

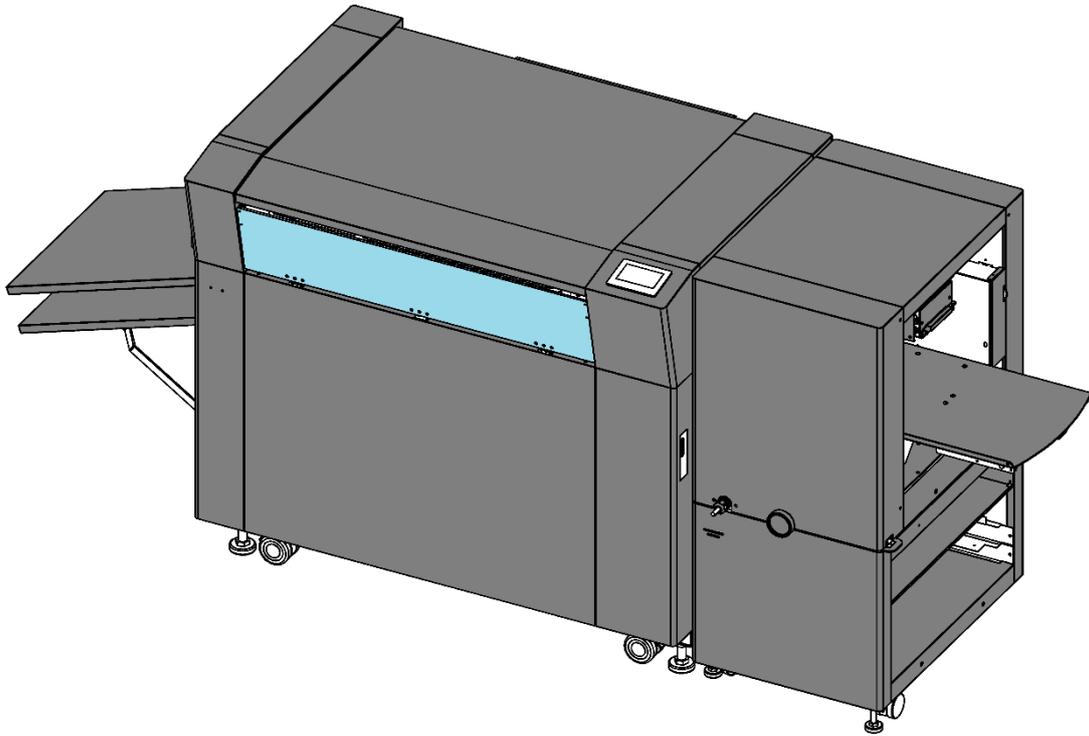
**UCHIDA**

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# *AeroDieCut*

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**OPERATION MANUAL**



**UCHIDA YOKO CO., LTD., TOKYO, JAPAN**

79-231 V1.02

- 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:

 <b>Warning</b>
<ol style="list-style-type: none"> <li>1. Don't put hands inside work area. May result in severe injury.</li> <li>2. Don't touch any rotating part. There is a danger of receiving an injury.</li> <li>3. Don't open the cover of the equipment. There is a danger of receiving an injury or electric shock.</li> <li>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.</li> <li>5. Don't disassemble gas spring. There is a danger of receiving an injury.</li> </ol>



## 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. Do not exceed the MAX level when stacking the paper.  
Exceeding it may cause a mechanical failure.
4. 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 2 to page 3) 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.	Paper weight / quality.....	6
2.	Operating instructions .....	7
2.1.	Turning the power on .....	7
2.2.	Initial setting .....	8
2.3.	Job select .....	8
2.4.	Paper setting .....	9
2.5.	Check the condition of the Press plate .....	10
2.6.	Job start .....	11
2.7.	Interruption .....	12
2.8.	Power off .....	12
3.	Job data.....	13
3.1.	Details screen .....	13
3.2.	Imposition control screen .....	14
3.3.	Data inputs .....	15
3.3.1.	Explanation of each data inputs .....	15
3.3.2.	Inputs .....	16
3.4.	Data save .....	18
3.5.	Data read .....	20
3.5.1.	Read from Job No.....	20
3.5.2.	Read from Job-data list .....	21
3.5.3.	Read input data .....	22
3.6.	Change saved data .....	22
3.7.	Delete saved data .....	23
4.	Die board setting .....	24
4.1.	Die board Changing .....	24
4.2.	Adjustment of the level of pressurization .....	27
5.	Manual control.....	28
5.1.	Manual control screen.....	28

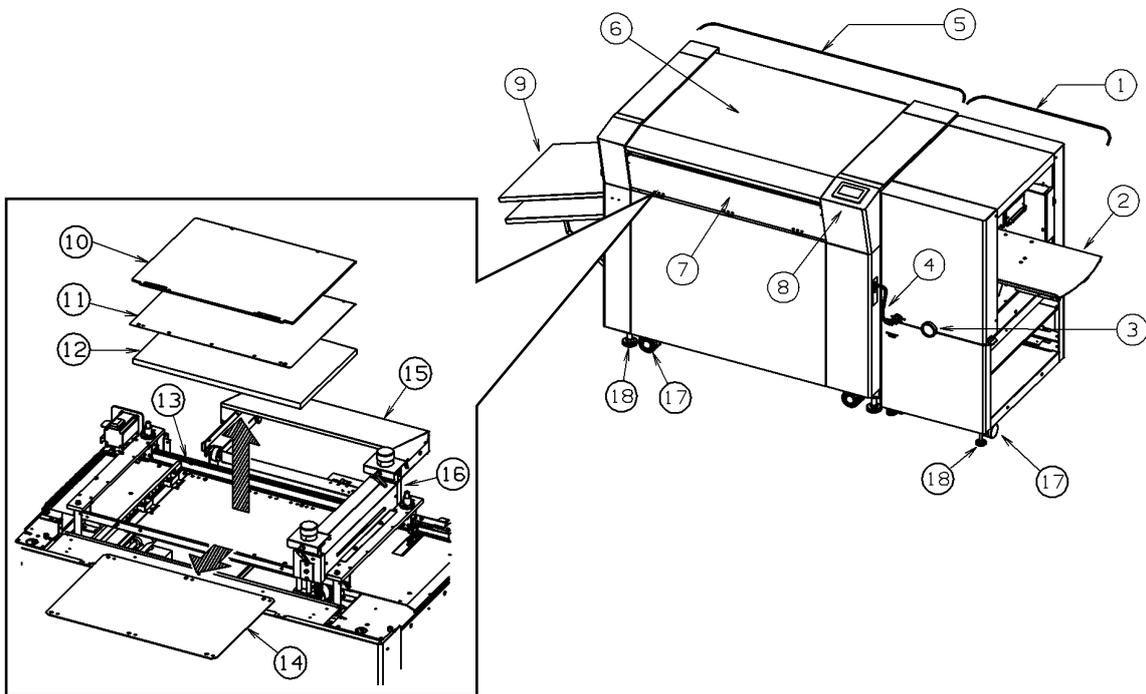
## AeroDieCut OPERATION MANUAL

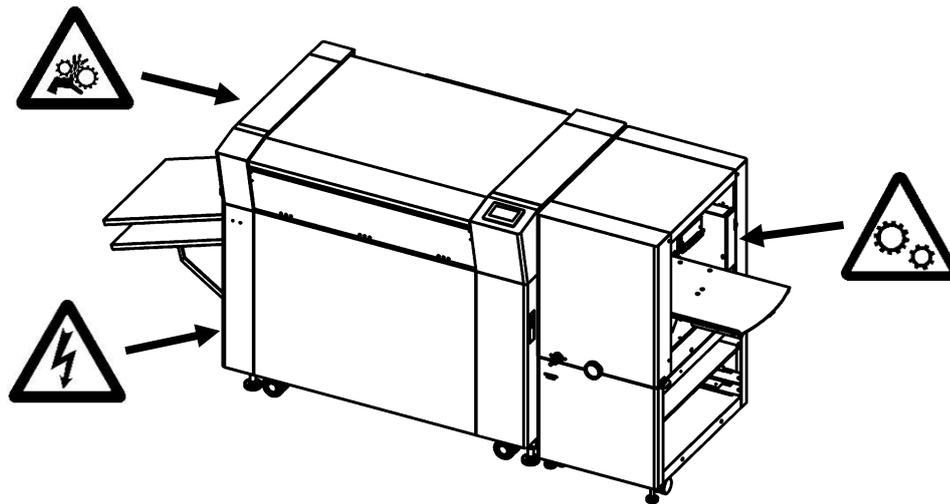
6.	Settings.....	30
6.1.	Settings screen .....	30
6.1.1.	Speed.....	30
6.1.2.	Double feed check .....	31
6.1.3.	Paper feed work time.....	31
6.1.4.	Table position after work.....	31
6.1.5.	Tri-suction .....	31
6.1.6.	Press Conditions.....	32
7.	Adjustment .....	34
7.1.	Respond for Feeding direction shift .....	34
7.1.1.	image shift compensation screen .....	34
7.1.2.	Cutting position adjustment .....	35
7.1.3.	Stretch/Shrink adjustment .....	36
7.2.	Respond for shift of depth direction .....	37
7.3.	Respond to printing skew.....	38
8.	Message dialog .....	39
9.	Maintenance.....	43
10.	Troubleshooting .....	44
11.	Product specifications.....	46

# 1 Introduction

## 1.1. Names of parts

No.	Name	No.	Name
01	Feed unit	10	Press plate
02	Feed table	11	Protective plate
03	Depth adjustment handle	12	Die board
04	Joint cable	13	Paper carrying belt
05	Press unit	14	Cutting plate
06	Top cover	15	Plate holder
07	Front cover	16	Press roller
08	Touch screen	17	Caster
09	Ejection table	18	Adjuster





 <b>Warning</b>	
	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.

## 1.2. Paper weight / quality

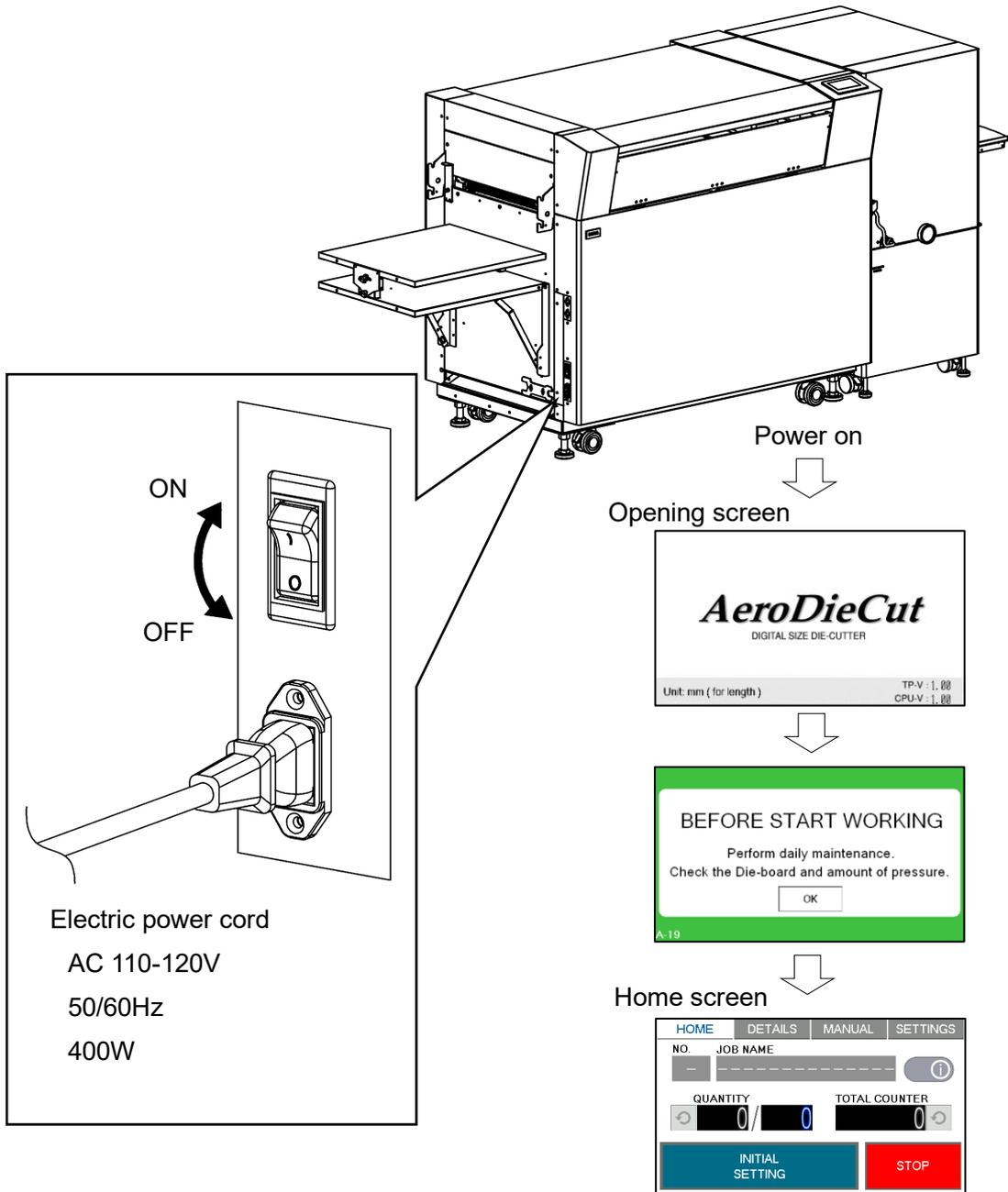
Use suitable paper stocks which weight is 120 to 400gsm (0.005" – 0.016").

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.

## 2. Operating instructions

### 2.1. Turning the power on



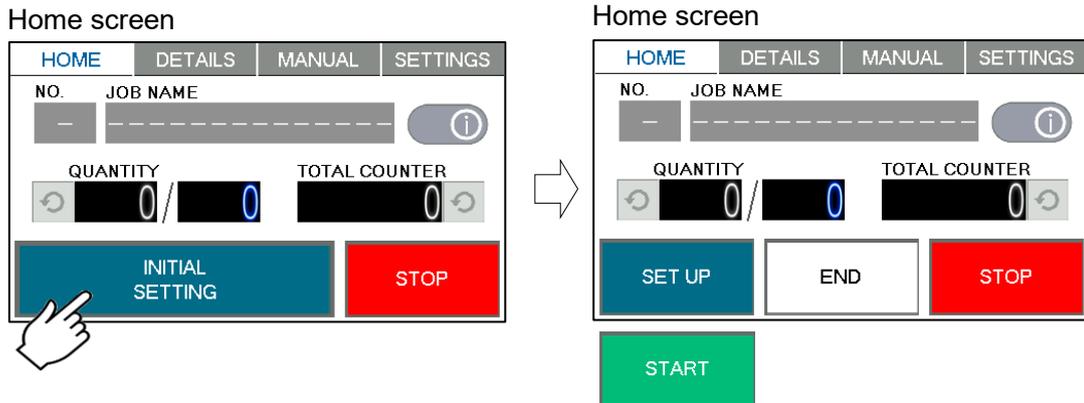
## Warning



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.

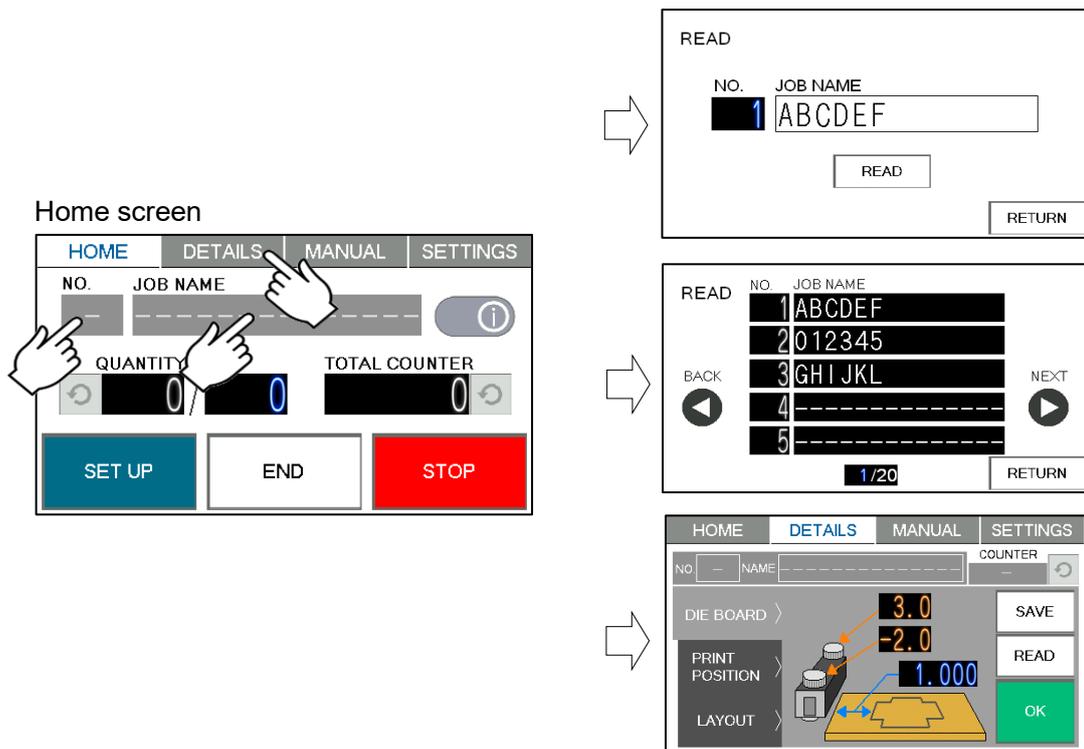
## 2.2. Initial setting

- ① After turning on the power , **INITIAL SETTING** is displayed on the Home screen.
- ② Press **INITIAL SETTING**.
- ③ Initial setting starts by automatically.
  - Press roller moves to Home position.
  - Hold to up the Die board.
- ④ After initial setting is completed , **SET UP** or **START** is displayed on the Home screen.



## 2.3. Job select

- ① Set the job data. (👉 Page20)
- ② Set the Die board on the machine. (👉 Page24)

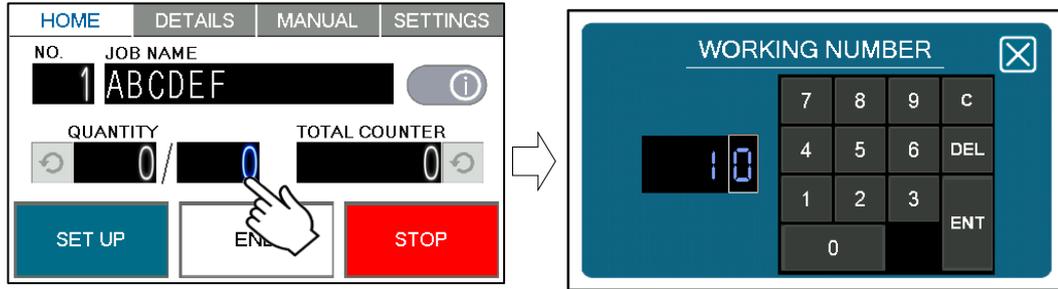


## 2.4. Paper setting

- ① Enter the number of sheets for operation.

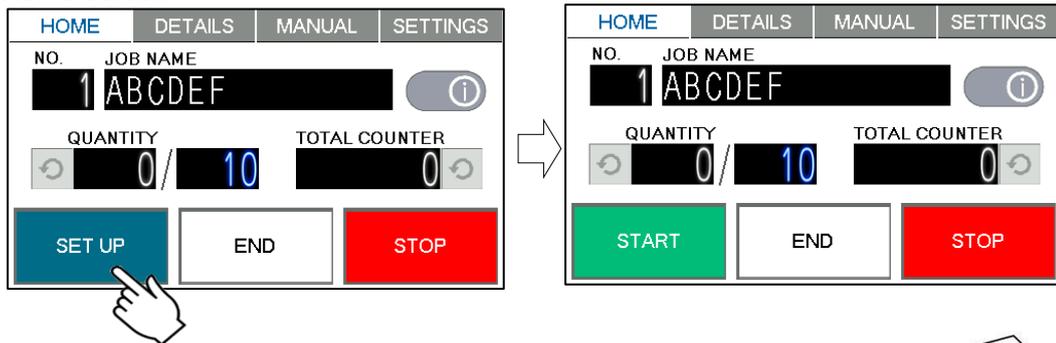
All the sheets on the feed table will feed in case 0 is entered in Quantity.

Home screen

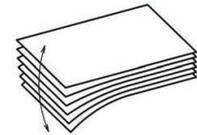


- ② If **SET UP** is displayed on the Home Screen, press **SET UP** .
- ③ Feed table goes down. when it reaches the bottom, it automatically stops and changes to the **START** display.

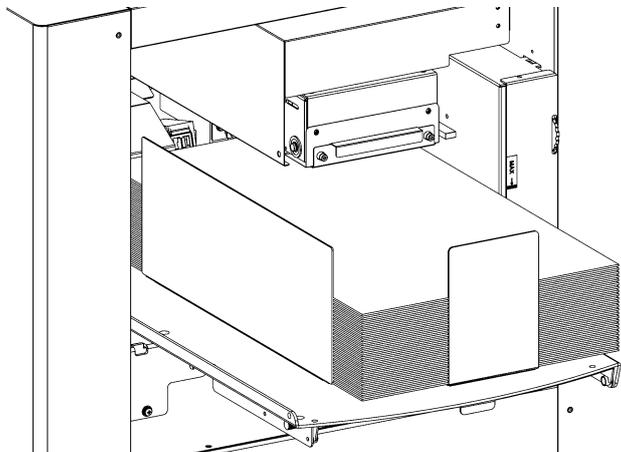
Home screen



- ④ Flip through the sheets well before you put them on the feed table.
- ⑤ Set the sheets on the feed table.

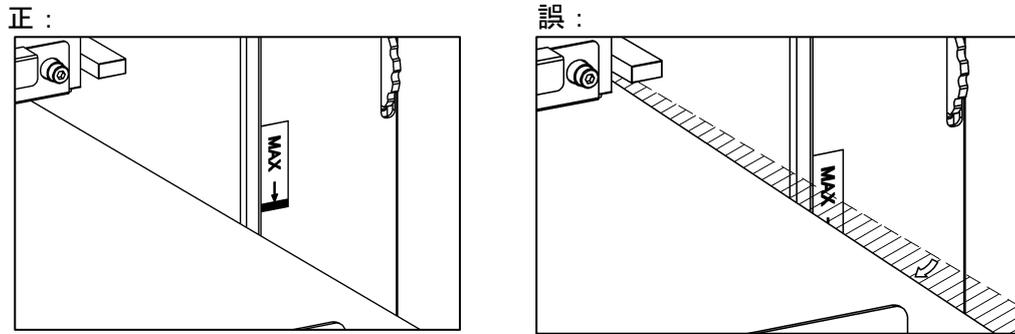


Use the paper guide (Large) and paper guides (Small) to fix the sheets.



Note.

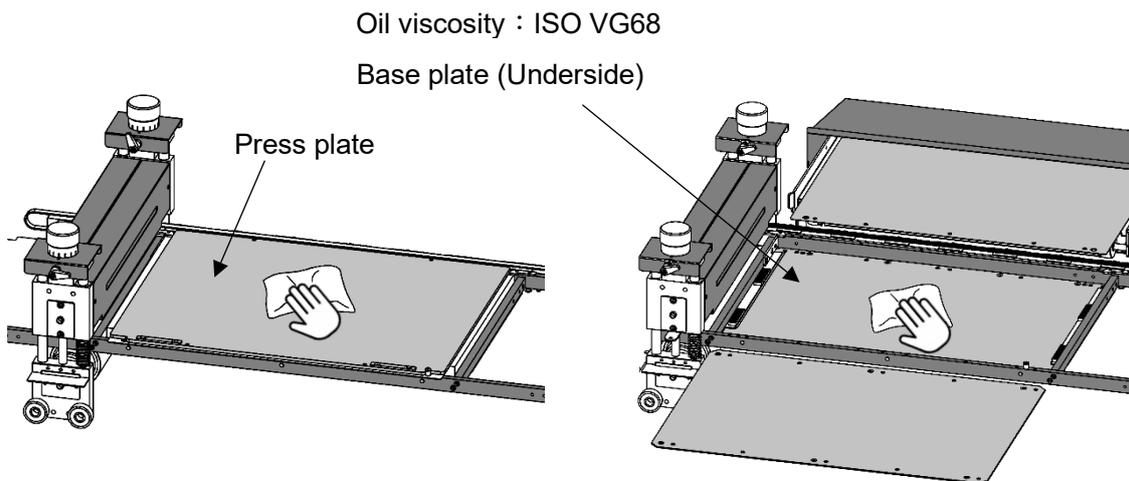
- Paper loading capacity is 4.00”.
- Make sure that the paper stack does not exceed the MAX label.
- It affects finishing accuracy if there is a gap between the side guide and the sheets.



 <b>Warning</b>	
	Don't put hands inside work area. May result in severe injury.

## 2.5. Check the condition of the Press plate

- Clean the Press plate and Base plate with a parts cleaner before starting work one day.
- After cleaner, wipe them with a cloth soaked in oil (machine oil) and refuel.

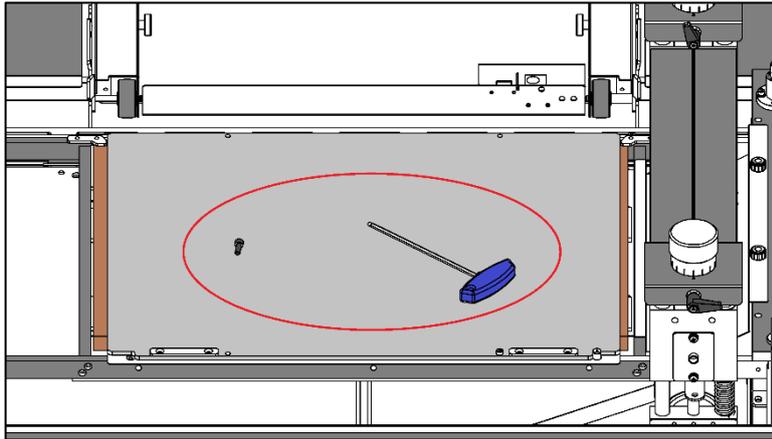


Note.

Insufficient lubricant will lead to increased wear and ultimately failure.

Keep the paper carrying belt without oil.

- Do not place anything on the Press plate as it may cause a malfunction.

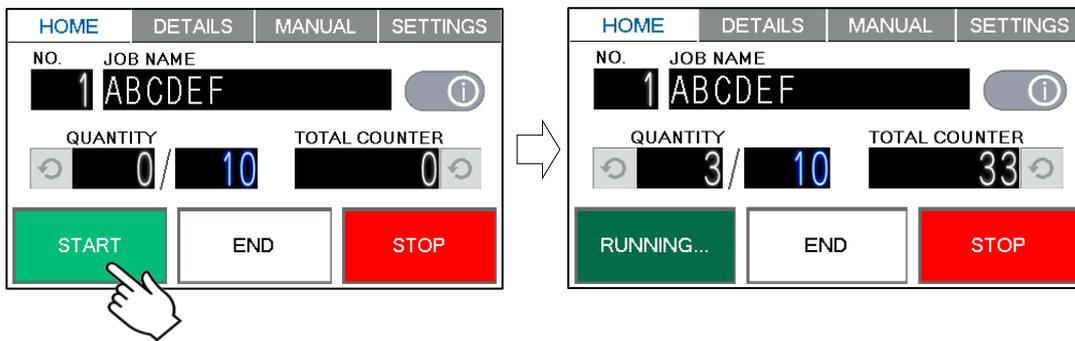


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## 2.6. Job start

- ① Press **START** to start an automatic operation. The display will change to **RUNNING**.

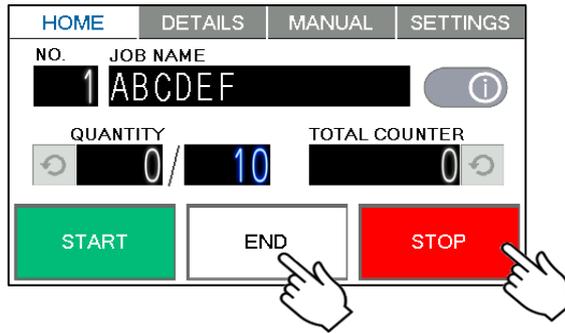
Home screen



- ② After processing the entered number of sheets in QUANTITY, the machine stops automatically.

## 2.7. Interruption

Home screen



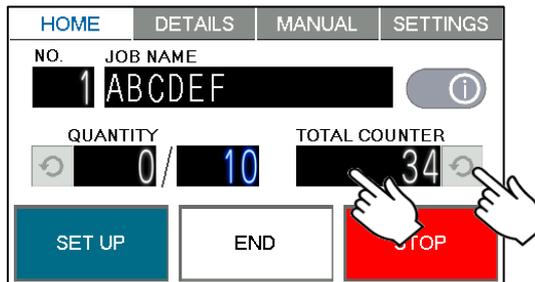
- Press **STOP** and the machine will make an EMERGENCY stop even if the operation is underway.
- Press **END** if you wish to stop the machine when the current sheet is completed.

Home screen



- **QUANTITY** indicates the number of finished sheet when the machine is stopped with **STOP** or **END** button.
- Press  to reset the counter to 0.

Home screen



- **TOTAL COUNTER** of processed sheets are counted.
- Press  and hold to clear the number.
- Can be change the total number.

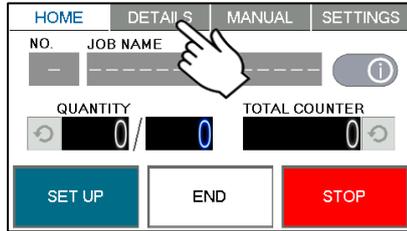
## 2.8. Power off

- Make sure that the machine is stopped.
- Turn off the Power switch.

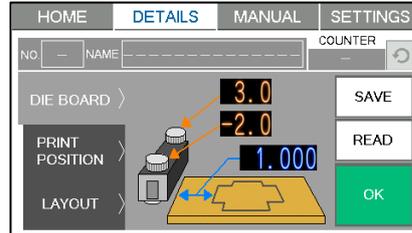
### 3. Job data

#### 3.1. Details screen

Home screen

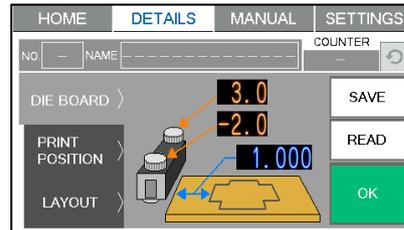


Details screen

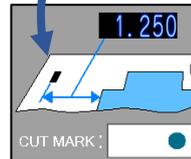
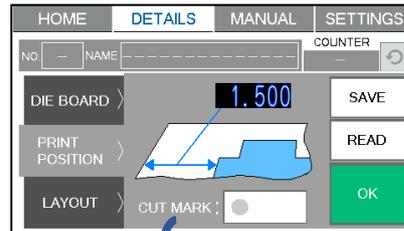


- Press **DETAILS** on the tab switch to display the Details screen.

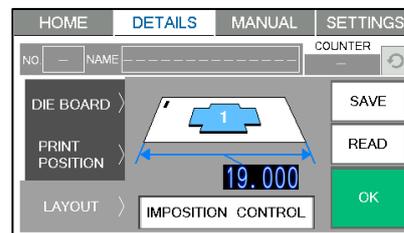
Details screen-1



Details screen-2



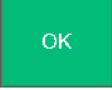
Details screen-3



- Press the tab in the Details screen to switch the input item.

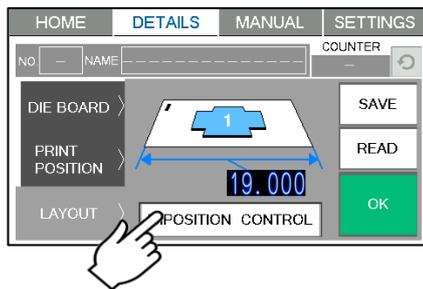


- The Job NO & NAME and COUNTER are displayed while selecting the saved data.

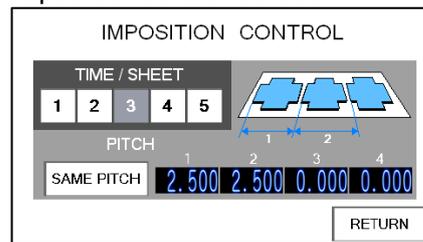
	Save the current job data.
	Read the stored job data for reference.
	Decide the current job data.
	Switching the cut marks ON or OFF.
	The counter the Die board has been used for each saved data is displayed. If the job data has not been saved — is displayed.
	Clear the counter for each job data.

### 3.2. Imposition control screen

Details screen-3



Imposition control screen

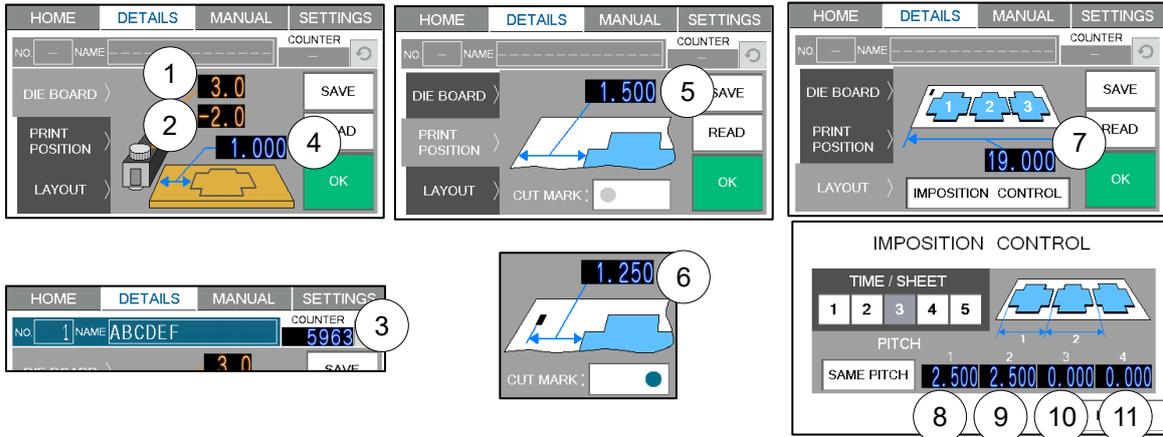


- Press **IMPOSITION CONTROL** on Details screen-3 to display Imposition control screen.

	Select the number of times for multifaceted control.
	The value input in pitch 1 is copied to pitches 2, 3 and 4.
	Returns the screen to Details screen-3.

### 3.3. Data inputs

#### 3.3.1.Explanation of each data inputs



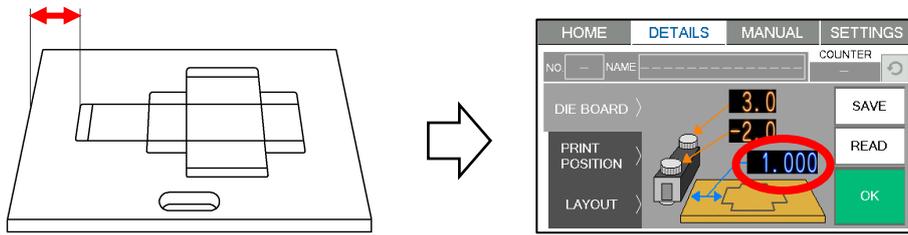
- Can be change the value by touching each number.

No.	Explanation
①	The level of pressurization on the opposite side press roller. Input the level after pressure adjustment.
②	The level of pressurization on the operation side press roller. Input the level after pressure adjustment.
③	The counter the Die board has been used for each saved data. Counts up with every pressurization.
④	Position of the blade on the Die board. Input the dimension from the left edge of the Die board to the blade.
⑤	Printing position. Input only when cut marks are nothing. Input the dimensions from the edge of the paper to the left edge of the job design.
⑥	Printing position. Input when cut marks are on. Input the dimensions from the edge of the cut mark position to the left edge of the job design.
⑦	Paper size.
⑧ ⑨ ⑩ ⑪	The number of times for multifaceted control. Even if enter the number of times for the pitch that has nothing to do with the number, it does not affect the operation.

### 3.3.2. Inputs

◆ Case of single cutting

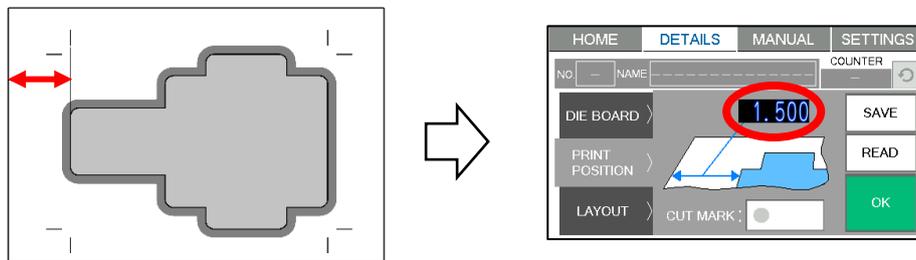
① Measure and input the dimension from the left end of the Die board to the blade.



② Input the layout of the design.

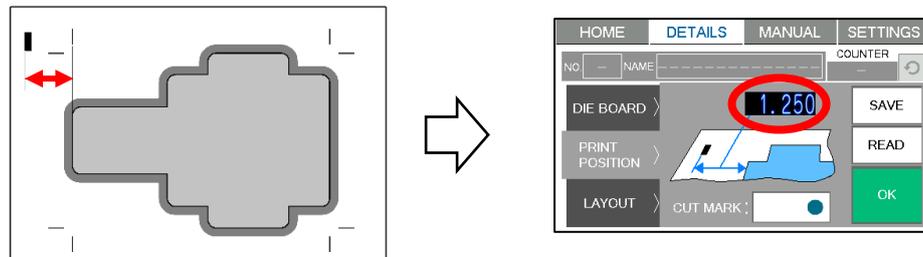
- When cut marks are nothing.

Input the dimension from the left edge of the paper to the cutting position.

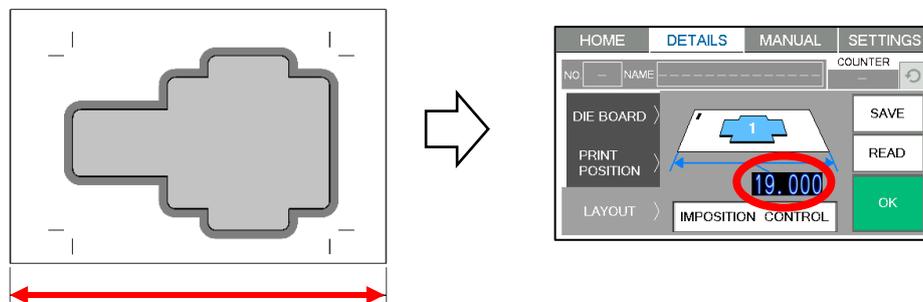


- When cut marks are on.

Input the dimension from the left edge of the cut mark position to the cutting position.



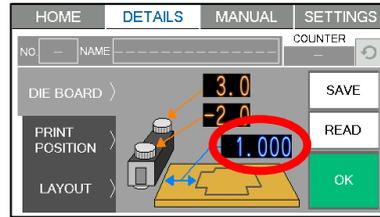
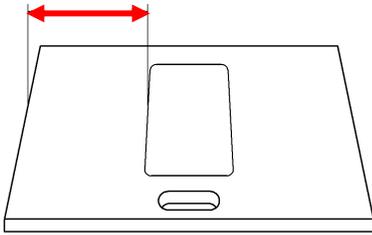
③ Input the paper feed length.



## AeroDieCut OPERATION MANUAL

### ◆ Case of multiple cutting

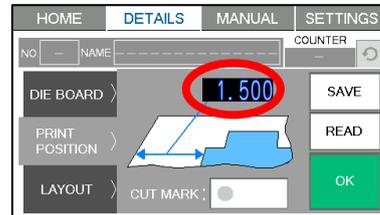
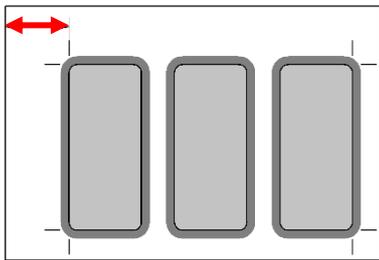
- ① Measure and input the dimension from the left end of the Die board to the blade.



- ② Input the layout of the design.

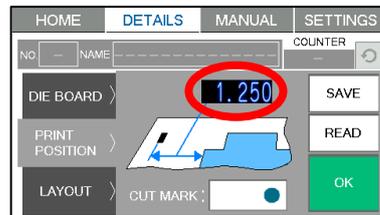
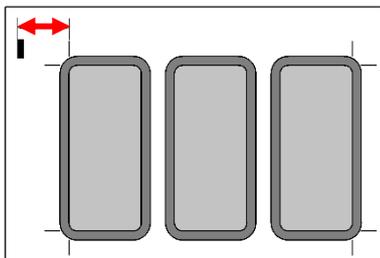
- When cut marks are nothing.

Input the dimension from the left edge of the paper to the first cutting position.

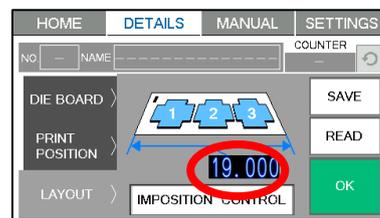
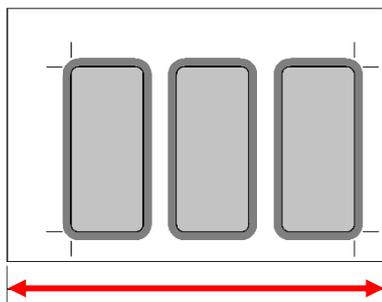


- When cut marks are on.

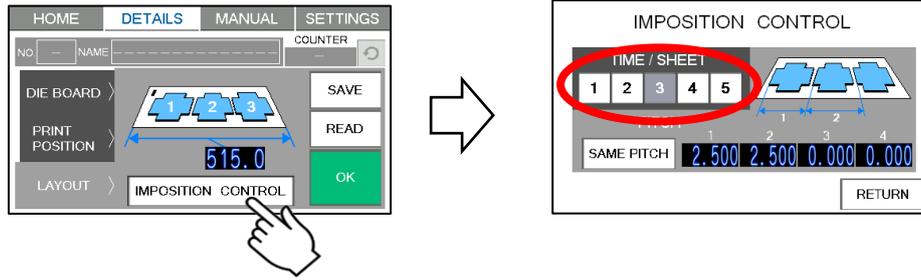
Input the dimension from the left edge of the cut mark position to the first cutting position.



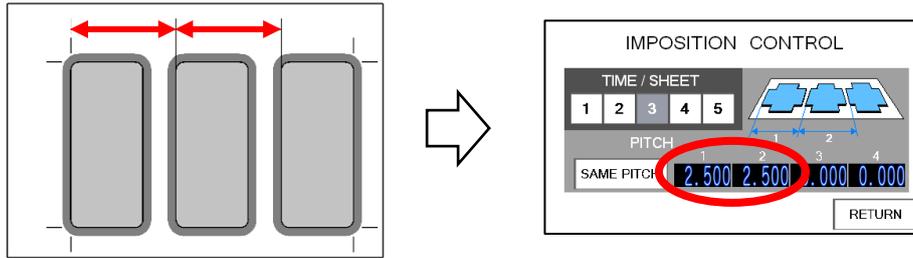
- ③ Input the paper feed length.



- ④ Select the number of times for multifaceted control.



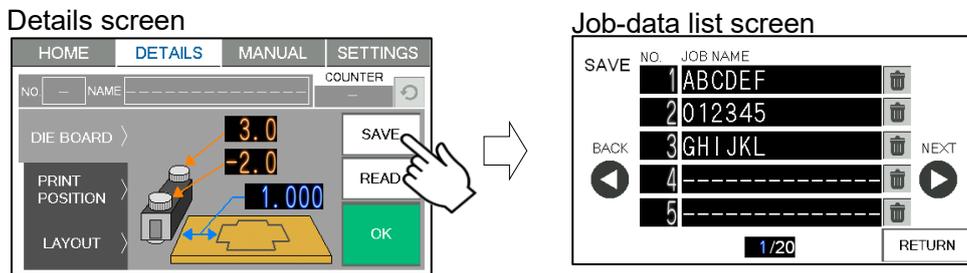
- ⑤ Input each pitch according to the number of times for multifaceted control.



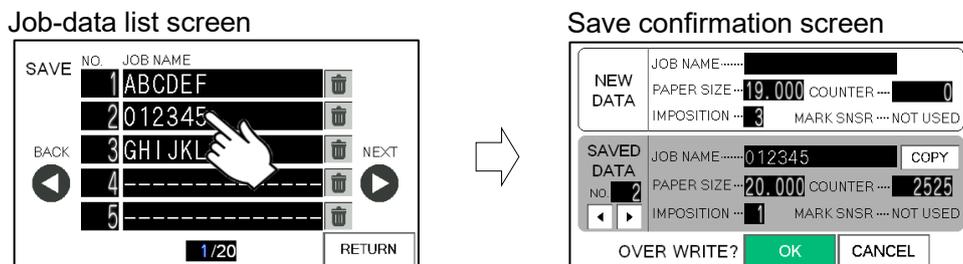
### 3.4. Data save

- Up to 100 data can be saved.

- ① Press **SAVE** on the Details screen. Job-data list screen is displayed.

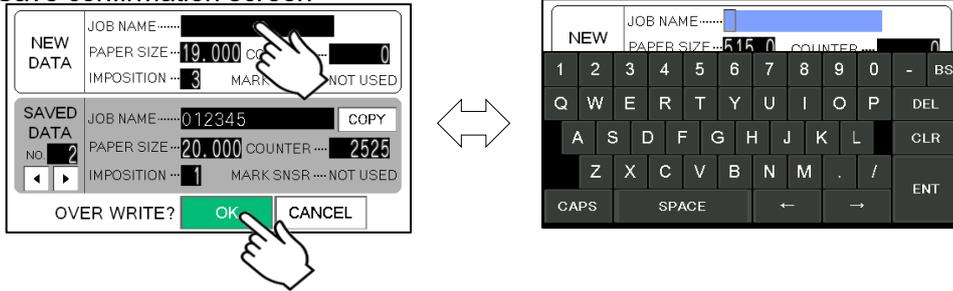


- ② Select any data on the Job-data list screen. Save confirmation screen is displayed.



- ③ Input the JOB NAME of NEW DATA and press **OK** to overwrite.

Save confirmation screen



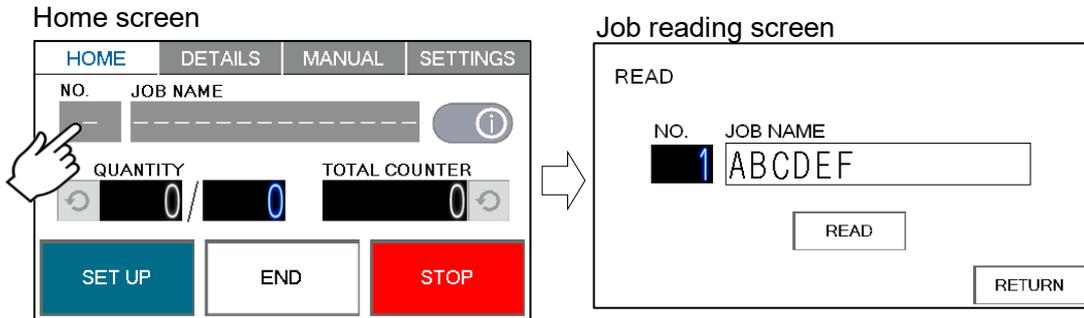
Job-data list screen	
<p>NEXT</p> 	Moves to the next page.
<p>BACK</p> 	Moves to the previous page.
<p>RETURN</p>	Return to the Details screen.

Save confirmation screen	
	Select SAVED DATA to the next data.
	Select SAVED DATA to the previous data.
<p>COPY</p>	Copy the JOB NAME of SAVED DATA to the JOB NAME of NEW DATA.
<p>OK</p>	Decide the job by overwrite the data.
<p>CANCEL</p>	Return to the Job-data list screen.

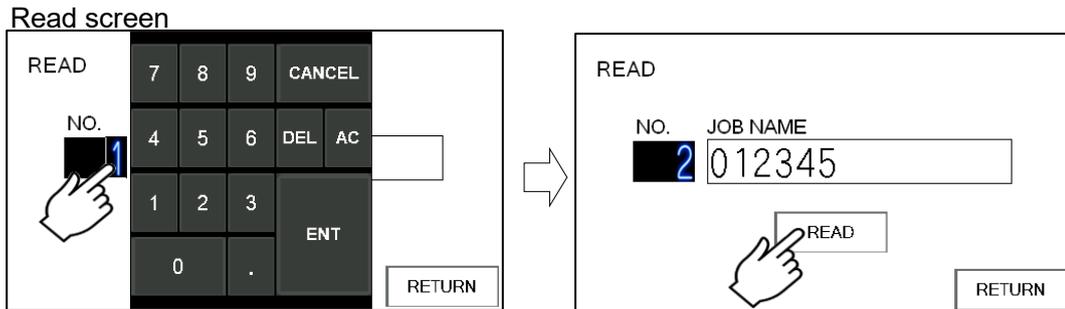
### 3.5. Data read

#### 3.5.1. Read from Job No.

- ① Press to Job No. on Home screen. Job reading screen is displayed.

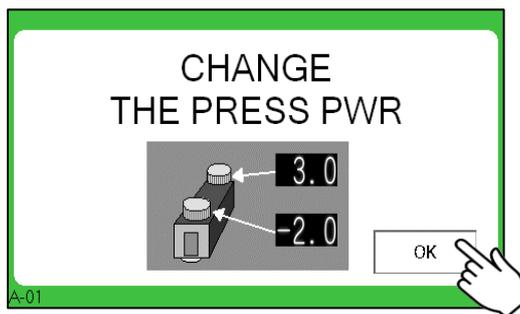


- ② Input the Job No. and press **READ** to read the data.



- ③ After reading, the level of pressurization of the stored data is displayed before returning to the Home screen.

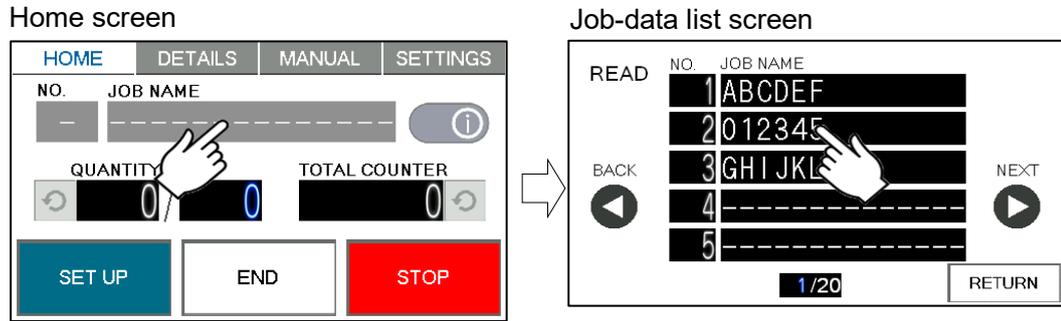
Adjust the level of pressurization referring to the stored data.



Job reading screen	
RETURN	Return to the Home screen.

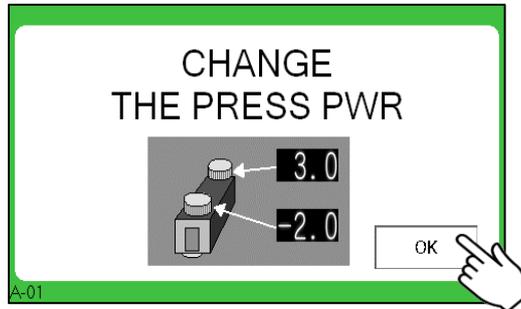
### 3.5.2. Read from Job-data list

- ① Press Job name on Home screen. Job-data list screen is displayed.
- ② Read the data by selecting any data on the Job-data list screen.



- ③ After reading, the level of pressurization of the stored data is displayed before returning to the Home screen.

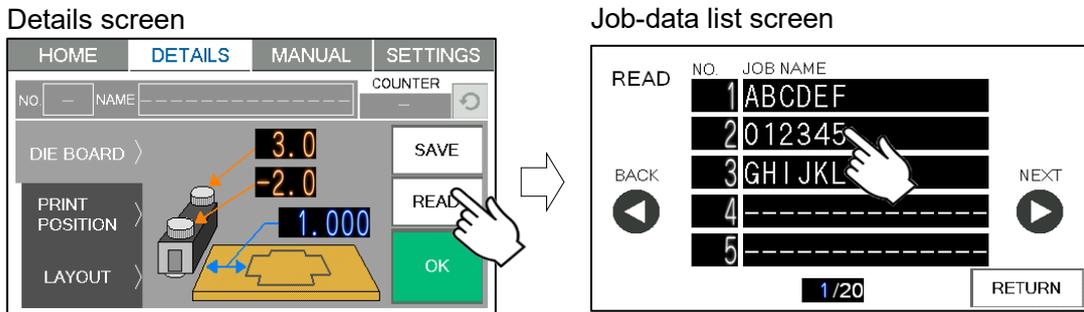
Adjust the level of pressurization referring to the stored data.



Job-data list screen	
NEXT 	Moves to the next page.
BACK 	Moves to the previous page.
RETURN 	Return to the Home screen.

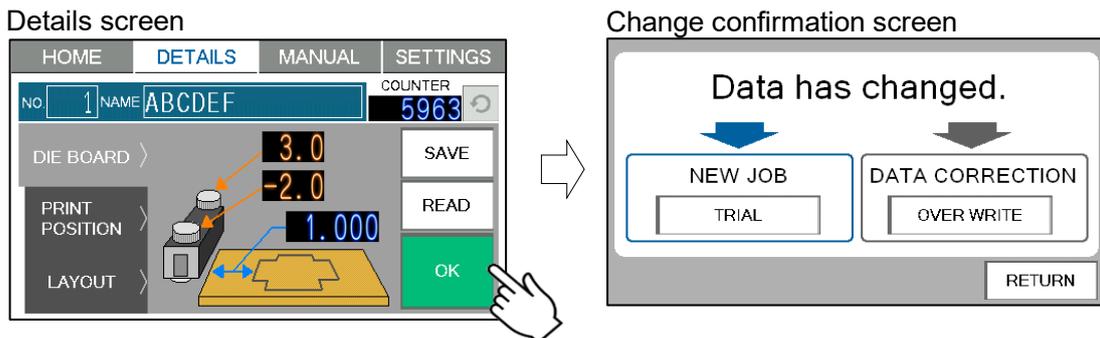
### 3.5.3. Read input data

- ① Press **READ** on Details screen. Job-data list screen is displayed.
- ② Read the data by selecting any data on the Job-data list screen.

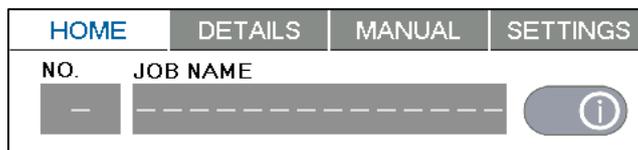


### 3.6. Change saved data

- ① Press **OK** when the changes are complete. If there are any change confirmation screen will be displayed.



- ② Press the switch according to the reason for the change.
  - ◆ Case of Now job
    - Press **TRIAL**.
    - Job no and Job name change to — automatically, and move to the home screen.

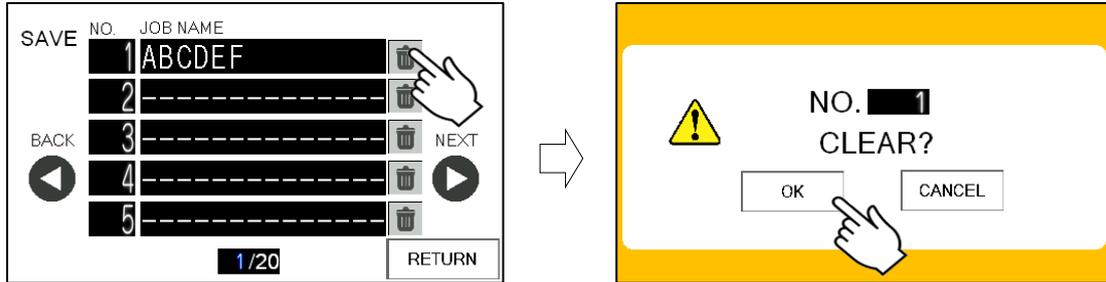


- Recommend that try to the test and save the data if there is no defect.
- ◆ Case of change the contents without changing Job no and Job name.
  - Press **OVER WRITE** .
  - Save changes and moves to the home screen.

### 3.7. Delete saved data

- ① Saved user data can be deleted with a press of  .

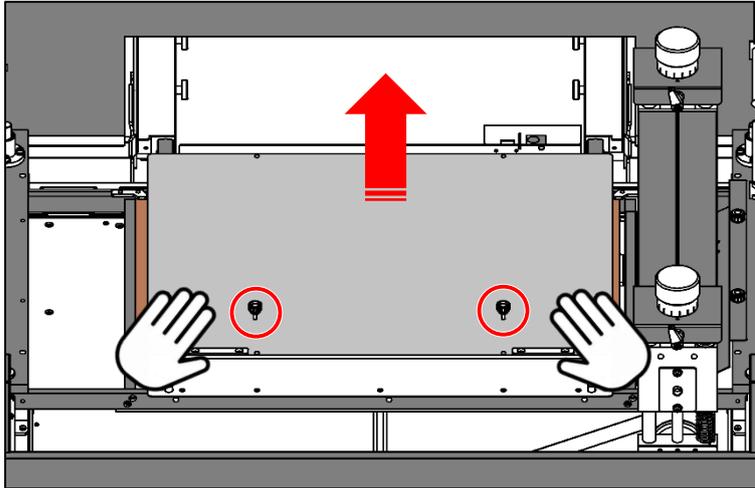
Job-data list screen



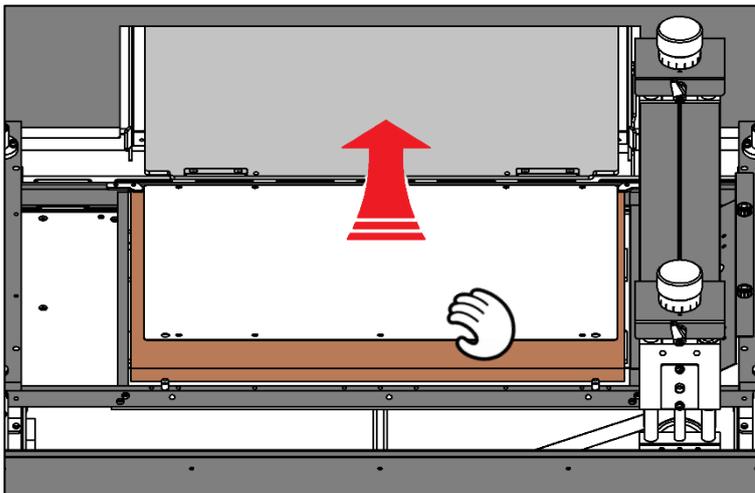
## 4. Die board setting

### 4.1. Die board Changing

- ① Remove the two knobs.
- ② Slide the Press plate into the Plate holder.



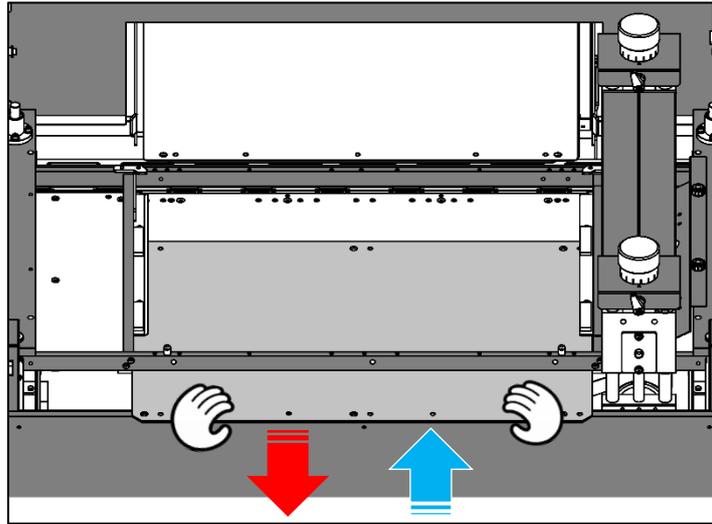
- ③ Remove the Protective plate and put on the Plate holder.



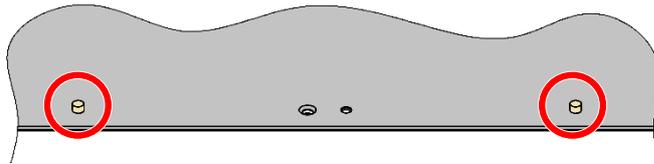
- ④ Remove the set Die board.

## AeroDieCut OPERATION MANUAL

- ⑤ Slide to the front the Cutting plate.
- ⑥ Remove the set one and attach a new Cutting plate.



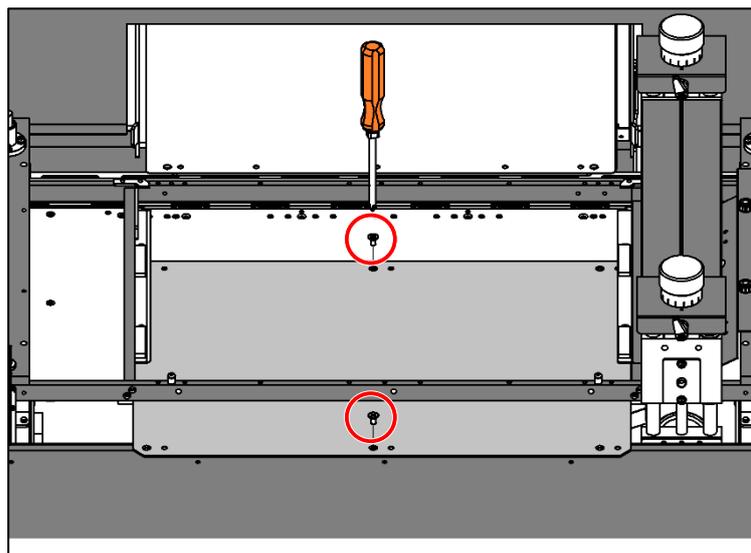
- ⑦ Make sure that it is firmly seated on the locating pin.



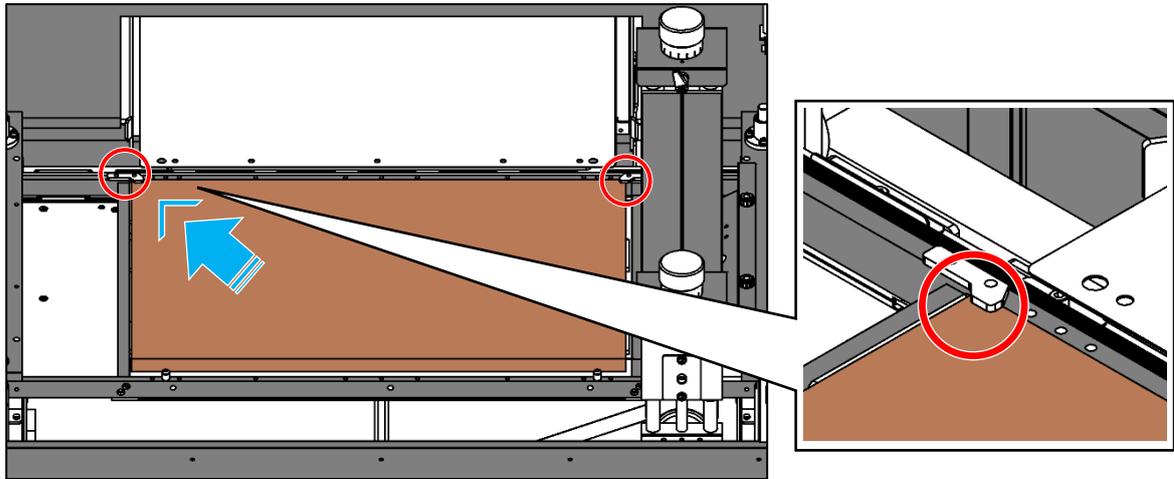
### Note.

The cutting plate may warp with continue to used. If the paper jam due to warpage, use the attached Countersunk head screw to increase the fixing points.

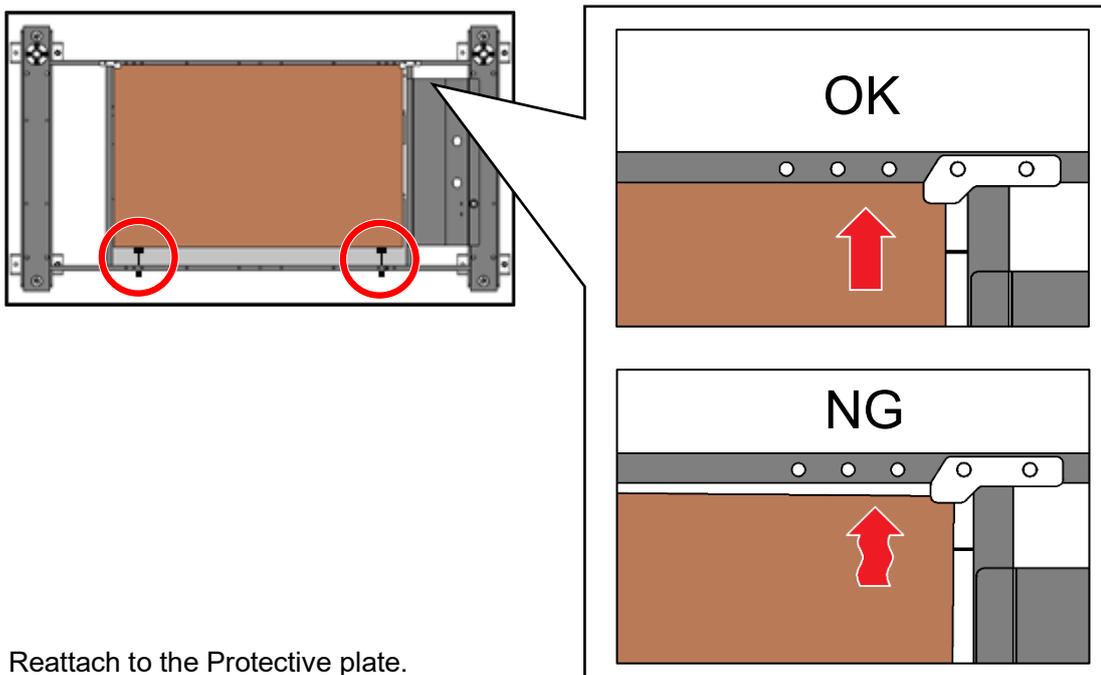
Clean it so that no dust such as paper dust remains under the cutting plate, it may cause reduce the cutting quality.



- ⑧ Set a new Die board.
- Set the Die board is under the left and right metal fittings.
  - Set the Die board by pressing it firmly to the left opposite.



- Tighten the blade die fixing knob to prevent the blade die from tilting.



- ⑨ Reattach to the Protective plate.

- ⑩ Reattach to the Press plate.

Note.

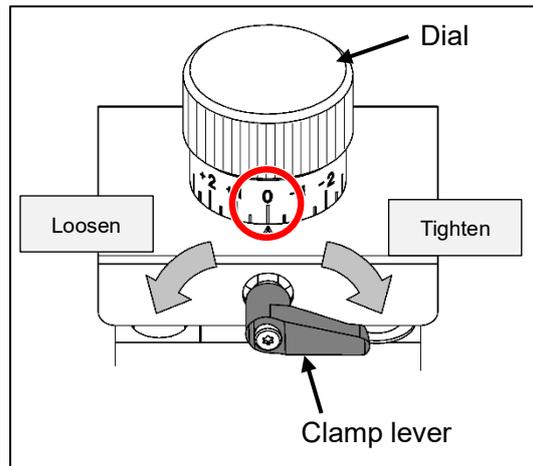
Depending on the shape of the Die board, it may not be held down by the holding metal fittings and the Press plate may rise.

Floating of the Press plate may cause malfunction. If the Press plate is floating, increase the fixing points with the attached Hexagon socket head cap screw and fix it.

Do not place anything on the Press plate as it may cause a malfunction.

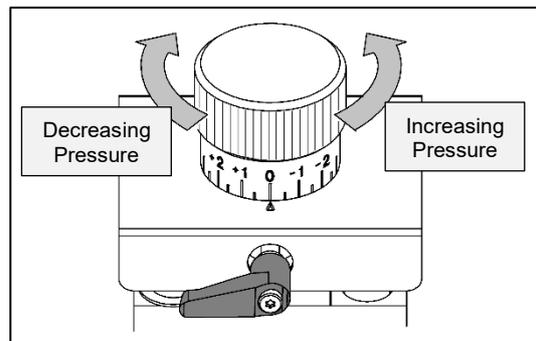
## 4.2. Adjustment of the level of pressurization

- ① Loosen the Clamp lever.
- ② Turn the level of pressurization to 0.
- ③ Tighten the Clamp lever.

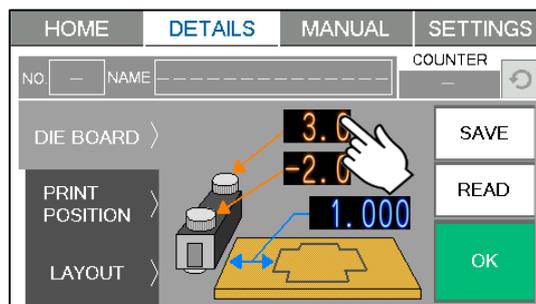


- ④ Set the Die board and cut it.
  - Depending on the design of the Die board, the finish may differ depending on the direction in which the Press roller moves. Check both cut samples of "left to right" and "right to left" operation of the press roller.

- ⑤ Check the cut samples.
  - If the press of pressurization is too much, adjust the dial in the "-" direction to reduce the pressure.
  - If the press of pressurization is not enough, adjust the dial in the "+" direction to reduce the pressure.
  - Scale: +1 = 0.0394" down, -1 = 0.0394" up



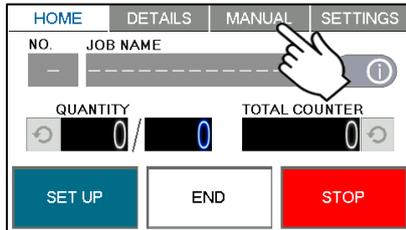
- Adjust the part that is not partly with the "unevenness removal" of the Die board.
- ⑥ Once again, process it and check the condition, and if there is no problem, it is completed.
  - ⑦ Recommend to save the data of pressurization level for the next time. Input the value in the saved data and overwrite.



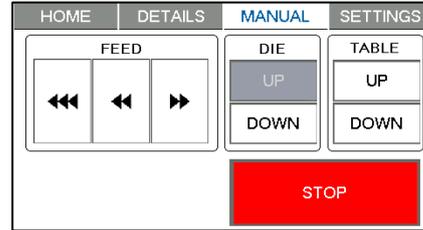
## 5. Manual control

### 5.1. Manual control screen

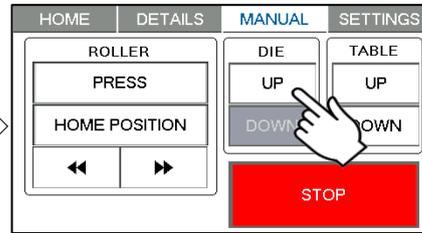
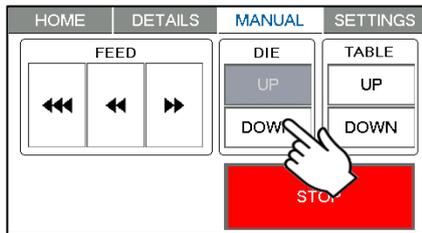
Home screen



Manual control screen

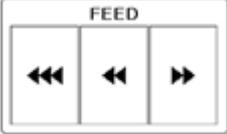


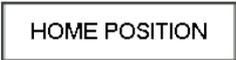
- Press **MANUAL** on the tab switch, Manual control screen is displayed.
- It will not switch unless the initial setting.



- Operable functions change depending on the position of the Die board.

Common function		
		The Feed table goes "up" only while pressed.
		The Feed table goes "down" only while pressed.
		Press to "up" the Die board.
		Press to "down" the Die board.
		Press to "stop" all movements.

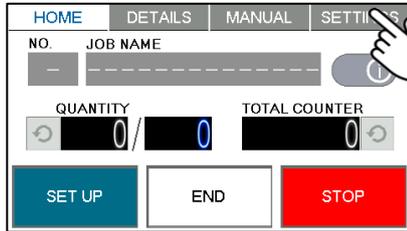
When the Die board is "up"	
	 <p>The Paper carrying belt is fed at the set speed only while pressed.</p>
	 <p>The Paper carrying belt is fed at the low speed only while pressed.</p>
	 <p>The Paper carrying belt is reverse fed at the low speed only while pressed. In addition, the Feed belt and the suction blower work at the same time.</p>

When the Die board is "down"	
	 <p>Press to automatically move the Press roller at the set speed.</p>
	 <p>Press to automatically move the Press roller to Home position.</p>
	 <p>The Press roller is moved to the left direction the set speed only while pressed.</p>
	 <p>The Press roller is moved to the right direction the set speed only while pressed.</p>

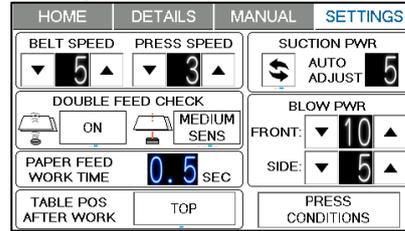
## 6. Settings

### 6.1. Settings screen

Home screen

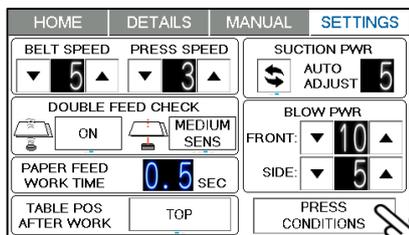


Settings screen

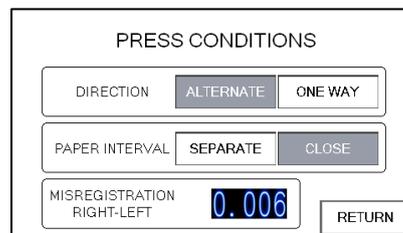


- Press **SETTINGS** on the tab switch, Settings screen is displayed.

Settings screen



Press conditions screen



- Press **PRESS CONDITIONS**, Press conditions screen is displayed.

#### 6.1.1.Speed

##### ◆ Belt speed

- The feeding speed of the Paper carrying belt can be changed in 5 steps.
- 5 is default setting.



##### ◆ Press speed

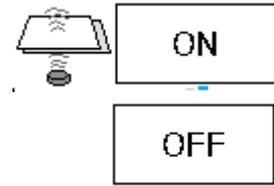
- The Pressing speed of the Press roller can be changed in 3 steps.
- 3 is default setting.
- If feel the vibration of the Press roller movement is bigger, down the speed.



### 6.1.2. Double feed check

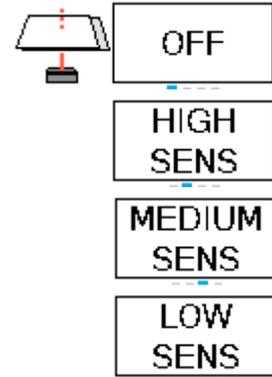
◆ Ultra-sonic double feed detection

- The ultra-sonic sensor detects multi-layered sheet and prevents double feed.
- By pressing the button shown on the right image, the ultra-sonic sensor can be activated / deactivated.



◆ Transmissive double feed detection

- The transmissive sensor detects the transmittance and prevents double feed.
- The sensitivity of the transmissive sensor can be adjusted by pressing the button shown on the right image.
- **MEDIUM SENS** is default setting.
- Do not print on the inspection position (edge of paper) of the transmission sensor.
- The transmission sensor does not respond normally to paper (thick paper, black paper, and dense paper) that does not transmit light.



⇒ Down the sensitivity setting or turn it off.

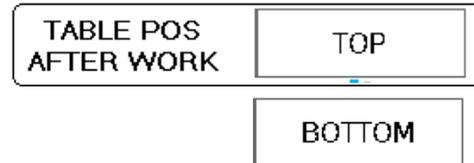
### 6.1.3. Paper feed work time

- Can be change in the range of 0 ~ 5.0 seconds.
- 0.5 seconds is default setting.



### 6.1.4. Table position after work

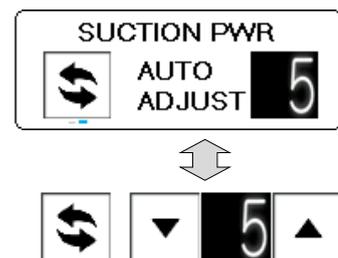
- When the switch is set to **TOP**, the feed table remains in the position where the previous job was finished.
- When the switch is set to **BOTTOM**, to make loading the next work easier, the feed table automatically moves back to the bottom dead position and stops.



### 6.1.5. Tri-suction

◆ Suction power

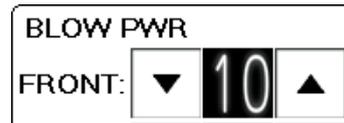
- The Suction power can be change in the range of 1~10.
- 5 is default setting.
- Down the Suction power is effective for double feeding.
- Up the Suction power is effective for feeding heavy paper.
- When set to 0, it does not suction.



- Press  to switch to the automatic suction power adjustment mode.

◆ Front blow power

- The Front blow power can be change in the range of 1~10.
- 10 is default setting.
- Down the Front blow power is effective for paper skew.
- Up the Front blow power is effective for feeding heavy paper and double feeding.
- When set to 0, it does not blow.



◆ Side blow power

- The Side blow power can be change in the range of 1~10.
- 5 is default setting.
- Down the Side blow power is effective for paper skew.
- Up the Side blow power is effective for feeding heavy paper and double feeding.
- When set to 0, it does not blow.



### 6.1.6.Press Conditions

◆ Pressurization direction



- **ALTERNATE** is default setting.
- Case of **ALTERNATE**.
  - ① Move the press roller from the current position to the opposite side.
  - ② Repeat the process of①.
- Case of **ONE WAY**.
  - ① Move the press roller from the current position to the opposite side.
  - ② If multifaceted control, Repeat the process of①.  
If multifaceted control is completed or not to select multifaceted control function, go to③.
  - ③ Eject paper
  - ④ Return the press roller to the initial position.

◆ Paper interval

- **CLOSE** is default setting.



- Case of **CLOSE**.

- ① Cut the first paper.
- ② Immediately after cutting, feed the next paper and cut.
  - The cutting speed becomes faster by closing the paper interval.

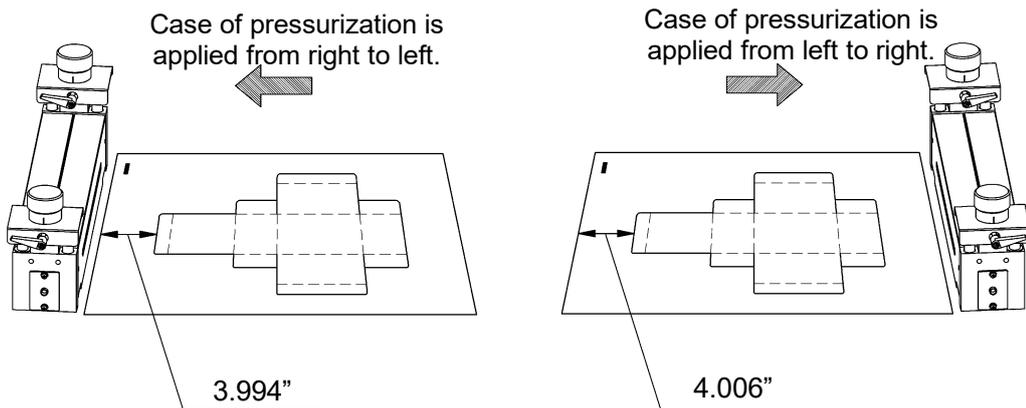
- Case of **SPARATE**.

- ① Cut the first paper.
- ② After cutting, the cutting paper is ejected first.
- ③ After ejected, the next paper is fed and cut.
  - Depending on the blade layout, can be avoid overlapping.
  - Effective for risk of paper jam.

◆ Positional deviation correction by Pressurization direction



- Cutting position differs depending on the pressurization direction.
- Measure the value difference between when pressurization is applied from right to left and when pressurization is applied from left to right, and input half the difference.
- 0.006 is default setting.
- Example



$$4.006 - 3.994 = 0.012''$$

$$0.012 \div 2 = 0.006''$$

## 7. Adjustment

### 7.1. Respond for Feeding direction shift

#### 7.1.1. image shift compensation screen

Home screen

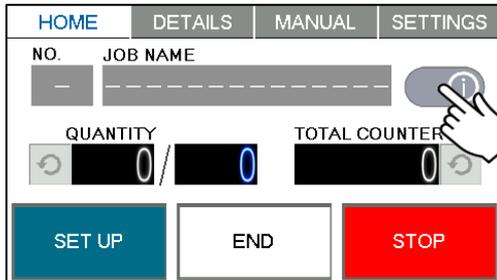
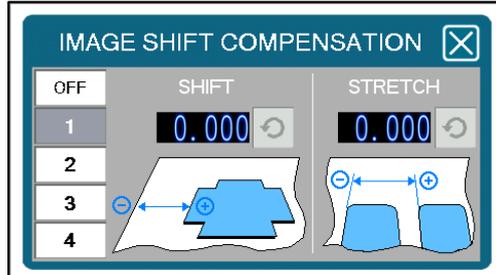


Image shift compensation screen



- (i) Press the switch to Image shift compensation screen is displayed.

Image shift compensation screen



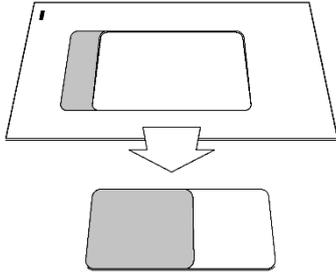
- Can be save four correction settings that correspond to print misalignment.
- The switch icon changes to the selected number.



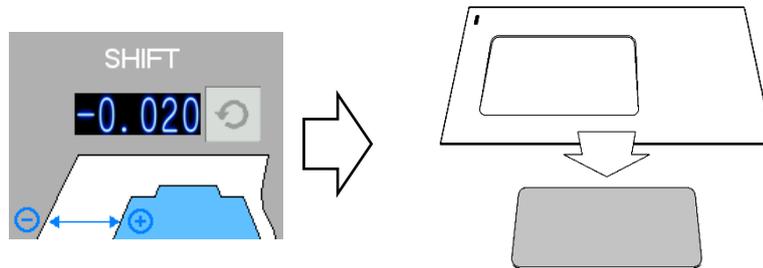
	 Clear the "SHIFT" value. The value will be 0.
	 Clear the "STRETCH" value. The value will be 0.

### 7.1.2. Cutting position adjustment

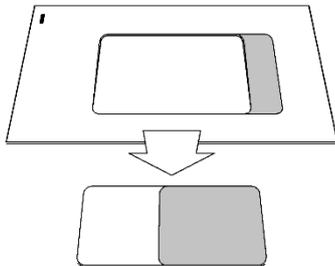
- ◆ Case of print is shifted to the left of the cutting position.



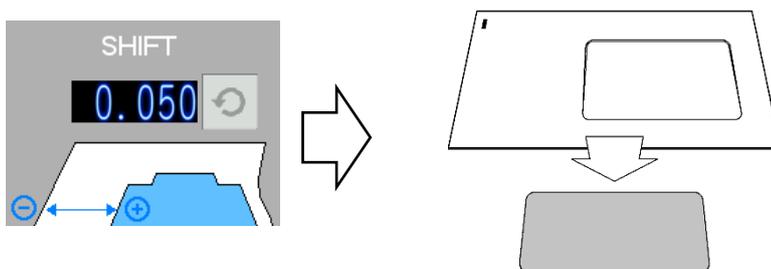
- ① Shift the cutting position to the left.
- ② Measure the value of shift and input a "-" value.



- ◆ Case of print is shifted to the right of the cutting position.



- ① Shift the cutting position to the right.
- ② Measure the value of shift and input a "+" value.

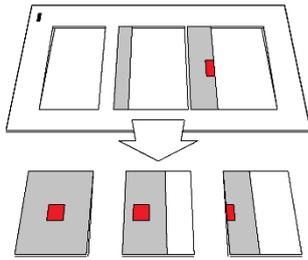


### 7.1.3.Stretch/Shrink adjustment

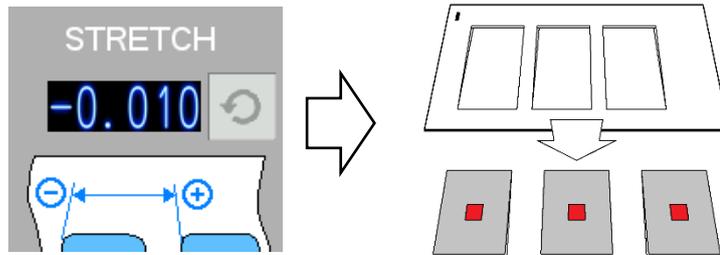
※This method is effective only for multifaceted control.

※The adjustment is effective for the position where the paper is cutting, not for the shape of Die board.

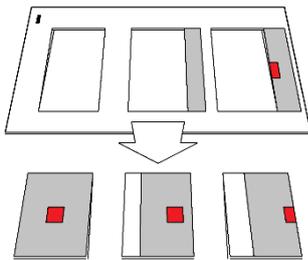
◆Case of print is gradually shifted to the left from the cutting position.



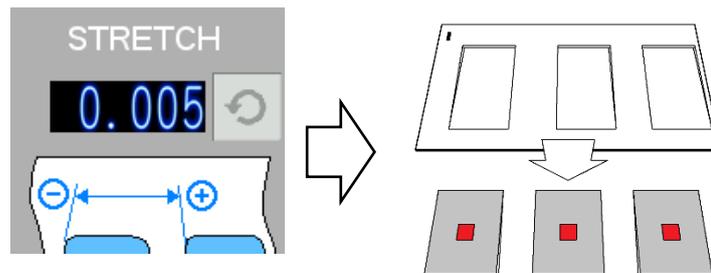
- ① Gradually shifts to the left, the print is shrinking.
- ② Measure the value of shrink and input a "-"value to shorten the pitch.



◆Case of print is gradually shifted to the right from the cutting position.



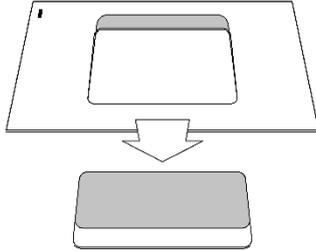
- ① Gradually shifts to the right, the print is stretching.
- ② Measure the value of stretch and input a "+"value to lengthen the pitch.



## 7.2. Respond for shift of depth direction

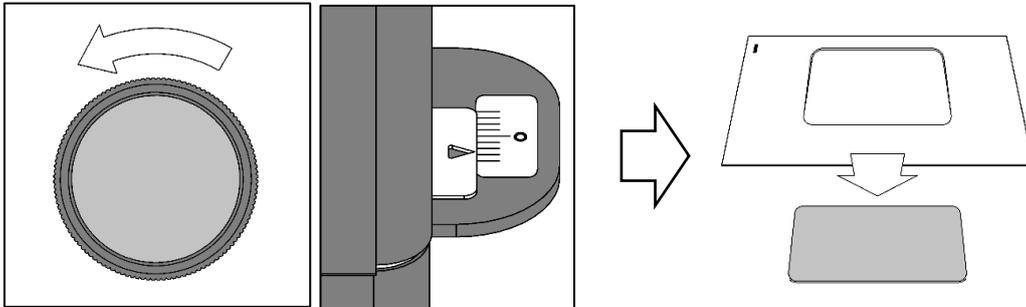
- Adjust the position of the Feed unit to respond with the shift in the depth direction.
- Use the pointer on the side of the Feed unit as a guide to adjust the Depth adjustment handle.

◆Case of print is shifted to the back of the cutting position.

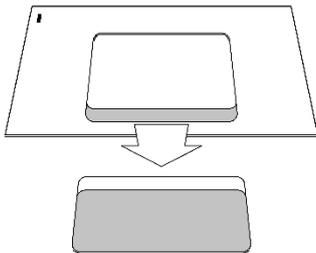


① Measure the value of shift.

② Turn the Depth adjustment handle and slide the Feed unit forward by the value of the shift.

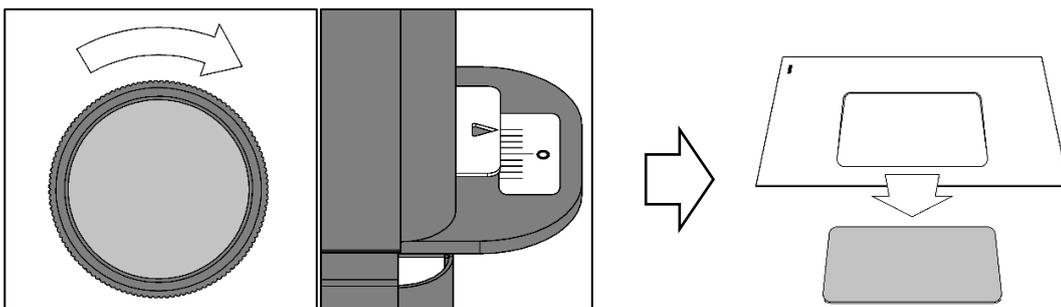


◆Case of print is shifted to the front of the cutting position.



① Measure the value of shift.

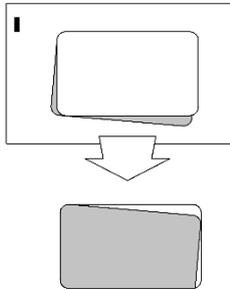
② Turn the Depth adjustment handle and slide the Feed unit backward by the value of the shift.



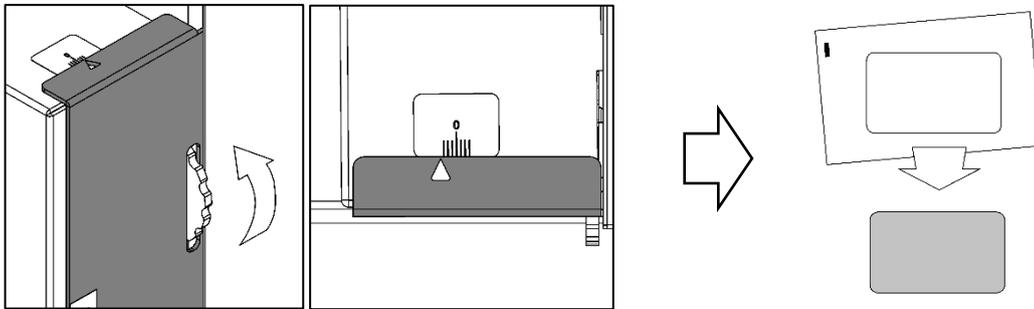
### 7.3. Respond to printing skew

- Adjust the tilt of the Feed guide to respond with the printing skew.
- Use the pointer above the Feed guide as a guide to adjust the Skew adjusting dial.

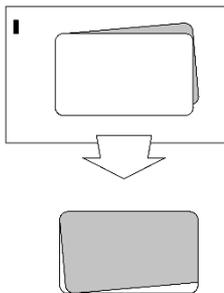
◆ Case of the print is skewed clockwise.



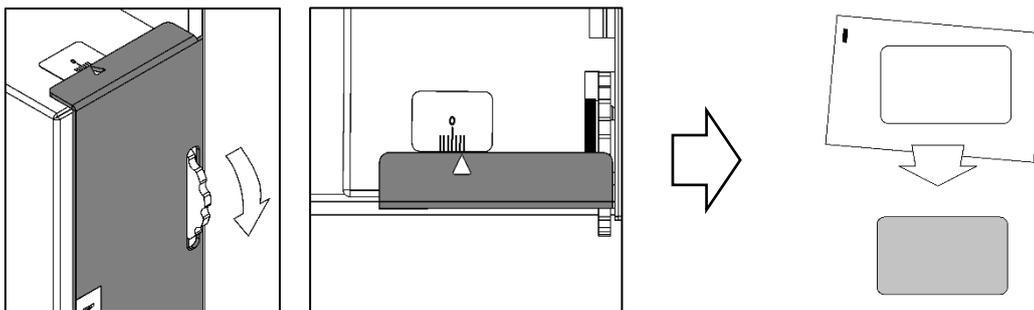
① Turn the Skew adjusting dial upward and tilt the Feed guide to the back.



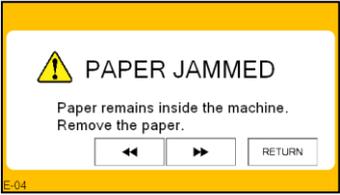
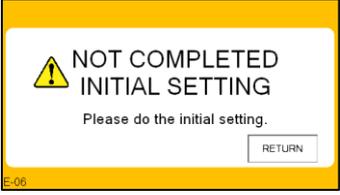
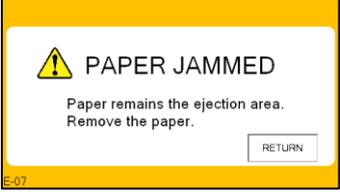
◆ Case of the print is skewed anticlockwise.



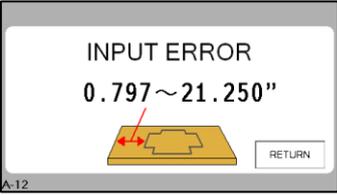
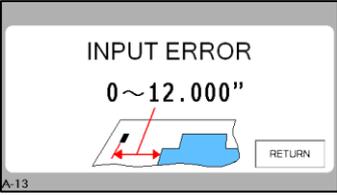
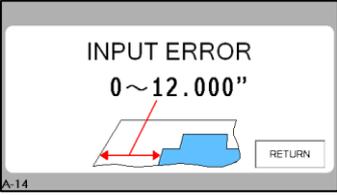
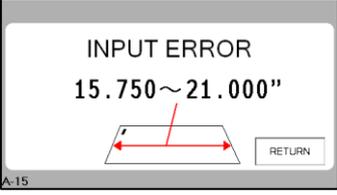
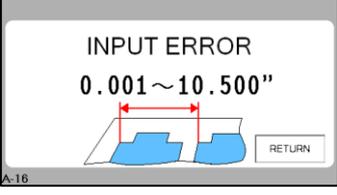
① Turn the Skew adjusting dial downward and tilt the Feed guide to the front.

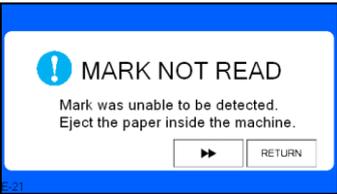
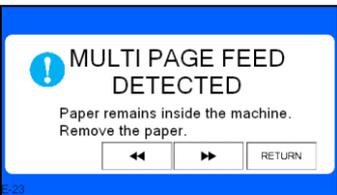
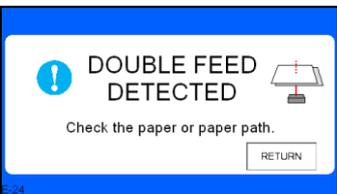
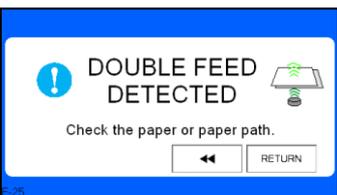


## 8. Message dialog

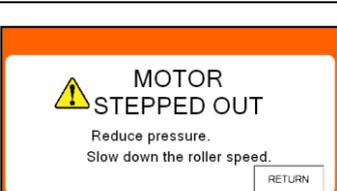
<p>E-02</p>		<ul style="list-style-type: none"> <li>• Top safety cover</li> <li>• Front safety cover</li> <li>• Safety cover for Option unit or Gear cover.</li> </ul> <p>Displayed when one of the above is open. The display clears when the cover is closed.</p>
<p>E-03</p>		<p>Displayed when Plate holder remains inside the press plate. The displayed clears when the Plate holder is emptied.</p>
<p>E-04</p>		<p>Displayed when paper remains inside the machine. Remove the paper. The display clears when press the <b>RETURN</b>.</p>
<p>E-05</p>		<p>Displayed when the Press roller is not waiting at Home position. The displayed clears when move the Press roller to Home position or press the <b>RETURN</b>.</p>
<p>E-06</p>		<p>Displayed when try to open the Manual control screen without initial setting. The displayed clears when press the <b>RETURN</b>.</p>
<p>E-07</p>		<p>Displayed when paper remains the ejection area. Remove the paper. The displayed clears when press the <b>RETURN</b>.</p>

AeroDieCut OPERATION MANUAL

<p>A-10</p>		<p>Displayed when try to move to another screen while inputting data in the details screen.</p> <p>Discard the input contents when press the <b>OK</b>. Return to the input scree when press the <b>RETURN</b>.</p>
<p>A-11</p>		<p>Displayed when the data tried to call was the default data.</p> <p>Select your own data.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>A-12</p>		<p>Displayed when input is out of the range.</p> <p>Input the distance from the left edge of the Die board to the blade within the range of 0.797 ~ 21.250" .</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>A-13</p>		<p>Displayed when input is out of the range.</p> <p>Input the distance from the cut mark to the left edge of the design within the range of 0.000" ~ the input paper size.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>A-14</p>		<p>Displayed when input is out of the range.</p> <p>Input the distance from the edge of the paper to the left edge of the design within the range of 0.000" ~ the input paper size.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>A-15</p>		<p>Displayed when input is out of the range.</p> <p>Input the paper size in the range of 15.750 ~21.000".</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>A-16</p>		<p>Displayed when input is out of the range.</p> <p>Input the pitch in the range from 0.001 to (paper size ÷ value of sides) inch.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>

<p>A-18</p>		<p>Displayed when the press roller rail is running out of grease. Please contact your dealer and greased up. The displayed clears when press the <b>OK</b>.</p>
<p>E-20</p>		<p>Displayed when the paper was not fed within a set time period. The displayed clears when press the <b>RETURN</b>.</p>
<p>E-21</p>		<p>Displayed when the Cut mark was unable to be detected. Eject the paper inside the machine. The displayed clears when press the <b>RETURN</b>.</p>
<p>E-22</p>		<p>Displayed when the paper longer than the input paper size is fed. Eject the paper inside the machine. The displayed clears when press the <b>RETURN</b>.</p>
<p>E-23</p>		<p>Displayed when paper is fed in a row. Eject the paper inside the machine. The displayed clears when press the <b>RETURN</b>.</p>
<p>E-24</p>		<p>Displayed when the transmission sensor detects a double feed. Eject the paper inside the machine. The displayed clears when press the <b>RETURN</b>.</p>
<p>E-25</p>		<p>Displayed when the ultrasonic sensor detects a double feed. Eject the paper inside the machine. The displayed clears when press the <b>RETURN</b>.</p>

AeroDieCut OPERATION MANUAL

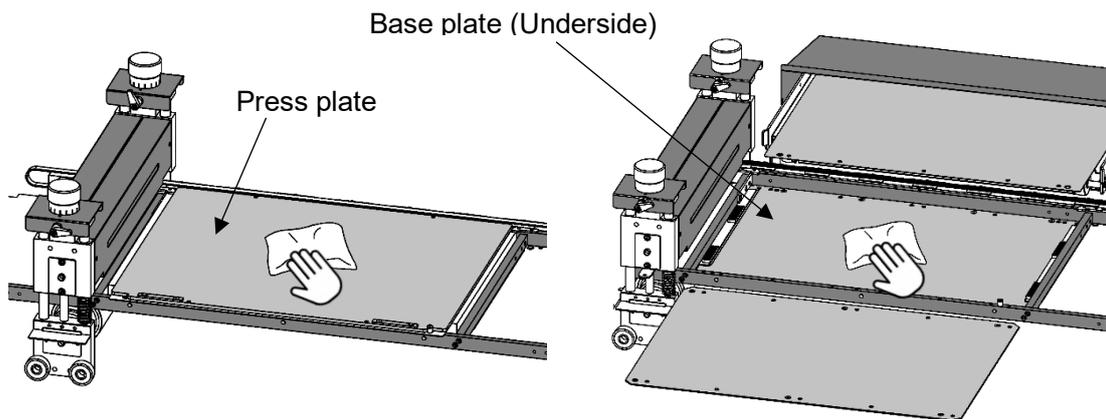
<p>E-30</p>		<p>Displayed when the die board does not move up and down within a set time period.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>E-31</p>		<p>Displayed when the feed table does not move up and down within a certain period of time.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>E-32</p>		<p>Displayed when an overload is detected in the Paper carrying unit.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>E-33</p>		<p>Displayed when an overload is detected in the Press roller.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>E-34</p>		<p>Displayed when die board is wrong position.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>E-35</p>		<p>Displayed when the Press roller teeth jumps while moving.</p> <p>The displayed clears when press the <b>RETURN</b>.</p>
<p>E-36</p>		<p>Displayed when Press roller is out of the range.</p> <p>Press <b>HOME POS</b> and press roller</p> <p>The displayed clears when move to the Home position.</p>

E-37		Displayed when a communication error occurs in the control board.
E-38		Displayed when an error occurs in the driver of the servo motor for feeding.
E-39		Displayed when an error occurs in the driver of the servo motor for pressurization.

## 9. Maintenance

- Clean the Press plate and Base plate with a parts cleaner before starting work one day.
- After cleaner, wipe them with a cloth soaked in oil (machine oil) and refuel.

Oil viscosity : ISO VG68



Note.

Insufficient lubricant will lead to increased wear and ultimately failure.

Keep the paper carrying belt without oil.

## 10. Troubleshooting

- ① Paper is not fed well.
  - UP to the Suction power. (☞ Page31)
  - Shorten the PAPER FEED WORK TIME. (☞ Page31)
  - Make sure the paper set guide is not too tight.
  - Make sure that the paper is not charged with static electricity.
  
- ② Occurs double feed
  - Down to the Suction power. (☞ Page31)
  - Up to the Front blow power. (☞ Page31)
  - Longer the PAPER FEED WORK TIME. (☞ Page31)
  - Make sure that the paper is not charged with static electricity.
  
- ③ Message dialog : E-24 is frequently displayed.
  - Lower the detection sensitivity or turn it off. (☞ Page31)
  
- ④ Frequently Paper Jam
  - Make sure that there is no paper, pieces of paper, paper dust, etc. remains inside the machine.
  - Down to the Belt speed. (☞ Page30)
  - Take measures that the paper does not get caught on the Die board or Cutting plate during to the paper passing.
  - Use a Die board with Ejection material (Ejection Sponge etc.) on both the sides of the blade.
  - Provide a "nick" on the Die board that the cutting workpieces pulled out during to the paper passing will not come apart.

- ⑤ The cutting position in the feed direction is not stable.
- Adjust the positional deviation depending on the pressurization direction. (☞ Page32)
  - Set the pressurization direction to **ONE WAY**. (☞ Page32)
  - Make sure the paper is loaded correctly.
  - Make sure the Die board is set correctly. (☞ Page24)
- ⑥ Skewing cut
- Make sure the print is not skewed against the paper.
  - Make sure the paper is set correctly.
  - Make sure the Die board is set correctly. (☞ Page24)
  - If the tilt is constant, adjust by the Skew adjusting dial. (☞ Page38)
  - If the tilt is not constant, the paper feed is not stable.
    - … Shorten the PAPER FEED WORK TIME. (☞ Page31)
    - … Down to the Belt speed. (☞ Page30)
- ⑦ Cutting quality is not well.
- Make sure that there is no paper, pieces of paper, paper dust, etc. remains inside the machine.
  - Make sure the Die board and Cutting plate for pain.
  - Depressurize the level of pressurization. (☞ Page27)

## 11. Product specifications

Specifications	
Pressurization system	Rotary press cylinder
Die board type	THOMSON
Multifaceted control	Up to 5
Paper feeding method	Tri-suction upper belt feeding mechanism
Input tray capacity	MAX 4.000"
Maximum paper size	W14.33" x L20.28" (B3)
Minimum paper size	W11.69" x L16.54" (A3)
Paper weight	120-400g/m <sup>2</sup> (Depending on paper)
Maximum paper curl size	±0.125"
Paper type	Offset, Coat, UV coat, Glossy, Laminate (Depending on paper)
Speed	1000 sheets per hour (Depending on paper)
Machine dimensions	W106.30" x D42.13" x H43.31"
Net weight	410kg
Power supply	Single phase 110- 120VAC, 50/60Hz
Power consumption	400W
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	110~120V +6%, -10%
Over voltage category	Category II according to IEC60664-1
Pollution degree	Degree 2 according to IEC60664-1

## AeroDieCut 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.