X 1¼ BH TAMPER PROOF HEX (.190OFB20). THREAD THE TAMPER PROOF HEX FROM THE SIDE ***OPPOSITE THE FLANGE*** ON THE DANCER STOP PLATE UNTIL IT IS FLUSH ON THE FLANGE SIDE. TIGHTEN THE KEPS HEX NUT WITH A WRENCH. THIS MAY NEED TO BE REMOVED WHILE SECURING THE DANCER-CURVED TO THE ASSEMBLY.



7) EXAMINE THE DANCER MOUNTING SHAFT (C30 294.4) LOFT 2 AND INSERT THE *SPLIT END OF THE SHAFT* THROUGH THE INNER RIGHT SIDE PANEL, OILITE BEARING FLANGE, LOCATED BELOW THE DANCER MOUNTING BAR.

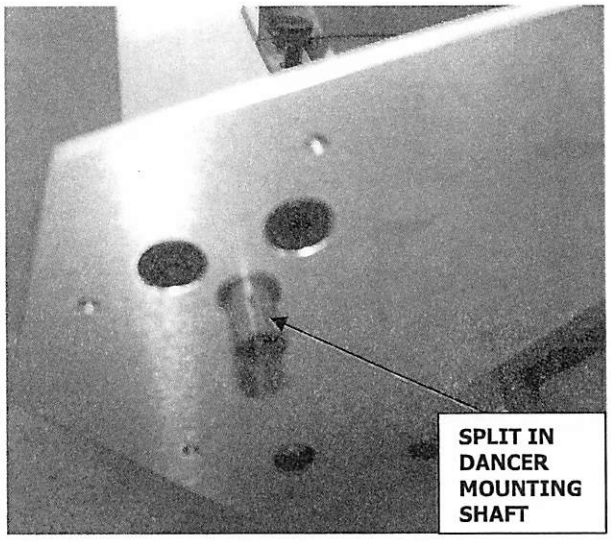
8) SLIDE THE DANCER STOP PLATE, WITH OILITE FLANGE TOWARD THE RIGHT SIDE PANEL, OVER THE DANCER MOUNTING SHAFT END LOCATED UNDER THE DANCER MOUNTING BAR. THE TAMPER PROOF BH HEX IN THE DANCER STOP PLATE FACES AWAY FROM THE DANCER MOUNTING SHAFT. SECURE THE DANCER STOP PLATE TO THE DANCER MOUNTING BAR USING (2) ¼-20 X ¾ THMS. THE DANCER MOUNTING SHAFT MUST SPIN EASILY. IF IT DOES NOT SPIN FREELY, REMOVE AND SAND THE OILITE FLANGE ON THE DANCER STOP PLATE.

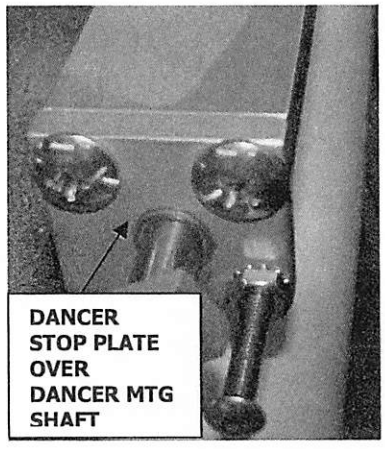
9) PREPARE THE DANCER BAR FOR TOUCHSCREEN, CURVED (C30 289.4A) RACK 11 BY FIRST SECURING A DANCER ROLLER (C30 292.4) RACK 11 THROUGH THE THREADED END, ***OPPOSITE THE KEYWAY***. INSERT A ¼ X 5/16 SHOULDER BOLT INTO THE WHITE DANCER ROLLER AND THREAD INTO THE DANCER BAR FOR TOUCHSCREEN, CURVED. SECURE THE SHOULDER BOLT THREADS WITH A 10-32 ACORN NUT ON THE SAME SIDE AS THE KEYWAY. TIGHTEN WITH WRENCH.

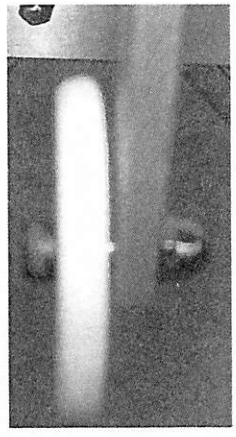
10) PLACE A 1/8 SQ X ¼ LG STRAIGHT KEY (H850 178.4) RACK 9 ***** CHOOSING THE SHORTEST KEY IN THE BOX ON THE RACK, INTO THE KEYWAY OF THE DANCER MOUNTING SHAFT. SOME SANDING MAY BE REQUIRED.

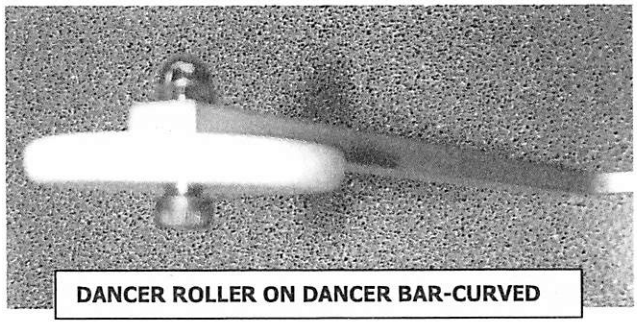
11) SLIDE THE KEYWAY OF THE DANCER BAR-CURVED OVER THE KEY IN THE DANCER MOUNTING SHAFT. SECURE THE DANCER BAR-CURVED TO THE DANCER MOUNTING SHAFT WITH AN EXTERNAL RETAINING RING (PRR098) RACK 12. THE DANCER BAR CURVED WILL REST ON THE TAMPER PROOF BH HEX IN THE DANCER STOP PLATE.

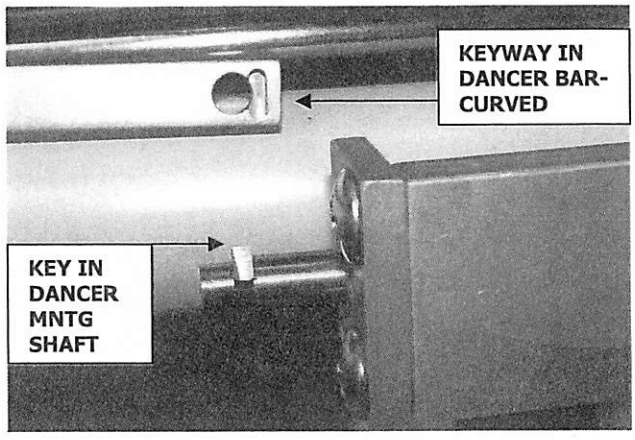
12) THREAD A ¼-20 HEX NUT ONTO A ¼-20



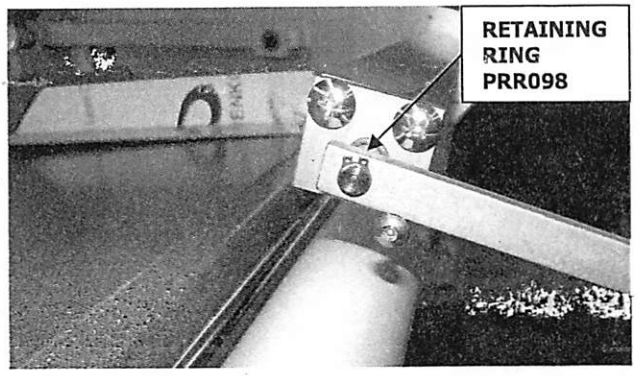




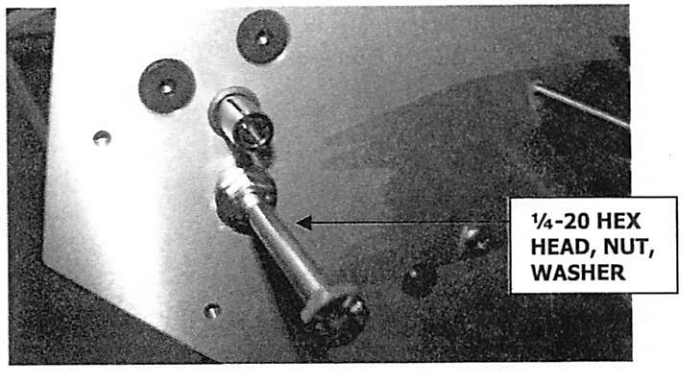




X 2 ½ HHCS. ADD A ¼ X 5/8 X 1/8 WILLIAMS FLAT WASHER AND FROM THE OUTER RIGHT SIDE PANEL, UNDER THE DANCER BAR MOUNTING SHAFT, THREAD INTO THE SIDE PANEL UNTIL IT IS FLUSH ON THE INNER SIDE PANEL. TIGHTEN THE HEX NUT WITH A WRENCH.



13) PREPARE A BOURNS POTENTIOMETER 10K (PRC0306) RACK 23 BY PLACING IT ON A DANCER POTENTIOMETER MOUNTING BRACKET (C30 293.4) RACK 11 WITH POTENTIOMETER TAB FITTING INTO THE OPENING ON THE MOUNTING BRACKET. ON THE OTHER SIDE OF THE POTENTIOMETER MOUNTING BRACKET, ADD A FLAT WASHER AND NUT PROVIDED IN (PRC0306 HARDWARE) RACK 23. NOTE POSITION OF TERMINAL POSTS TO MOUNTING BRACKET NOTCH.

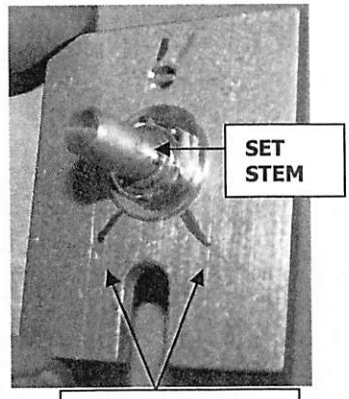


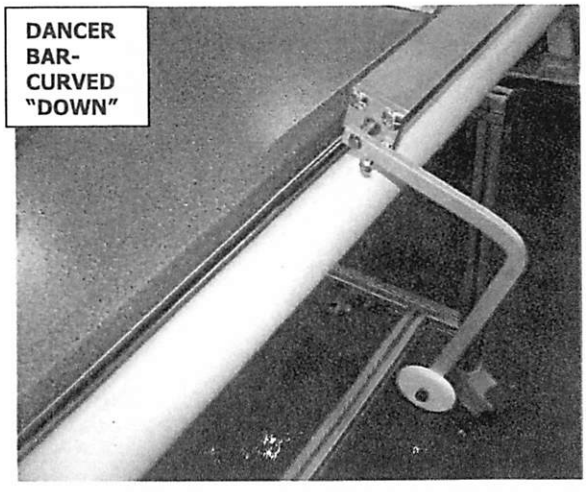
Turn stem all the way clockwise the back off a bit

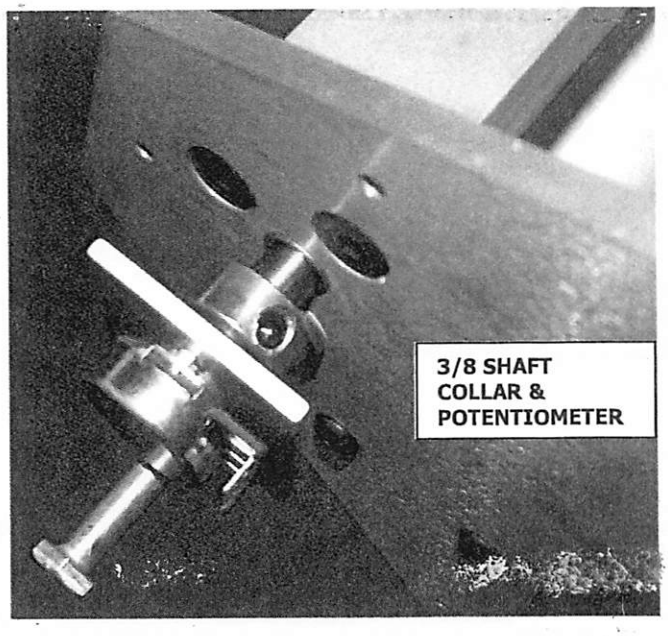
14) TURN & MARK POTENTIOMETER STEM TO IDENTIFY FULL RANGE. SET THE STEM TO THE MIDDLE RANGE.

15) SLIDE A 3/8 SHAFT COLLAR (PRC095) LD03 ONTO SPLIT END OF OUTER DANCER MOUNTING SHAFT. WITH DANCER BAR-CURVED IN THE <u>DOWN POSITION</u> AND MOUNTING SHAFT SPLIT UP, OR AT 'NOON' SLIDE SHAFT COLLAR TO THE END OF THE MOUNTING SHAFT. FULLY INSERT POTENTIOMETER STEM INTO SPLIT MOUNTING SHAFT. ORIENT TERMINAL POSTS FACING CUTTER REAR AND POTENTIOMETER BRACKET NOTCH FITTING OVER ¼-20 HEX HEAD BOLT. ALIGN 3/8 SHAFT COLLAR SS OFF THE SPLIT, OVER STEM AND TIGHTEN WELL. DANCER MUST HAVE FULL RANGE OF MOVEMENT, TO TOUCH STRIPPER.









1.10.17

We measured metal for distance - paper is too vague

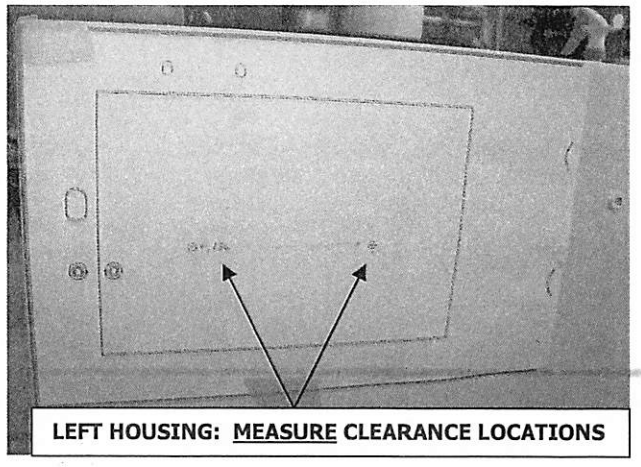
4,136

M3 x 10mm Pan head Phillips

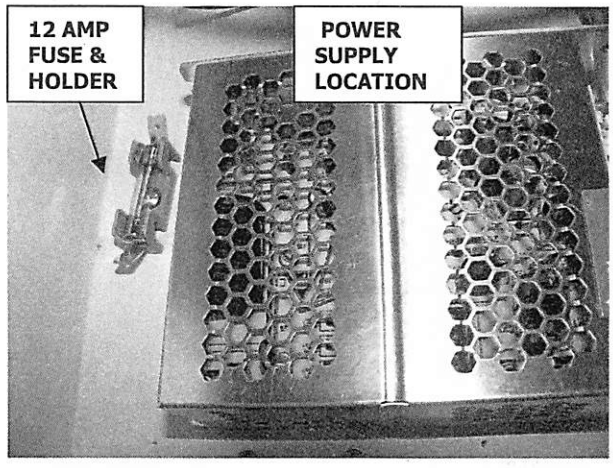
C30 AUTOCUTTER HOUSING ASSEMBLY 2017

1) CLEAN THE LEFT SIDE HOUSING W/TOUCHSCREEN (C30 094.4LB) AS18 BEFORE SECURING ANY PARTS.

2) PLACE THE LEFT HOUSING ON ITS SIDE, WITH OUTER EDGE UPWARD. ***MEASURE*** AND TAPE A TEMPLATE TO THE UNDERSIDE OF THE OUTER, REAR LEFT HOUSING. PRICK PUNCH (2) CLEARANCE HOLE LOCATIONS FOR THE METRIC M3 X 6 MM PHMS SCREWS. OPEN INDICATED LOCATIONS THROUGH TEMPLETE AND BOTTOM HOUSING, USE A #29 DRILL.



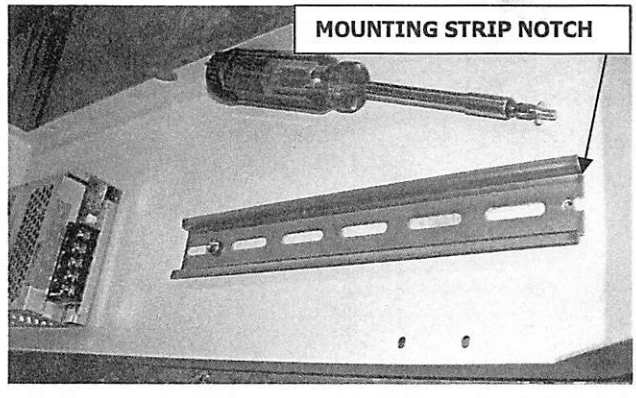
3) ***AFTER HOUSING IS ON SIDE PANEL,*** SECURE AN IN/OUT POWER SUPPLY (PRC0323) RACK 13 TO THE LOCATION DRILLED. ORIENT THE POWER SUPPLY WITH THE TERMINAL BLOCK FACING THE RIGHT/FRONT. SECURE WITH (2) M3 X 6 MM PHMS RACK 4 FROM HOUSING UNDERSIDE INTO THE POWER SUPPLY DIAGONAL THREADS.



4) SECURE FUSE HOLDER (PRF126) AS09 IN REAR BOTTOM HOUSING THREADS. USE A 6-32 X ¼ PHMS.

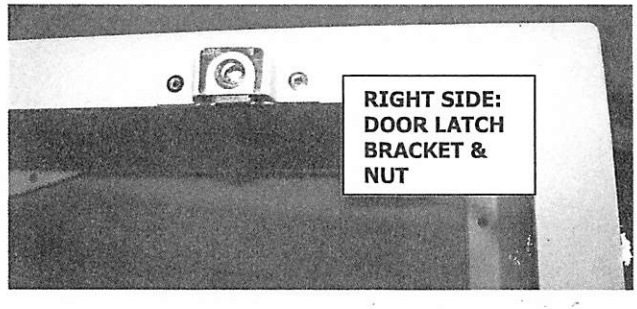
5) INSERT A 12 AMP FUSE (PRF131) AS09 INTO THE FUSE HOLDER.

6) NOTE THE LOCATION FOR THE DINRAIL MOUNTING STRIP HOUSING. THE MOUNTING STRIP IS ASSEMBLED IN THE WIRE HARNESS WITH TERMINALS ON IT. NOTE END NOTCH FOR FUTURE SCREW LOCATION ONLY.



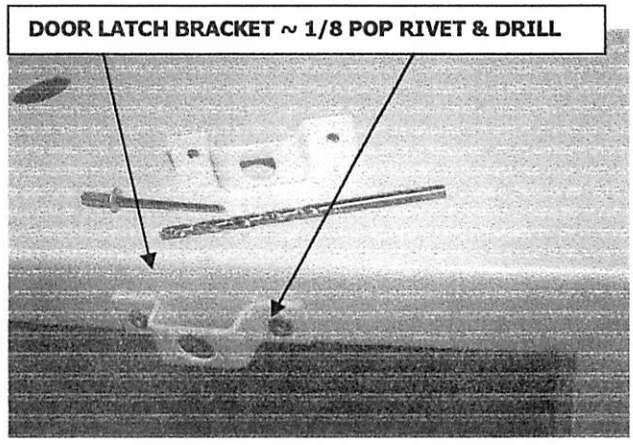
7) THE UPPER, OUTER LIP OF THE RIGHT HOUSING W/TOUCHSCREEN (C30 094.4RA) AS18 WILL *LATER* HAVE A HAMLIN PROXIMITY SWITCH MAGNET (PRS351) WHICH IS IN THE WIRING HARNESS. THE RED WIRES WILL HAVE FERRULE CONNECTORS. WHEN SECURING USE (2) 4-40 X 3/8 PHMS ON OUTER LIP AND (2) 4-40 HEX NUTS.

AS16

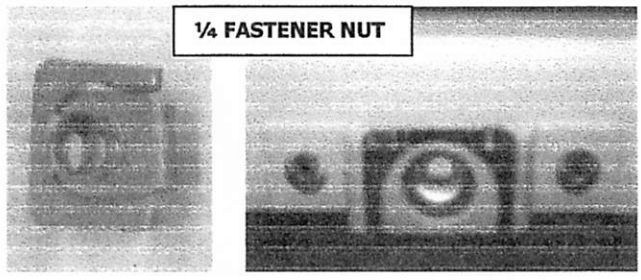


ON THE RIGHT HOUSING THE RED WIRES FACE THE REAR OF THE CUTTER. THE LEFT HOUSING PROXIMITY SWITCH MAGNET IS ALSO IN WIRING HARNESS. THE WIRES WILL FACE THE FRONT.

8) OPEN THE OUTER HOUSING LIP HOLES AND THE (4) DOOR LATCH BRACKET (I30 097.4) RACK 15 HOLES WITH A 1/8 DRILL. SECURE DOOR LATCH BRACKETS TO RIGHT AND LEFT HOUSING LIP WITH 1/8 FH POP RIVETS (.125BOQ06) AS12.

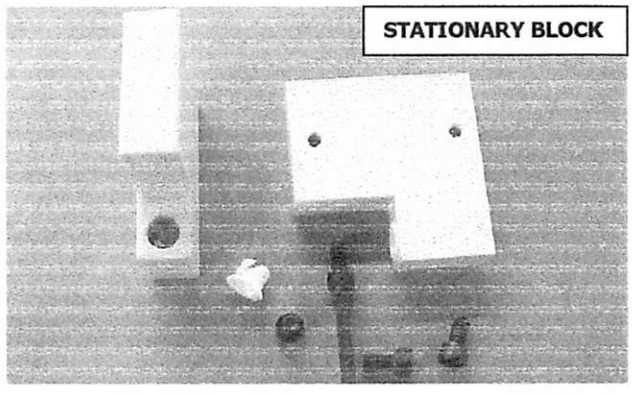


9) FROM THE ¼ TURN LATCH SET (PML002) AS08 CLIP (2) ¼ TURN FASTENER NUTS ONTO DOOR LATCH BRACKETS, WITH SQUARE SIDE OUTWARD, CENTER OVER DOOR LATCH BRACKET OPENINGS. SNAP ON FROM THE INSIDE OUTWARD.

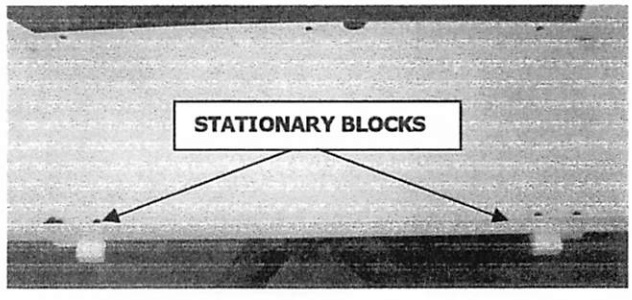


10) CONNECT THE RIGHT SIDE HOUSING (C30 094.4R) AS15 TO THE RIGHT SIDE PANEL USING (14) 10-32 X ¼ THMS. DO ***NOT USE THE THREADS ON THE UPPER REAR***, ACROSS FROM THE OPEN THREADS ON THE LEFT SIDE PANEL.

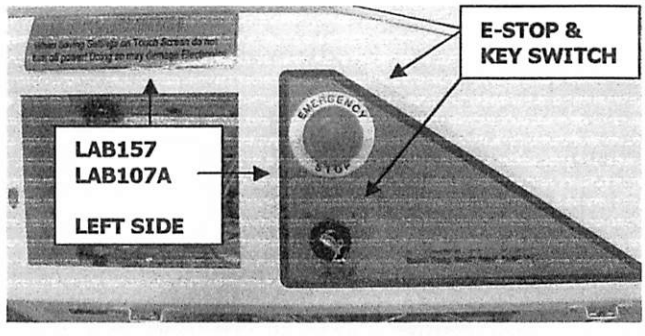
11) INSERT (4) WHITE NYLINER BEARINGS 3/16 ID (PRB202) RACK 1 INTO (4) STATIONARY HINGE BLOCKS (C25 105.4) RACK 11. ORIENT (2) HINGE BLOCKS WITH BOTH ***NYLINER BEARINGS OUTWARD*** AND SECURE TO BOTH LOWER HOUSINGS WITH (4) 6-32 X ¼ SHCS ON EACH SIDE, INWARD ON CHANNEL.



12) SECURE LEFT HOUSING TO THE LEFT SIDE PANEL USING (14) 10-32 X ¼ THMS. ANGLE A LONG SCREWDRIVER THROUGH THE TOP ACCESS OPENING AND CONNECT THAT SCREW TO HOLD HOUSING IN PLACE. INSERT THE REMAINING SCREWS. OFTEN ADJUSTMENT OR TAPPING IS REQUIRED. ***DO NOT USE THE REAR TOP THREADS***.



13) CENTER AND ADHERE THE AUTOCUTTER CONTROL DECALL (LAB107A) RACK 13 OVER THE (2) LEFT HOUSING SWITCH APERTURES, COVERING SCREW ACCESS HOLES. ALIGN LABEL TO EXPOSE BOTH SWITCH "CATCH" NOTCHES.



HOLES. ALIGN LABEL TO EXPOSE BOTH SWITCH "CATCH" NOTCHES.

14) FROM AS07 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.

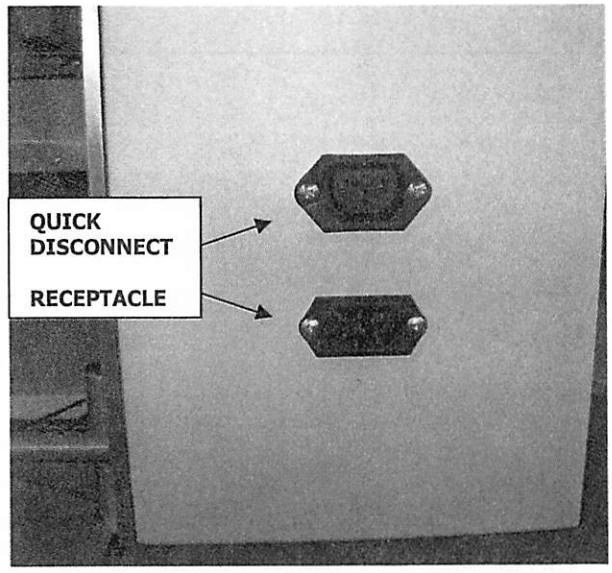
15) BELOW THE E-STOP SWITCH INSERT THE IDEC 2 POSITION KEY SWITCH (PRS003) RACK 12, "TOP" INDICATION UPWARD, *BLUE SIDE FACES THE REAR*. THE KEY REMAINS IN THE SWITCH. TIGHTEN WITH CASTLE TOOL.

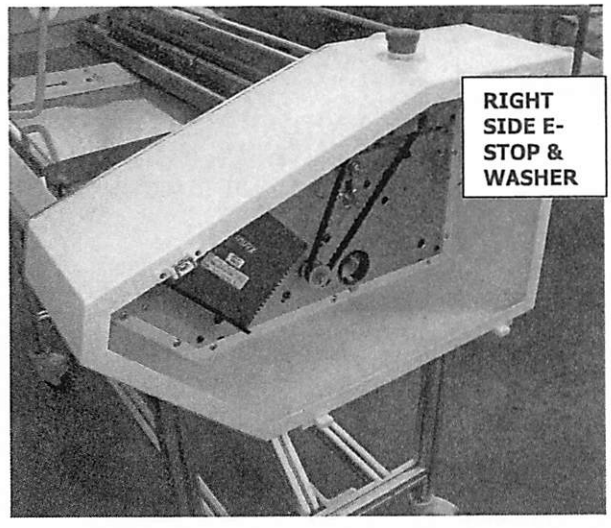
16) WITH THE SINGLE PLUG OPENING DOWNWARD, INSERT THE QUICK DISCONNECT AC OUTLET (PRR253) RACK 11 INTO THE UPPER REAR POSITION ON THE LEFT HOUSING. SECURE TO LEFT HOUSING WITH (2) 6 X 3/8 TH SMS.

17) BELOW THE QUICK DISCONNECT AC OUTLET INSERT THE RECEPTACLE CORD PANEL MOUNT (PRC117) AS09, POSITIONING THE SINGLE TERMINAL POST DOWNWARD. USE (2) 6 X 3/8 TH SMS TO SECURE THE RECEPTACLE TO THE LEFT HOUSING.

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

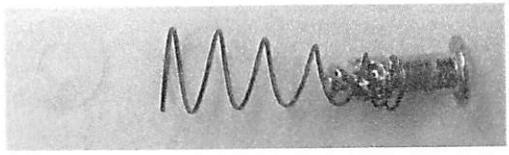




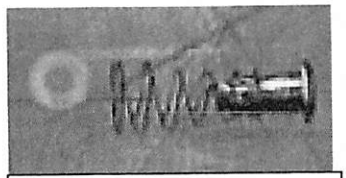


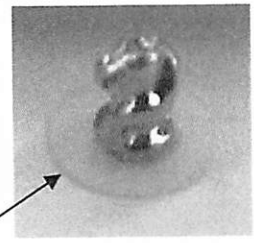
C30 AUTOCUTTER
DOOR ASSEMBLY 2015

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

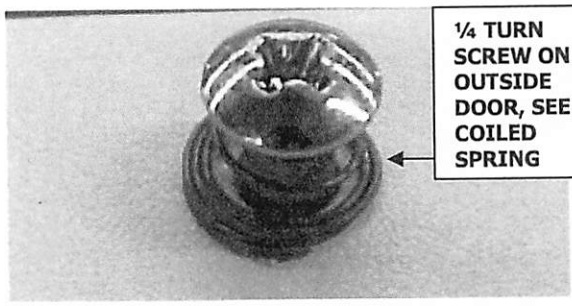


2) THE RIGHT HOUSING DOOR (C30 095.4R) AS16 IS ASSEMBLED BY FIRST ATTACHING (2) HINGE QUARTER TURN LATCHES, USING THE QUARTER TURN DOOR LATCH KIT (PML002) AS08. PLACE THE SMALLER END OF THE SPRING ON A QUARTER TURN FASTENER SCREW. INSERT QUARTER TURN FASTENER SCREW INTO OPENING ON THE OUTSIDE OF DOOR, DEPRESSING SPRING ON OUTSIDE. FROM INSIDE, SLIDE THE PLASTIC WASHER OVER THREADS OF QUARTER TURN FASTENER SCREW AS YOU TURN THE SCREW, UNTIL WASHER RESTS ON SHAFT PAST THREADS.



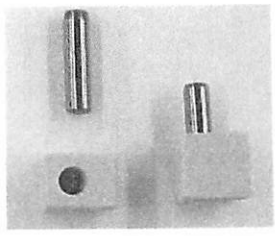


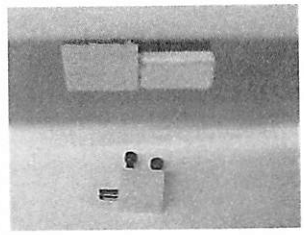
¼ TURN SCREW INSIDE DOOR, PASTIC WASHER



¼ TURN SCREW ON OUTSIDE DOOR, SEE COILED SPRING

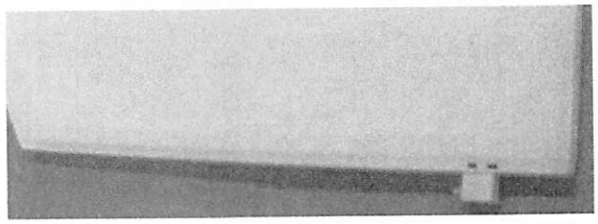
3) ARBOR PRESS (4) 3/16 X ¾ DOWEL PINS (.187J0P12) ONE EACH INTO (4) ROTATING HINGE BLOCKS (C25 106.4) RACK 11, TWO FOR EACH DOOR.

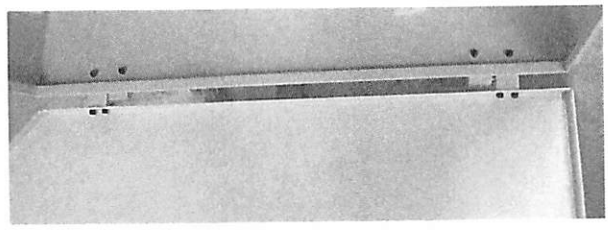




4) CONNECT THE REAR ROTATING HINGE BLOCK WITH DOWEL PIN TO THE LOWER LIP OF THE DOORS, ORIENTED WITH THE DOWEL FACING INWARD. USE (2) 6-32 X ¼ SHCS.

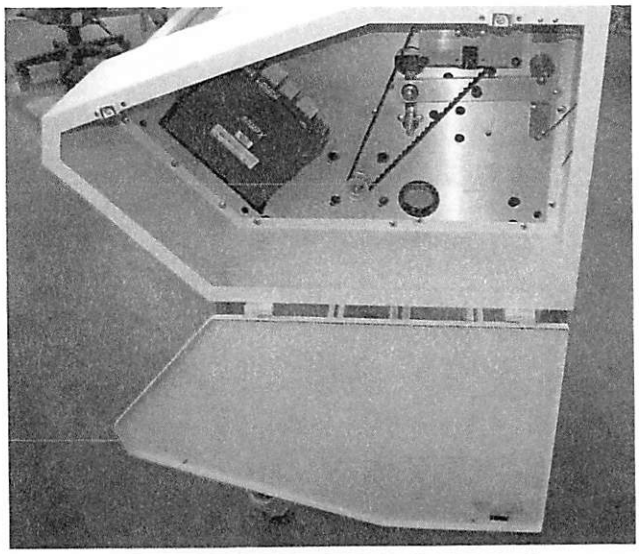
5) THE SECOND ROTATING HINGE BLOCK IS ATTACHED WHEN THE DOOR IS CONNECTED TO THE HOUSING. FIRST, INSERT THE REAR DOWEL PIN INTO THE HOUSING STATIONARY HINGE BLOCKS. THEN INSERT THE FRONT DOWN PIN INTO THE STATIONARY HINGE BLOCK, ALIGN THE SCREW THREADS AND SECURE THE ROTATING HINGE BLOCK TO THE FRONT HOUSING. USE (2) 6-32 X ¼ SHCS TO SECURE THE ROTATING HINGE BLOCK.



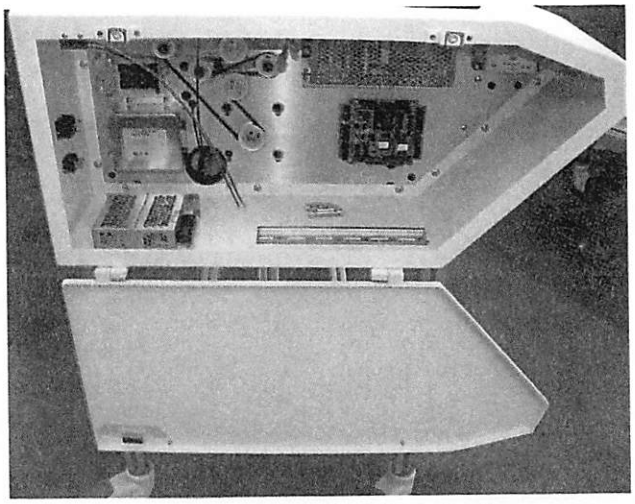


6) THE LEFT SIDE HOUSING DOOR (C30 095.5.4L) AS16 HAS (2) QUARTER TURN LATCHES. ASSEMBLE THESE LATCHES THE SAME WAY AS ON THE RIGHT SIDE HOUSING DOOR DESCRIBED ABOVE.

7) AFTER THE ROTATING HINGE BLOCKS ARE CONNECTED TO THE STATIONARY HINGE BLOCKS CLOSE DOORS TO TEST FIT.



MAGNET ON INNER RIGHT DOOR



MAGNET ON INNER LEFT DOOR