

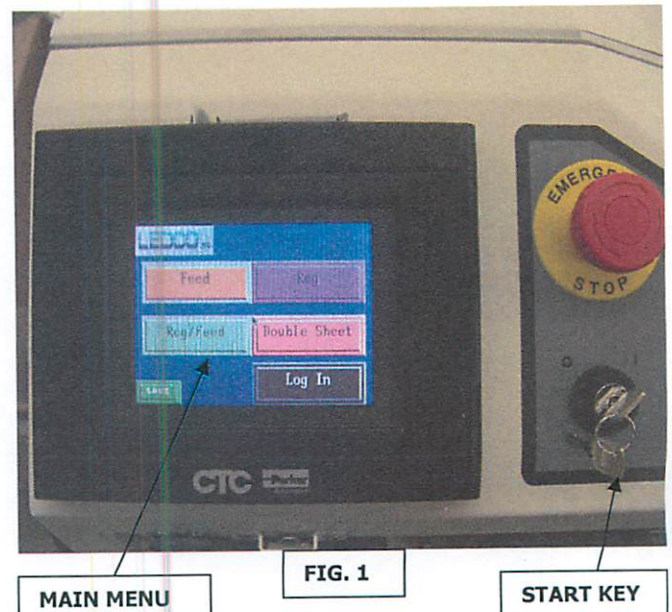
# C30 AUTOCUTTER TESTING 2015

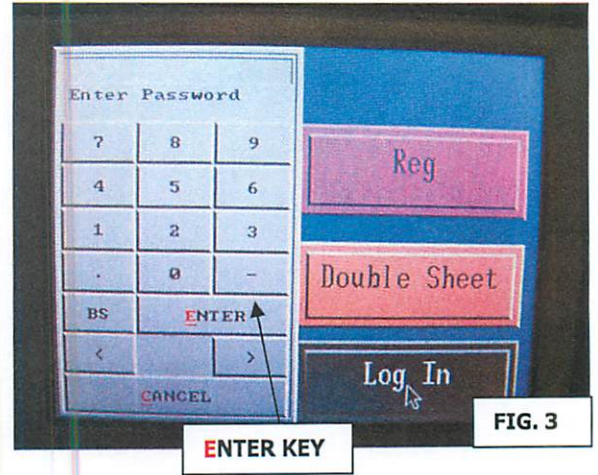
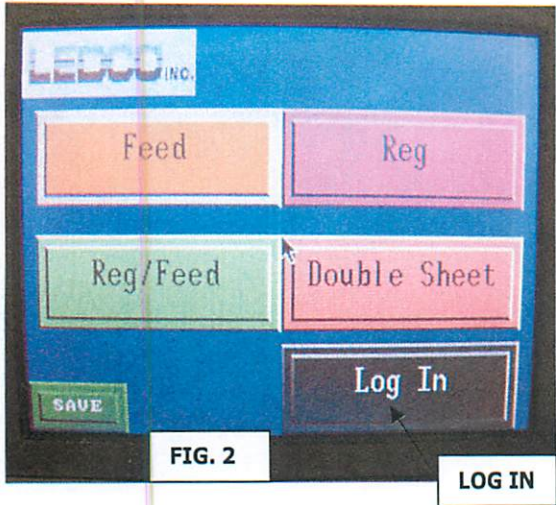
- 1) PREPARE TO TEST THE CUTTING MECHANISM BY FIRST CHECKING THAT THE 2 POSITION KEY IS IN THE 'O' OFF POSITION.
- 2) PLUG A 110 VOLT TEST CORD (PRC118) INTO THE C30 AUTOCUTTER RECEPTACLE AND INSERT THE OTHER END OF THE CORD INTO A 110V OUTLET.
- 3) TEST WITH THE DOORS OPEN. SNAP A TEMPORARY MAGNET (PRS352) ONTO THE RIGHT AND LEFT HOUSING PROXIMITY MAGNETS. USE MASKING TAPE TO SECURE, SO MAGNETS DO NOT FALL OFF WHILE TESTING, WHICH WOULD MAKE THE TOUCHSCREEN LOOSE ACTIVATION.
- 4) TURN THE 2 POSITION KEY TO THE 'I' ENGAGE POSITION. ALLOW TIME FOR THE TOUCHSCREEN TO INITIALIZE. THE TOUCHSCREEN WILL ENERGIZE CUTTER AND THE GUILLOTINE CONNECTING BLOCK WILL MOVE TO THE "HOME" POSITION.



## C30-B CUTTER INITIAL PROGRAMMING SETUP

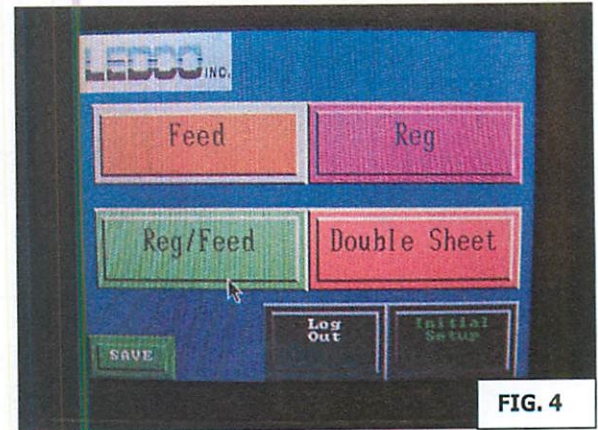
- 5) TURN KEY TO THE START POSITION TO ENERGIZE CUTTER. TOUCH SCREEN WILL ILLUMINATE, WAIT UNTIL MAIN MENU COMES UP BEFORE PROCEEDING, SEE (FIG. 1).





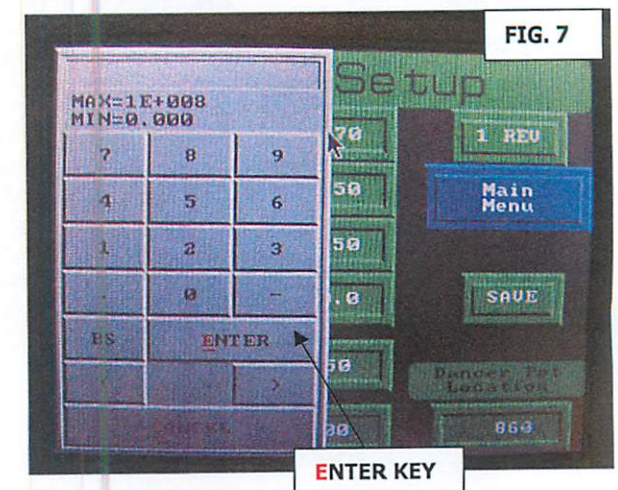
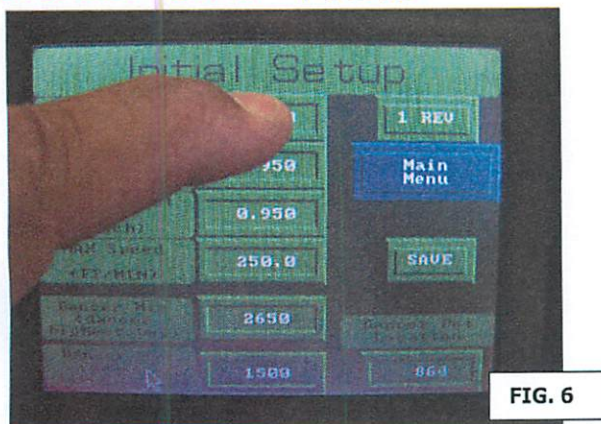
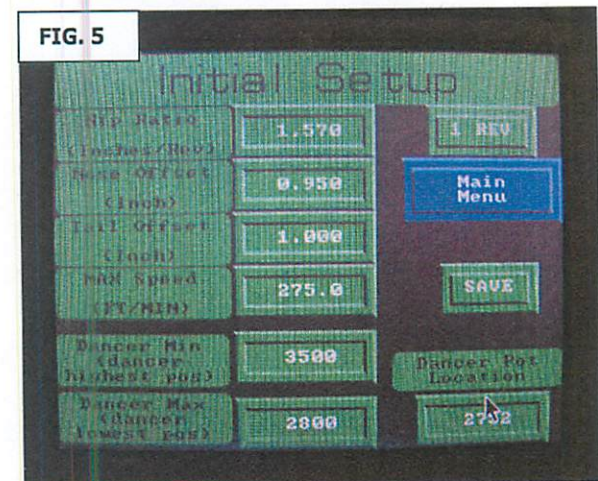
6) AT MAIN MENU PRESS "Log In" BUTTON (FIG.2). GRAY NUMBER PAD APPEARS. TYPE IN PASSWORD NUMBERS **6457** AND PRESS THE "ENTER" KEY, SEE (FIG. 3).

7) PRESS "Initial Setup" BUTTON ON LOWER RIGHT SIDE OF SCREEN, SEE (FIG.4). 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) AND MAY HAVE TO CHANGE IF THEY DIFFER IN LENGTHS DURING SAMPLE RUNS**). TO CHANGE NUMBER, PRESS BUTTON OF NUMBER YOU WANT TO CHANGE (FIG. 6) AND ENTER NUMBER YOU WANT THEN PRESS THE "ENTER" KEY, SEE (FIG. 7).

**NIP RATIO: 1.570**  
**NOSE OFFSET: 0.950**  
**TAIL OFFSET: 1.000**  
**MAX SPEED: 275.0 → 250.0**



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



FIG. 8

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

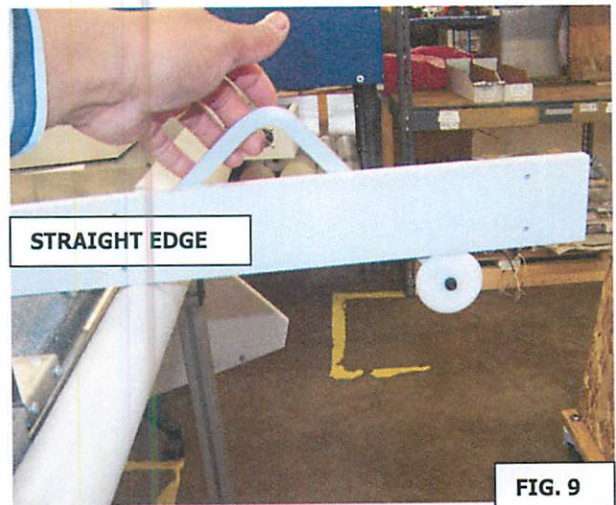


FIG. 9

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

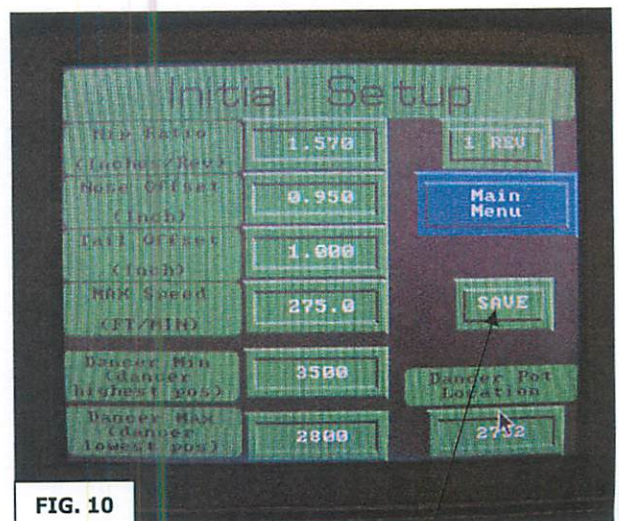


FIG. 10

SAVE

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

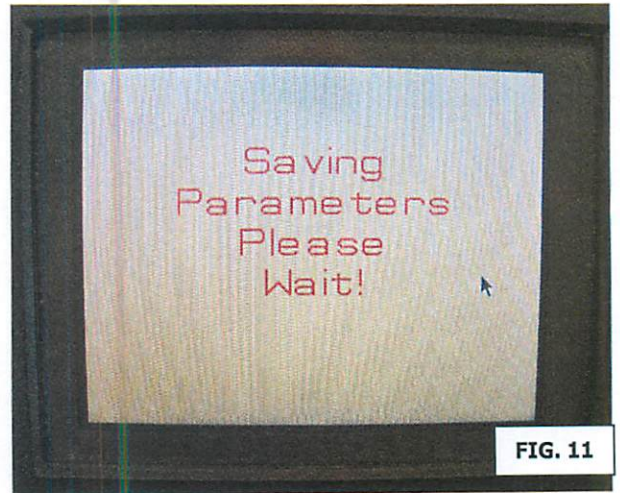


FIG. 11

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.

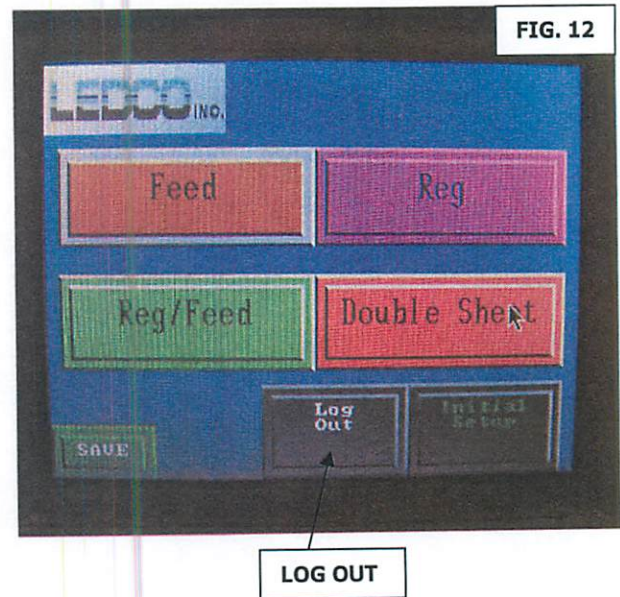
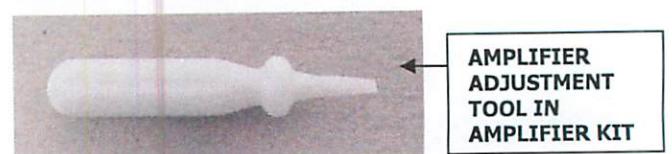
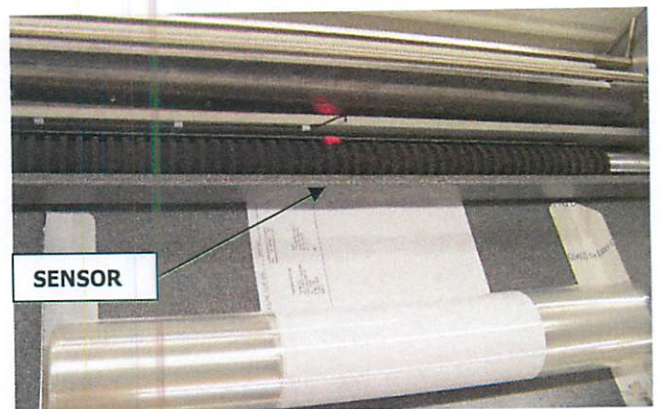


FIG. 12

15) WITH THE SAFETY SHIELD *UP* AND THE TOP RUBBER ROLL *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.



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

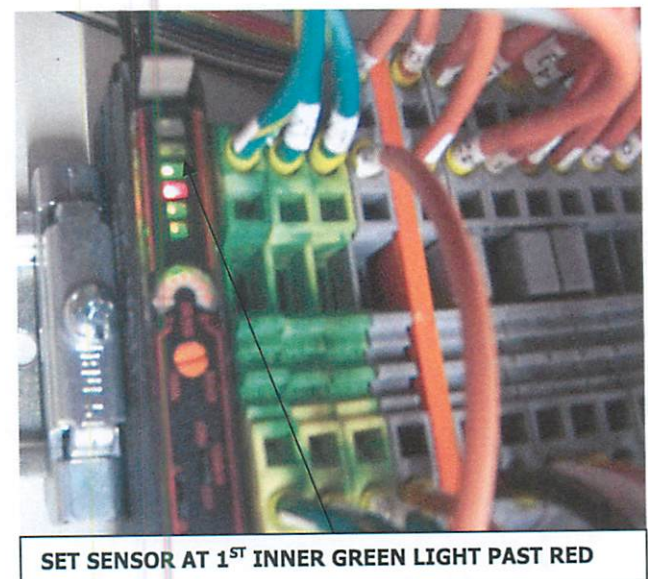
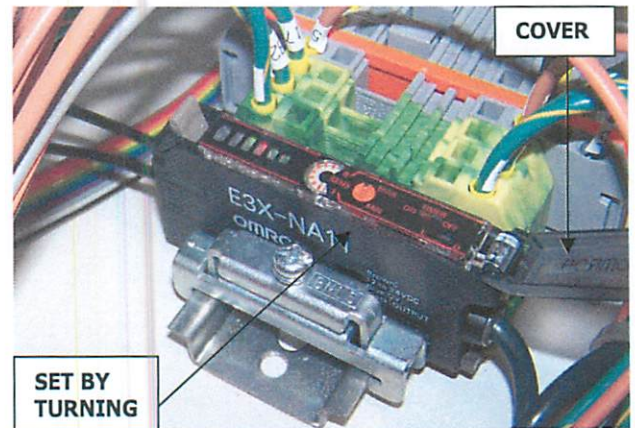
17) OPEN AMPLIFIER COVER. USE THE ADJUSTMENT TOOL AND ROTATE THE SLOTTED ADJUSTMENT SCREW COUNTERCLOCKWISE UNTIL IT CLICKS. ONLY THE RED LIGHT WILL REMAIN ON.

18) TURN THE ADJUSTING SCREW SLOWLY CLOCKWISE. THE OUTER (2) GREEN LIGHTS WILL APPEAR. THEN THE RED LIGHT CONTINUES ON. STOP TURNING WHEN THE FIRST GREEN LIGHT INWARD OF THE RED LIGHT APPEARS. CONTINUE CLOCKWISE TURNING UNTIL GREEN LIGHT COMES ON BRIGHT AND STABLE.

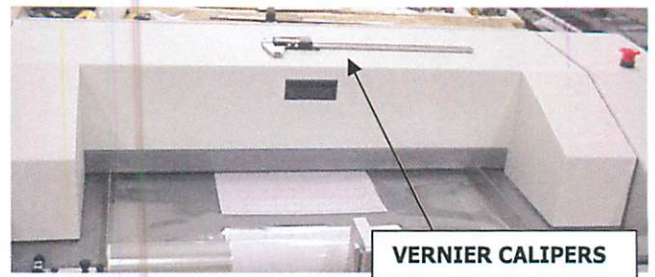
19) CLOSE THE AMPLIFIER COVER. THE AMPLIFIER IS IN THE RUN POSITION. AMPLIFIER IS NOW SET FOR THE MIL FILM UNDER FIBER OPTIC SENSOR.

20) CHECK FUNCTION OF (2) EMERGENCY STOPS. REMOVE THE TEMPORARY MAGNETS ON DOORS AND SECURE DOORS WITH 1/4 TURN SCREWS, ALIGNING WITH HOUSING MAGNETS FUNCTION PROPERLY. OPEN DOORS AND REPLACE EXTRA MAGNETS. OPEN AND CLOSE SAFETY SHIELD TO CHECK SAFETY SHIELD POSITION MAGNET FUNCTION.

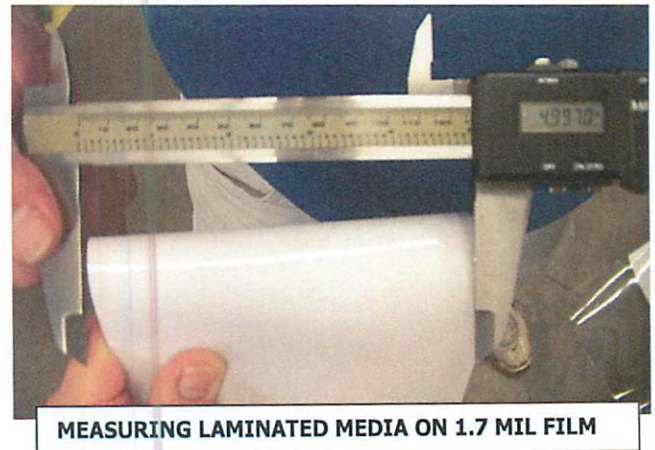
21) DEPRESS THE "START" BUTTON ON THE TOUCHSCREEN TO BEGIN CUTTING ACTION. A REGULATED CUTTING SOUND BEGINS. TEST THE DANCER BAR FUNCTION BY SLOWLY RAISING AND LOWERING DANCER BAR. AT ABOUT 45 DEGREES THE C30 SHOULD STOP CUTTING AND SHOULD RESUME CUTTING WHEN THE DANCER BAR IS LOWERED.



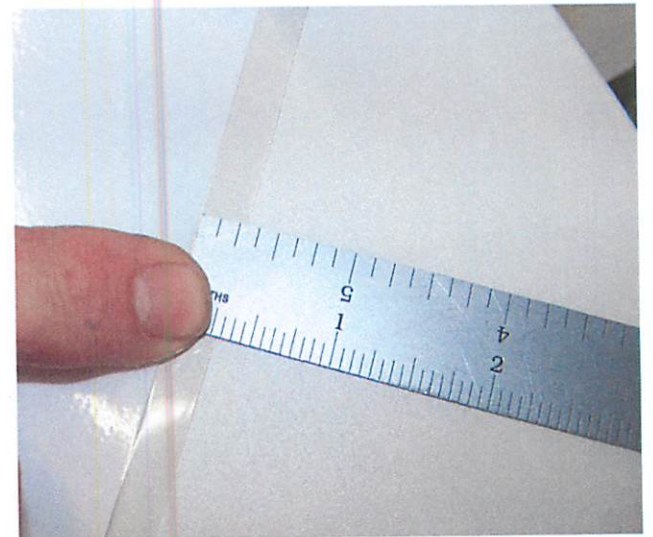
- 22) USE VERNIER CALIPERS TO MEASURE THE (5) CUT STRIPS TO FIVE INCHES. ONE PERSON CAN HOLD THE FIVE STRIPS TIGHTLY TOGETHER AND A SECOND PERSON WORKS ADJUSTS THE VERNIER CALIPER. THE DIFFERENCE SHOULD BE NO MORE THAN .003 WITH TWO MEASUREMENTS.



- 23) USE A STRAIGHT RULER TO TEST THE EDGE OF THE CUT TO 1/4 INCH.



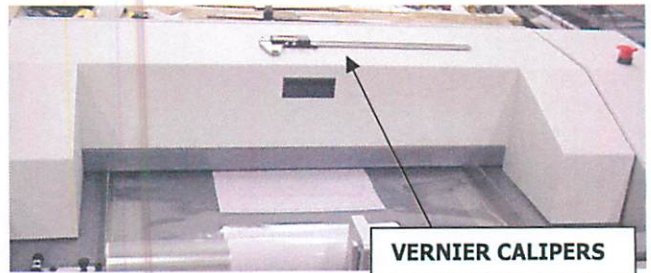
- 24) UNDERSTAND THE DISPLAY BOARD READING TERMS: FD (FEED MODE) CUTS TO A SPECIFIC LENGTH. THE RG (REGISTRATION MODE) SETS TRIMMING TO SENSED EDGE IE. FRONT (NOSE) AND REAR (TAIL). THE RF (REGISTRATION FEED) TRIMS BEFORE AND AFTER A SENSED EDGE AND CUTS TO A SPECIFIC LENGTH. THE **PASSWORD IS "6457"**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



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



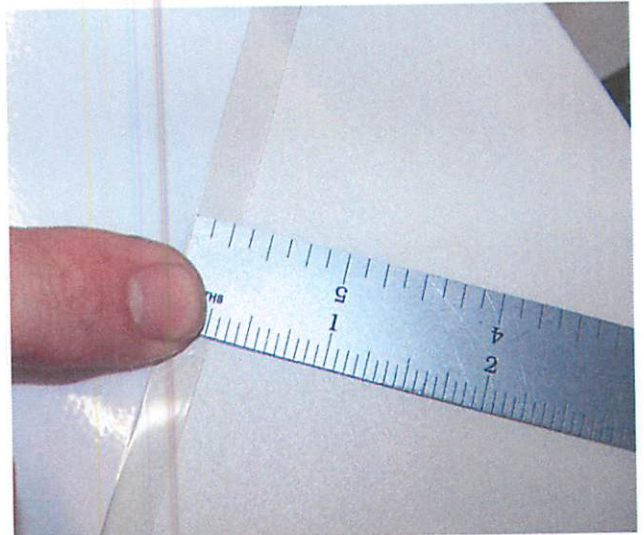
- 22) USE VERNIER CALIPERS TO MEASURE THE (5) CUT STRIPS TO FIVE INCH CUTS. ONE PERSON HOLDS THE FIVE STRIPS TIGHTLY TOGETHER, A SECOND PERSON MEASURES STRIPS WITH THE VERNIER CALIPER. THE DIFFERENCE SHOULD BE NO MORE THAN .003 AFTER TWO MEASUREMENTS ARE TAKEN.



- 23) USE A STRAIGHT RULER TO MEASURE THE EDGE OF THE CUT TO 1/4 INCH.



- 24) UNDERSTAND THE DISPLAY BOARD READING TERMS: 'FEED' (FEED MODE) CUTS TO A SPECIFIC LENGTH. THE 'REG' (REGISTRATION MODE) SETS TRIMMING TO SENSED EDGE IE. FRONT (NOSE) AND REAR (TAIL). THE REG/FEED (REGISTRATION FEED) TRIMS BEFORE AND AFTER A SENSED EDGE AND CUTS TO A SPECIFIC LENGTH. THE **PASSWORD IS "6457"** WHEN CALLED FOR.



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

