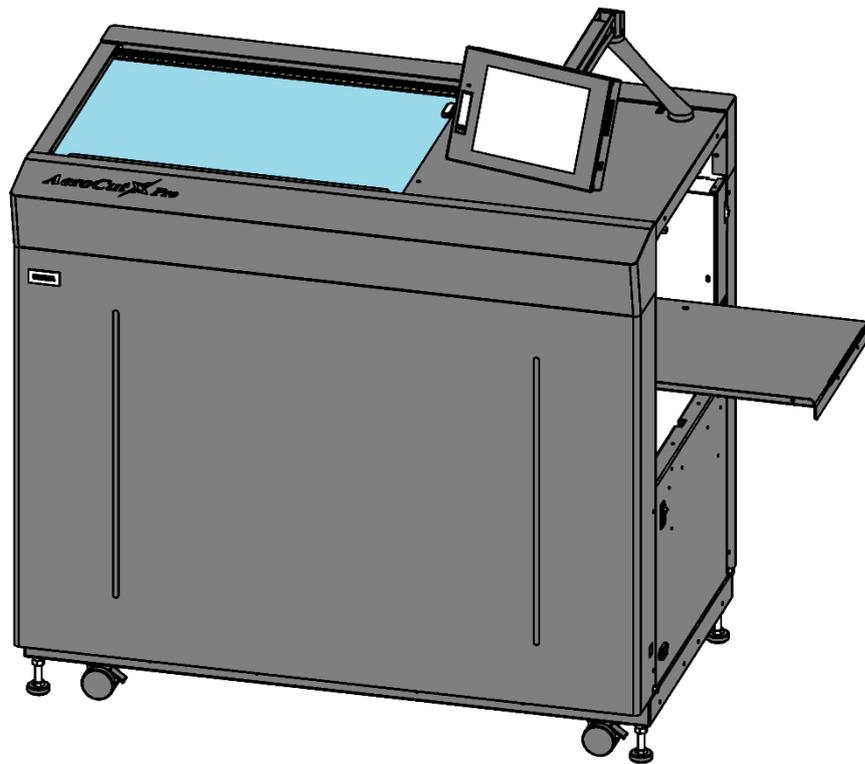


UCHIDA

AeroCut *Pro*

OPERATION MANUAL



UCHIDA YOKO CO., LTD.

78-705 V1.00

- Use machine only after reading the "Safety Instructions" given below carefully.
- These safety instructions are given to ensure that the machine will be used safely and properly and to prevent operators from sustaining harm and injuries.
- This equipment is not suitable for use in locations where children are likely to present.

Explanation of markings

Marking	Meaning of marking
 Warning	This symbol stands for immediate danger threatening the life and health of persons. Disregarding these instructions may cause severe damage to health and even serious injuries.
 Caution	This symbol stands for an endangering situation that may occur. Disregarding these instructions may lead to slight injuries or damage to property.

Definition of Symbols and Notes

In this manual the following names and signs stand for possible dangers.



Caution

This symbol stands for an endangering situation that may occur. Disregarding these instructions may lead to slight injuries or damages to property.



Note

This symbol stands for notes, operational hints, and other useful information.

They are convenient for exploiting the machine's functional abilities.

SAFETY INSTRUCTIONS

Explanations of the illustrations used in the Safety Instructions are given as follows:

 Warning
<ol style="list-style-type: none"> 1. Don't open the cover of the equipment. There is a danger of receiving an injury or electric shock. 2. Don't touch any rotating part. There is a danger of receiving an injury. 3. Don't put hands inside work area. May result in severe injury. 4. Be sure to connect the power cord to a grounded outlet. If the ground is not securely connected, it could lead to electric shock or fire.



Caution

- ① Don't put a hand into the cover or a clearance between parts. There is a danger of receiving an injury.
- ② Don't bring a hand, face, hair, sleeves of clothes and the like close to the rotating parts of the machine. There is a danger of receiving an injury.
- ③ Don't touch the blade point of the cutter. There is a danger of receiving an injury.
- ④ Turn off the power supply beforehand when setting the feed table. There is a danger of receiving an injury.
- ⑤ Turn off the power supply beforehand when removing paper scraps. There is a danger of receiving an injury.
- ⑥ Do not exceed the MAX level when stacking the paper. Exceeding it may cause a mechanical failure.
- ⑦ Turn off the power supply beforehand when starting maintenance or inspection. There is a danger of receiving an injury.
- ⑧ When you install a machine, please install to a place with no dust, and the place which is not influenced with a liquid. It becomes the cause of failure if the installation method is mistaken.
- ⑨ When you put a machine into operation, please change into the state where all covers were closed. If it works where a cover is opened, there is fear of an injury.

Before use

Read this "Operation Manual" carefully before use. In particular, be sure to read "Safety Instructions" (page 1 to page 2) to ensure that the machine will be used properly.

Keep the manual at an appointed place with care so that it may be accessible whenever necessary.

The specifications of this product are subject to change for improvement. Therefore, don't mistake the "Operation Manual" of one product of the same model for that of another because descriptions in the "Operation Manual" of products of the same model may differ.

Contents

1	Introduction.....	5
1.1	Names of parts.....	5
1.2	Accessories.....	7
1.3	Touch panel.....	8
1.4	Paper weight / quality.....	9
1.5	Layout terminology.....	10
2	Operating instructions	11
2.1	Lock a caster brake、 Adjuster settings	11
2.2	Turning the power on	11
2.3	Initial position	12
2.4	Input	12
2.5	Set.....	13
2.6	Paper setting.....	14
2.7	Waste box setting.....	15
2.8	Stacker and Card stacker wire settings	15
2.9	Start.....	17
2.10	Stop.....	18
2.11	Waste disposal.....	19
2.12	Power off	19
3	Cut pattern input.....	20
3.1	Outline.....	20
3.2	PRESET.....	20
3.3	MANUSET.....	22
3.4	FLEX MODE	24
3.5	Save / Read	27
3.5.1	Save.....	27
3.5.2	Read	28
3.5.3	Copy and Paste Job name	29

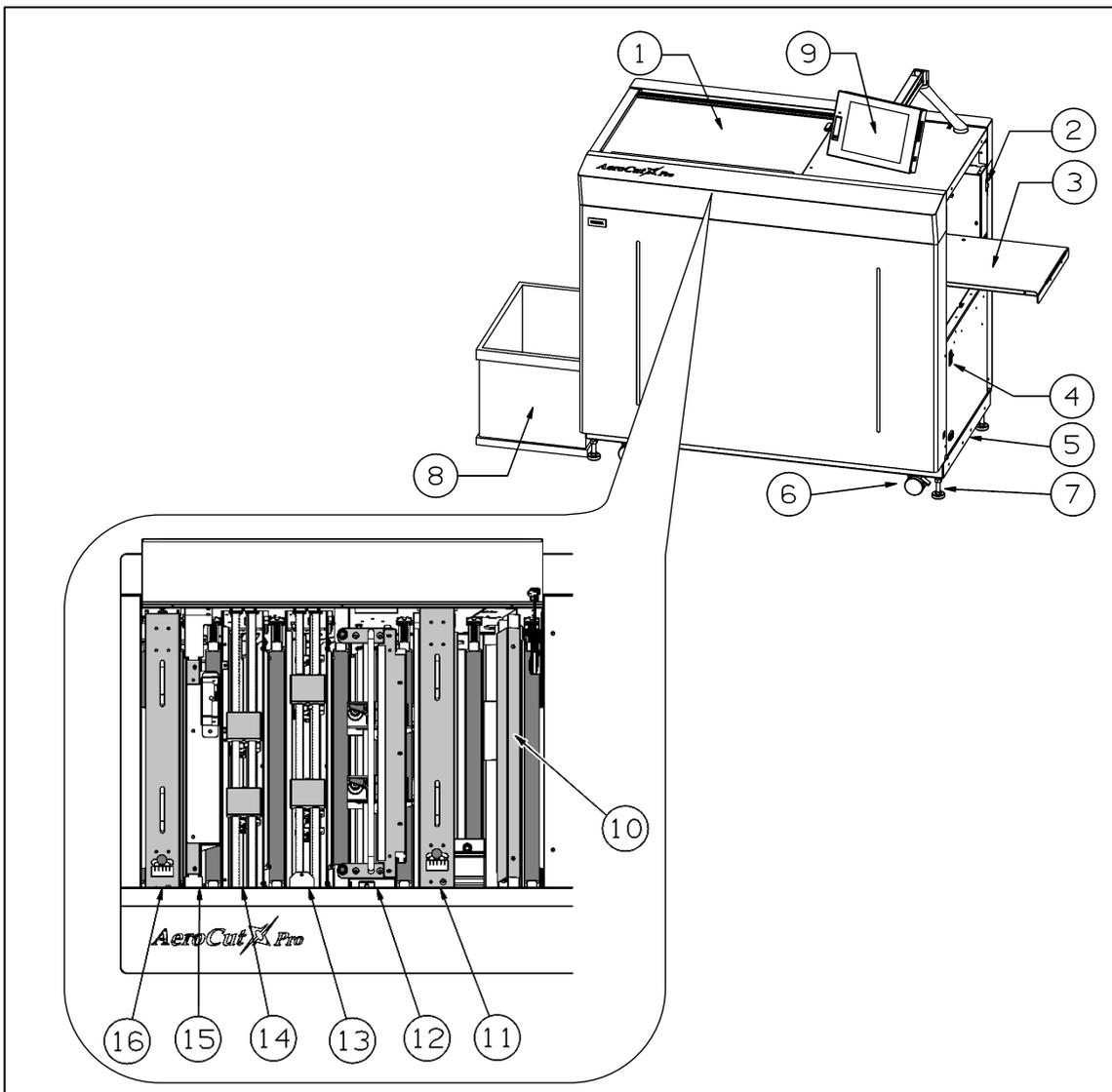
AeroCut XPro OPERATION MANUAL

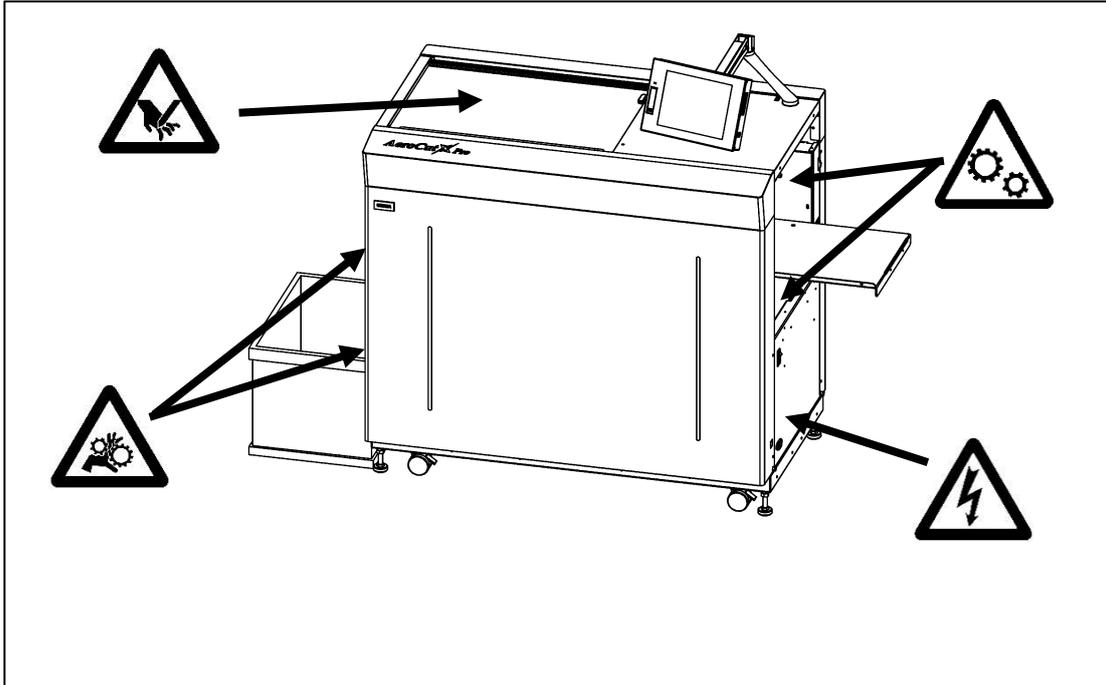
4	How to use options	30
4.1	X-perforator	30
4.2	How to adjust the depth of X-perforation	31
4.3	Y-perforator	31
4.4	How to adjust the location of Y-perforation	32
4.5	How to adjust the depth of Y-perforation	34
4.6	Barcode reader	34
4.7	Belt conveyor tray	35
5	Adjustment	36
5.1	Adjustments on the paper feed section	36
5.1.1	Upper suction adjustment	36
5.1.2	Lower suction adjustment	37
5.1.3	Side suction adjustment	37
5.1.4	Air blow adjustment	38
5.1.5	PAPER FEED WORK TIME adjustment	38
5.1.6	Sensitivity of Double feed sensor	38
5.2	Change speed	39
5.2.1	Speed of delivery	39
5.2.2	Speed of X-Perfo	39
5.3	Feed frequency	39
5.4	Skew adjustment	40
5.5	Creaser adjustment	40
5.6	Fine adjustments on processing positions	41
5.6.1	In cases cutting positions don't match to image positions.	41
5.6.2	If the cut measurement does not match the input value	44
6	Manual control	47
6.1	Settings screen	47
6.2	Slitter	48
6.3	Paper jam	48
7	Error messages	49
8	Troubleshooting	57
9	Product specifications	58

1 Introduction

1.1 Names of parts

No.	Name	No.	Name
01	Safety cover	09	Touch panel
02	Skew adjustment dial	10	Barcode reader
03	Feed table	11	X-perforator
04	Power switch	12	Y-perforator
05	Inlet	13	Margin slitter unit
06	Caster	14	Gutter slitter unit
07	Adjuster	15	Guillotine
08	Waste box	16	Creaser





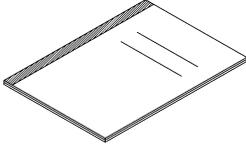
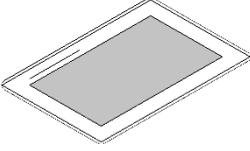
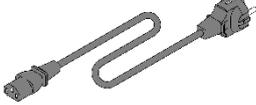
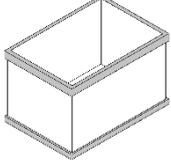
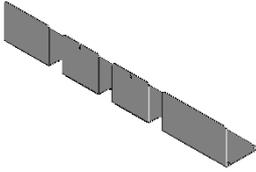
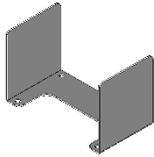
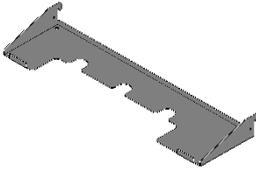
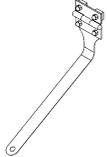
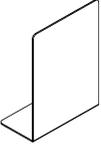
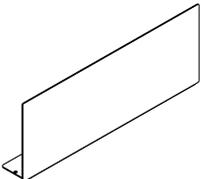
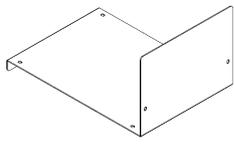
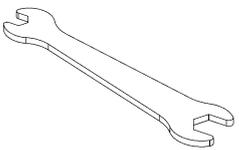
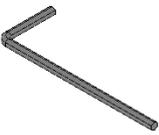
 **Warning**

	Don't put hands inside work area. May result in severe injury.
	Don't touch any rotating part. There is a danger of receiving an injury.
	Don't open the cover of the equipment. There is a danger of receiving an injury or electric shock.

 **Caution**

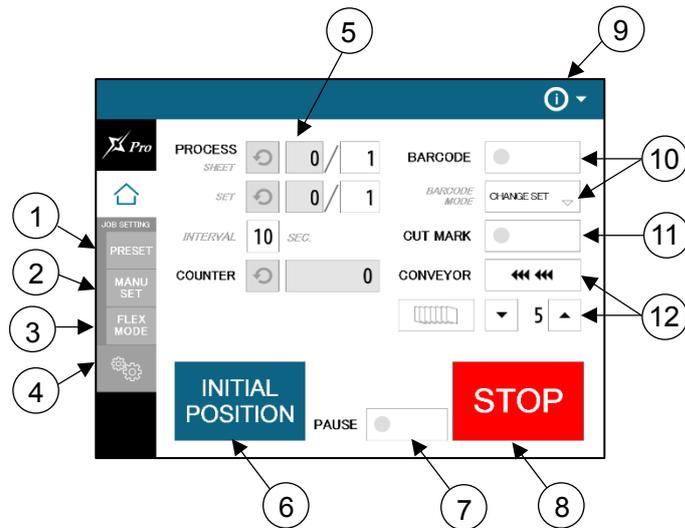
	Don't touch the blade point of the cutter. There is a danger of receiving an injury.
---	---

1.2 Accessories

Operation manual	Template	Electric power cord	Waste box
 × 1	 × 1	 × 1	 × 1
Stacker end	Business card partition	Card stacker	Card stacker wire
 × 1	 × 2	 × 1	 × 3
Paper guide (Small)	Paper guide (Large)	Long paper feed guide	
 × 2	 × 2	 × 1	
Spanner	Hexagonal wrench 2mm	Hexagonal wrench 2.5mm	
 × 1	 × 1	 × 1	

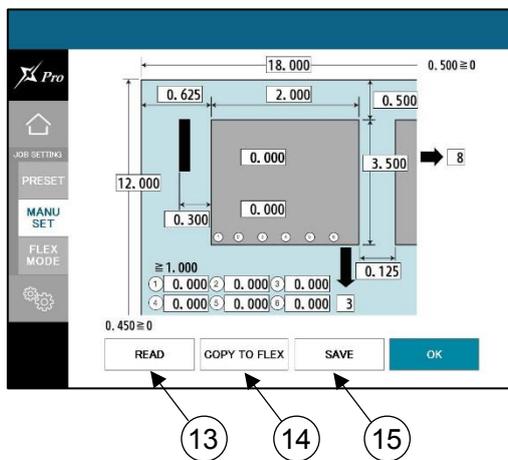
1.3 Touch panel

- Home screen



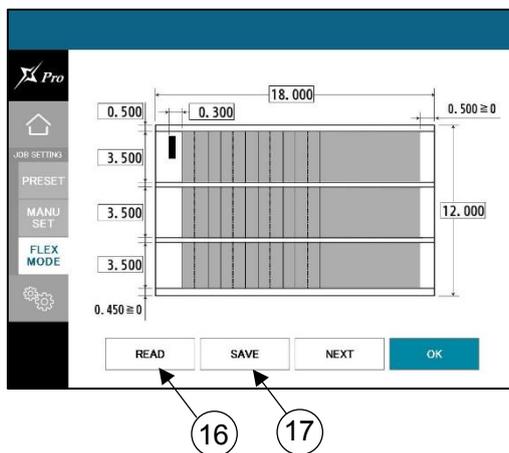
Home screen		
①	PRESET	Page.20
②	MANU SET	Page.22
③	FLEX MODE	Page.24
④	Setting	Page.47
⑤	Counter	Page.18
⑥	Initial position	Page.12
⑦	Pause	Page.16
⑧	Stop	Page.18
⑨	Compensation	Page.41
⑩	Barcode	Page.34
⑪	Cut mark	Page.13
⑫	Conveyor	Page.35

- MANU SET screen



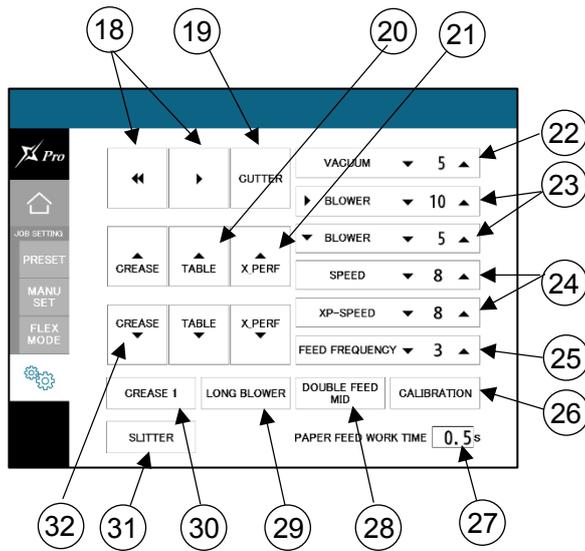
MANU SET screen		
⑬	Read	Page.28
⑭	Copy to FLEX	Page.22
⑮	SAVE	Page.27

- FLEX MODE screen



FLEX MODE screen		
⑯	Read	Page.28
⑰	SAVE	Page.27

• Settings screen



Settings screen		
18	Inching	Page.47
19	Cutter (Guillotine)	Page.47
20	Table	Page.47
21	X- perforator	Page.47
22	Vacuum	Page.36
23	Blower	Page.37
24	Speed	Page.39
25	Feed frequency	Page.39
26	Calibration	Page.44
27	Paper feed work time	Page.38
28	Double feed	Page.38
29	Air Blow	Page.38
30	Crease	Page.40
31	Slitter	Page.48
32	Crease	Page.47

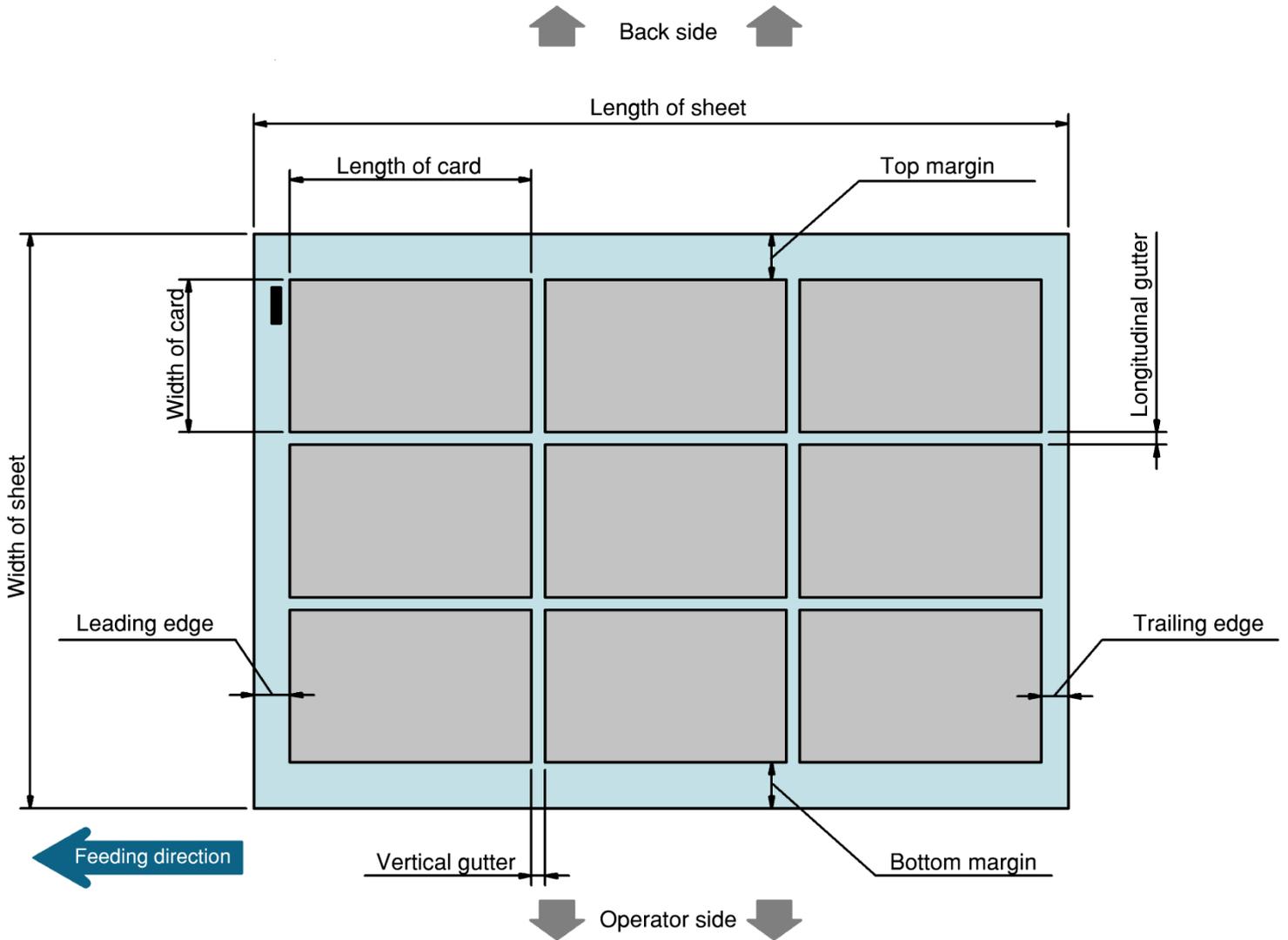
1.4 Paper weight / quality

Use suitable paper stocks which weight is 120 to 400gsm (0.005” – 0.016”).

These paper stocks are not suitable in use.

- Papers that has heavily electric static charged. It may cause miss-feed, double feed or paper jam.
- Papers that are more than 0.125” curled or waved. It may cause miss-feed, double feed or paper jam.
- Papers that have ink or toner not fused properly. It may cause contaminating the work and the machine.
- Papers that are too slippery. It may cause miss-feed or inaccurate results.
- Prints that are shrank, stretched or skewed inconsistently. It may cause inaccurate results.

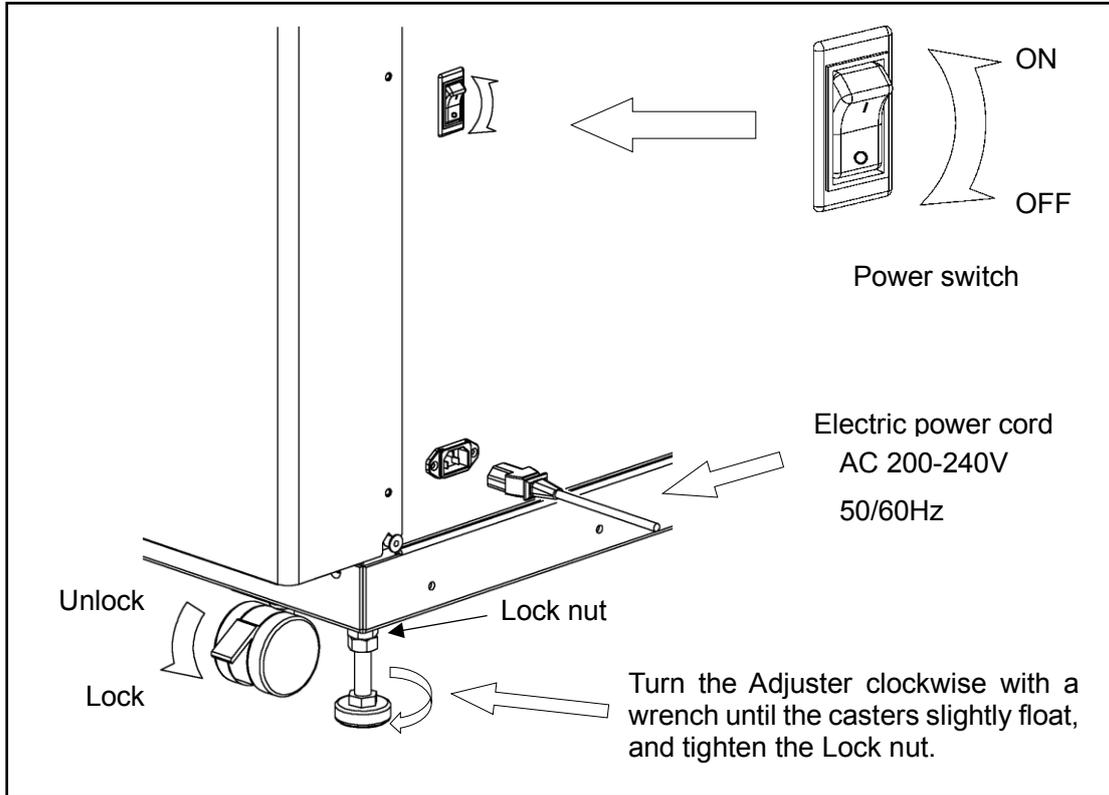
1.5 Layout terminology



2 Operating instructions

2.1 Lock a caster brake, Adjuster settings

2.2 Turning the power on



Warning



Be sure to connect the power cord to a grounded outlet. If the ground is not securely connected, it could lead to electric shock or fire.

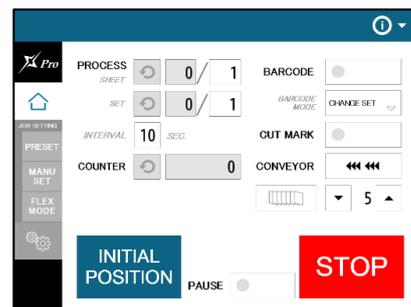
Power on



Opening screen



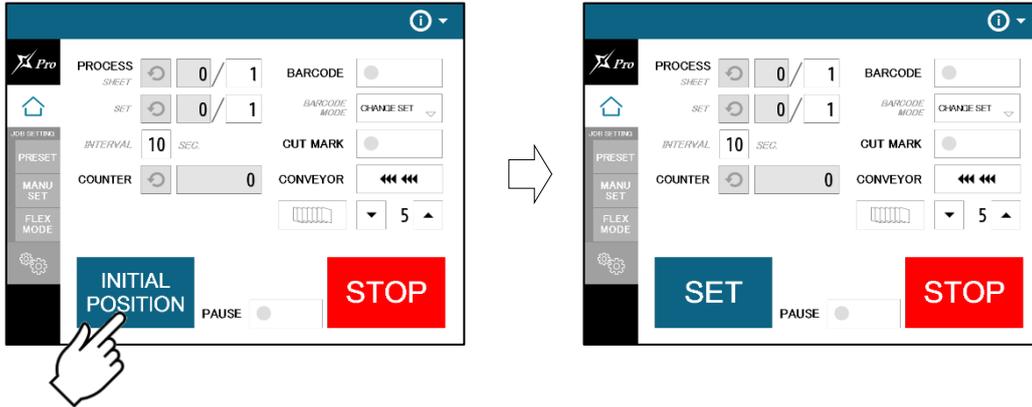
Home screen



2.3 Initial position

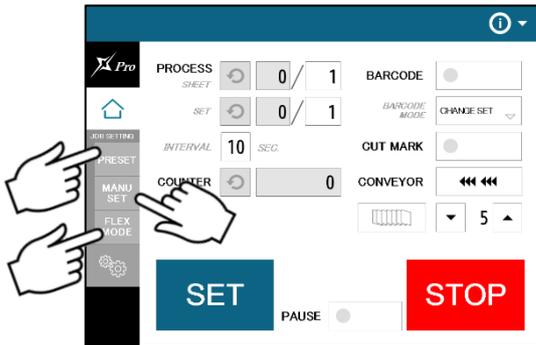
- ① When the power turned on, the touch screen shows **INITIAL POSITION** button. Press **INITIAL POSITION** button.
- ② The slitters will move to their initial position automatically. Then the button changes to **SET**.

Home screen



2.4 Input

- ① Enter the cut pattern.

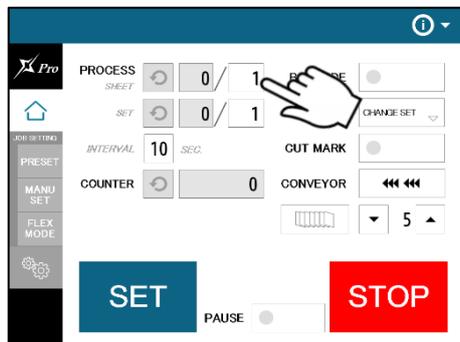


PRESET : Page.20

MANUSET : Page.22

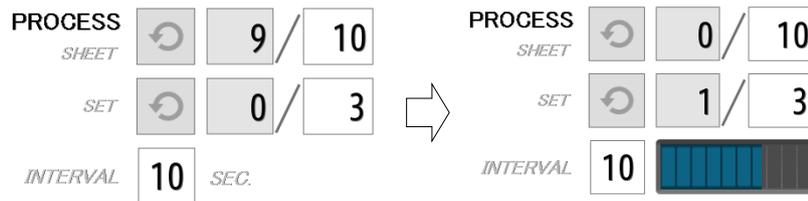
FLEX MODE : Page.24

- ② Enter the number of sheets for operation.



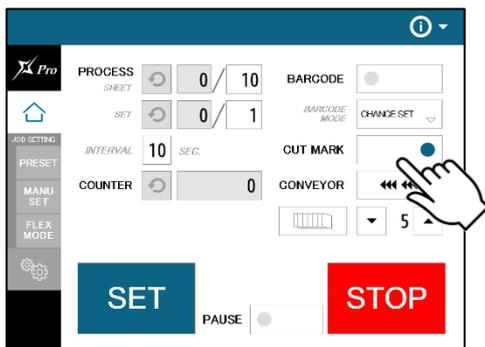
- When 0 is entered in the number of sheets, the machine will continue to process all the sheets on the feed table.

- When the number of sheets is 1 or more, the machine will process the number of the sheets entered, which becomes one set.
- The machine stops running when the number of sets processed reaches the number of sets entered.
- When the number of sets is 2 or more, the machine goes into an interval after each set completed.
- During the interval, the machine stops feeding until the entered interval time is elapsed.



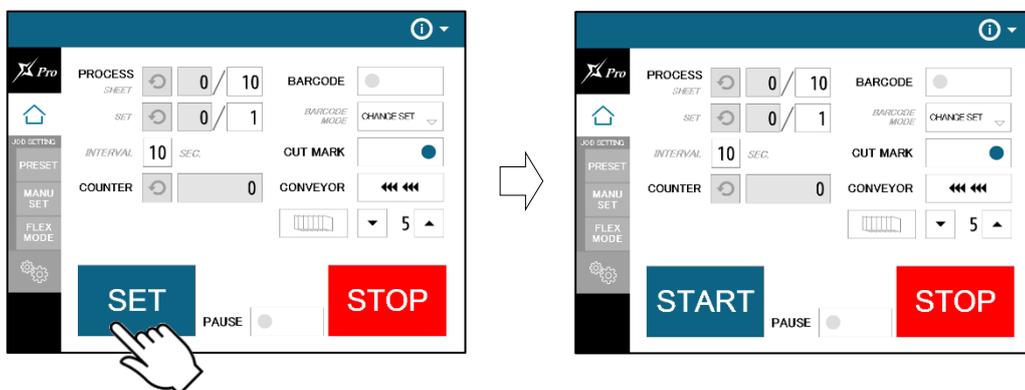
- ③ Touch the screen to have **CUT MARK** to activate cut-mark registration.

When it is on, the machine reads the cut-mark and cross cuts at proper positions even the image is drifted.



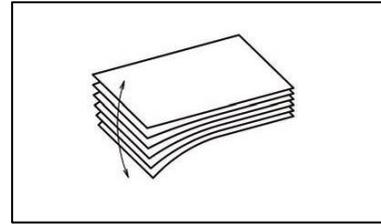
2.5 Set

- ① With a press of **SET** button, the slitters will move to the positions according to the selected cut pattern.
- ② At the same time, Feed table will move to the lower end position.
- ③ **START** button will be indicated upon all slitters are completely set.



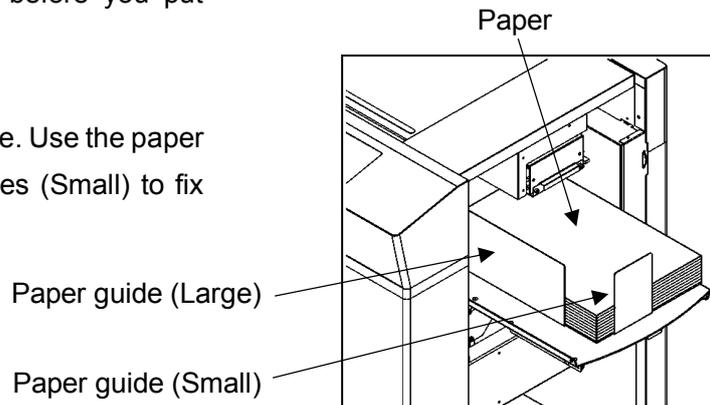
2.6 Paper setting

- ① Press the **START** button on the home screen.
If the feed table is in upper position. The feed table moves down. Press **STOP** button to stop the table moving.



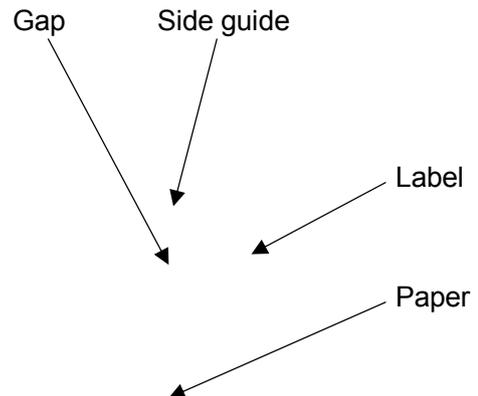
- ② Flip through the sheets well before you put them on the feed table.

- ③ Set the sheets on the feed table. Use the paper guide (Large) and paper guides (Small) to fix the sheets.



Note.

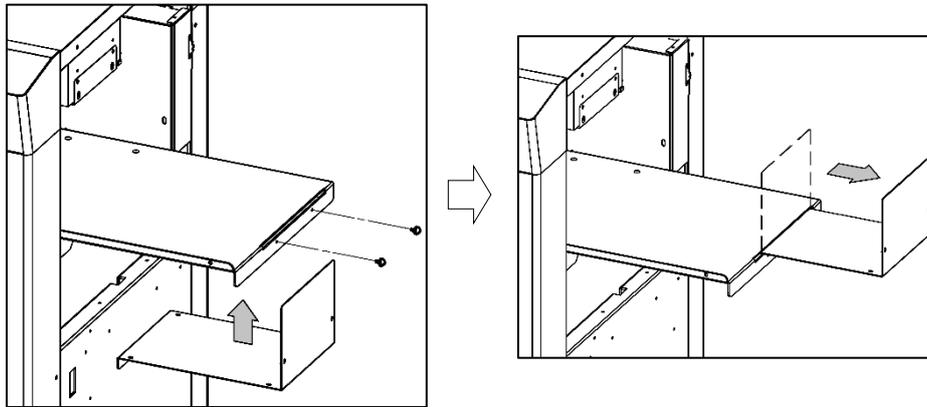
- Paper loading capacity is 4.0".
- Make sure that the paper stack does not exceed the MAX label.
- It affects finishing accuracy if there is a gap between the side guide and the sheets.



- If the print is skew on the sheets, the angle of the side guide can be adjusted.

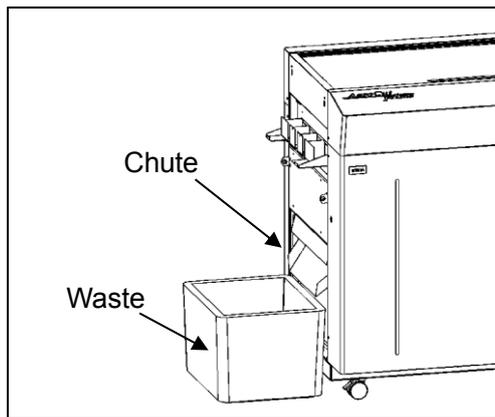
 Warning	
	Don't put hands inside work area. May result in severe injury.

- ④ When finishing long papers, use the long paper feed guide.
- Remove the screws for fall prevention, slide the guide into the slot of the feed tray, and tighten the screws.



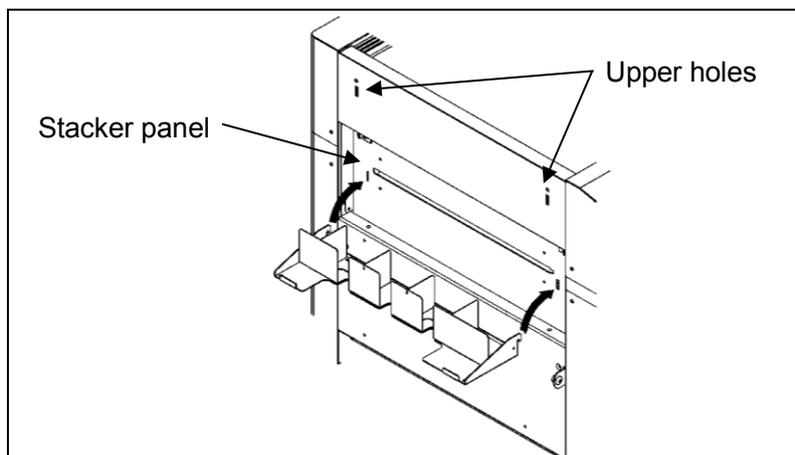
2.7 Waste box setting

- Place the Waste box under the Chute.



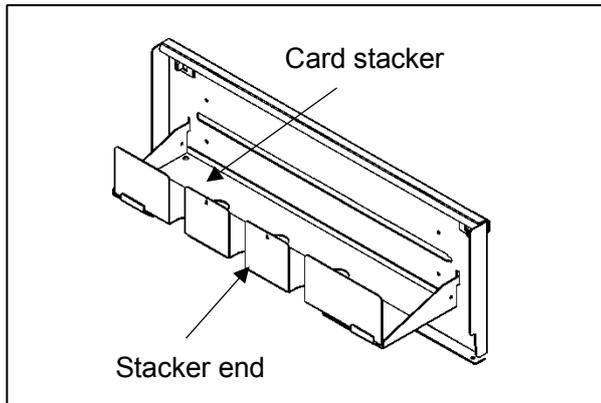
2.8 Stacker and Card stacker wire settings

- Use the Card stacker when cutting papers to cards.
- Hang the business card stacker to the Stacker panel.
- When it is not used, it may be hooked to the upper holes in the stacker panel.



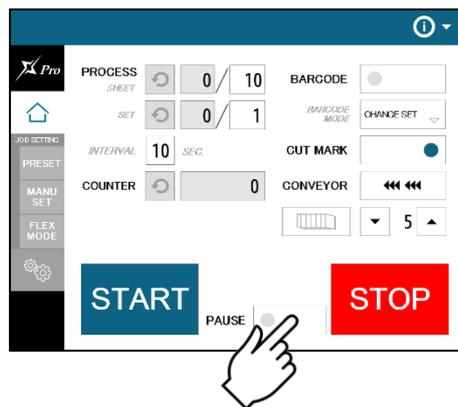
- Change the settings of the stacker according to the cut pattern.

When cutting papers into Post cards



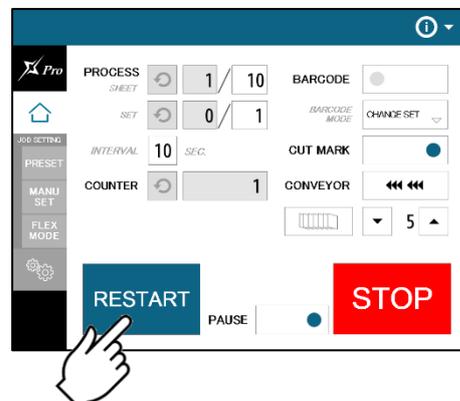
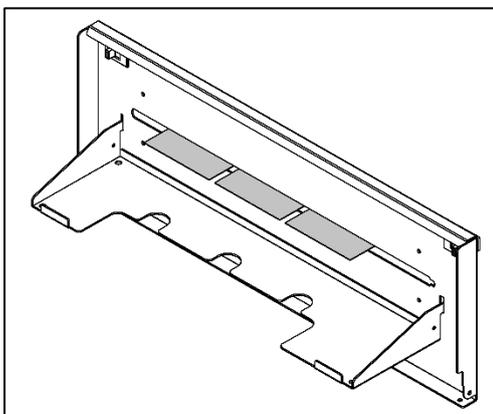
When cutting papers into Business cards

- ① Press the **PAUSE** button before starting to process.

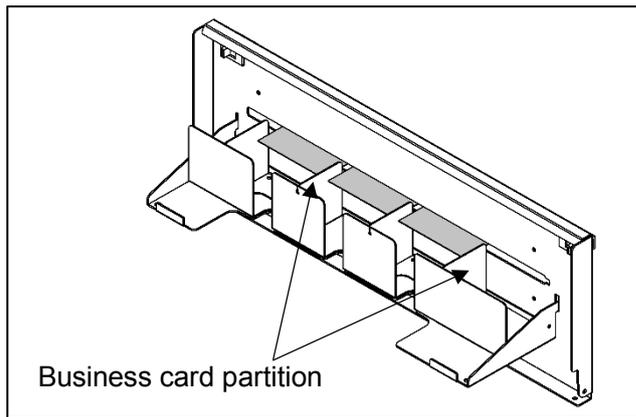


- ② After pressing the Start button, the machine will pause near the ejection of the first row of cards.

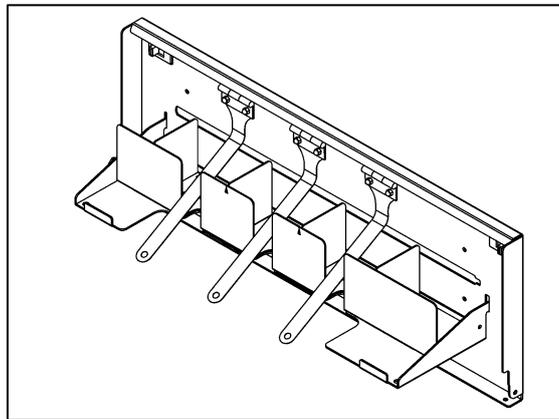
Press the **RESTART** button to restart the process.



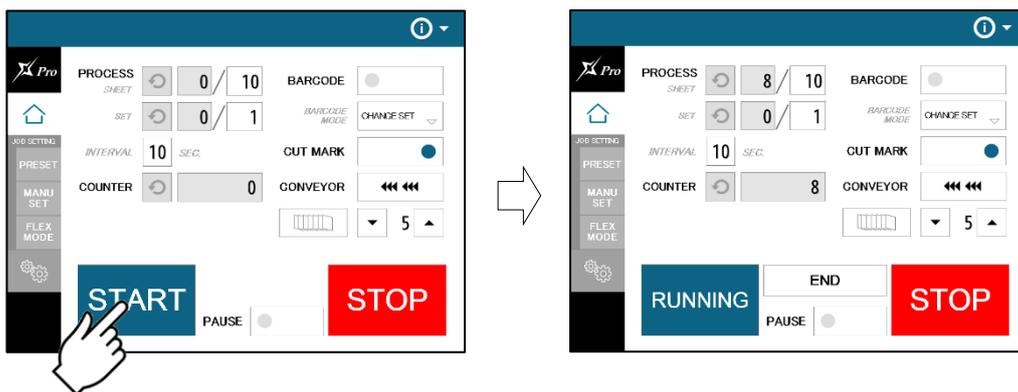
- ③ Place the business card partitions according to the positions of the paused cards.



- ④ If the cards flip over due to momentum, install the Card stacker wires.

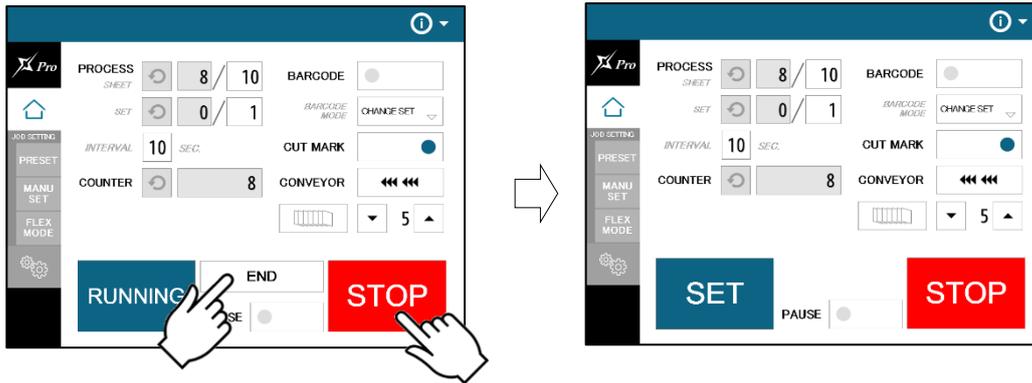


2.9 Start

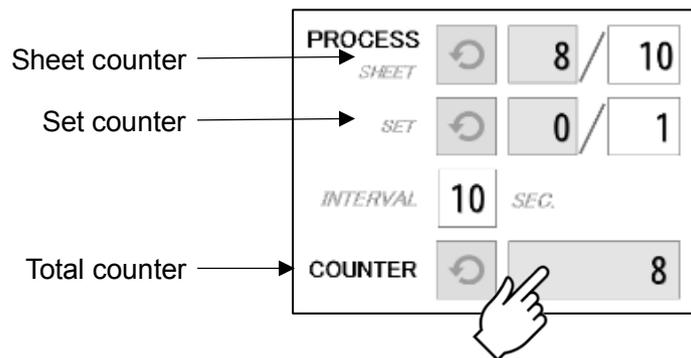


- Press **START** to start an automatic operation. The display will change to **RUNNING**.
- After processing the entered number of sheets in quantity, the machine stops automatically.
- Do not open the Safety cover while the machine is running. Machine will stop immediately.

2.10 Stop



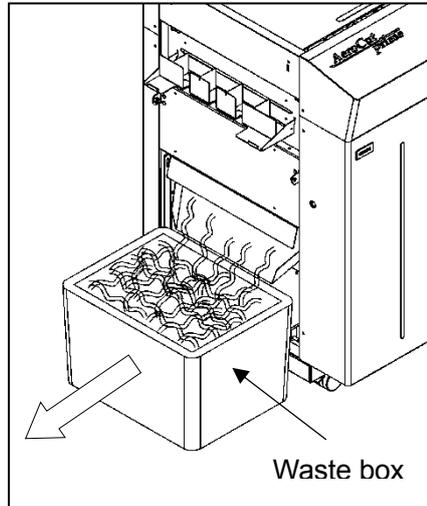
- Press **STOP** and the machine will make an EMERGENCY stop even if the operation is underway.
- Press **END** if you wish to stop the machine when the current sheet is completed.
- If paper is left in the machine, remove it by inching.



- The sheet counter indicates the number of finished sheets when the machine is stopped with **STOP** or **END** button.
Press  to reset the counter to 0.
- The set counter indicates the number of finished sets when the machine is stopped with **STOP** or **END** button.
Press  to reset the counter to 0.
- The total counter indicates the accumulated number of finished sheets when the machine is stopped with **STOP** or **END** button.
Press  to reset the counter to 0.
You can make a little adjustment on Total number.

2.11 Waste disposal

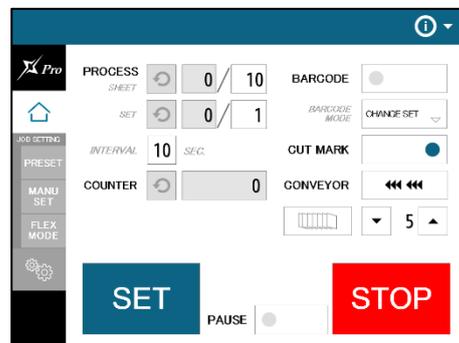
- Dispose the wastes in the waste box appropriately.
- Overloading wastes causes errors or a breakdown.



2.12 Power off

- Make sure that the machine is stopped.
- Return to the Home screen.
- Turn off the Power switch.

Home screen



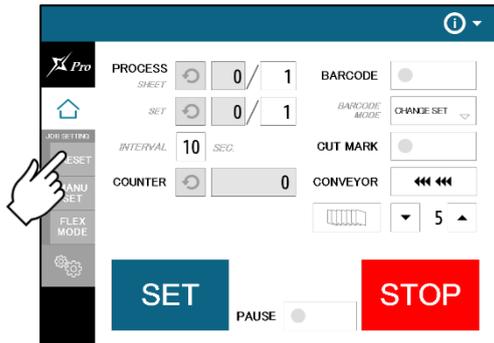
3 Cut pattern input

3.1 Outline

	<p>PRESET</p>	<p>PRESET is a series of cut patterns that are already stored in the machine.</p>
	<p>MANU SET</p>	<p>In MANUSET mode, user programs can be created and stored into the machine.</p>
	<p>FLEX MODE</p>	<p>In FLEX MODE, you can generate user data with a lot of flexibility in layout. And also these data can be stored into the machine.</p>

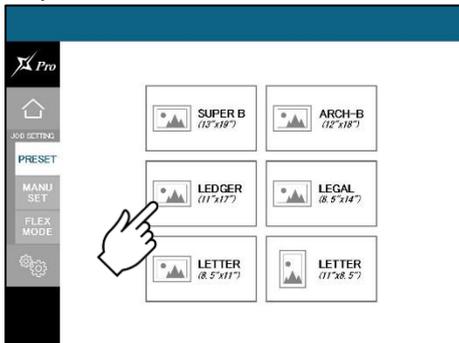
3.2 PRESET

- ① Press PRESET.



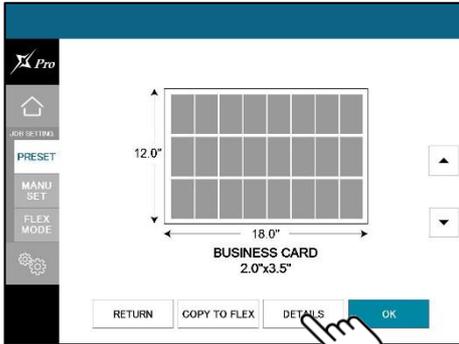
- ② Press the size of the original sheets.

Paper Selection Screen 1

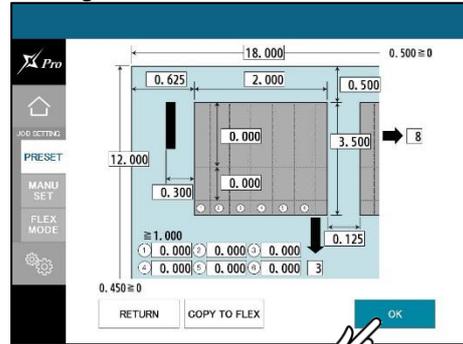


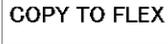
③ Select the cutting pattern.

Cutting Pattern Selection Screen

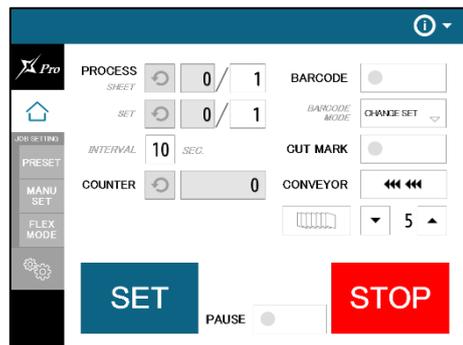
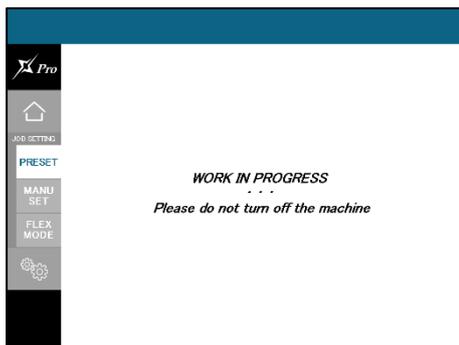


Cutting Pattern Confirmation Screen



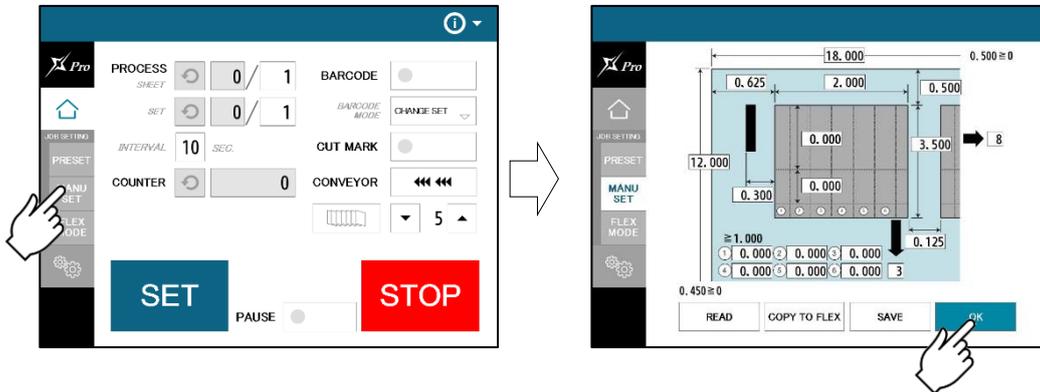
	<p>Cut pattern can be checked in detail and the measurements can be changed. Refer to MANUSET for measurement setting procedures.</p>
	<p>Copy the selected cutting pattern to FLEX MODE, then move to FLEX MODE screen.</p>
	<p>Confirm the cut pattern.</p>
	<p>Cutting pattern switching.</p>
	<p>Return to the previous page.</p>

④ The machine recalls the preset pattern and automatically returns to the home screen.



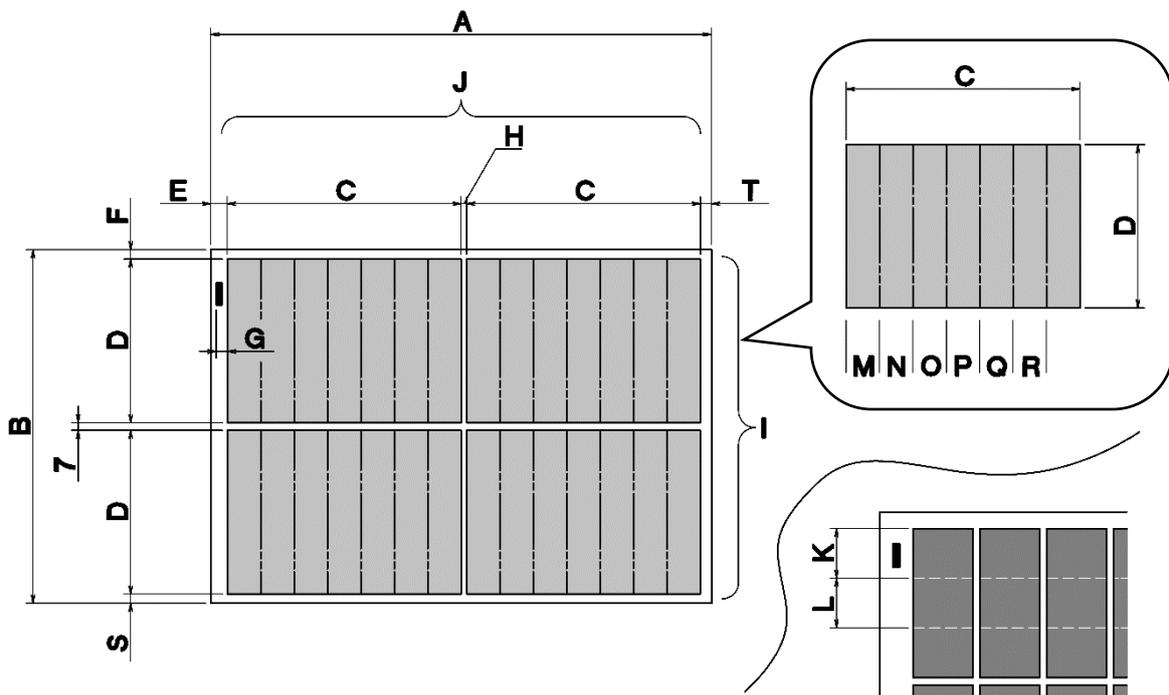
3.3 MANUSET

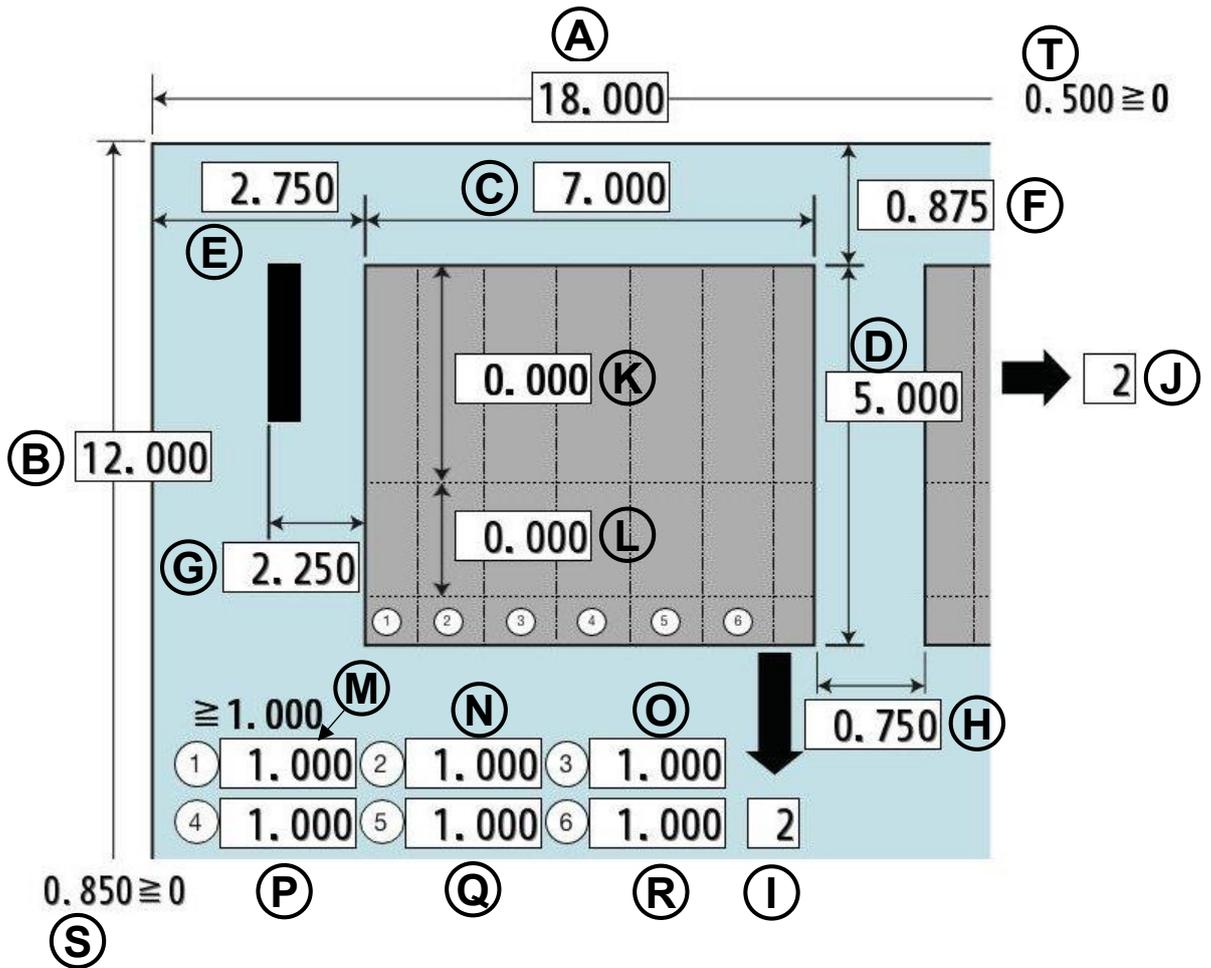
- ① Press MANUSET.
- ② The screen displays the current cut pattern.



READ	Move to User Program Selection Screen.
COPY TO FLEX	Copy the selected cutting pattern to FLEX MODE, then move to FLEX MODE screen.
SAVE	Save Cut pattern as inputted into User Program memory.
OK	Confirm Cut pattern as inputted.

- ③ Press the number to change the value.
Measurement A-R can be customized.
Measurement S, T will be calculated automatically.



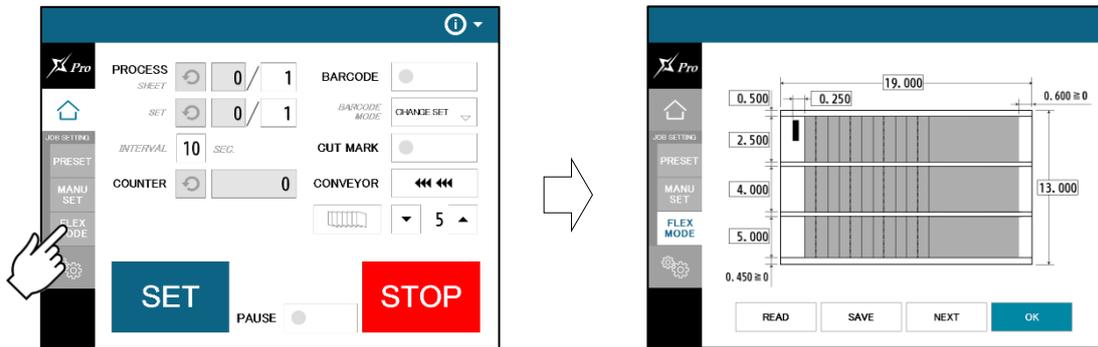


④ There are some limitations in value as shown on below table.

	[inch]
A : Paper size	8.25 – 29.53
B : Paper size	8.25 – 14.6
C : Cut size	2.165 -
D : Cut size	1.775 -
E : Leading edge size	It doesn't make the first cut if 0 is entered.
F : Top margin size	0 or 0.125 – 2.25
G : Cut-mark Position	Only smaller number than the front margin can be entered.
H : Gutter size	0.08 - (Depending on paper) When 0 is entered, the machine makes single cuts.
L : Distance between perforator	2 or more
S : Bottom margin size	0 or 0.125 – 2.25

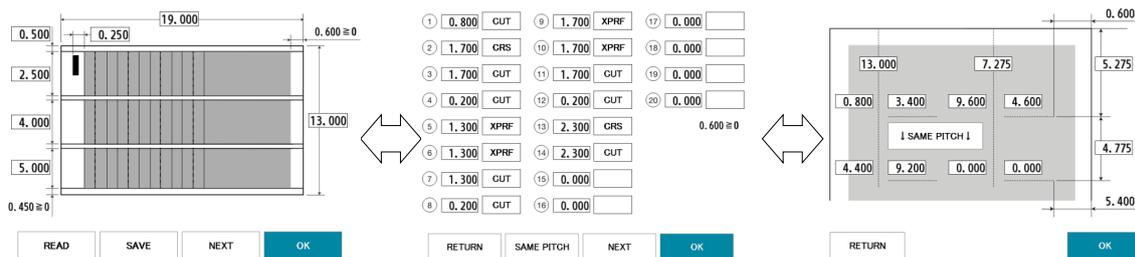
3.4 FLEX MODE

① Press FLEX MODE.



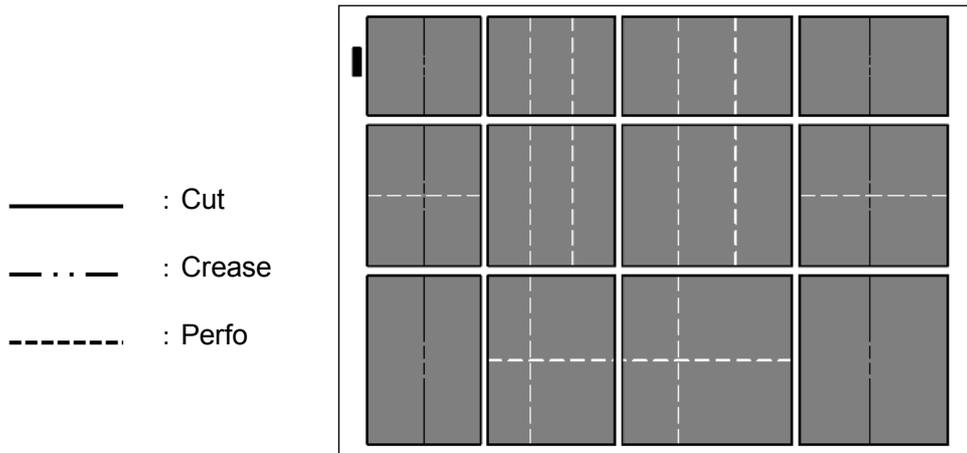
② FLEX mode is an operation mode where you can input up to 20 actions (cross cut, crease or perforate) per page.

This allows the machine to finish jobs which MANU SET cannot finish, such as multiple sizes of cards from a page and pass through pages without any actions.

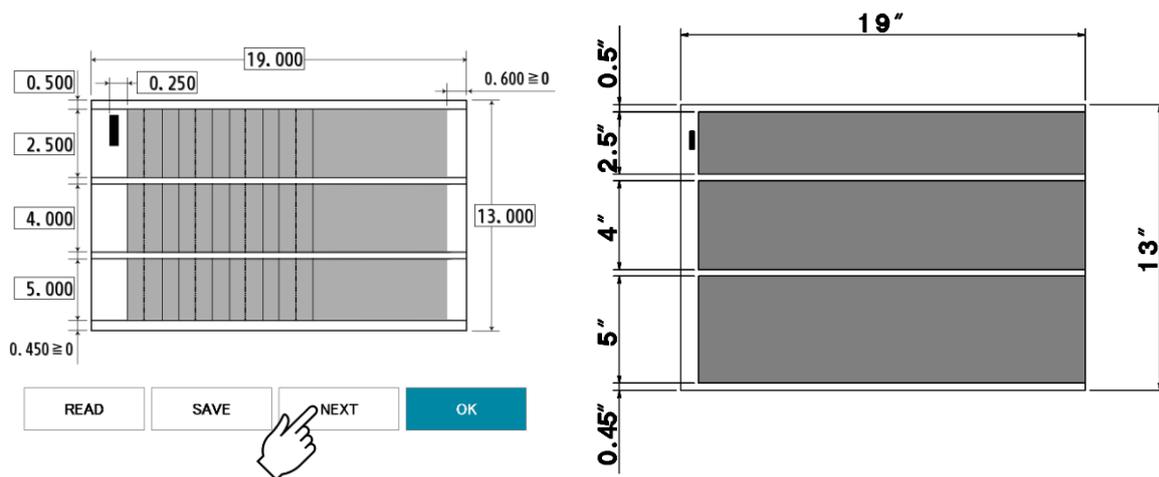


READ	Move to User Program Selection Screen.
SAVE	Save Cut pattern as inputted into User Program memory.
RETURN	Return to the previous page.
NEXT	Go to the next page.
OK	Confirm Cut pattern as inputted.

- ③ The picture below is an example which will explain how to input values.



- ④ Press the number to change the value.
 ⑤ When data input is completed, press **NEXT** to the next screen.

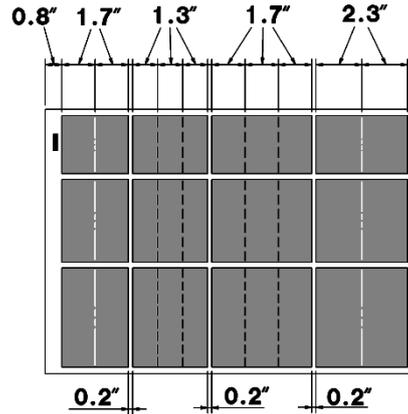


- ⑥ This screen allows you to input each pitch from No. 1 to No. 20.
- The adjacent switches are used for selecting no operation, guillotine, creaser, or X-perforator.
 - Every time the switch is pressed, the selected operation changes.
 - If the pitch of 0.0 is input, all the pitches after that one are corrected to 0.0 (no operation).
 - Pressing **SAME PITCH** copies the No. 1 pitch and its relevant operation to No. 2 to No. 20 pitches.

⑦ When data input is completed, press **NEXT** to the next screen.

① 0.800 CUT	⑨ 1.700 XPRF	⑰ 0.000
② 1.700 CRS	⑩ 1.700 XPRF	⑱ 0.000
③ 1.700 CUT	⑪ 1.700 CUT	⑲ 0.000
④ 0.200 CUT	⑫ 0.200 CUT	⑳ 0.000
⑤ 1.300 XPRF	⑬ 2.300 CRS	0.600 ≥ 0
⑥ 1.300 XPRF	⑭ 2.300 CUT	
⑦ 1.300 CUT	⑮ 0.000	
⑧ 0.200 CUT	⑯ 0.000	

RETURN SAME PITCH **NEXT** OK



: No operation **CRS** : Creaser
CUT : Guillotine **XPRF** : X-perforator

⑧ Press the number to change the value.

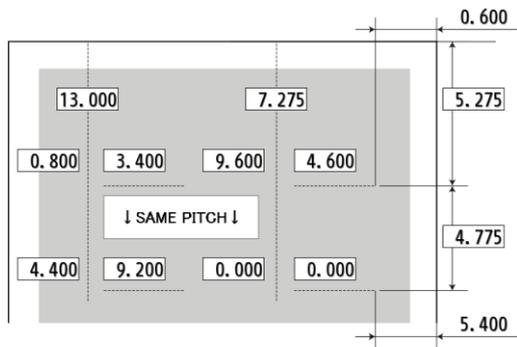
- For X-perforator, 2 different lengths (A and B) can be inputted.

When X-perforator is selected, it perforates a page from the counter operation side edge to the input lengths, firstly at A length and secondly at B length.

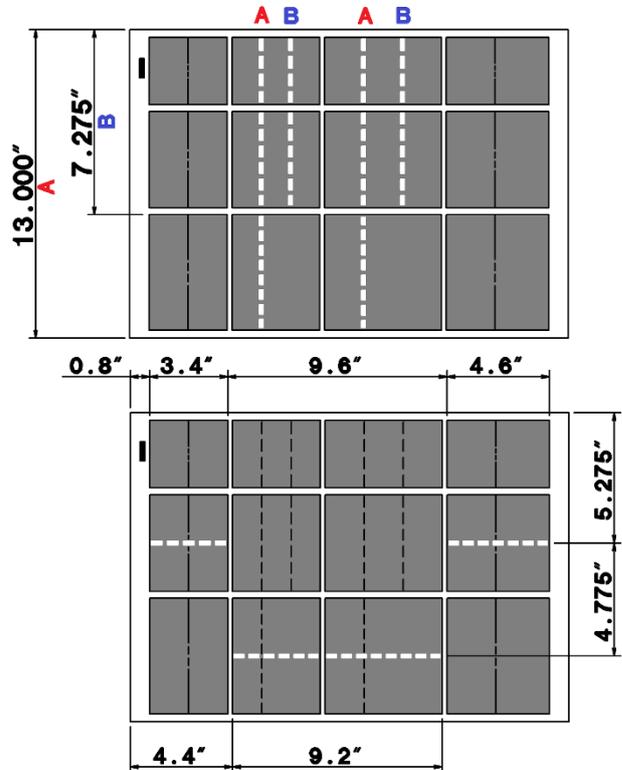
From the third perforation, it keeps perforating at selected lengths alternately.

(3rd: A length. 4th: B length...)

- Pressing **SAME PITCH** copies the values on the above slots to the bottom slots.

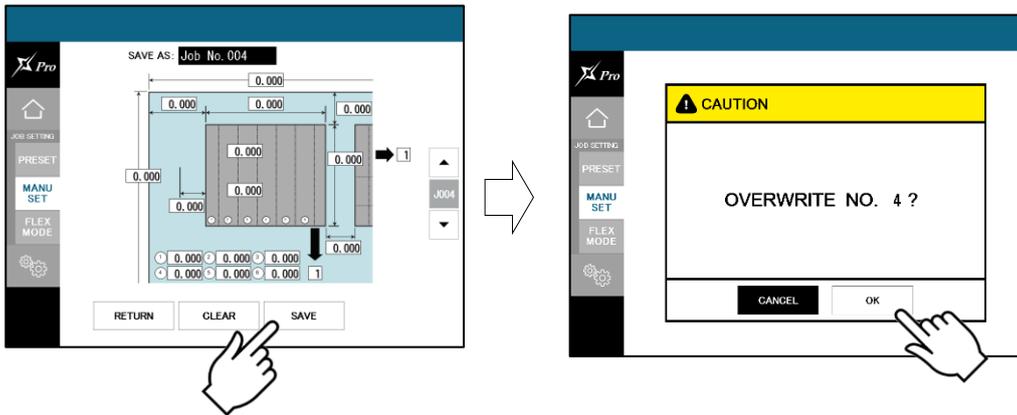


RETURN

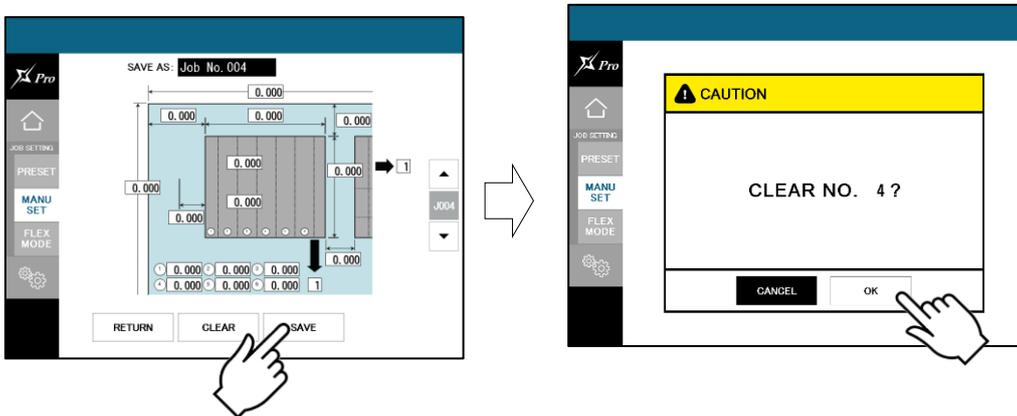


⑨ When data input is completed, Press **OK** to Home Screen.

- ④ This message will be shown if **SAVE** was pressed. Then press **OK** and save data.



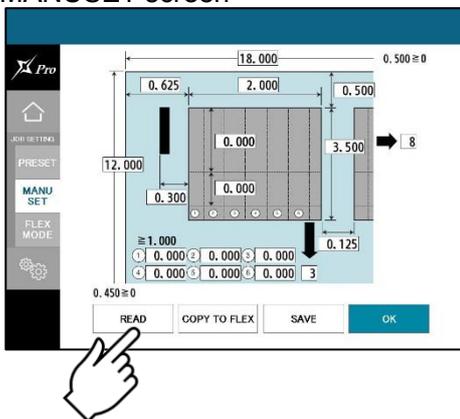
- ⑤ Saved user data can be deleted with a press of **CLEAR**.



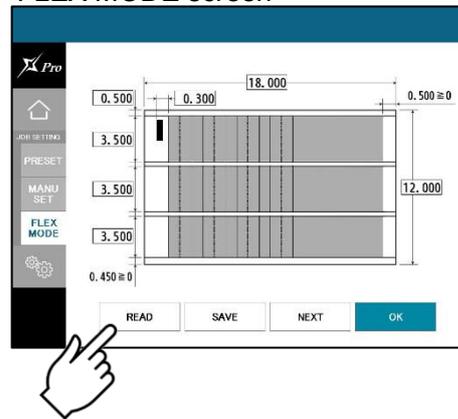
3.5.2 Read

- ① Can store the contents of the MANUSET or FLEX MODE, Press the **READ**.

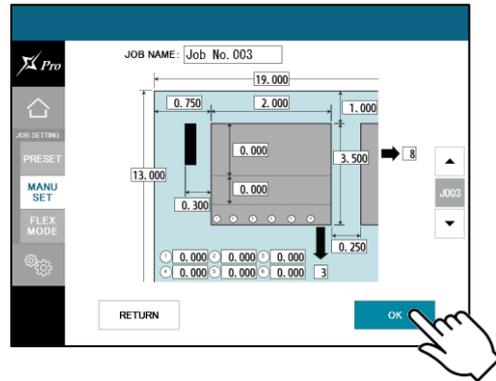
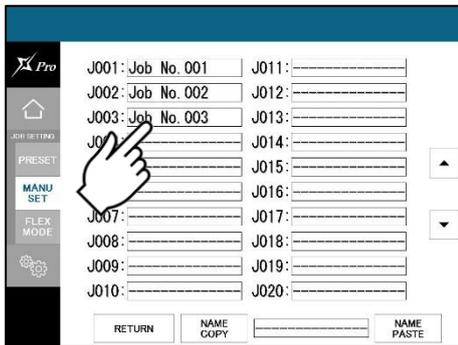
MANUSET screen



FLEX MODE screen

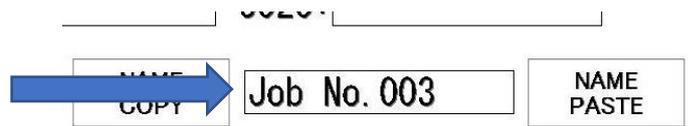
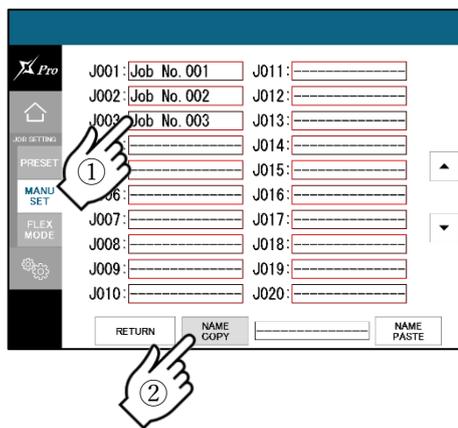


- ② Press the button of the name you wish to retrieve.
- ③ Confirm the details of the program for retrieval. Data can be accessed with a press **OK**.

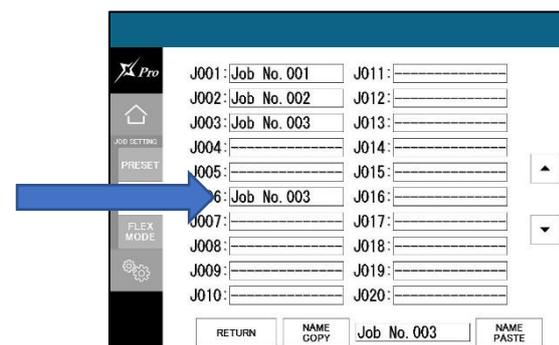
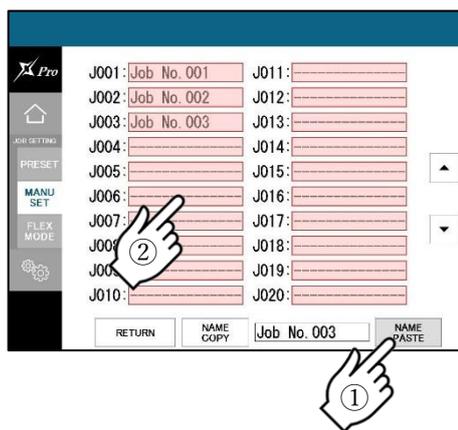


3.5.3 Copy and Paste Job name

- ① After pressing **NAME COPY**, select the job name you want to copy, and it will be copied to the box below.



- ② After pressing **NAME PASTE**, select the job you want to paste, and the copied job name will be pasted.



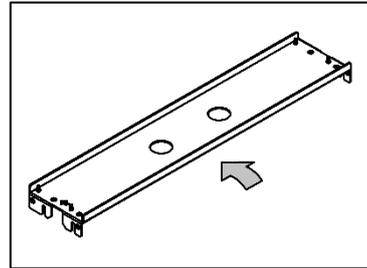
4 How to use options

4.1 X-perforator

- ① Remove the delivery guide.

Note.

In case Perforator unit is not set in the machine, please attach the delivery guide instead in order to avoid paper jam.

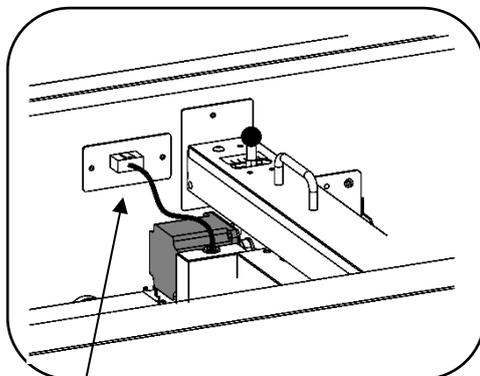
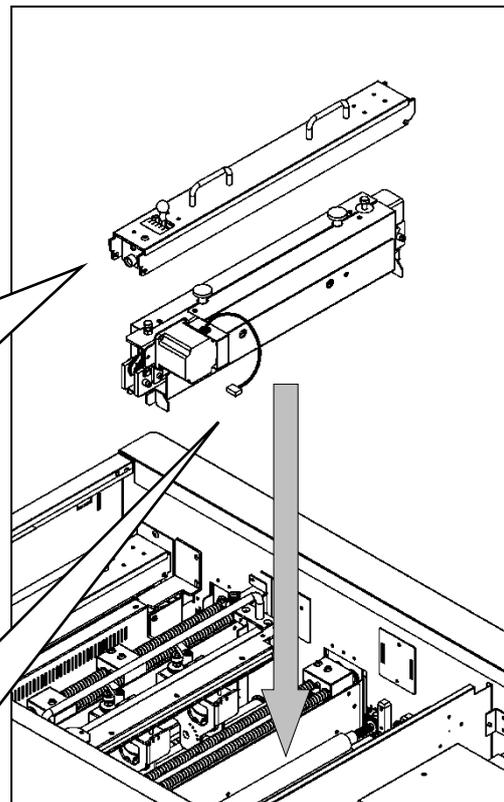
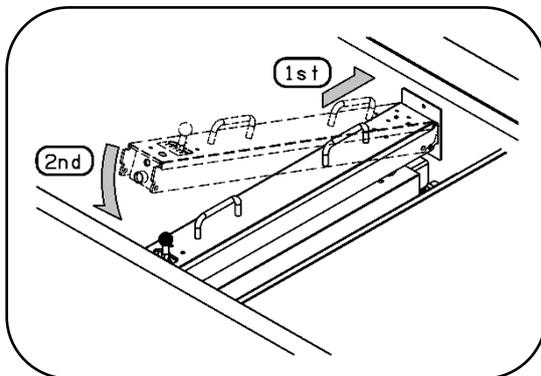


- ② Attach X-Perforator unit.

- Upper part

Ensure to hold the perforator with both hands and attach it with pushing it against the counter-operation side as shown in the figure.

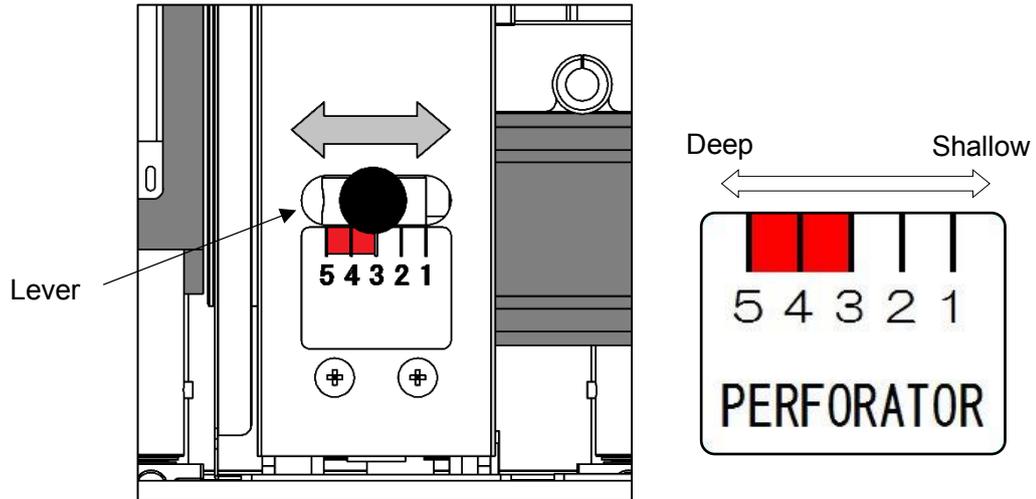
- Don't forget to connect cables.



Connector

4.2 How to adjust the depth of X-perforation

- Turn the lever shown in the drawing below to adjust the perfo depth.



Note.

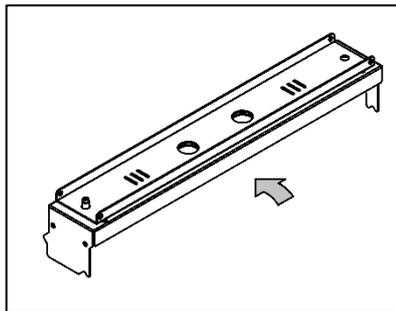
The recommended paper weight for the perforator is 250 g/m² or less.

4.3 Y-perforator

- ① Remove the delivery guide.

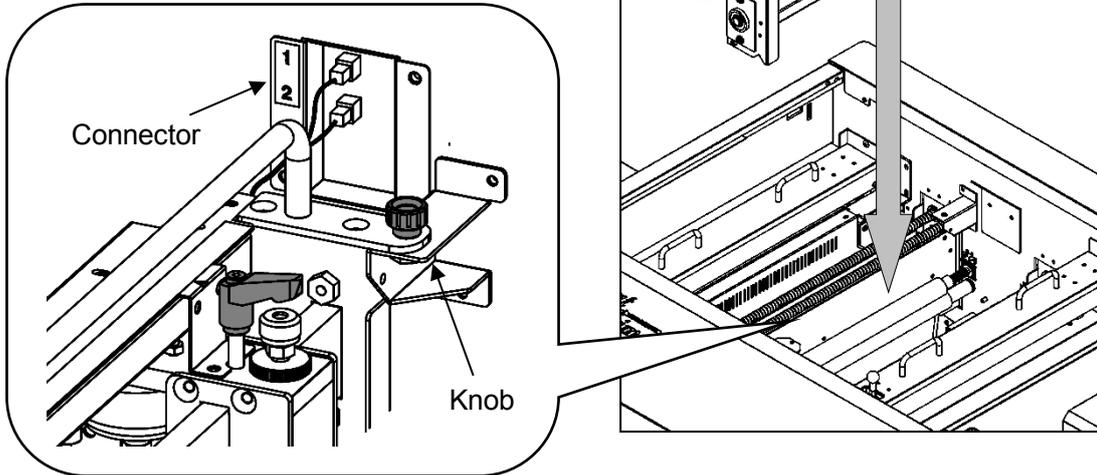
Note.

In case Perforator unit is not set in the machine, please attach the delivery guide instead in order to avoid paper jam.



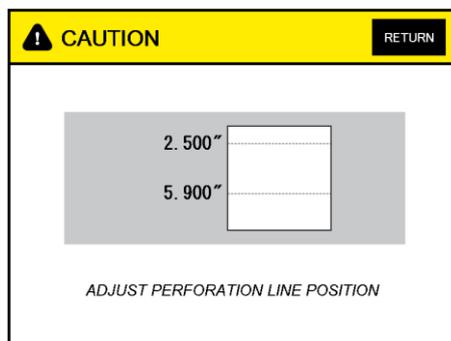
② Attach Y-Perforator unit.

- Be sure to hold the perforator with both hands and attach it as shown in the figure.
- Fasten knobs to fix the position of the unit.
- Put the connectors into sockets according to the numbers shown.

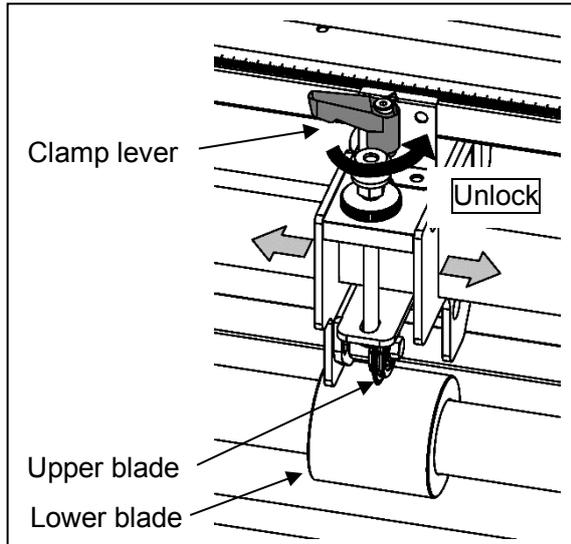


4.4 How to adjust the location of Y-perforation

- ① When using the perforator, the screen will display where to fix the perforator, as shown below.

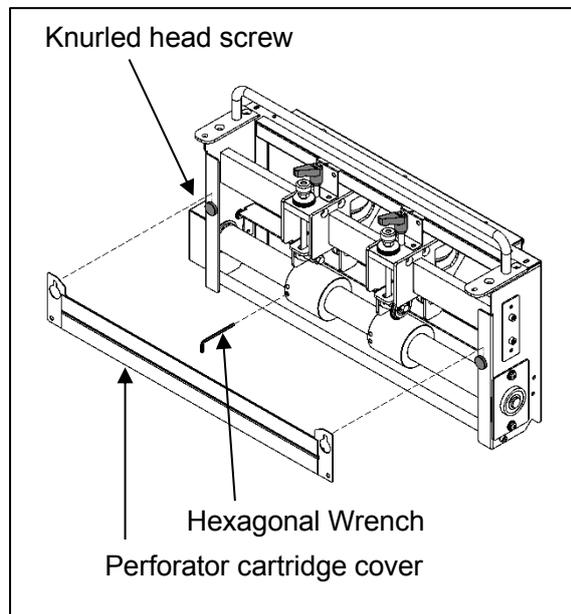


- ② If the upper blades are positioned to come into contact with the lower blades, the upper blade position can be adjusted with the perforator attached to the main body.



- ③ Loosen the clamp levers, move the perforator to the desired position based on the scale, and tighten the clamp levers firmly.

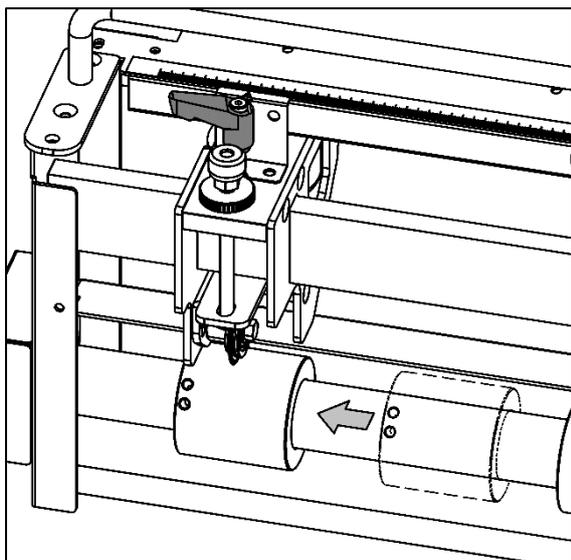
- ④ If the upper blades are not positioned to come into contact with the lower blades, remove the perforator from the main body for adjustment.



- ⑤ Loosen the two knurled head screws to remove the perforator cartridge cover.

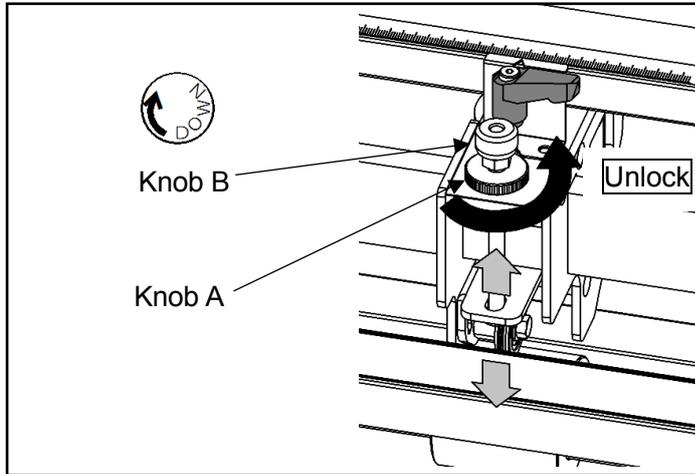
- ⑥ Loosen the clamp levers, move the perforator to the desired position based on the scale, and tighten the clamp levers firmly.

- ⑦ Then, loosen screws with an accessory wrench and adjust the lower blade position to near the center of the upper blades.



4.5 How to adjust the depth of Y-perforation

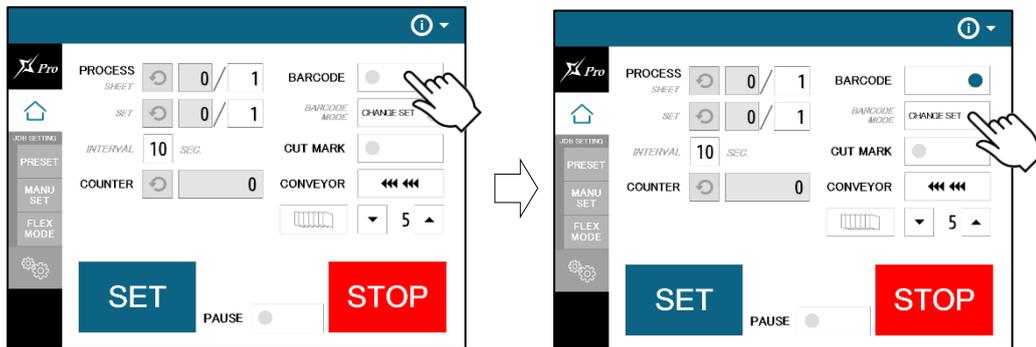
- ① Loosen knob A
- ② Adjust height with knob B.
- ③ Tighten knob A to fix the position.



4.6 Barcode reader

- With the barcode reader, the machine is capable to read barcodes (job number) printed on papers, recall jobs and process papers automatically.

- ① To activate the Barcode reader, press **BARCODE** button.

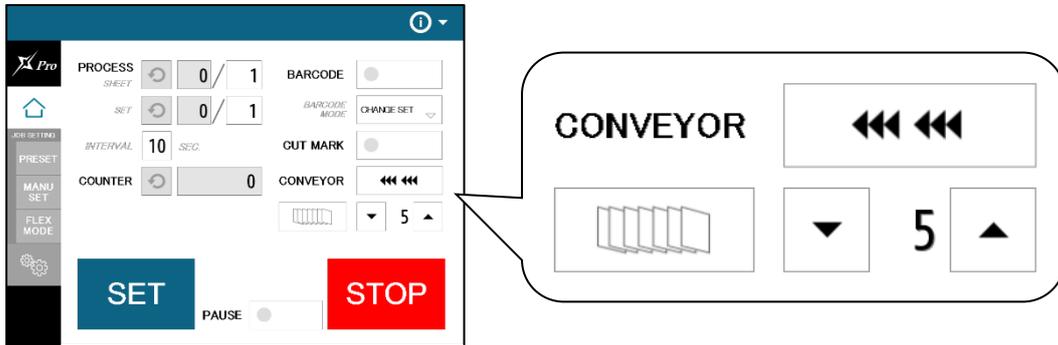


- ② Press the **BARCODE MODE** button to switch barcode reading modes according to the purpose.

	<p>CHANGE SHEET – Automatic job changeover</p> <ol style="list-style-type: none"> 1. The machine reads the barcode and compares to the selected job. 2. If the job number read is different from the job selected, the machine will recall the job number read, and change over the setting. 3. After the job setting changeover, the machine will automatically start processing.
	<p>CHANGE SET – Prevention of contamination</p> <ol style="list-style-type: none"> 1. The machine records the barcode on the first sheet of the new job. 2. When the machine reads a barcode, which is different from the recorded one during one set, it stops processing.

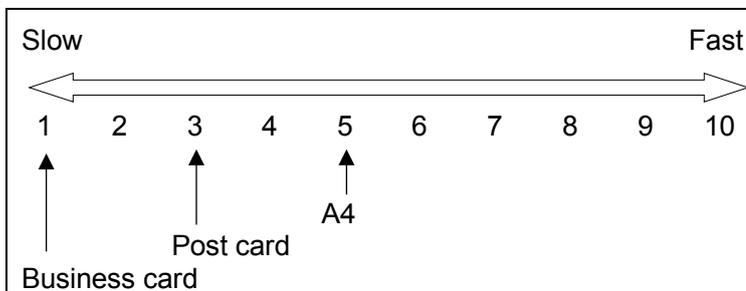
4.7 Belt conveyor tray

- The conveyor control appears on the home screen by turning on the machine power with the belt conveyor tray connected.

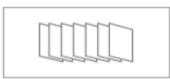


- Adjust the belt speed.

In case cut measurement is short, slow down the speed. If it is long, speed up.



- Select the card stacking method:

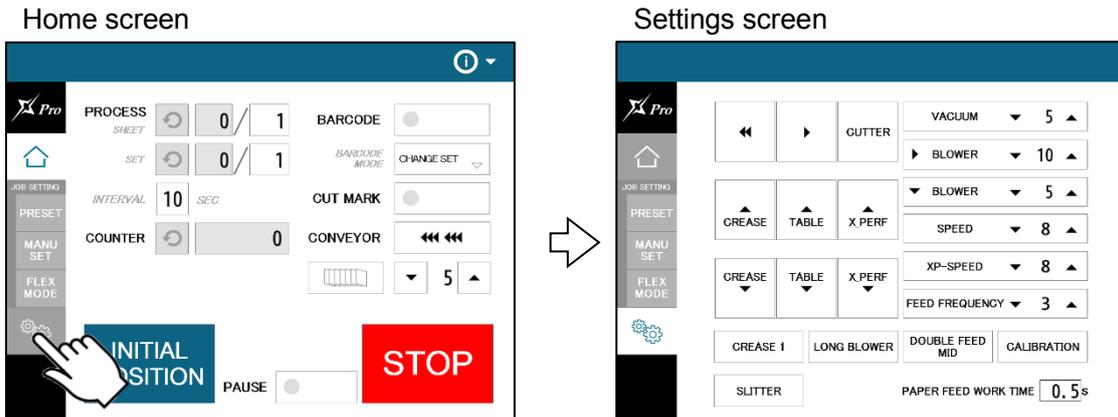
	The belt conveyor moves gradually as the cards are delivered.
	The belt conveyor moves gradually as the cards are delivered. After 1 set is finished, the belt conveyor moves additionally to make a gap between sets.

- When AeroCut XPro starts operation, the conveyor also starts to drive automatically.
- The conveyor drives forward by pressing . And it stops by pressing  again or **STOP**.

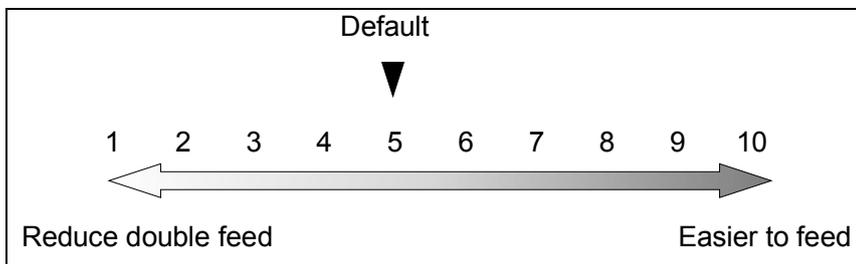
5 Adjustment

5.1 Adjustments on the paper feed section

- Adjustments are required when the machine is likely to feed double or skew.

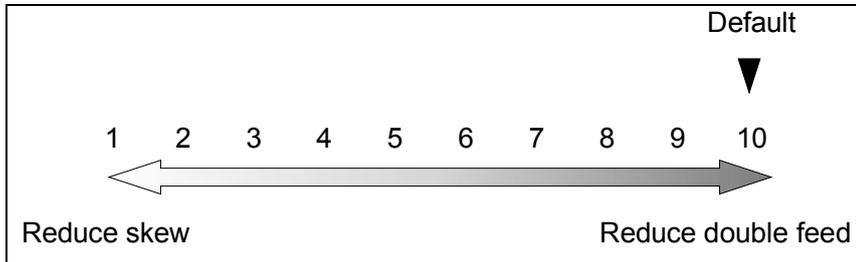


5.1.1 Upper suction adjustment



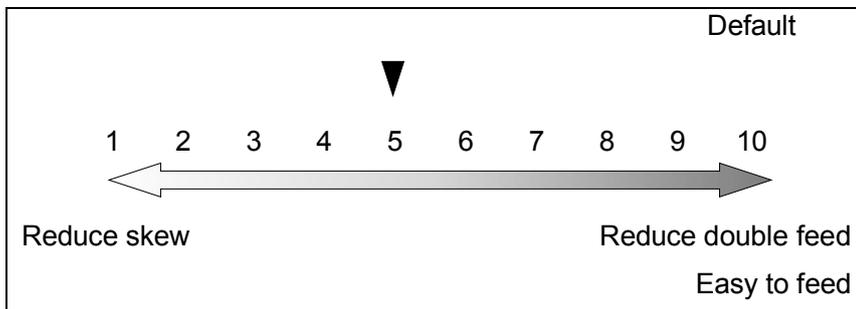
- Double paper feeds may occur in case of feeding thin or low-density papers. In such cases, turn down the VACUUM.
- Empty feed may occur in case of feeding heavy paper. In such a case, turn up the VACUUM.
- VACUUM will be turned off when the value is 0.

5.1.2 Lower suction adjustment



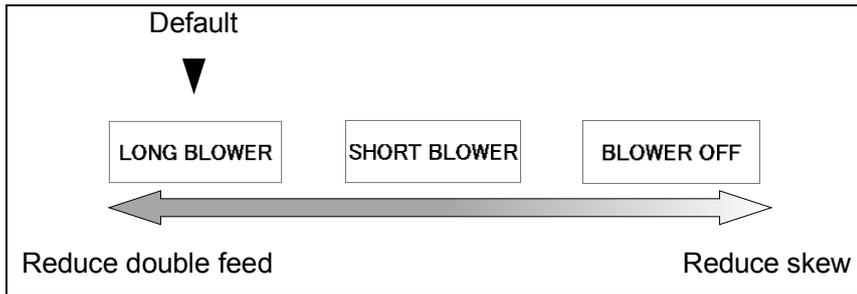
- BLOWER will be turned off when the value is 0.
- Empty feed may occur when paper is heavy. In such cases, turn up the blower.
- Papers with statics may cause double paper feed. In such cases, turn up the blower.

5.1.3 Side suction adjustment



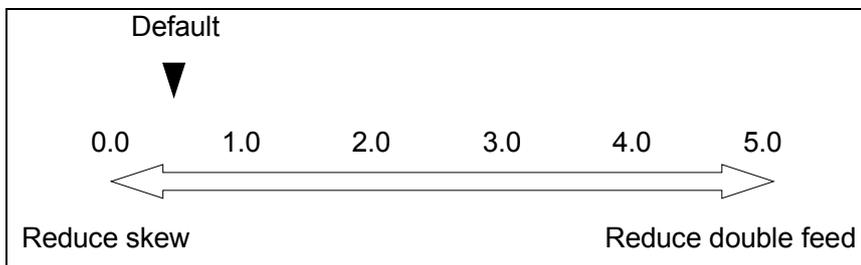
- BLOWER will be turned off when the value is 0.
- Thin paper might be bent and fed. In this case, turn down the side blower.
- Empty feed may occur when paper is heavy. In such cases, turn up the blower.
- Papers with statics may cause double paper feed. In such cases, turn up the blower.

5.1.4 Air blow adjustment



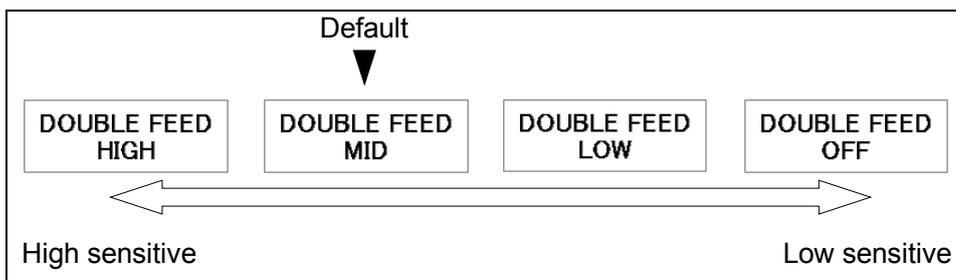
5.1.5 PAPER FEED WORK TIME adjustment

PAPER FEED WORK TIME s

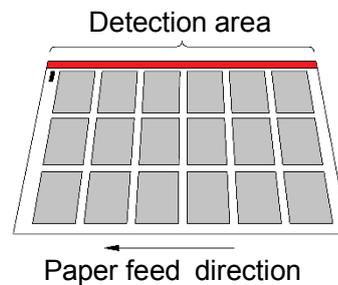


- 0.5 sec. is the default setting.
- Paper fed work time can be adjusted with a fraction of 0.1s.

5.1.6 Sensitivity of Double feed sensor



- If the machine detects double feed even with a single sheet, lower the sensitivity of the detection sensor.
- The detection sensor detects double feed by checking the edge of sheets as shown on the drawing. It is recommended not to print on the sheet edge.



5.2 Change speed

- There are eight feeding speed levels.

5.2.1 Speed of delivery

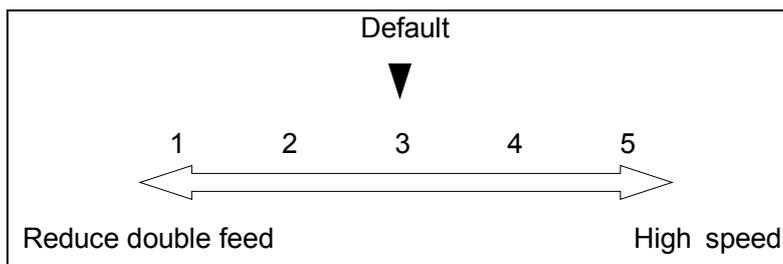


5.2.2 Speed of X-Perfo



- When X-perforating on heavy papers at high speed, it may cause noise and inaccurate cut. In such a case, slow down the XP-SPEED.

5.3 Feed frequency

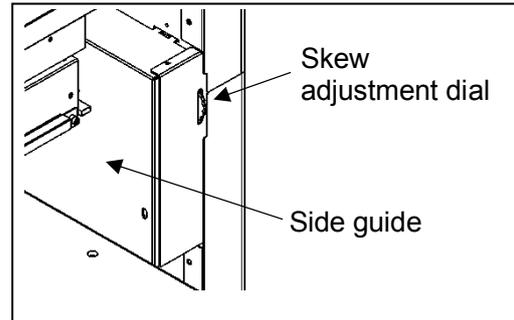


- Feed frequency is the function to alter intervals between paper feeds.
- As the number increases, feed frequency is increased and the interval is decreased.
- At level 5 the machine can feed papers at the highest speed, but the risk of double feed is also increased.
- is the default setting.

5.4 Skew adjustment

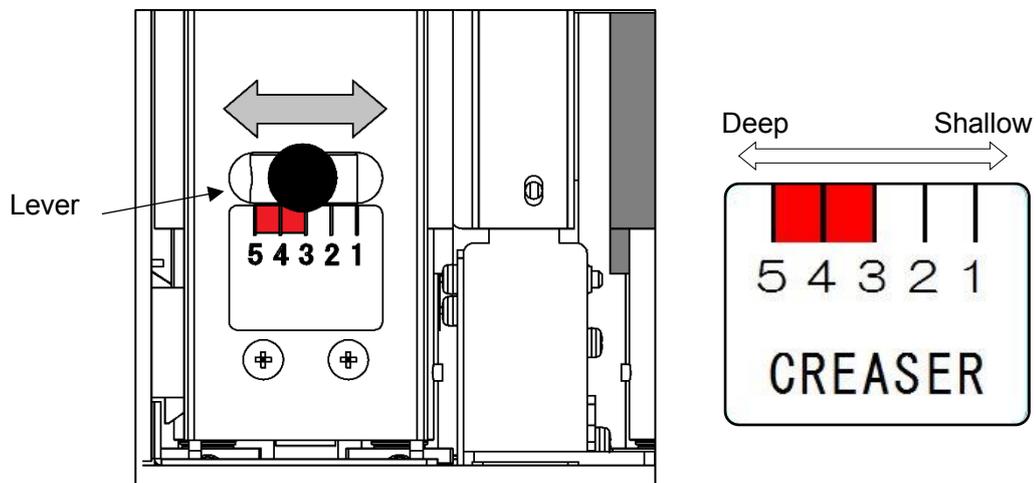
- If print is skew on the sheet, the angle of the side guide can be adjusted.

- ① The angle of the side guide changes as the skew adjustment dial is turned.
- ② Set the sheets again.



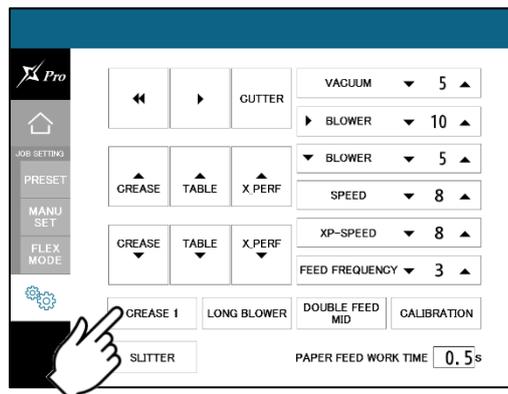
5.5 Creaser adjustment

- Turn the lever shown in the drawing below to adjust the crease depth.



- If creasing pressure is not enough even the lever is adjusted, pressing **CREASE 1** button and changing creasing mode to **CREASE 2** may help.

CREASE 2 mode enables the machine to cycle the creaser twice at creasing positions, which results in deeper creases.



Note.

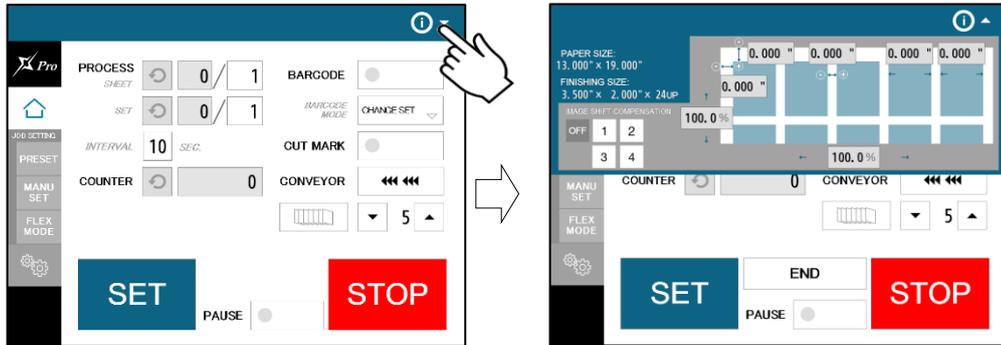
Use less than 3 in case of creasing on heavier paper than 300 gsm to avoid paper jam.

5.6 Fine adjustments on processing positions

- Make sure the original sheets are printed correctly and consistently.

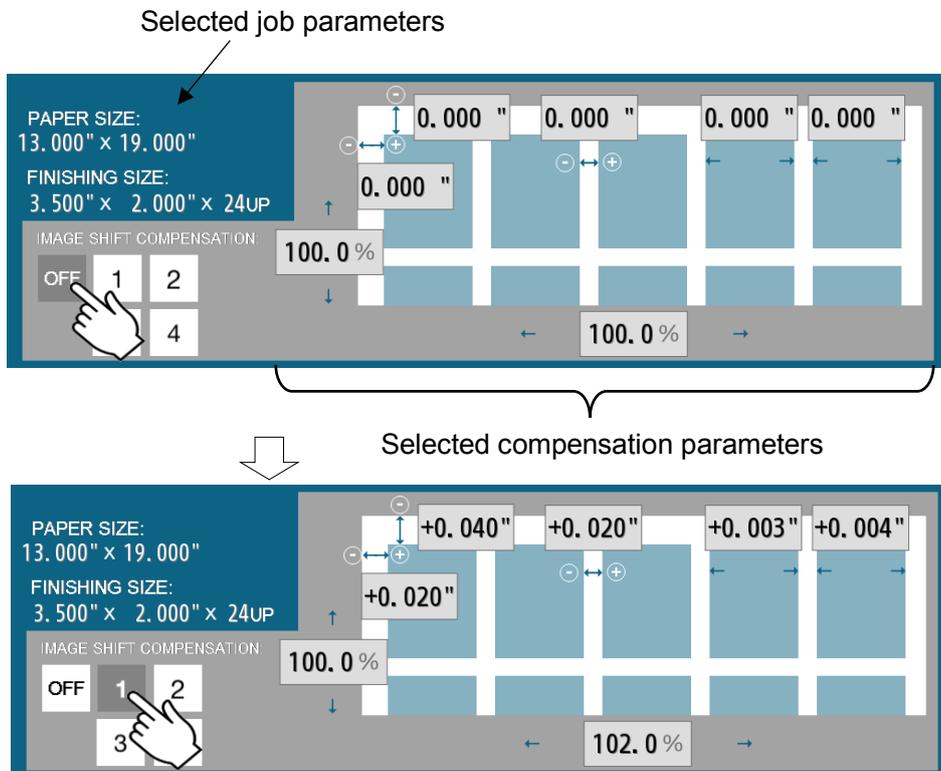
5.6.1 In cases cutting positions don't match to image positions.

- ① Image shift compensation tab will pop up by pressing  button.



- ② Select an Image shift compensation setting.

- 4 patterns of Image shift compensation setting can be saved in **1**~**4**.
- When processing without any compensation, select **OFF**.

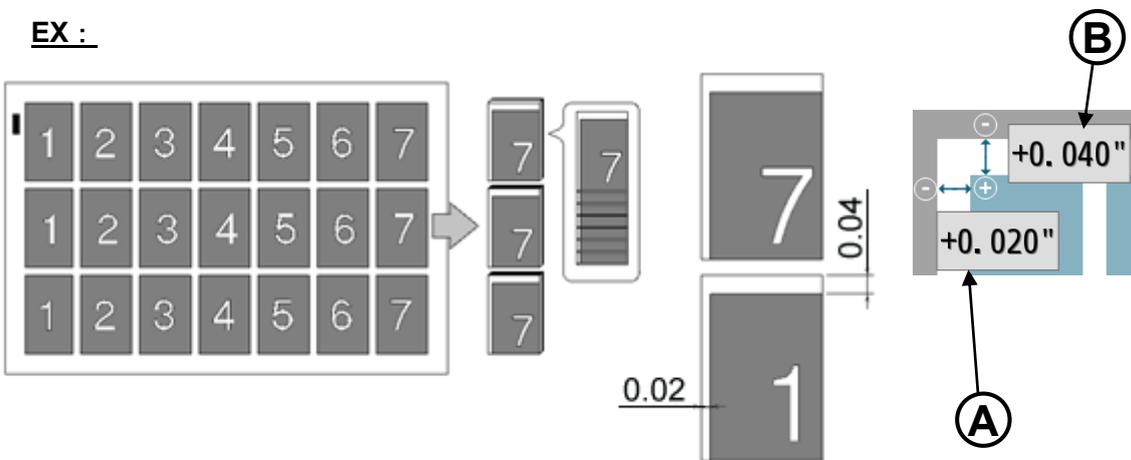


③ Compensate the image shift by following procedure.

When the leading edge and top margin are different from the artwork file.

- If the leading edge was printed larger than as it should be, the images on cards seem moved to right.
⇒ Enter a ⊕ correction value in A to cut the leading edge longer.
- If the leading edge was printed shorter than as it should be, the images on cards seem moved to left.
⇒ Enter a ⊖ correction value in A to cut the leading edge shorter.
- If the top margin was printed wider than as it should be, the images on the cards seem moved to the bottom.
⇒ Enter a ⊕ correction value in B to cut the top margin wider.
- If the top margin was printed narrower than as it should be, the images on the cards seem moved to the top.
⇒ Enter a ⊖ correction value in B to cut the top margin narrower.

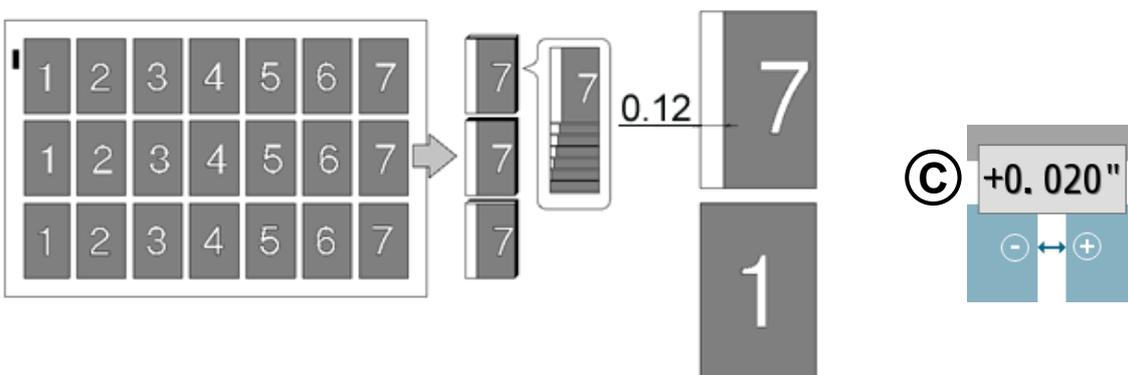
EX :



When the images on the cards seem moving gradually

- If the print was shrunk, images on the cards seem gradually moving to left.
⇒ Enter a ⊖ correction value to C to shorten the gutter length.
- If the print was stretched, images on the cards seem gradually moving to right.
⇒ Enter a ⊕ correction value to C to extend the gutter length.

EX :



In case the gap is 0.12" and there are 6 gutters between cards,
 $0.12 \div 6 = 0.02$ [inch] should be inputted.

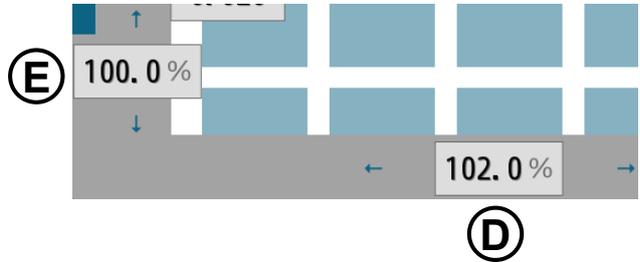
When the print is shrunk or stretched.

- Input ratio into D if the printing is stretching to the feed direction.
- Input ratio into E if the printing is stretching to the width direction.
- Ensure that when these ratios are changed, all parameters such as card size and gutter size will be changed as well.
- Must be from 80% to 120%

EX:

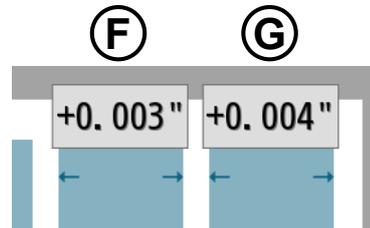
If printing should be 4.000" width,
but actual printing is 4.080",
input 102.0% into D.

$$\frac{4.080''}{4.000''} \times 100 = 102\%$$



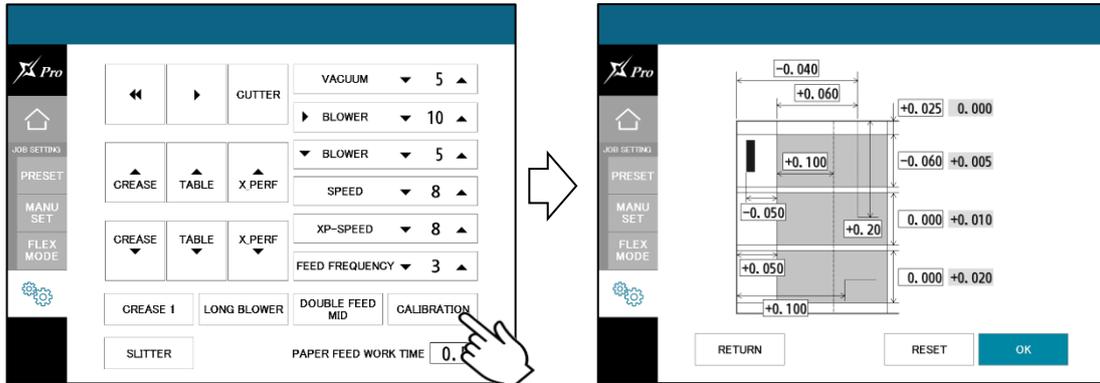
When the lengths of the last 2 cards are different from others.

- F Input a correction value to F to compensate the length of the second last card.
- Input a correction value to G to compensate the length of the last card.



5.6.2 If the cut measurement does not match the input value

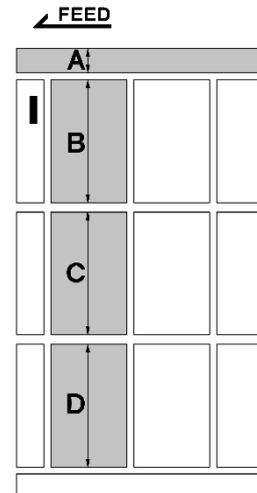
- If the actual size and measurements of output differs from input values, calibrate the machine via calibration screen.



RETURN	Reset the machine to the factory setting, all the adjusted values will be 0.
RESET	Save the adjusted values and go back to Manual speed Screen
OK	Go back to manual speed Screen without making any changes.

① In cases the width of a card or a top margin is different from inputted values, Input differences between inputted values and actual sizes of outputs into A, B, C and D.

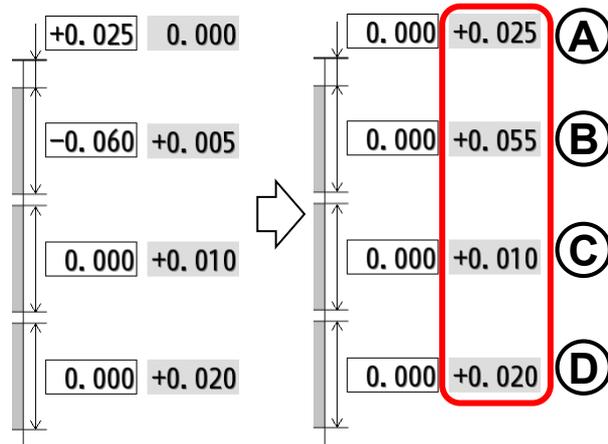
- If you press OK after you input values into A, B, C and D, those values will be added to each total measurements which are circled on the image below.
- Then, A, B, C and D will be reset to 0.000".
- You can change the measurement by 0.002".
- Each adjustment should be within ± 0.080 " at one time.
- If the gap is more than ± 0.080 ", repeat the process until the desired measurement is reached.



EX:

If the input value is 0.200" and cut measurement is 0.175", input +0.025.

If the input value is 3.500" and the cut measurement is 3.560", input -0.060.



② In case the length of leading edge is wrong.

- With cut mark

Input the difference between inputted value and actual measurement into E.

EX:

In case input value is 0.400" and cut measurement is 0.450", input -0.050 to E.

(You can input ± 0.400 " at the most)

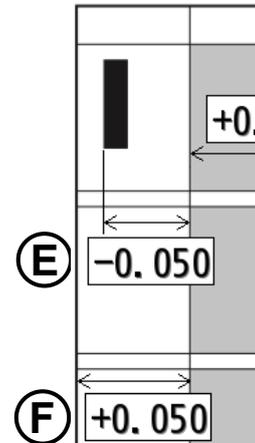
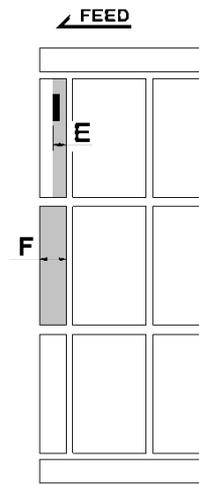
- Without cut mark

Input the difference between inputted value and actual measurement into F.

EX:

In case input value is 0.600" and cut measurement is 0.550", input +0.050 to F.

(You can input ± 0.400 " at the most)



③ In case X-perforation position in feeding direction is wrong.

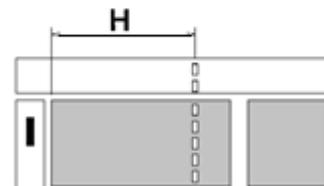
- In case the layout has X-Perforation only.

Input the difference between inputted value and actual position of X-perforator into G.

EX:

In case input value is 7.750" and actual perforation position is 7.790", input -0.040 to G.

(You can input ± 0.400 " at the most)



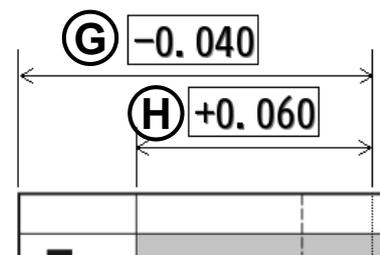
- In case the layout has X-perfo and other processes such as cross cut at the same time.

Input the difference between inputted value and actual position of X-perforator into H.

EX:

In case input value is 2.000" and actual perforation position is 1.940", input +0.060 to H.

(You can input ± 0.400 " at the most)

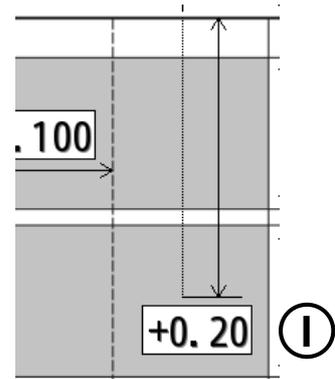


- ④ In case the length of X-Perforator is incorrect.
- Input the difference between inputted value and actual length of X-Perforator into I.

EX:

In case input value is 5.900" and actual perforation is 5.700" length, input +0.200 to I.

(You can input ± 0.400 " at the most)

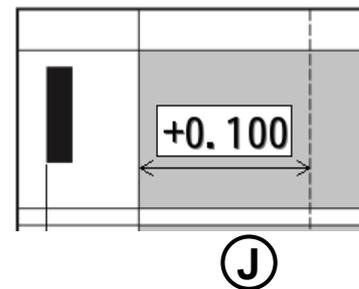


- ⑤ In case creasing position is incorrect
- Input the difference between inputted value and actual creasing position into J.

EX:

In case input value is 2.000" and the actual creasing position is 1.900" length, input +0.100 to J.

(You can input ± 0.400 " at the most)

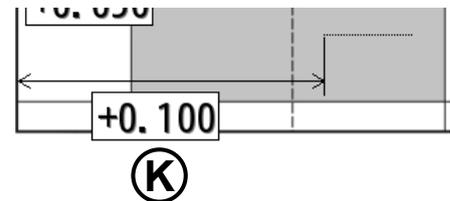


- ⑥ In case the timing of Y-Perforation is incorrect.
- Input the difference between inputted value and start position into K.

EX:

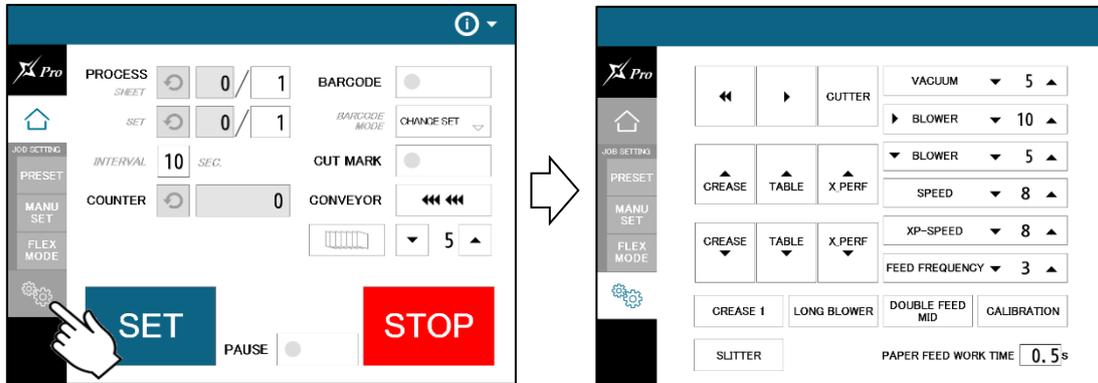
In case input value is 2.000" and the actual starting position of creasing is 1.900" length, input +0.100 to K.

(You can input ± 0.400 " at the most)



6 Manual control

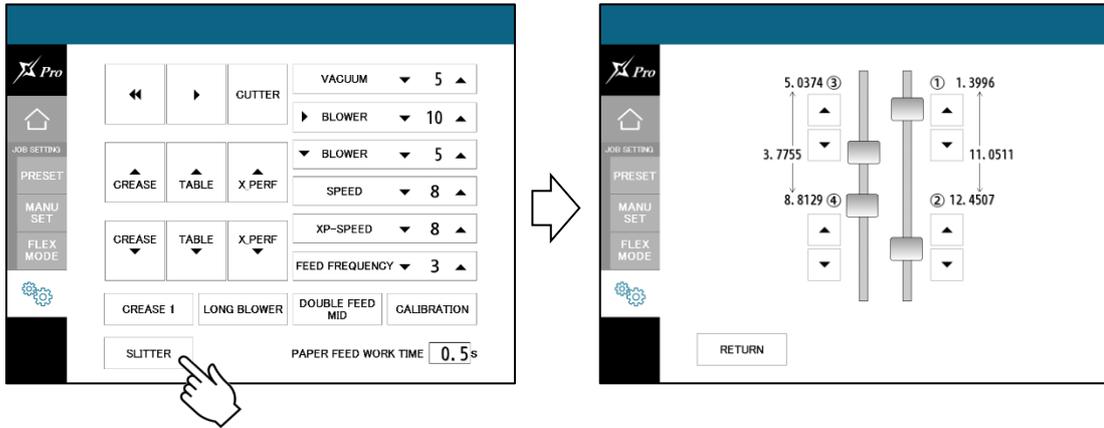
6.1 Settings screen

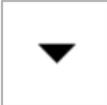


	Feed roller will rotate. Inching.
	Feed roller will rotate in reverse. Inching.
	Guillotine will move once.
 CREASE  CREASE	Crease will move.
 TABLE  TABLE	Feed table will move.
 X_PERF  X_PERF	X-perforator will move.

6.2 Slitter

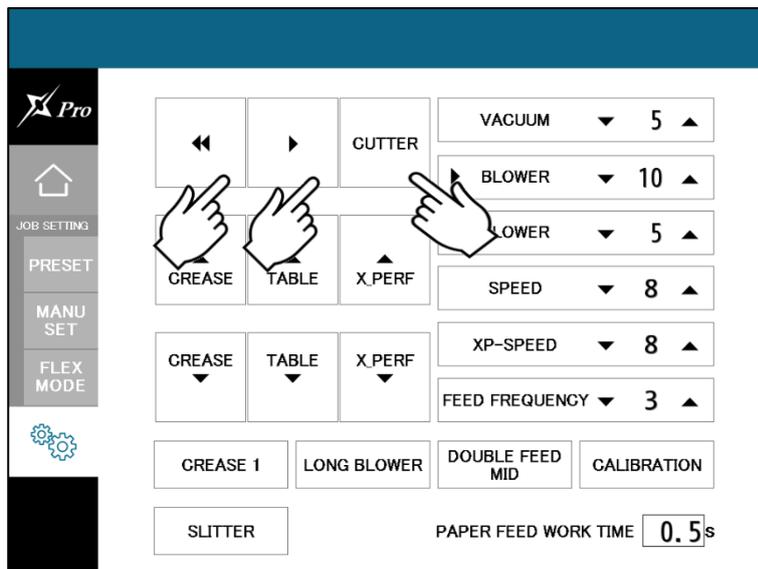
- After turning on the machine power and press “Initial position”, SLITTER button will appear.



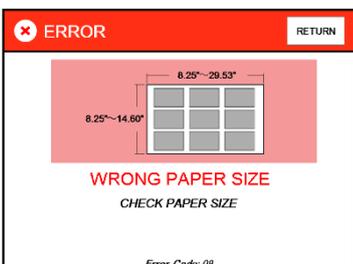
 	Slitter will move. Inching.
	Return to the previous page.

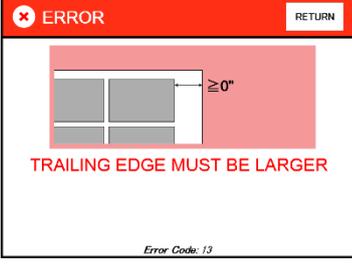
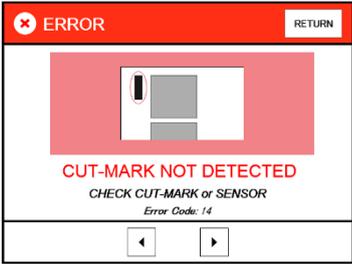
6.3 Paper jam

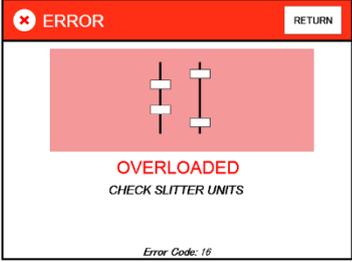
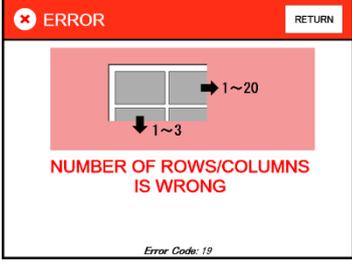
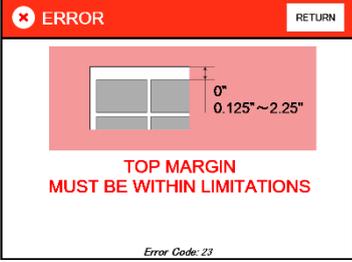
- Enter settings screen, press  ,  buttons to inch the rollers forward / backward and remove the jammed paper.
- If paper is stuck around the guillotine section, press  to cycle the guillotine to chop jammed paper.

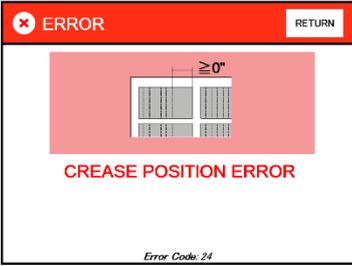
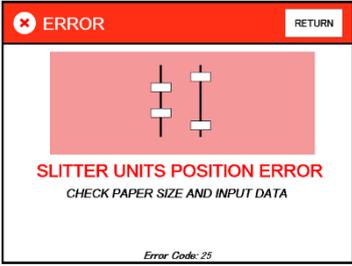
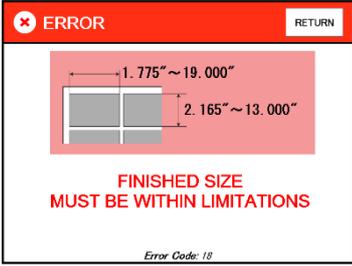
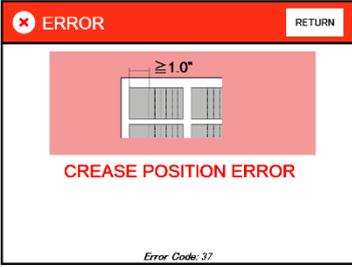


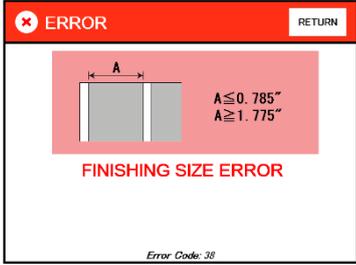
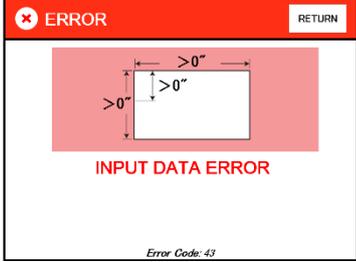
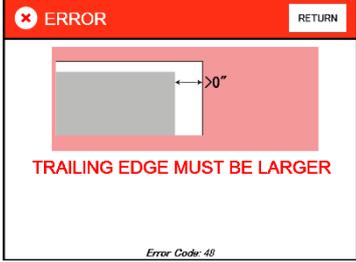
7 Error messages

Code	Screen	What to do
04	 <p>The screenshot shows a red header bar with a white 'x' icon and the word 'ERROR'. Below the header, the text reads 'COVER IS OPEN' in red, followed by 'CLOSE THE COVER' in black. At the bottom, it says 'Error Code: 04'.</p>	<p><u>Cover Open error</u> Safety cover might be open. Make sure to close the Safety cover closed.</p>
05	 <p>The screenshot shows a red header bar with a white 'x' icon and the word 'ERROR', and a 'RETURN' button on the right. The main text reads 'PAPER JAM' in red, followed by 'REMOVE JAMMED PAPER' in black. At the bottom, it says 'Error Code: 05' and has left and right navigation arrows.</p>	<p><u>Cut Paper Jammed error 1</u> Paper remains inside the machine. Remove the paper.</p>
06	 <p>The screenshot shows a red header bar with a white 'x' icon and the word 'ERROR', and a 'RETURN' button on the right. The main text reads 'TIME OUT ERROR' in red, followed by 'CHECK PAPER PATH.' in black. At the bottom, it says 'Error Code: 06'.</p>	<p><u>Timeout error 1</u> Paper was not fed within a set time period. Check the paper feeder.</p>
07	 <p>The screenshot shows a red header bar with a white 'x' icon and the word 'ERROR', and a 'RETURN' button on the right. The main text reads 'TIME OUT ERROR' in red, followed by 'CHECK PAPER PATH.' in black. At the bottom, it says 'Error Code: 07' and has left and right navigation arrows.</p>	<p><u>Timeout error 2</u> Paper did not pass through within a set time period. Remove the paper remaining inside the machine.</p>
09	 <p>The screenshot shows a red header bar with a white 'x' icon and the word 'ERROR', and a 'RETURN' button on the right. The main text reads 'WRONG PAPER SIZE' in red, followed by 'CHECK PAPER SIZE' in black. Below the text is a diagram of a paper sheet with dimensions: 8.25"~14.60" (width) and 8.25"~29.53" (height). At the bottom, it says 'Error Code: 09'.</p>	<p><u>Paper size error</u> Correct the paper size to fit in the value range below.</p>

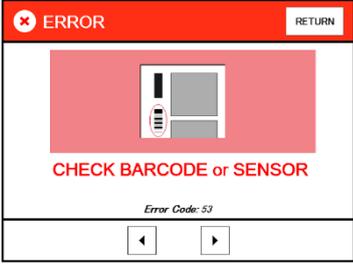
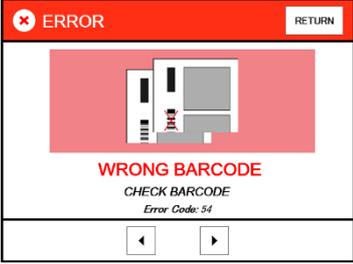
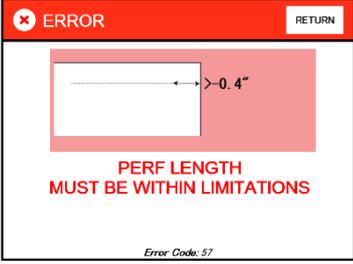
<p>10</p>		<p><u>Cut Paper Jammed error 2</u></p> <p>Paper remains inside the machine. Remove the paper.</p>
<p>11</p>		<p><u>Overload error 1</u></p> <p>Cutting or creasing did not complete within a set time period. Remove the paper remaining inside the machine.</p>
<p>13</p>		<p><u>Trailing edge error.</u></p> <p>Correct the trailing edge to fit in the value specified below.</p>
<p>14</p>		<p><u>Cut-mark error</u></p> <p>Cut-mark was unable to be detected. Check the cut mark. Eject the paper inside the machine.</p> <p>Note.</p> <p>Cut-mark sensor detects the black mark by infrared light. Some types of toner or ink may reflect the infrared light and cause the sensor not reading the cut-mark. Please inactivate the cut-mark registration in such cases.</p>
<p>15</p>		<p><u>Overload error 2</u></p> <p>An overloading error occurred at the feed table. Check the feed table.</p>

<p>16</p>		<p><u>Overload error 3</u> An overloading error occurred at the slitter. Check the blinking slitter.</p>
<p>17</p>		<p><u>Final cutting measurement error</u> Correct the final cutting measurement to exceed the value specified below.</p>
<p>19</p>		<p><u>Cut piece number error</u> Correct the number of cut pieces to be in the value range below. The maximum number of pieces is subject to change depending on the operation.</p>
<p>21</p>		<p><u>Guillotine error</u> The cutter blade has moved and is staying at lower position. Move the cutter to top dead center.</p>
<p>22</p>		<p><u>Bottom margin error</u> Correct the bottom margin to fit in the value range below.</p>
<p>23</p>		<p><u>Top margin error</u> Correct the top margin to fit in the value range below.</p>

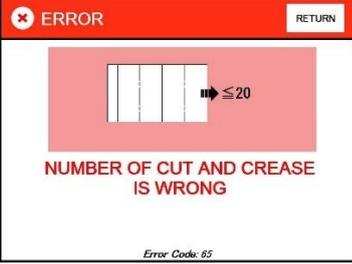
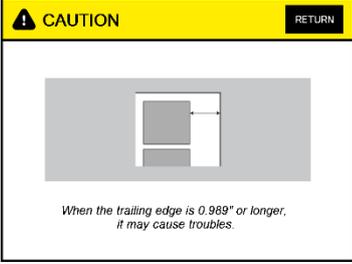
<p>24</p>		<p><u>Crease trailing edge error</u> Correct the crease trailing edge to exceed the value specified below.</p>
<p>25</p>		<p><u>FLEX MODE input error 2</u> Slitter units positioning error. Slitter position is out of valid range. Check paper size and input data.</p>
<p>28</p>		<p><u>Crease error</u> The creaser has moved and staying at upper position. Move the creaser to bottom dead center.</p>
<p>29</p>		<p><u>Cutting measurement error</u> Correct the cutting measurement to fit in the value range below. The maximum value is subject to change depending on the entered paper size.</p>
<p>36</p>		<p><u>Communication error</u> Communication with the touch panel is not possible. Turn off the power, and turn it on again after 5 seconds or longer.</p>
<p>37</p>		<p><u>Crease leading edge error</u> Correct the crease leading edge to exceed the value specified below.</p>

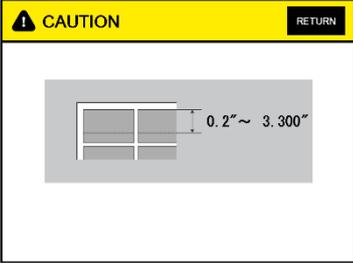
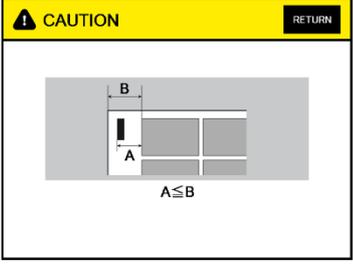
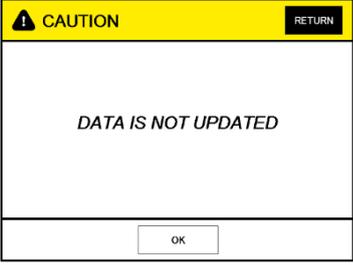
<p>38</p>		<p><u>FLEX MODE input error 3</u></p> <p>Make sure for the first cut line must be 0.785” or shorter from the edge of the paper.</p> <p>If you want to cut off 0.785” or more, please cut off 0.785” or less at first and then cut off again and again.</p> <p>If you try to move the slit cut line at 1.85” or more position, the slit will be ejected on Paper ejection table instead of waste box.</p>
<p>42</p>		<p><u>Double feed error</u></p> <p>Check the paper or paper path.</p>
<p>43</p>		<p><u>FLEX MODE input error 1</u></p> <p>This error results when the three input values shown in the following figure are “0” or lower at FLEX MODE time.</p>
<p>45</p>		<p><u>Servo error</u></p> <p>Servo motor error detected. Turn off the power, and turn it on again after 5 seconds or longer.</p>
<p>48</p>		<p><u>FLEX MODE input error 4</u></p> <p>Trailing edge error.</p> <p>Correct the trailing edge to fit in the value specified below.</p>
<p>52</p>		<p><u>Option unit error 1</u></p> <p>Cable of X-Perforator has not been connected.</p> <p>Connect the cable</p>

AeroCut XPro OPERATION MANUAL

<p>53</p>		<p><u>Barcode error1</u> Barcode was unable to be detected. Check the barcode.</p>
<p>54</p>		<p><u>Barcode error2</u> A wrong barcode was detected. Check the barcode.</p>
<p>55</p>		<p><u>Option unit error2</u> Overload error. An overloading error occurred at the X-Perforator.</p>
<p>56</p>		<p><u>Option unit error3</u> The X-perfo blade is not at the initial position. Move X-perfo to initial position. Initial position is on far side from operation screen.</p>
<p>57</p>		<p><u>FLEX MODE input error 5</u> Correct the Y-perfo length to exceed the value specified below.</p>
<p>61</p>		<p>Eject the paper inside the machine. Check the paper size.</p>

AeroCut XPro OPERATION MANUAL

<p>62</p>		<p><u>Double feed error</u> Check the paper or paper path. Eject the paper inside the machine.</p>
<p>63</p>		<p><u>Overload error 4</u> Eject the paper inside the machine.</p>
<p>64</p>		<p><u>Over feed error</u> Check the paper on the delivery tray.</p>
<p>65</p>		<p><u>Copy to FLEX error</u> The data cannot be processed in FLEX mode. Correct the figures so that the number of actions will be 20 times or less, or proceed in MANUSET.</p>
<p>66</p>		<p><u>Wrong job data error</u> This job data cannot be processed. Check the job data.</p>
<p>—</p>		<p><u>Trailing edge warning</u> When the trailing edge is 1.000” or longer, it may cause troubles.</p>

<p>—</p>		<p><u>Perforation location warning</u></p> <p>Correct the perforation location to fit in the value range below.</p> <p>The maximum value is subject to change depending on the entered paper size.</p>
<p>—</p>		<p><u>Leading edge and cut mark margin warning</u></p> <p>Correct the measurement so that the leading edge becomes larger than the cut mark margin.</p>
<p>—</p>		<p><u>Update message</u></p> <p>This error message appears as a warning when proceeding to another screen without saving the corrected dimensions in the MANU SET or FLEX MODE screen.</p> <p>Press <input type="button" value="OK"/> if you want to proceed to the other screen; otherwise, press <input type="button" value="RETURN"/>.</p>

8 Troubleshooting

- ① Papers are not fed well.
 - Turn up Upper suction.
 - Shorten the PAPER FEED WORK TIME. i.e. less than 1.0
 - Check if the paper guides on the feed table hold sheets too tight.
 - Make sure that the paper edges are not curled or waved.
 - Make sure that the papers are not heavily electric static charged.

- ② The machine feeds double-sheets.
 - Turn down Upper suction.
 - Turn up Lower suction.
 - Make sure that the papers are not heavily electric static charged.
 - Lengthen the PAPER FEED WORK TIME. i.e. 2.0

- ③ The machine detects double-feed mistakenly.
 - Adjust the sensitivity of the double-feed detection sensor.
 - The detection sensor detects double feed by checking the edge of sheets. It is recommended not to print on the sheet edge.

- ④ Cut skewing
 - Make sure that the stock is put on the feed table correctly.
 - Check whether the skewings are consistent or inconsistent.
 - If skewings are consistent
 - + Make the skewing adjust via the skew adjustment dial.
 - + Set the paper guides without play.

Do not set them too tight as the sheet may not be fed well.
 - If skewings are inconsistent
 - + Shorten the PAPER FEED WORK TIME. i.e. less than 1.0
 - + Make sure that the sheets are printed consistently and aligned well.

- ⑤ Paper jam often occurs.
 - Make sure that papers, paper strips or paper dusts not remain inside of the machine.
 - Check the conditions of the paper stock.

9 Product specifications

Specifications	
Slitter	4 sets (6 slitter blades)
Guillotine	1 set
Creaser	1 set
X perforator	1 set(Depends on configuration)
Y perforator	2 set (Jump perforation) (Depends on configuration)
Maximum paper size	14.60" x 29.53"
Minimum paper size	8.25" x 8.25"
Minimum work size	2.165" x 1.775"
Paper weight	120-400g/m ² Depending on paper
Maximum paper curl size	±0.125"
Paper type	Offset, Coat, UVcoat, Glossy, Laminate Depending on paper
Paper feeding method	Tri-suction upper belt feeding mechanism
Input tray capacity	MAX 4.000"
Speed	9.0 sheets per minute (21 business cards from SRA3)
Machine dimensions [inch]	W46.34x D27.95x H42.32 (Occupancy area: W79.53 x D27.95 x H60.83)
Net weight	640lbs(Depends on configuration)
Power supply	Single phase 110- 120VAC, 50/60Hz,
Power consumption	400VA
Use temperature	-5°C~+40°C
Preservation temperature	-25°C~+65°C
Use temperature humidity	45~85%RH
Preservation humidity	25~100%RH
Use the uplands	~1000M
One's tolerance level	200~240V ±10%
Over voltage category	Category II according to IEC60664-1
Pollution degree	Degree 2 according to IEC60664-1

AeroCut XPro OPERATION MANUAL

Keep this "Operation Manual" at an appointed place with care so that it may be available whenever required.

If this "Operation Manual" is stained or lost, make contact with the distributor or our salesman or customer service section to ask for a new operation manual after making sure of its contents.

When ordering consumables or parts, be sure to specify the machine model.