

Scrap Tape Cutter
TC220E

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T50393807 Rev. B

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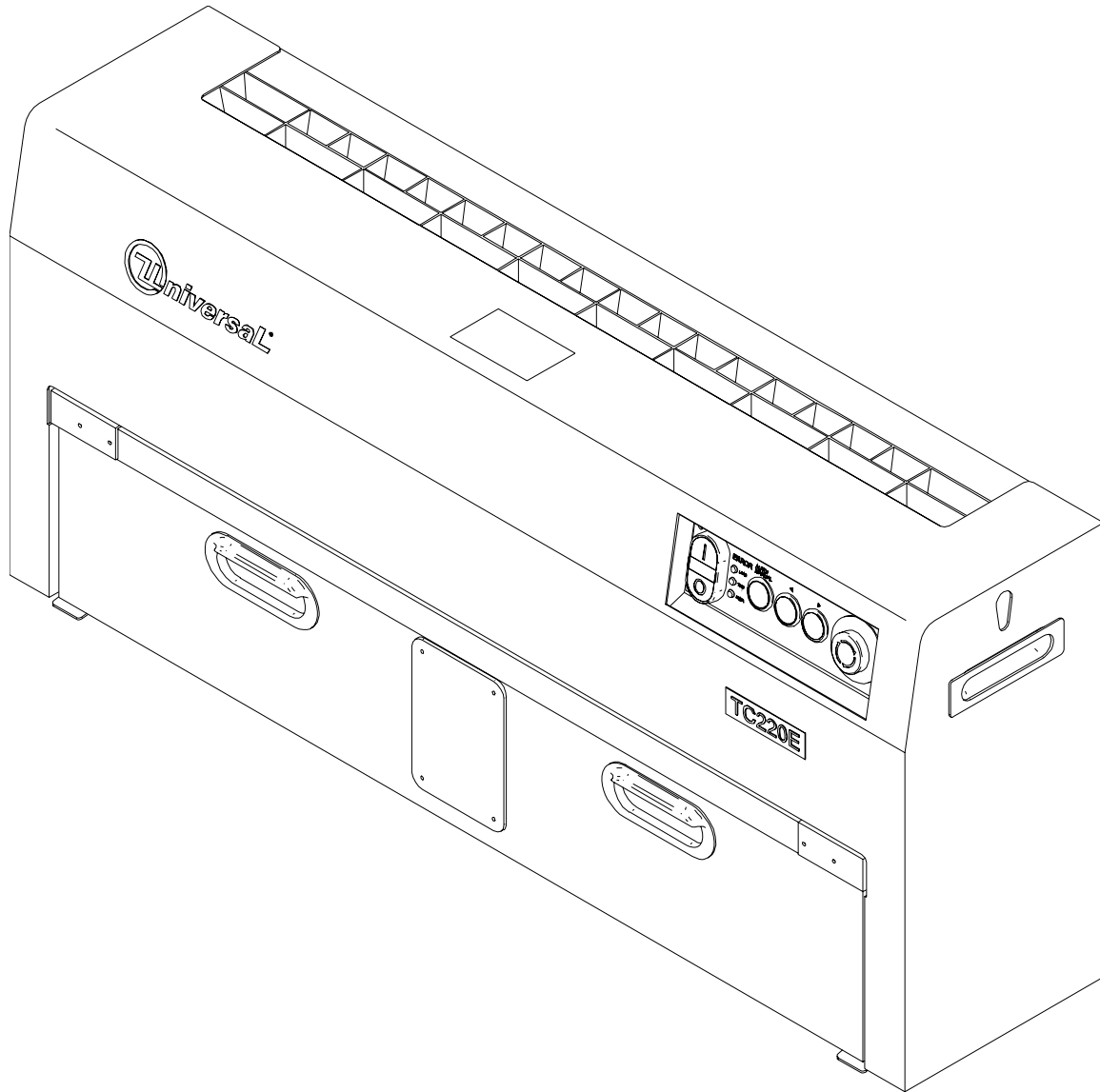
This document supports
assembly 50393807 Rev. B

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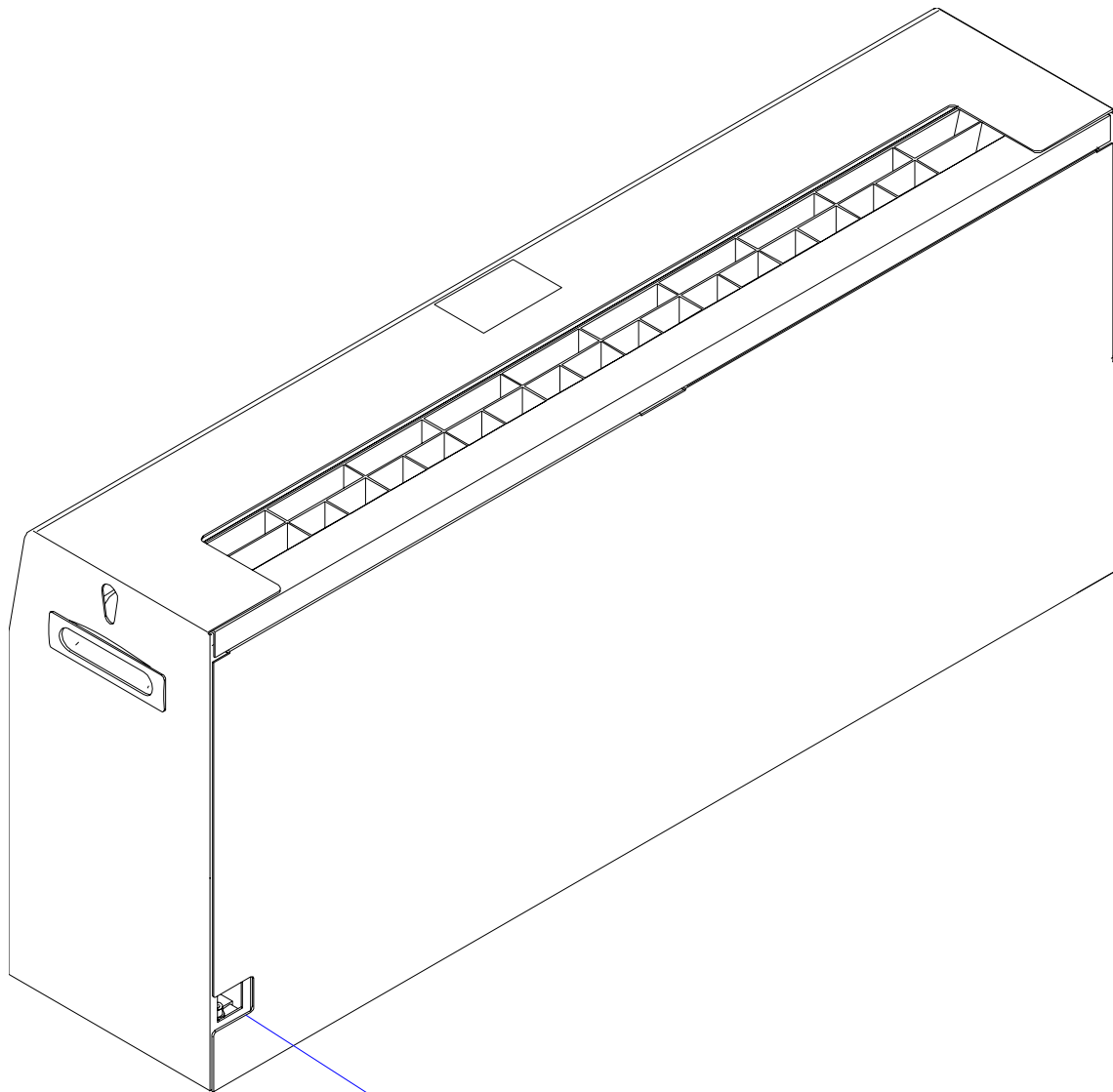
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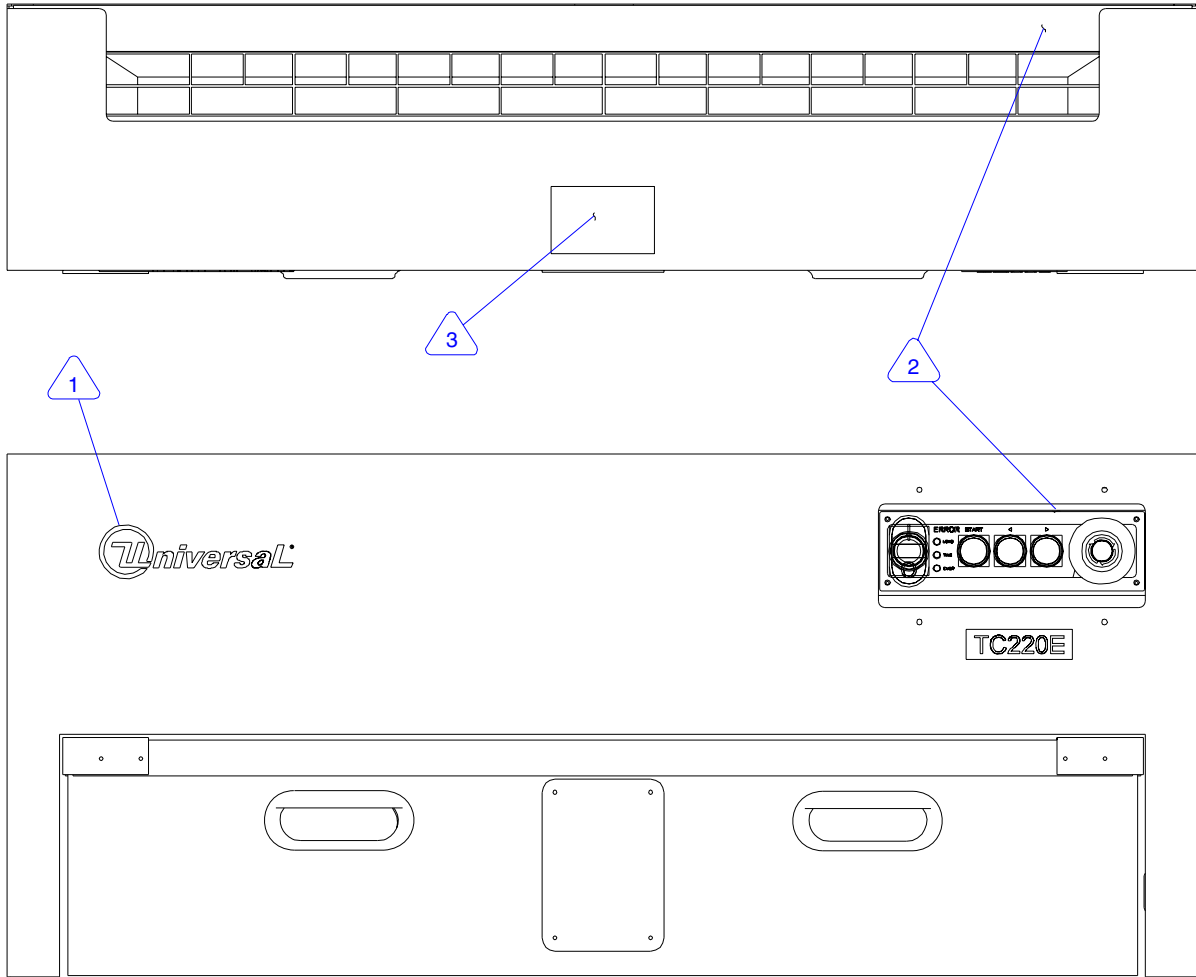


220V AC Input Power

Rear View

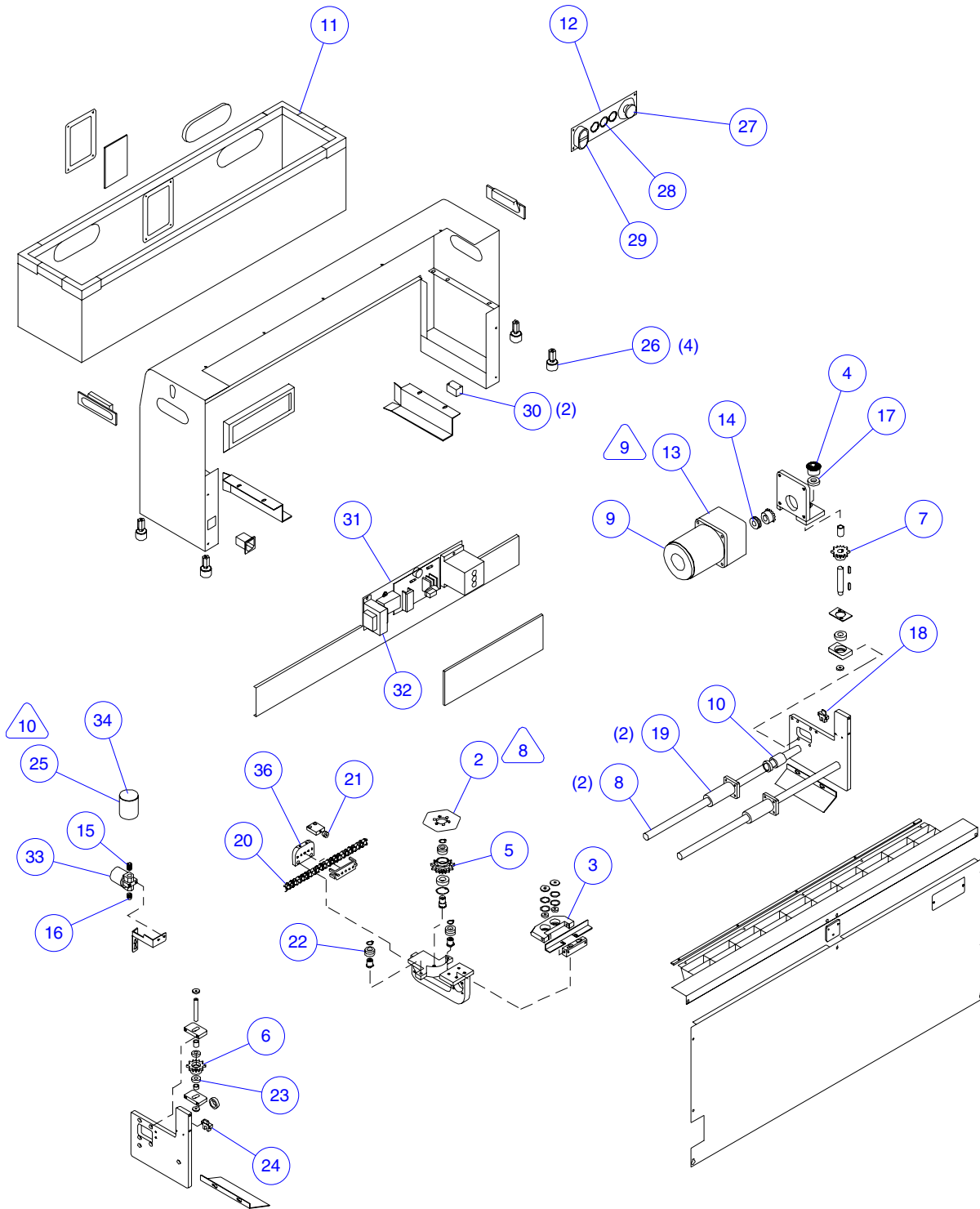
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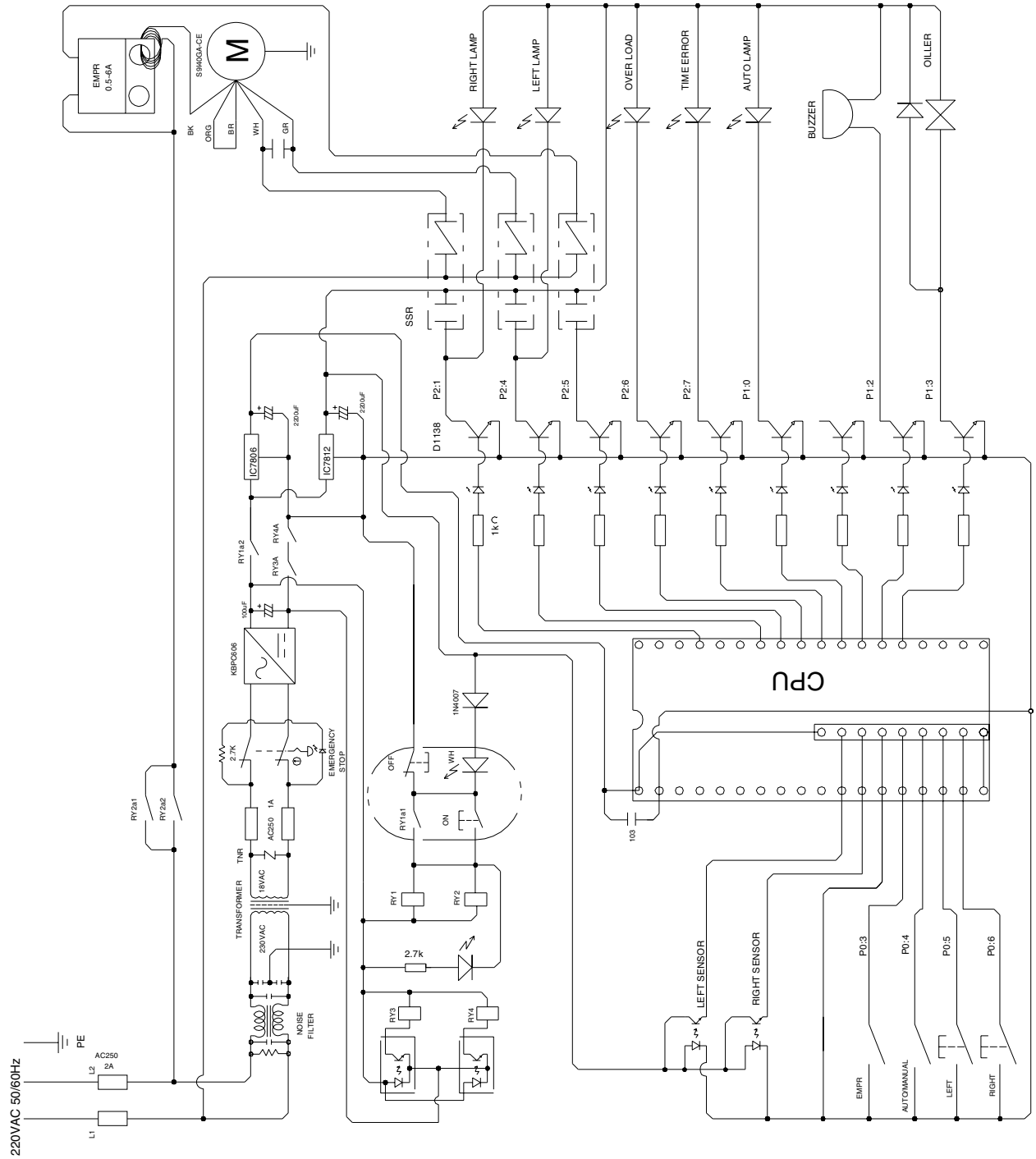
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



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





T50393807 Rev. B**Scrap Tape Cutter TC220E****Notes**

1. PURCHASE FROM ESER CORPORATION.
2. TIME DELAY 2S, TRAVEL TIME 9S.
-  3. UNIVERSAL LOGO TO BE APPLIED IN THIS AREA.
-  4. SHEET METAL COLOR TO BE GRAY SPEC EQUIVALENT TO THE FOLLOWING:

CARDINAL INDUSTRIES T031-GR397

SHERWIN WILLIAMS HAT6-3040

PPG NXP 1379
-  5. ENTANGLEMENT WARNING LABEL TO BE APPLIED.
6. 220VAC MOTOR
-  8. INCLUDES FIXED BLADE, HEXAGONAL BLADE AND ALL REQUIRED HARDWARE.
-  9. THE GEAR HEAD ASSY IS A COMSUMABLE ITEM. COMPLETE ASSEMBLY ALSO INCLUDES BEVEL GEAR AND BEARING.
-  10. COMPLETE ASSY ALSO INCLUDES BOTH NIPPLES, SOLENOID VALVE AND CAP.

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DET NO.	ITEM NO.	DESCRIPTION	QTY	U/M
8	1	BLADE KIT, COMPLETE (STS001A)	EA	1
	2	HEXAGONAL KNIFE (STS001)	EA	1
	3	FIXED KNIFE (STS002)	EA	1
	4	BEVEL GEAR (STS010)	EA	1
	5	SPROCKET (STS011)	EA	1
	6	SPROCKET (STS012)	EA	1
	7	SPROCKET (STS013)	EA	1
	8	LM SHAFT (STS014)	EA	2
	9	INDUCTION MOTOR (STS01CE)	EA	1
	10	STOPPER (STS020)	EA	1
	11	DUMP BOX, TC220E (STS021AESD)	EA	1
9	12	O/P PANEL (STS029)	EA	1
	13	GEAR HEAD ASSY (STS02CA-1)	EA	1
	14	BEARING (STS03C)	EA	1
	15	NIPPLE (STS042)	EA	1
	16	NIPPLE (STS043)	EA	1
	17	BEARING (STS04C)	EA	1
	18	SENSOR (STS06C)	EA	1
	19	LM BEARING (STS07C)	EA	2
	20	CHAIN (STS08C)	EA	1
	21	PUSH BEARING (STS11C)	EA	1
	22	BEARING (STS12C)	EA	1
10	23	BEARING (STS13C)	EA	1
	24	SENSOR (STS14C)	EA	1
	25	OILER SET ASSY (STS28CA)	EA	1
	26	CASTER, BALL (STS17C)	EA	4
	27	EMERGENCY SWITCH (STS20C)	EA	1
	28	PUSH BUTTON (STS21C)	EA	1
	29	I/O SWITCH (STS22C)	EA	1
	30	PROXIMITY SENSOR (STS38C)	EA	2
	31	PC BOARD ASSY (STS24CV5E)	EA	1
	32	TRANSFORMER (STS25C)	EA	1

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33	50638823	SOLENOID VALVE (STS28C)	EA	1
34	50638824	CAP (STS33C)	EA	1
35	50638835	CHAIN BLOCK ASSY (STS028A)	EA	1
36	50638843	BOX GUIDE, LEFT (STS022)	EA	1
37	50638844	BOX GUIDE, RIGHT (STS023)	EA	1
USED BUT NOT SHOWN ITEMS				
39	50493201	F CUTTER PWR CABLE ASSY (STS-37C)	EA	1
40	T50393807	DOC, SCRAP TAPE CUTTER TC220E	EA	1

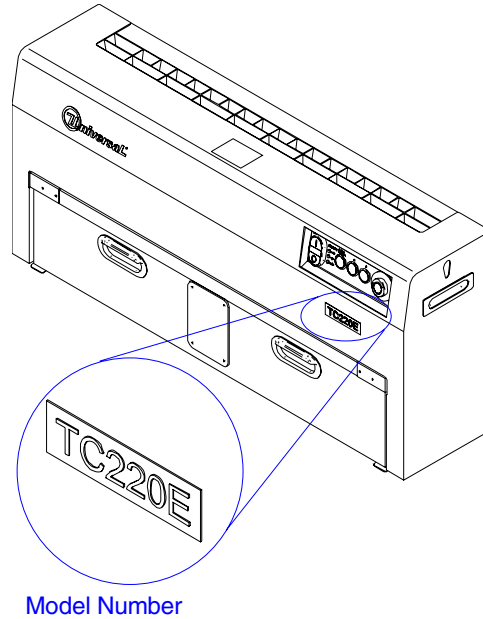
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Functional Description

The Scrap Tape Cutter is designed to cut off small pieces of reel tape and collect them in a dump box for ease of disposal. This document explains important safety information, as well as proper operation and maintenance of the unit.

The Scrap Tape Cutter model number is located below the operator control panel. Refer to the following illustration.



Maintenance Concept

The following table defines the recommended Maintenance Concept for this assembly. For a more detailed explanation of the Maintenance Concept and its structure refer to the *Prerequisite Information and Introduction* document.

Maintenance Procedures	Recommended Frequency	Minimum Skill Required	Spares Kit Required	Tool Kit Required
Empty the Dump Box	As Required	Maintenance Technician	No	No
Replace the Blade	As Required	Maintenance Technician	Yes	No
Replenish the Oil	Every 3 months	Maintenance Technician	No	No
Adjust Chain Tension	As Required	Maintenance Technician	No	No

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Scrap Tape Cutter TC220E

Related Information

The following table defines documents and sources containing information that may be required while performing the procedures in this document.

Document Title	Procedure or Section
Kit, Scrap Tape Cutter	Install the Scrap Tape Cutter

Product Safety

**WARNING**

- Do not put objects other than reel tape in the cutter unit.
- Use caution with long hair and when wearing loose clothing near the cutter unit.
- Unplug the unit when replacing the blade and replenishing the oil.
- Do not operate the machine near flammable gas.
- Do not open/disassemble the cutter unit while the machine is operating.
- Follow all safety labels on the cutter unit.

Procedures and Adjustments

Install the Scrap Tape Cutter

Use the following procedure when installing the Scrap Tape Cutter.



1. Power down the machine and perform Lockout/Tagout according to local procedures.

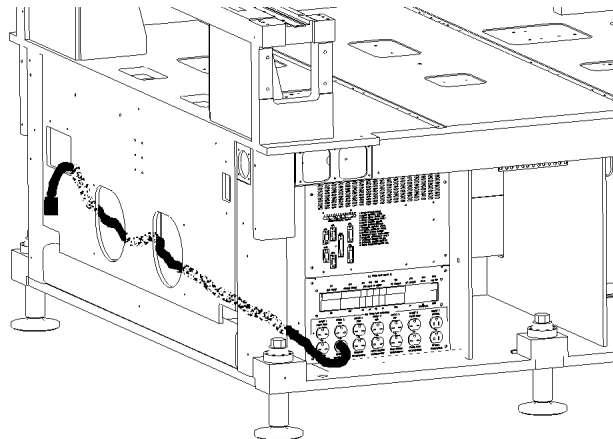
**WARNING**

The machine must be powered down and the local Lockout/Tagout procedure performed to ensure personal safety during this procedure.

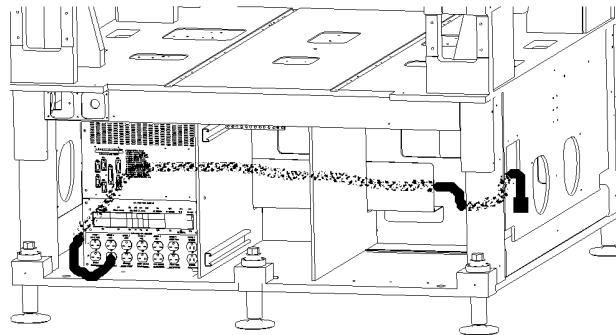
2. Remove the front lower covers to access the AC Chassis.
3. Remove the side covers.
4. Route the Cutter Power Cable Assembly as shown in the following illustrations and plug into the AC Chassis.

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Cutter Power Cable Assembly routing for Rear of the machine



Cutter Power Cable Assembly routing for Front of the machine

5. Re-install the front lower covers and side covers.
6. Place the cutter unit in front of the desired feeder bank and plug into the Cutter Power Cable Assembly.
7. Install the dump box into the cutter unit.
8. Feed the empty reel tape from the feeder into the top of the cutter unit.
9. Power up the Platform machine.
10. Push the main power I/O button. The unit is now ready to operate.

Operate the Scrap Tape Cutter

The Scrap Tape Cutter has two modes of operation; manual and automatic. Manual mode should only be used when trying to cut objects that jammed the unit when it was operating in automatic mode. This could be an indication the blade needs replacement. Otherwise, the cutter should be used in automatic mode.

Automatic Mode

1. Rotate the Emergency Stop switch.
2. Push the flashing [Start] button. The blade unit begins to move. The blade continues to cycle until the dump box is removed or the Emergency Stop switch is pushed.

If the unit jams, the blade automatically backs up and tries again. If after a second attempt the unit is still jammed, the machine will stop and a buzzer will sound. The jam must be cleared using manual mode before the unit can be returned to operating in automatic mode.

Manual Mode

1. Rotate the Emergency Stop switch.
2. Push and hold the Left or Right Directional Arrow button. The unit stops once the blade reaches the limit of travel.

Recover From a Jam

Use the following procedure to clear a jam.

1. Push the Emergency Stop switch to stop the buzzer.
2. Rotate the Emergency Stop switch.
3. Push and hold the Left or Right Directional Arrow button to move the blade back away from the jam.
4. Push the Emergency Stop switch and clear the jam.
5. Rotate the Emergency Stop switch.
6. Push the flashing [Start] button. The blade unit begins to move.

Empty the Dump Box

Use the following procedure when emptying the Scrap Tape Cutter dump box.

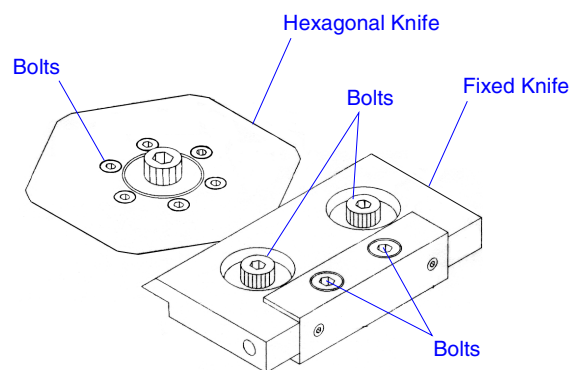
1. Grasp the handles on the dump box and remove it from the Scrap Tape Cutter unit. The cutter automatically stops.
2. Empty and then re-install the dump box. Push the [Start] button to resume operation.

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Replace the Blades

The blade unit of the Scrap Tape Cutter consists of a fixed and hex blade. Replace both blades when the cutter jams frequently or when the blades become damaged or worn. Use the following procedure when replacing the cutter blades.

1. Push the Emergency Stop switch and unplug the unit.
2. Remove the back cover and tape inlet guide from the cutter unit.
3. Remove the 4 screws that secure the fixed blade to the housing. Use caution so as not to lose the washers that are under the blade.



4. Remove the idler guide from the housing.
5. Remove the 6 screws that secure the hex blade to the housing.
6. Clean any debris that may have gathered under the blades.
7. Install the new hex blade. Note the correct orientation of the blade.
8. Install the idler guide and secure to the housing.
9. Verify that the washers are in place and install the new fixed blade.
10. Install the tape inlet guide making certain the plate is aligned with the screw holes.
11. Install the back cover, plug in the unit, and rotate the Emergency Stop switch. The unit is ready for operation.

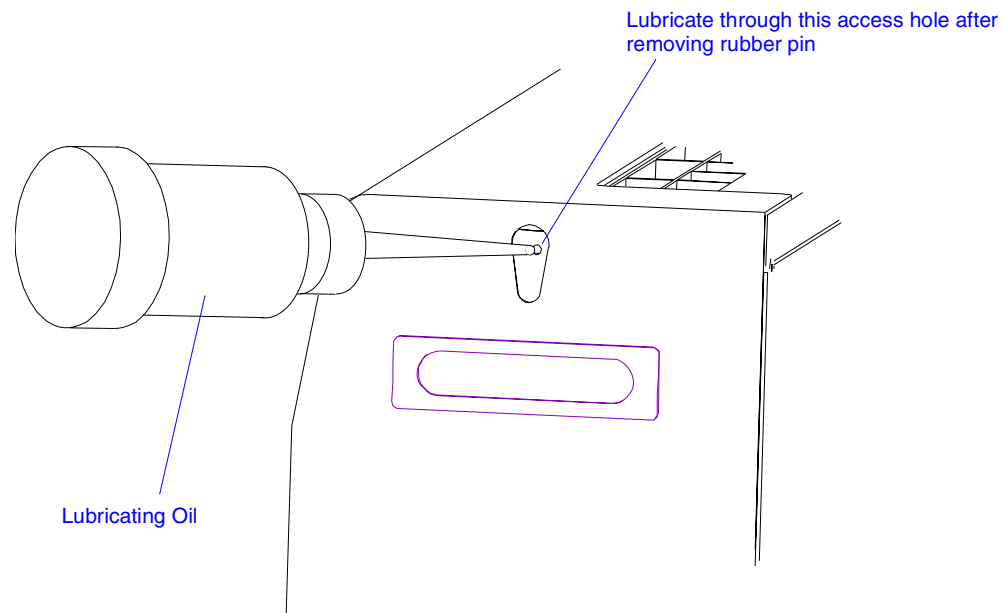
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Replenish the Oil

Use the following procedure when replenishing the lubricating oil.

1. Push the Emergency Stop switch and unplug the unit.
2. Access the lubricant reservoir on the right side of the unit (the same end as the control panel).



3. Remove the rubber pin and using light machine oil or way-lube, fill the reservoir approximately four-fifths of the container.
4. Insert the rubber pin, reassemble the cover, plug in the unit, and rotate the Emergency Stop switch. The machine is ready for operation.

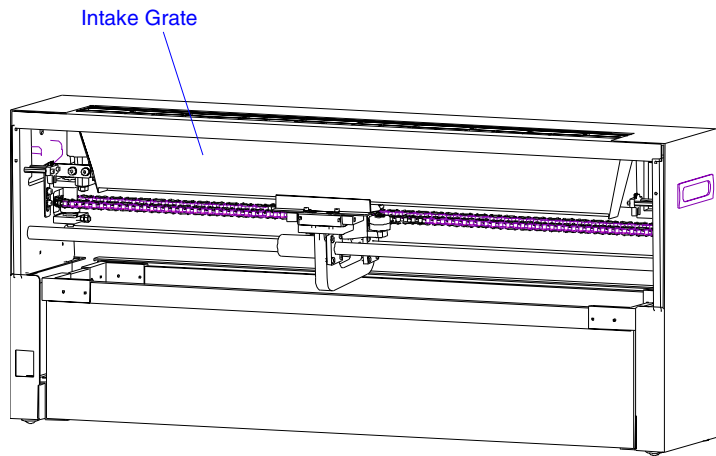
Chain Adjustment

Use the following procedure when adjusting chain tension:

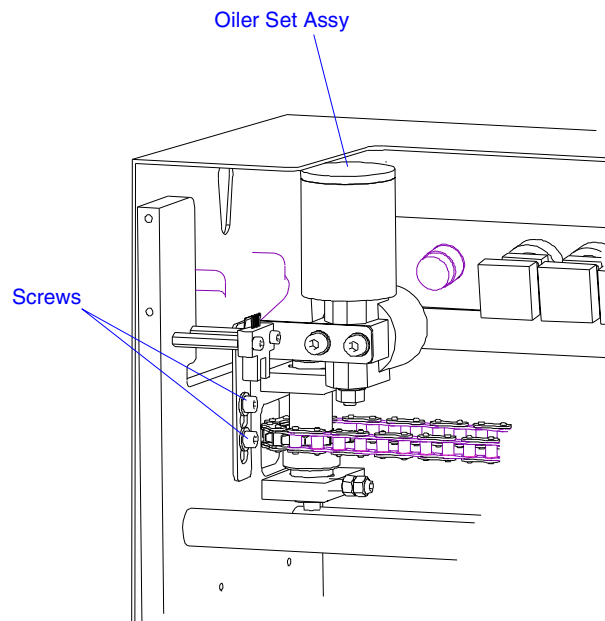
1. Unplug the unit.
2. Remove rear sheet metal cover.
3. Loosen, but do not remove intake grate screws, enough to allow removal of intake grate.

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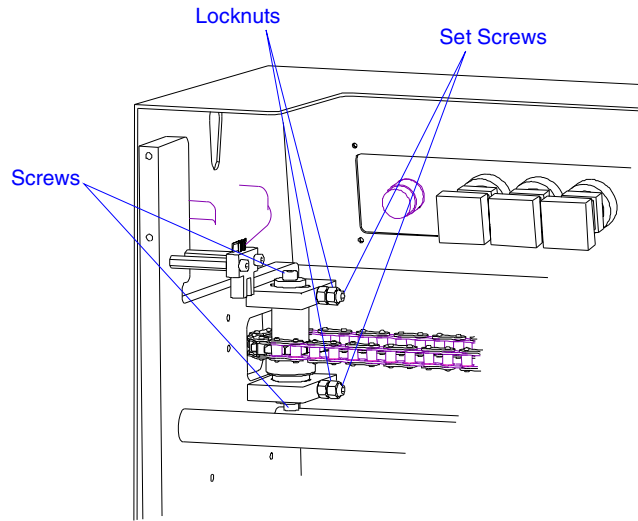
4. Remove two screws holding the oiler set assembly to allow oiler to be placed out of the way.



5. Loosen two screws and four locknuts.
6. Apply tension to chain by evenly tightening two setscrews to remove excess slack from chain. Chain should have 5-10 mm slack at center with cutter at end of travel.

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7. Tighten screws and locknuts.
8. Reinstall oiler set assembly.
9. Reinstall intake grate and rear sheet metal cover.

Scrap Tape Cutter TC220E**T50393807 Rev. B*****Changes To This Revision***

- Eliminate extra power cable because it is not needed; delete note 7 and BOM item 38.
- Change chain part number.