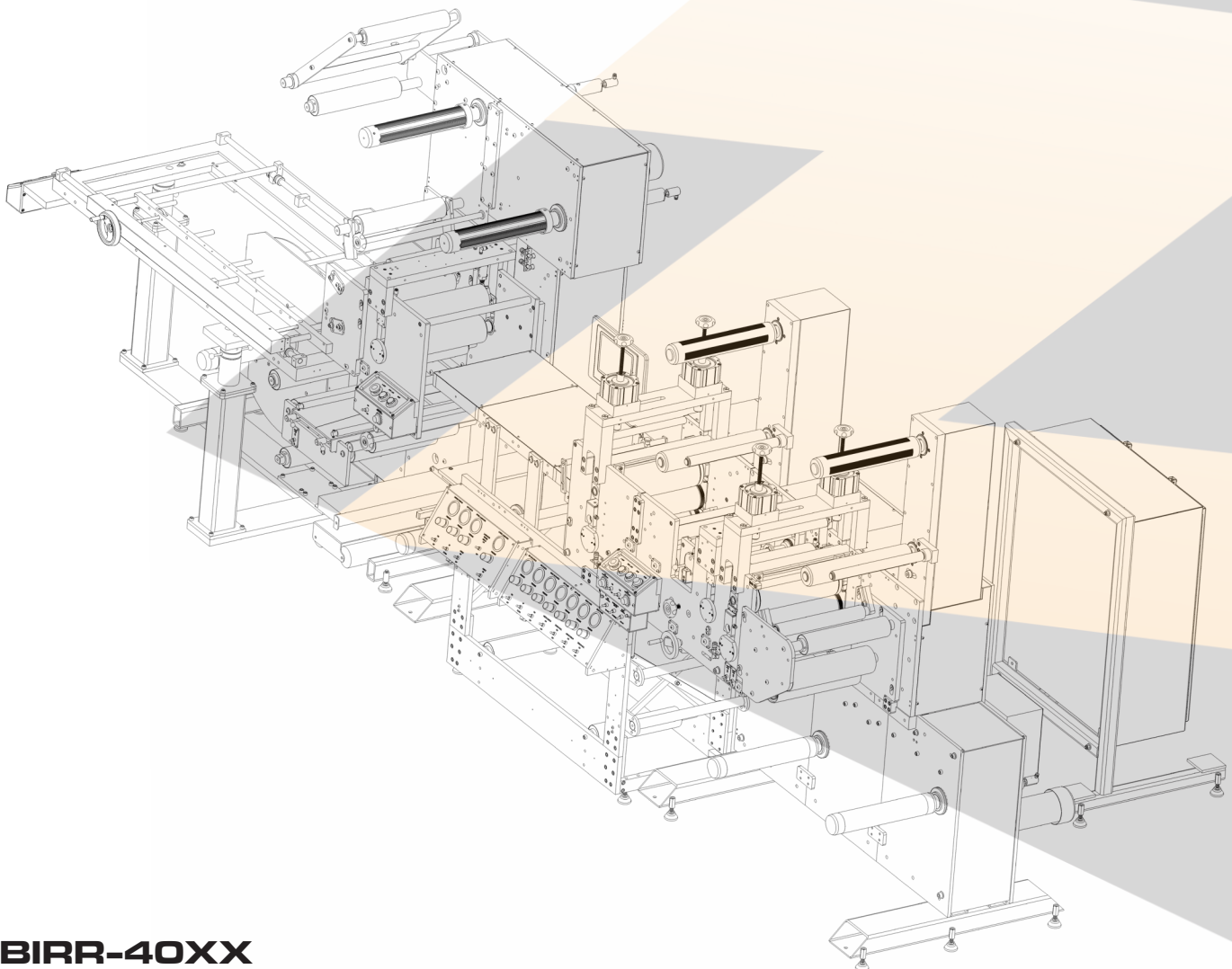




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BOOK INSERTER User Manual **BIRR-30XX**



BIRR-40XX



AZTECH CONVERTING SYSTEMS

**BIRR-30XX
USER MANUAL**

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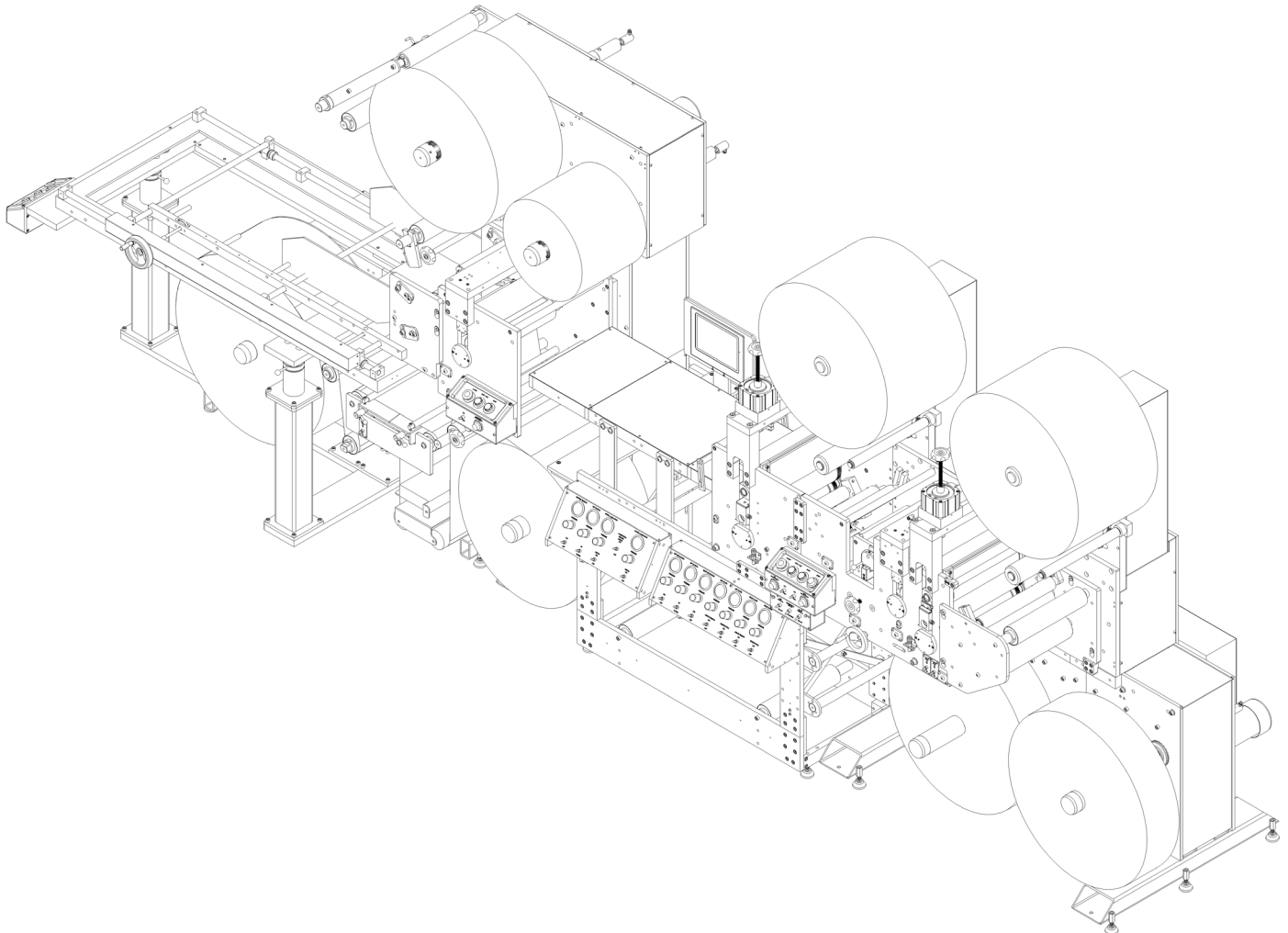


Section 1: General Information

1-1: Introduction

The AZTECH web handling unit is available in 13 inch (33.02 cm), 15 inch (38.1cm), 18 inch (45.72 cm) and 20 inch (50.8cm) widths, with dual-spindle rewinds, and web speeds up to 500 feet/minute. The unit is designed to be highly productive, versatile, and simple to operate and maintain. Before operating your new unit, fully read and understand all facets of this manual. Following the Procedures outlined in this manual will help assure maximum performance. Keeping your machine properly set-up and maintained will assure years of productive and satisfactory service.

1-2: Machine Information and Specifications

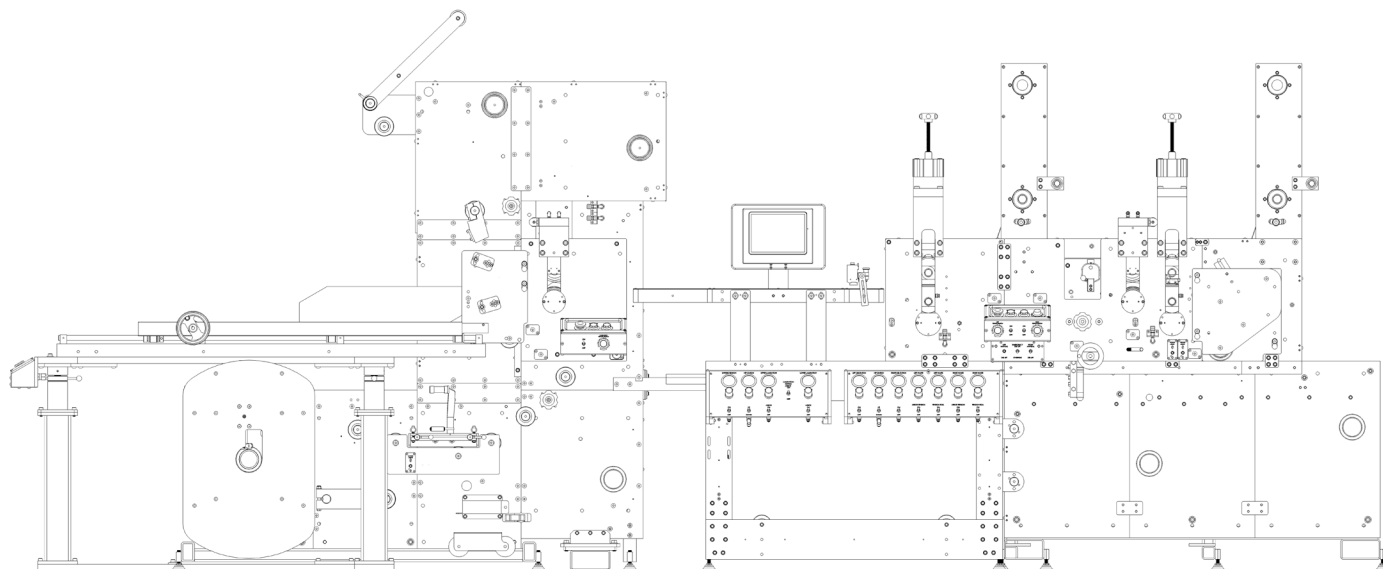




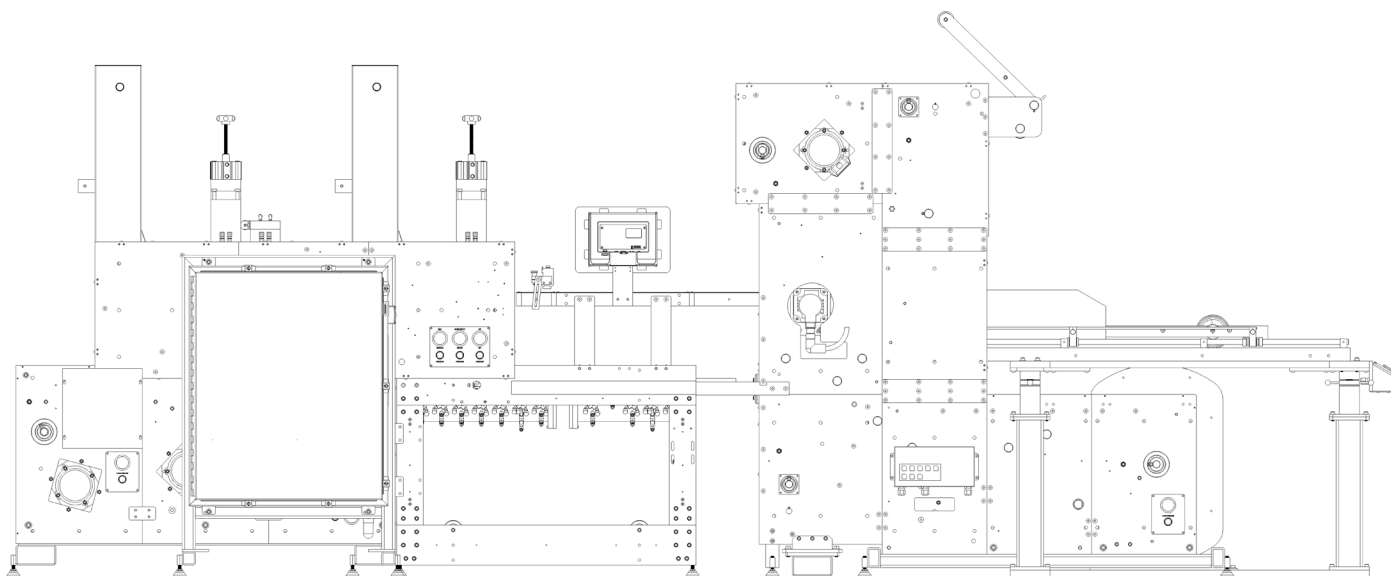
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FRONT LAYOUT



REAR LAYOUT

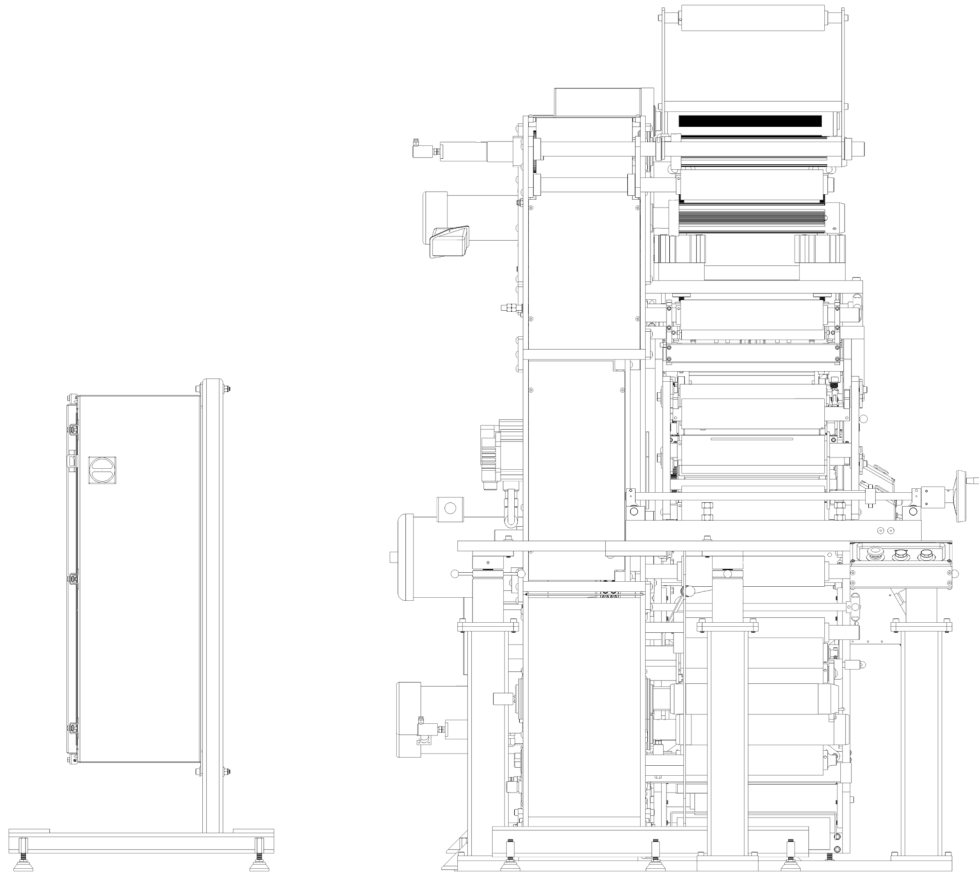


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SIDE LAYOUT



Web Width: 13.0in (33cm)

Unwind Capacity: 40in (101.6cm)

Rewind Capacity: 16in (40.6cm) dual RW
24in (60.9cm) single RW

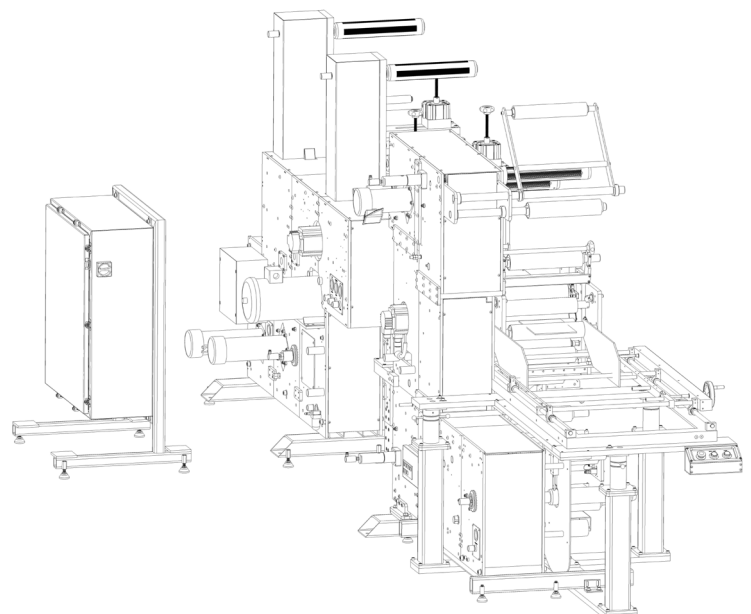
Web Speed: 500FPM (Job Dependant)

Main Drive: 5 HP DC

Rewind Drive: 2 HP DC

Die Nip: Yaskawa 1.3kW Servo x2

Power Requirements: 80A 220VAC 60Hz
90PSI @ 0.9CFM





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1-3: Care and Maintenance

To assure maximum performance and longevity of your machine, it is very important to perform periodic maintenance. Read Chapter 5 for more information.

1-4: Safety

The unit is designed to operate at high rates of speed, employing rollers, gears, pulleys, and other moving parts. Where possible, guards are provided to protect operator from injury. Operators must keep their hands clear of the machine when it is in operation. Making all operators aware of potential safety hazards will help minimize any chances of operator injury.

Section 2: Machine Installation

2-1: Preparation

It is important that your machine be situated on solid and level ground. Make sure that site allows for access to machine from all 4 sides. If the machine is placed on unstable or un-level ground, it may tip over risking damage or serious personal injury.

2-2: Un-crating Machine

To avoid damage to your new machine, begin by unfastening the latches on the front panel and removing the panel to expose the machine. Carefully remove all boxes from inside the crate and set aside to avoid damage. Remove all 4 lag bolts which hold the machine to the base.

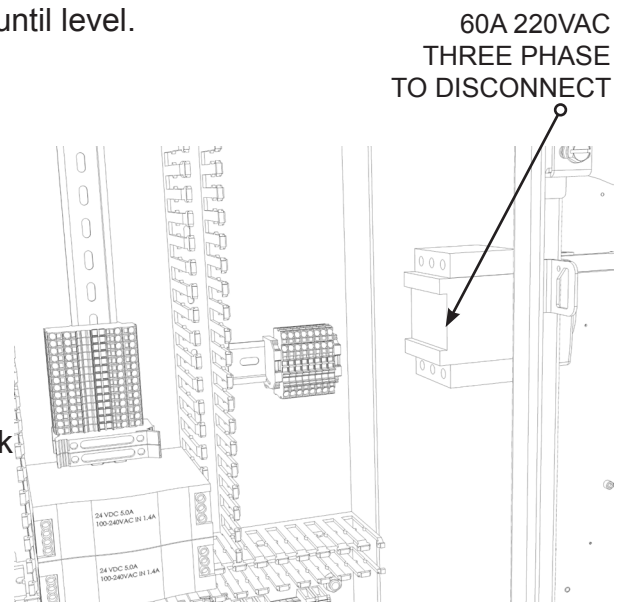
2-3: Removal and Positioning

It is critical that the machine be removed from the crate using a fork lift, making sure that the forks fit directly inside the 2 slots at base of the machine. Lift and remove from crate, and if equipped with adjustable feet, thread all 4 feet into threaded holes at machine's base, and lower into desired position. Machine may be leveled by turning adjustable feet until level.

2-4: Electrical and Pneumatic Connections

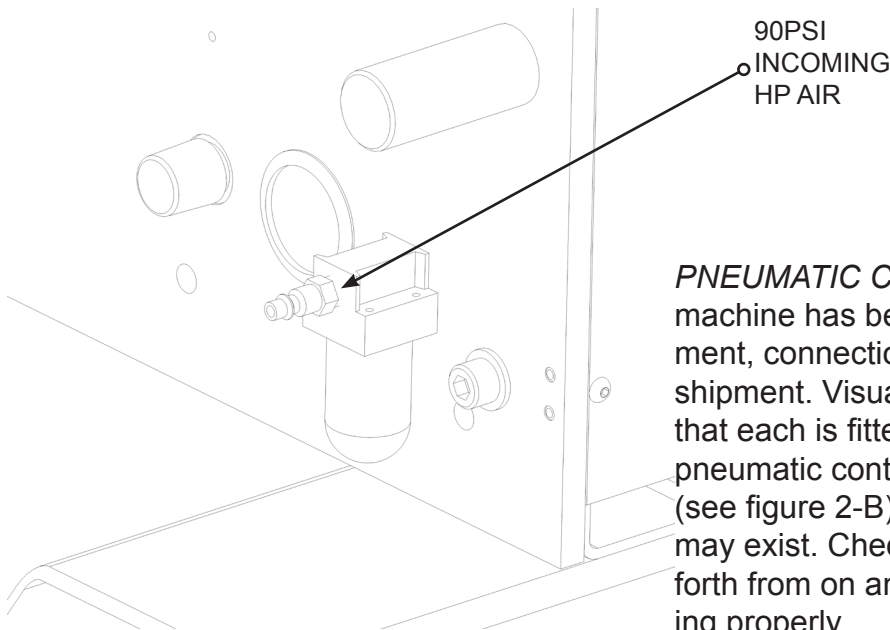
ELECTRICAL CONNECTIONS: Your machine uses a power supply of 220 volts, 80 amps 3 Φ AC. Improper connections or mishandling may cause serious personal injury. AZTECH highly recommends that electrical service be performed only by a qualified electrician.

Electrical connection to the machine is performed by bringing electrical service to the electrical box at the back of the machine and making connections as shown.



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PNEUMATIC CONNECTIONS: Although your machine has been thoroughly tested before shipment, connections on occasion may loosen during shipment. Visually inspect all pneumatic to assure that each is fitted securely. Connect airline to the pneumatic control panel at the back of the machine (see figure 2-B), and listen for any air leaks that may exist. Check all switches by switching back and forth from on and off to make sure they are operating properly.

NOTE: Red lines on air dials indicate proper default settings.

2-5: Testing Before Operation

Make sure the area around your machine is clear of any objects which may impair the machine. Also inspect and make sure all belts, pulleys, rollers, and spindles are free and clear of any objects which may impede operation, and risk machine damage. Before threading your machine, accelerate and decelerate your machine through a full range of speeds, and make sure acceleration is smooth and free of any unnatural sounds or movements. Using control switches, switch Unwind and Rewind Spindle(s) from on and off positions making sure the pneumatic system is performing properly. Then turn power on, run machine at low speed to assure machine is working properly. Then with speed set at maximum setting, press the stop button to assure that the brake is working properly.



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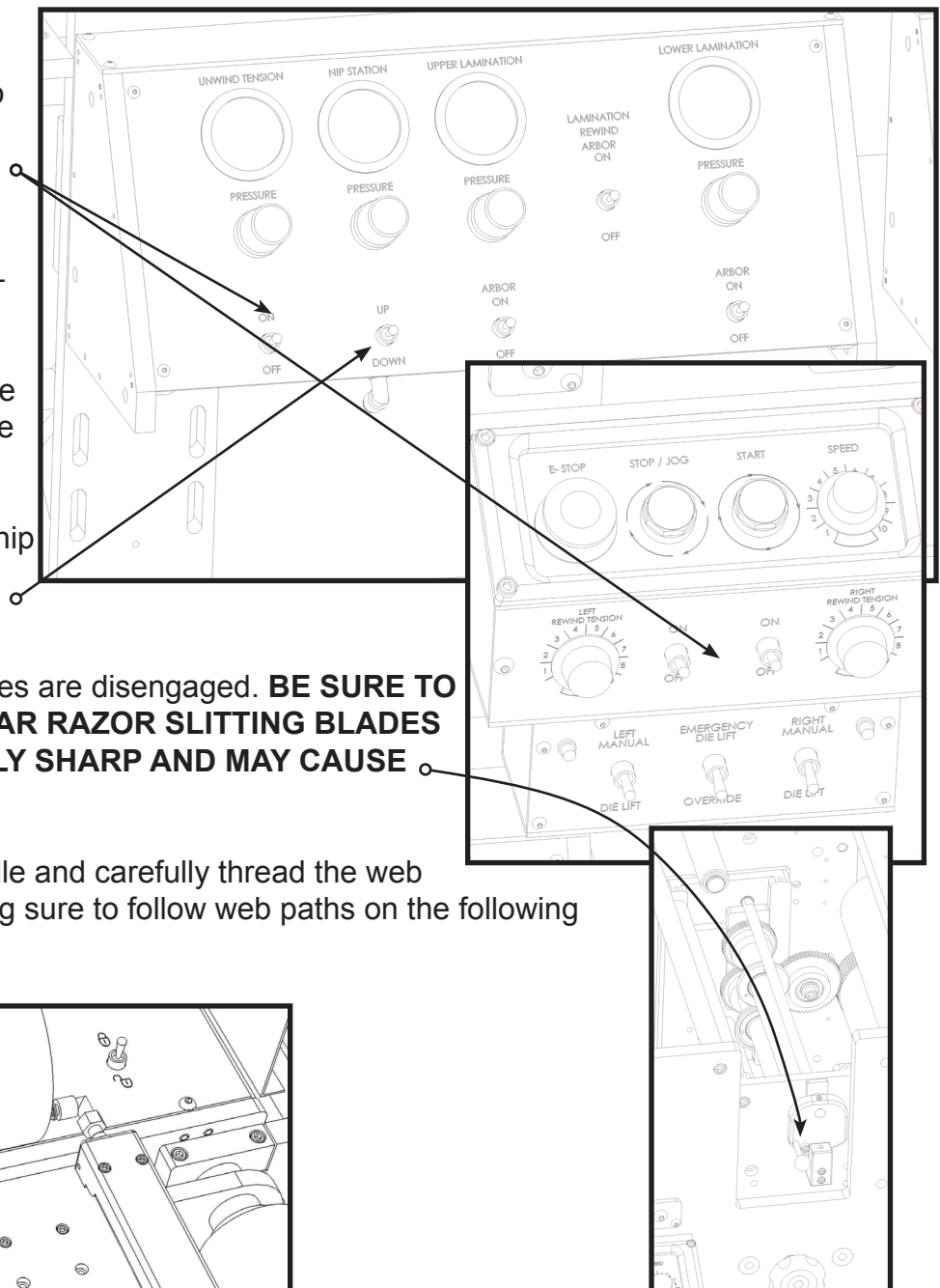
Section 3: Machine Setup

3-1: Webbing the Machine

Proper webbing of your machine is vital to optimal machine performance. The proper way to thread your machine for various substrates is shown on the following page. Any improper webbing of the machine may cause tension problems that will impede operation.

To web the machine:

1. Turn unwind arbor switch to “DEFLATE” position.
2. Assure that the rewind and unwind switches on main panel are in the “OFF” position
3. Assure that both splice-table clamps are released into the up position.
4. Assure that the pneumatic nip roll is disengaged in the up position.
5. Assure that the slitting blades are disengaged. **BE SURE TO USE CAUTION WHEN NEAR RAZOR SLITTING BLADES AS THEY ARE EXTREMELY SHARP AND MAY CAUSE SERIOUS INJURY.**
6. Load roll onto unwind spindle and carefully thread the web through the machine making sure to follow web paths on the following page.







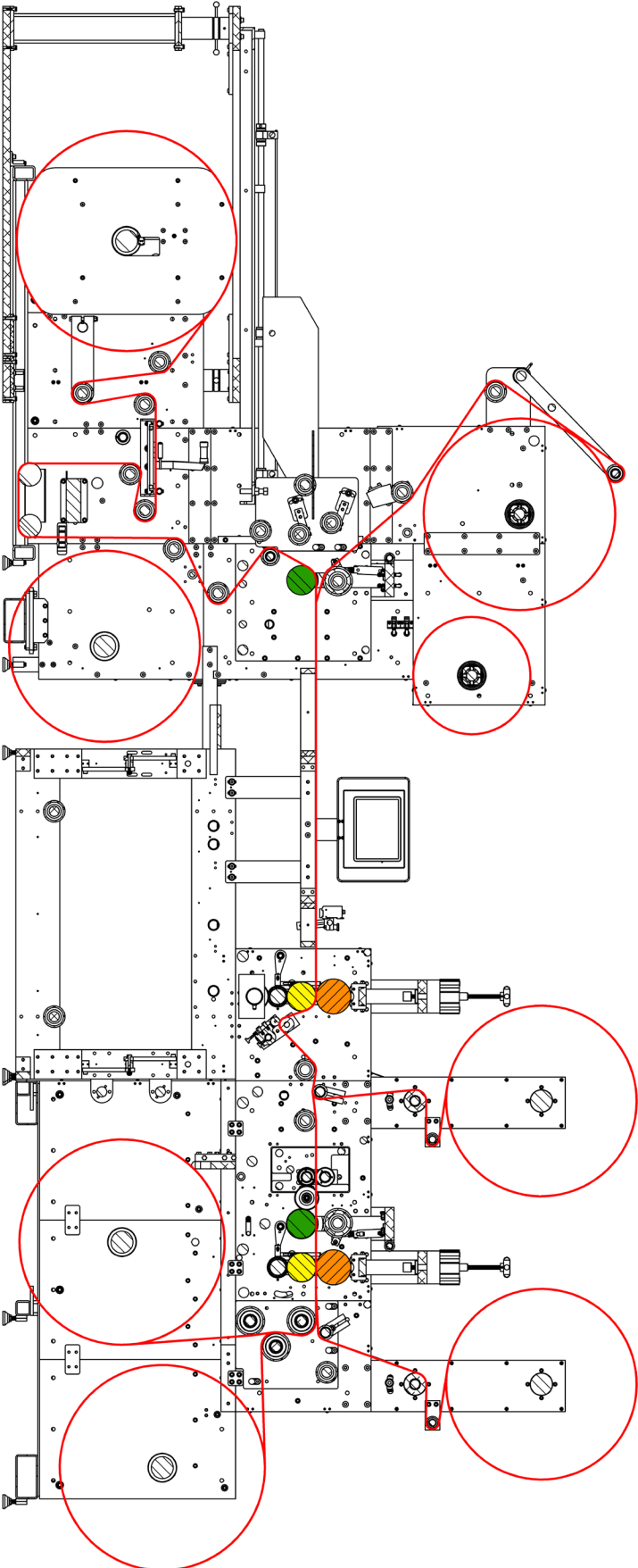
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BIRR 40XX w/ UDB Web Path

-  SERVO NIP ROLLS
-  MAGNETIC DIE ROLLS
-  IMPRESSION ROLLS
-  MINIMUM WEB PATH



Proper webbing of your machine is vital to optimal machine performance. The proper ways to thread your machine for various substrates are shown. Any improper webbing of the machine may cause tension problems that will impede operation.

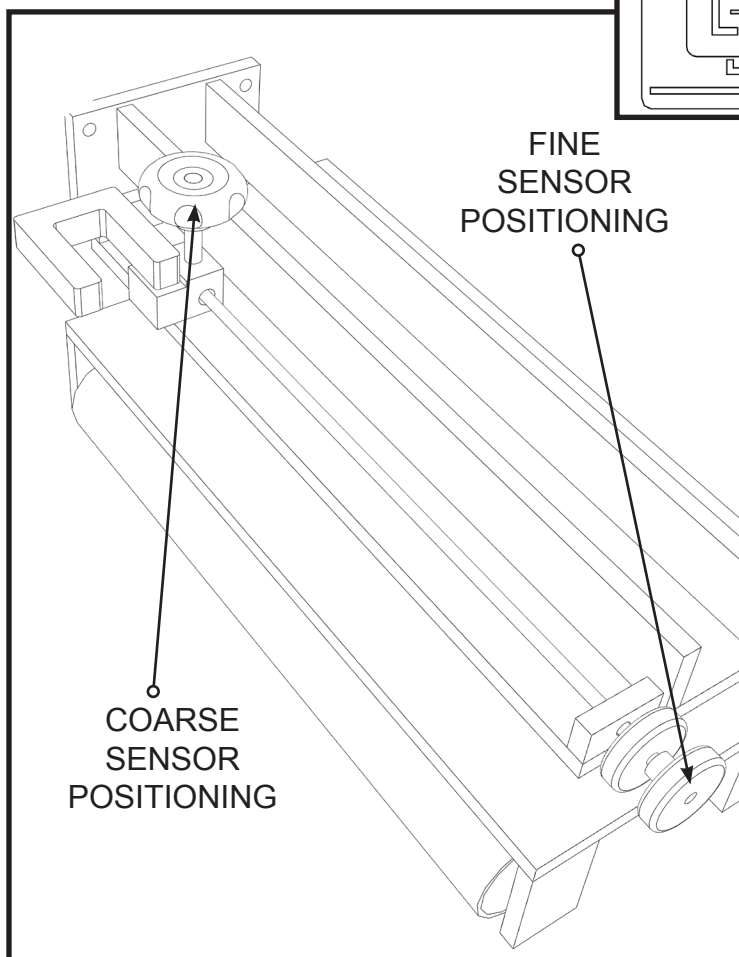


AZTECH CONVERTING SYSTEMS

BIRR-40XX USER MANUAL

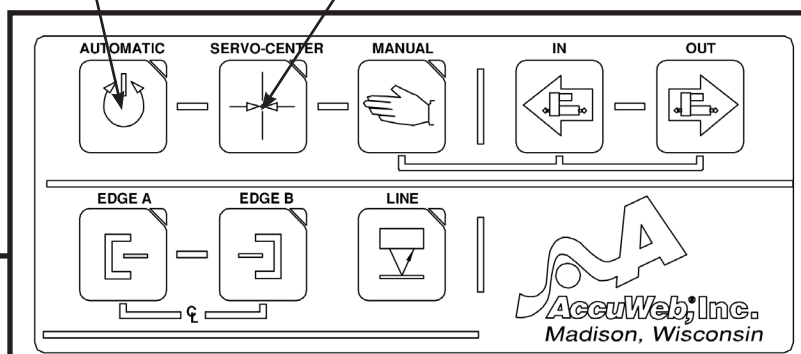
3-2: Web Guide Setup

The web guide is located in the center of the machine between the unwind and re-wind stations. After webbing the machine, set the web by doing the following:



AUTOMATIC

SERVO CENTER

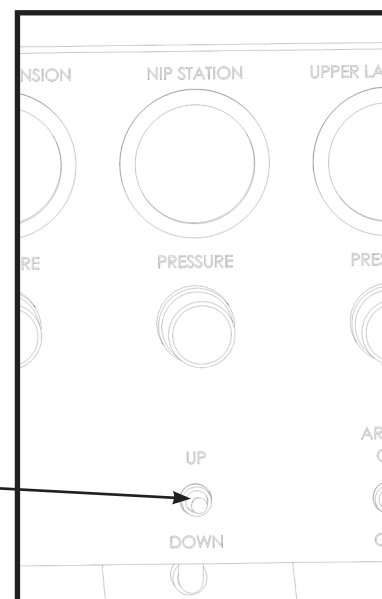


Setting the Web Guide:

1. Press the "SERVO-CENTER" button on the front of the web guide.
2. Align the sensor with the inside edge of the web. For fine alignment adjustment, turn knob on outside of web guide.
3. Jog the machine briefly to assure that the web is moving smoothly.
4. Press the "AUTOMATIC" button which will engage the sensor and allow the web guide to adjust itself to the movement of the web.
5. For more specific instructions about the features of the web guide, refer to the Accu-Web manual included with this manual.

3-3: Nip Roll Operation

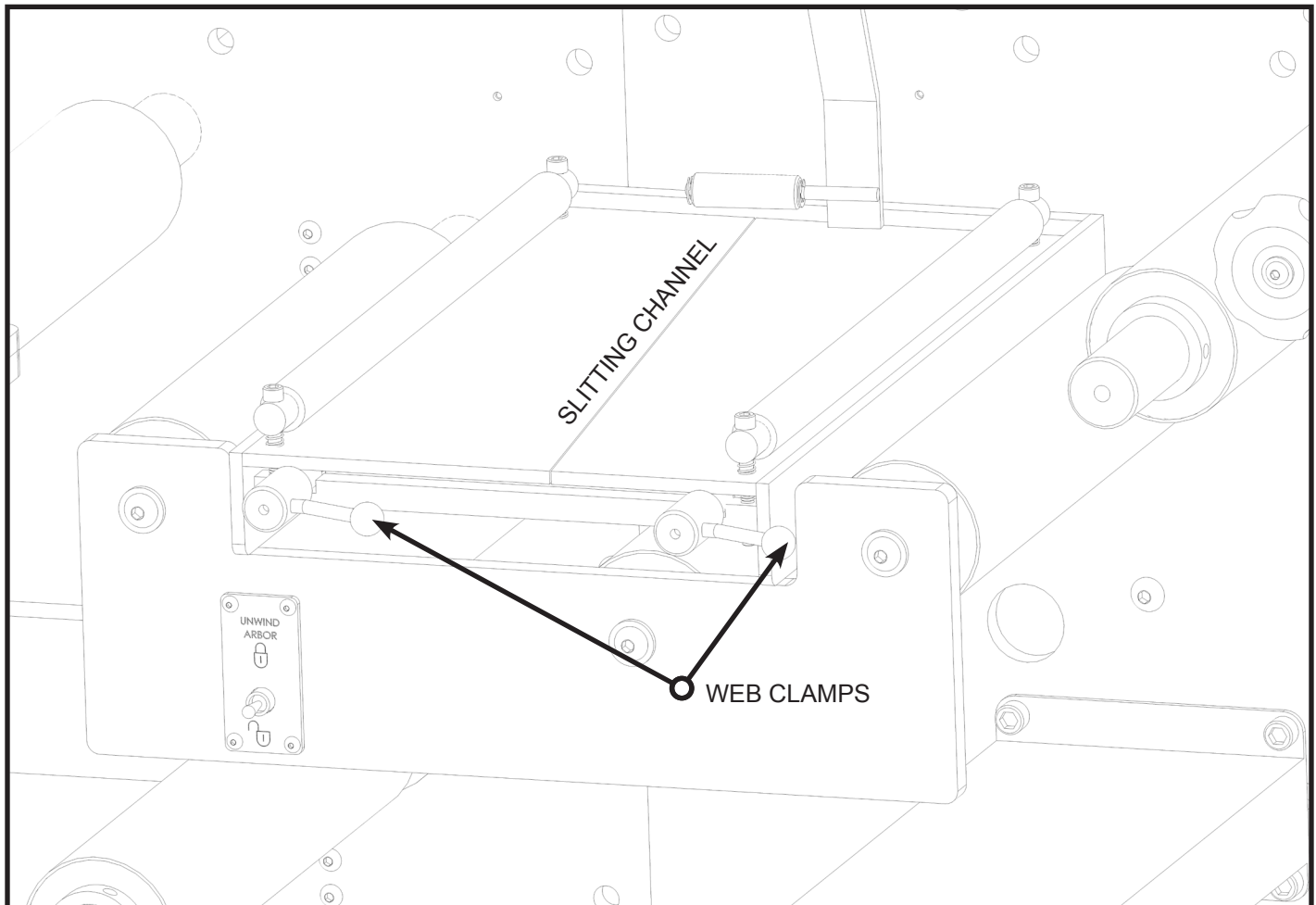
The Nip Roll is pneumatically controlled using control switch and must be in the up position while machine is running, and in the down position when threading machine.





3-4: Splice Table Operation

The splice table on your machine is located just down-web of the Unwind Station. To operate the Splice Table, simply follow the following steps:



1. Turn off machine and engage both web clamps.
2. Using a razor blade, carefully cut the web along the slicing channel. Disengage the clamp nearest the unwind station. Be sure to leave the other clamp engaged.
3. After waste has been removed, pull through new web, carefully align with web, and lower the handle to hold.
4. Again using a razor blade, cut the web, discard waste, pull tape under webs, fold to secure and cut tape.
5. Disengage both Web clamps.



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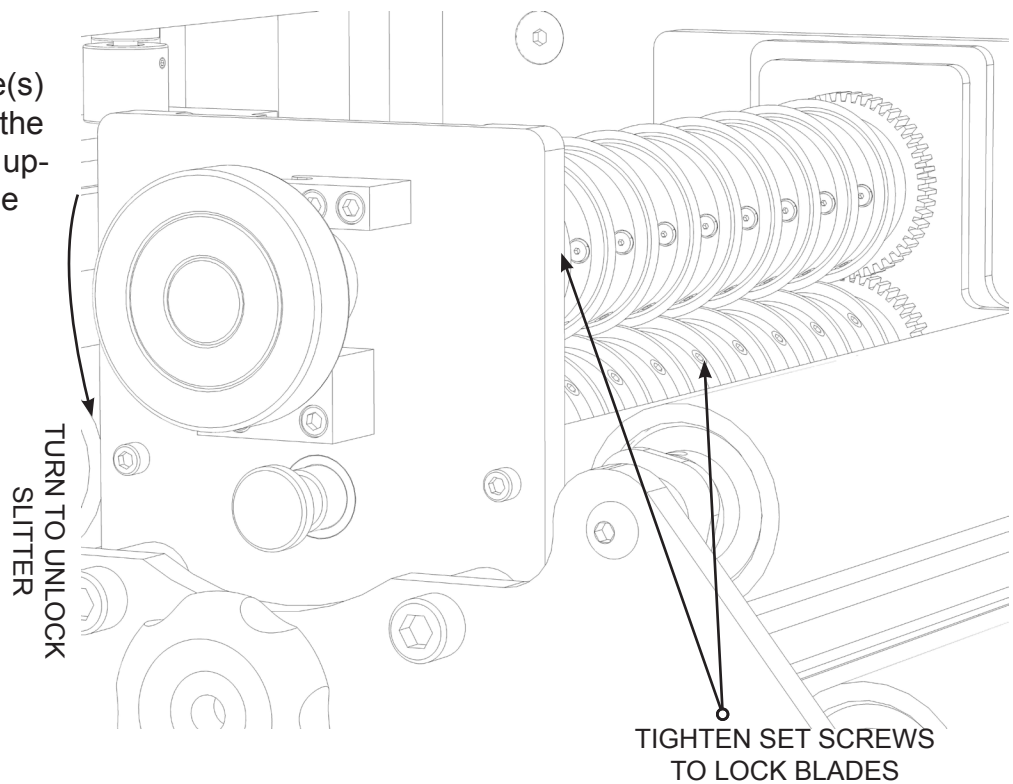
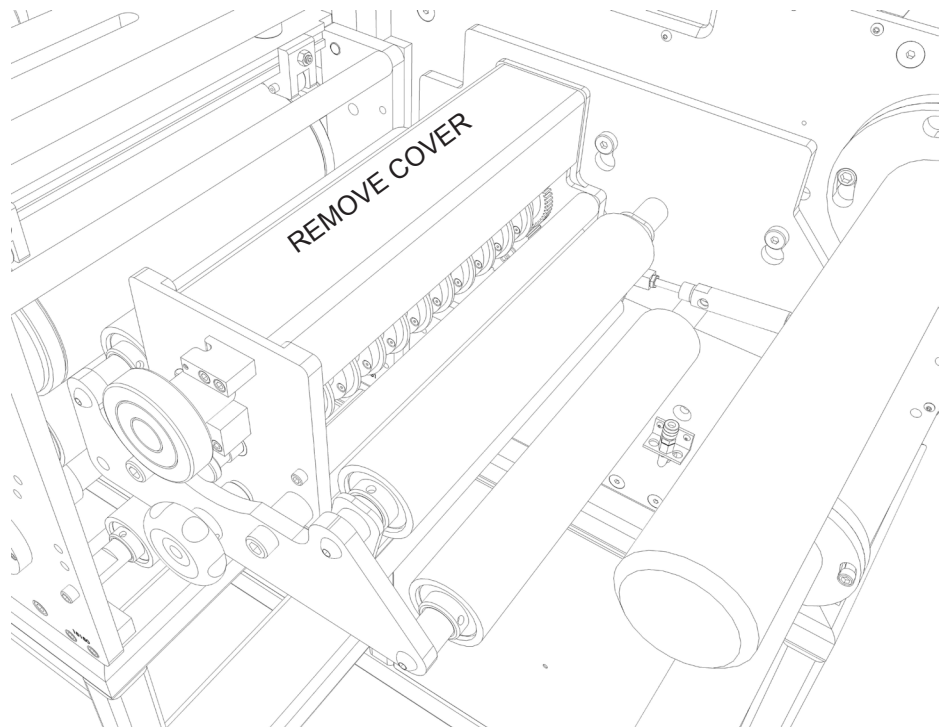
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3-5: ROTARY SHEAR SET-UP

Step 1 Set lower blades for desired Slit-widths and tighten set-screws, making sure upper blades are up and not in lock position.

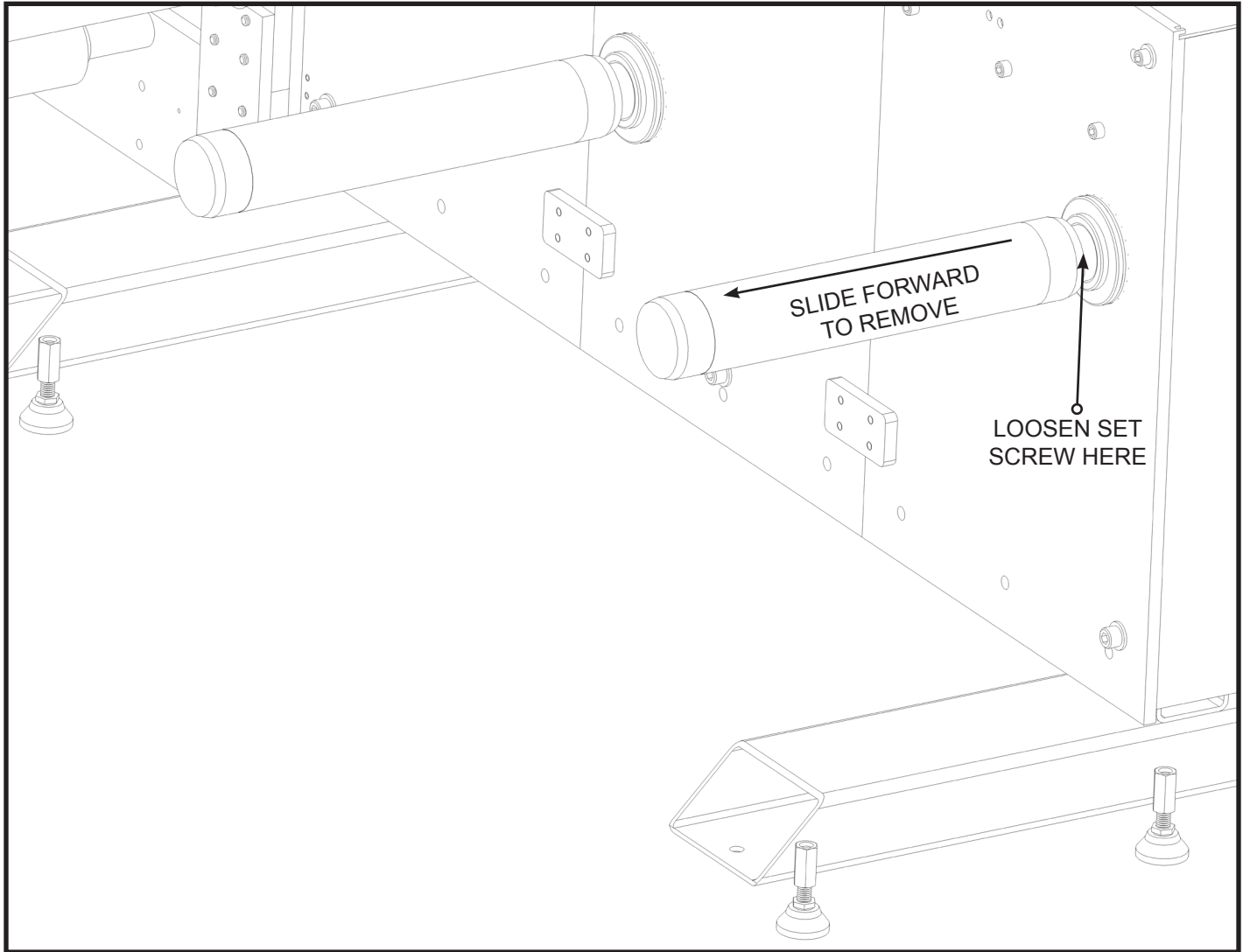
Step 2 Lower upper blade assembly by turning handle counter-clockwise and snap into lock position, making sure that the upper blades are clear of lower blades to avoid blade damage.

Step 3 Gently slide upper blade(s) into cutting position flush against the lower blade(s) by pushing on both sides of the blade to avoid wobble. Hold upper blade against lower blade and tighten set-screw.



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3-6: Changing Rewind Spindle

Your AZTECH web handling unit is equipped with Converttech pneumatically inflatable rewind spindles. These spindles are easily removed by loosening the hex-screw at the machine side and pulling away from machine. To insert new spindle, simply insert spindle into rewind station and tighten hex-screw firmly.

CAUTION: Utilizing Rewind Spindles less than 1.5" in diameter require the use of Outboard Support Apparatus which is NOT included in the standard equipment. Operating the machine without the support apparatus and with spindles less than 1.5" may result in serious injury.



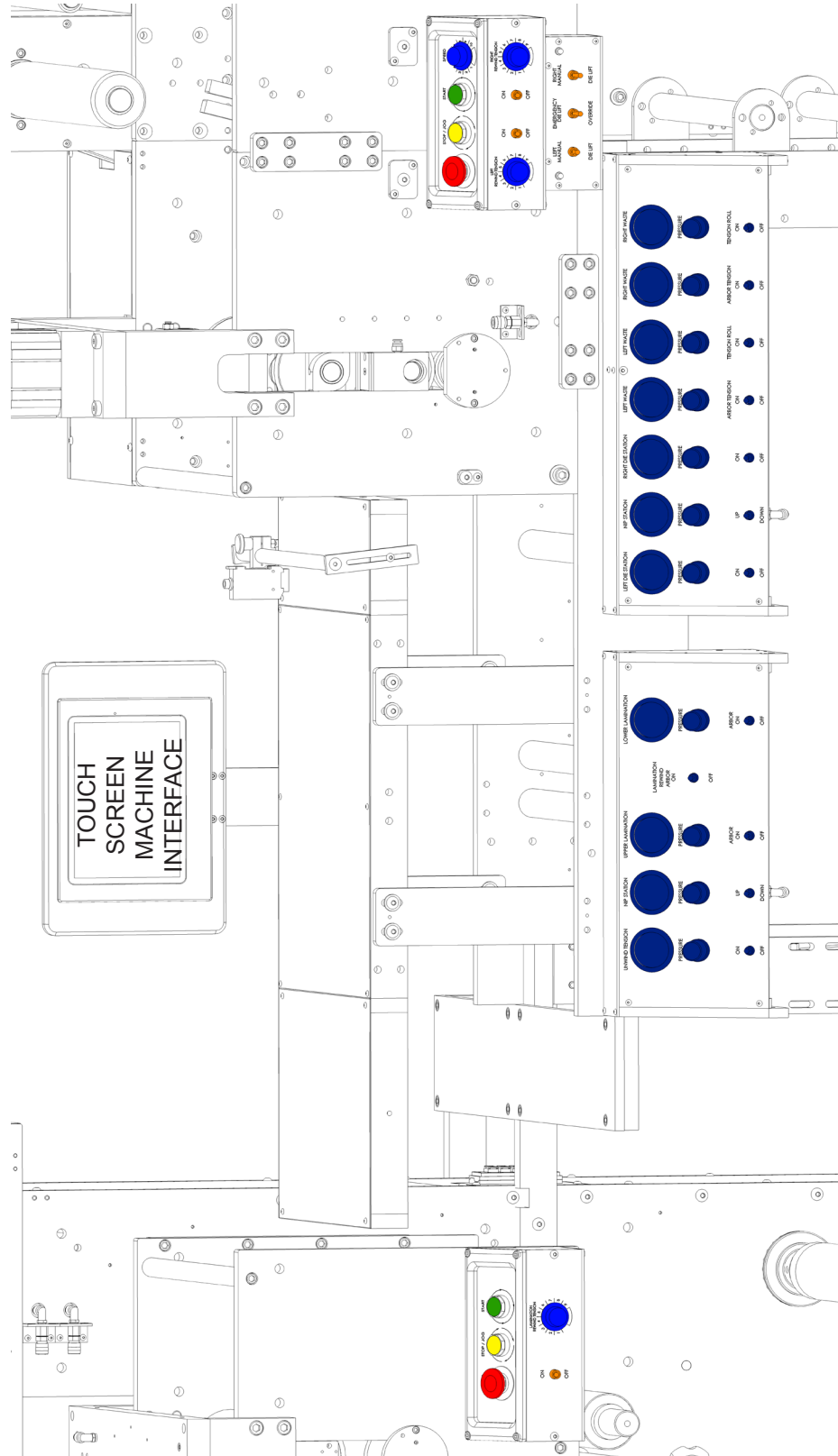
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Section 4: Machine Operation

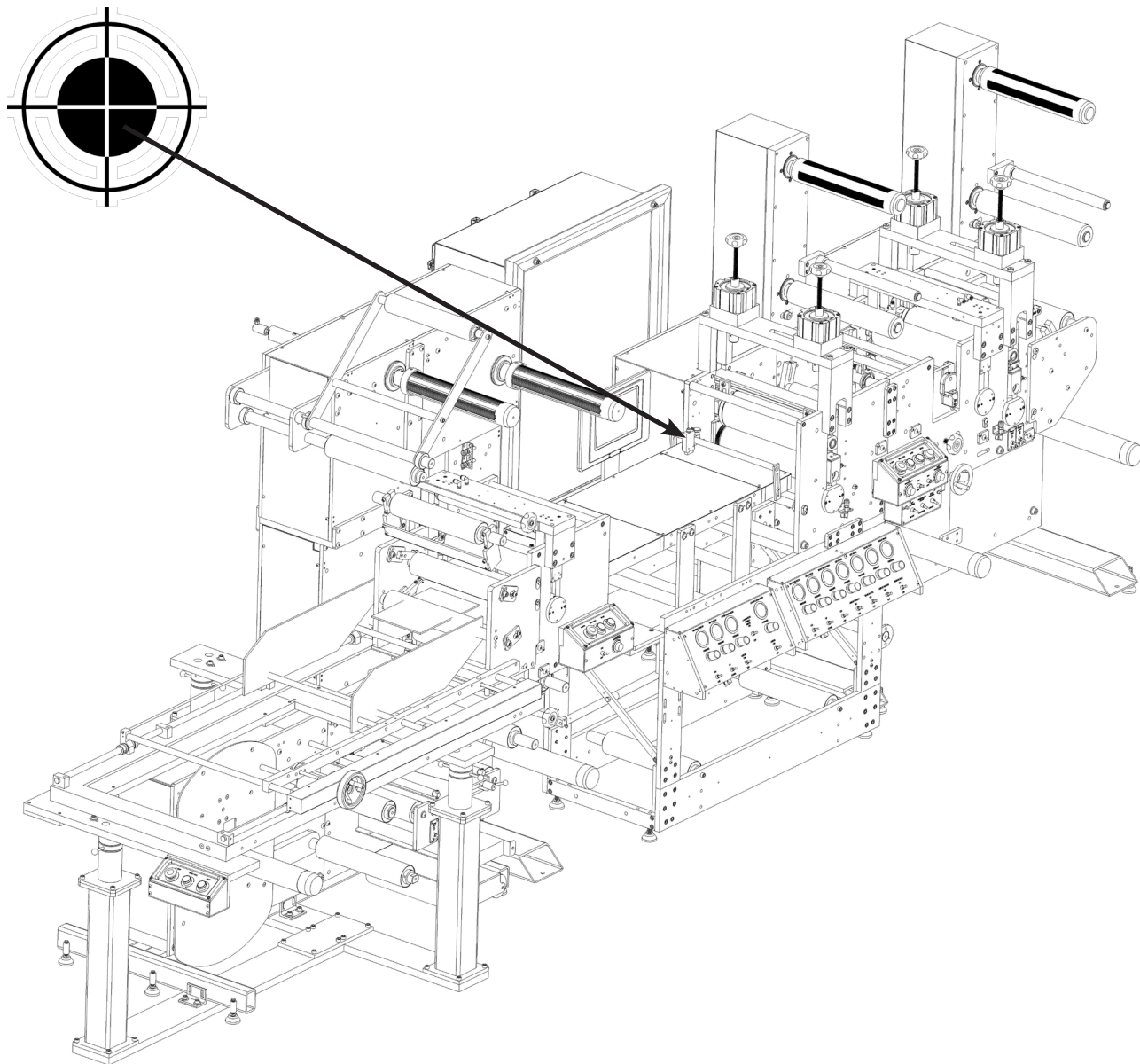
4-1: Operator Control Layout

- START BUTTONS
- ARBOR LOCKS
- STOP/JOG BUTTONS
- E-STOP
- SPEED/TENSION CONTROLS
- PNEUMATIC CONTROLS





4-2: Registration Overview



Your AZTECH web handling system is equipped with a Re-Registration system for precisely controlling web tension as well as web position with relation to the die stations. This allows the machine to be used as an all-in-one converting solution for printing or other registration controlled processes.

The registration system is controlled by an industrial-PC running an HMI program and controlling multiple servo-motor controllers within the electrical control cabinet separate from the main machine.

On power-up the PC boots and displays the AZTECH logo. Once it is finished loading, the MAIN MENU screen will be displayed.



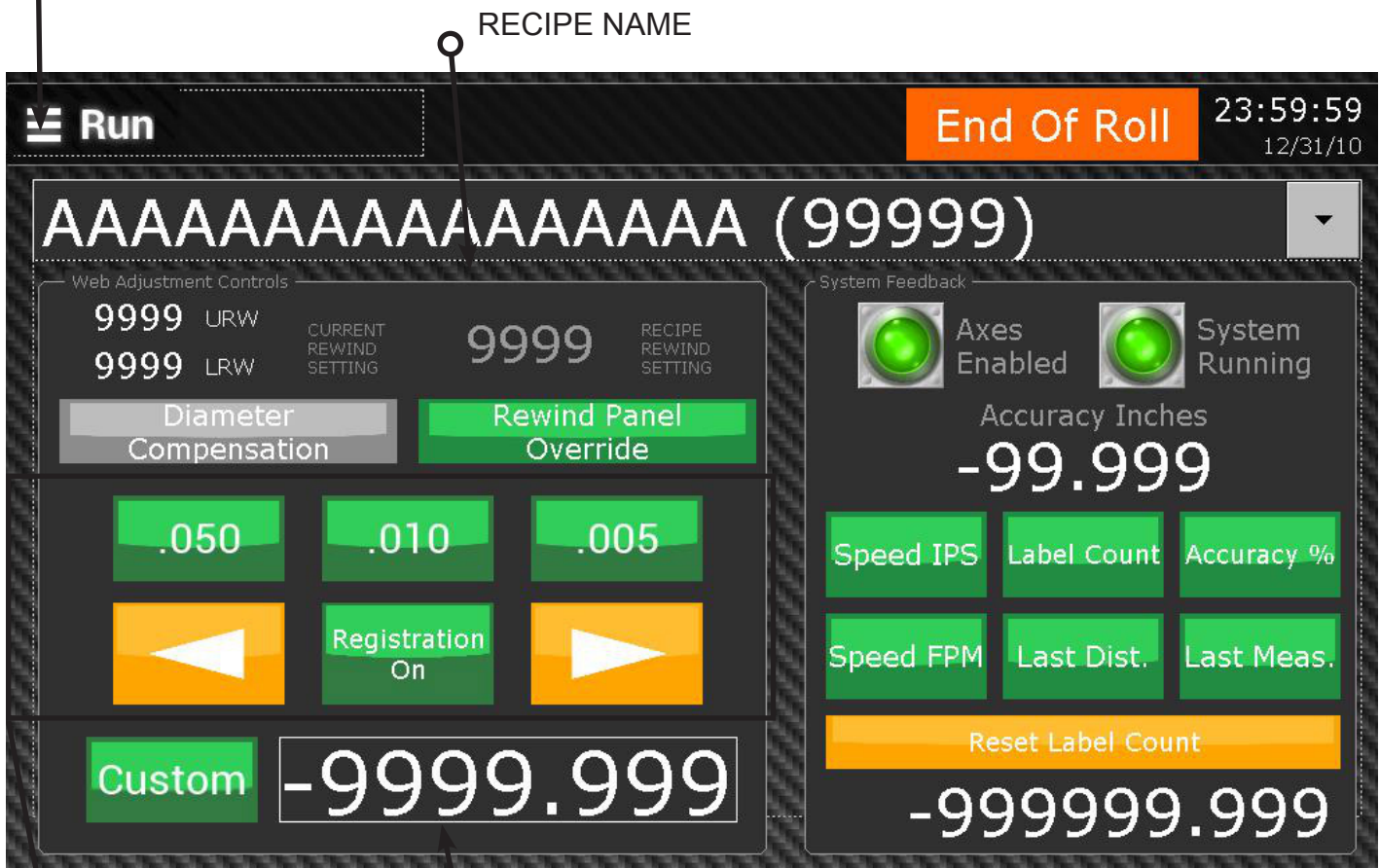
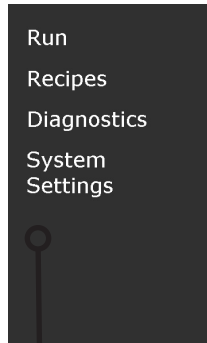
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Run Screen

Setting up a job:

1. Use the RECIPIE NAME selection tool to call up a pre-programmed job
2. Turn the Registration system ON by pressing the Registration ON/OFF button in the lower right section of the screen.
3. Check to see that the machine is clear, the E-Stop is unpressed and there are no warnings present.
4. Press the start button on the operator panel and run the job.
5. Observe the run status by changing the readout units of the number displayed in the lower right corner by pressing the selections directly above the number.

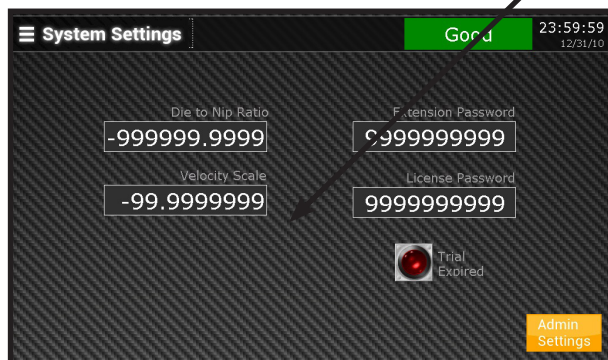
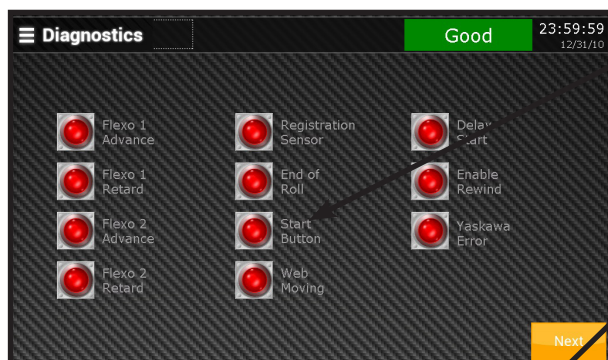
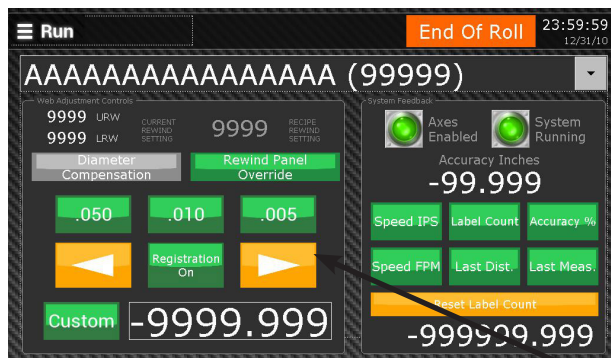


REGISTRATION ENABLE AND MANUAL REPEAT ADJUSTMENT

DIE REPEAT

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The various HMI menu selection prompts will direct you to the different sub-sections of the HMI.



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Recipe Editor

 Recipes

End Of Roll23:59:59
12/31/10

AAAAAAAAAAAAAAAAAAAA (99999)

| | |
|-----------------------------|----------------------|
| Name | AAAAAAAAAAAAAAAAAAAA |
| Die Tooth Qty | -9999 |
| Repeat Qty | -9999 |
| Print Size | -9999999.999 |
| Overdrive | -9999 |
| Accel | -9999 |
| Decel | -9999 |
| Flexo 1 | -9999 |
| Flexo 2 | -9999 |
| Rewind (0-100) | 999 |
| Label Count (-1 to disable) | -999999 |
| Max Error (inches) | -99.999 |
| Finish Diameter (in) | 99 |
| Finish TQ Addition % | 999 |

Save Recipe

Help

Press value to edit values

Press to save changes.

X

Name

Overdrive

Accel

Decel

Die Tooth Qty

Repeat Qty

Print Size

Flexo 1

Flexo 2

Name of recipe

The Help menu provides an explanation of each recipe value.



Help Menu

| | | |
|---------------|-------------|---|
| Name | Rewind | <div>X</div> <p>The % of added torque at the finished diameter.</p> |
| Overdrive | Label Count | |
| Accel | Max Error | |
| Decel | Finish Dia | |
| Die Tooth Qty | Finish TQ + | |
| Repeat Qty | | |
| Print Size | | |
| Flexo 1 | | |
| Flexo 2 | | |

Accel: Scalar value determining the acceleration of a registration correction.

Decel: Scalar value determining the deceleration of a registration correction.

Die Tooth Qty: The number of teeth in the die pattern

Repeat Qty: The number of repeats in the die

Print Size: The distance from mark to mark in inches

Flexo 1: The percent of overdrive on Flexo 1, 0.01%

Flexo 2: The percent of overdrive on Flexo 2, 0.01%



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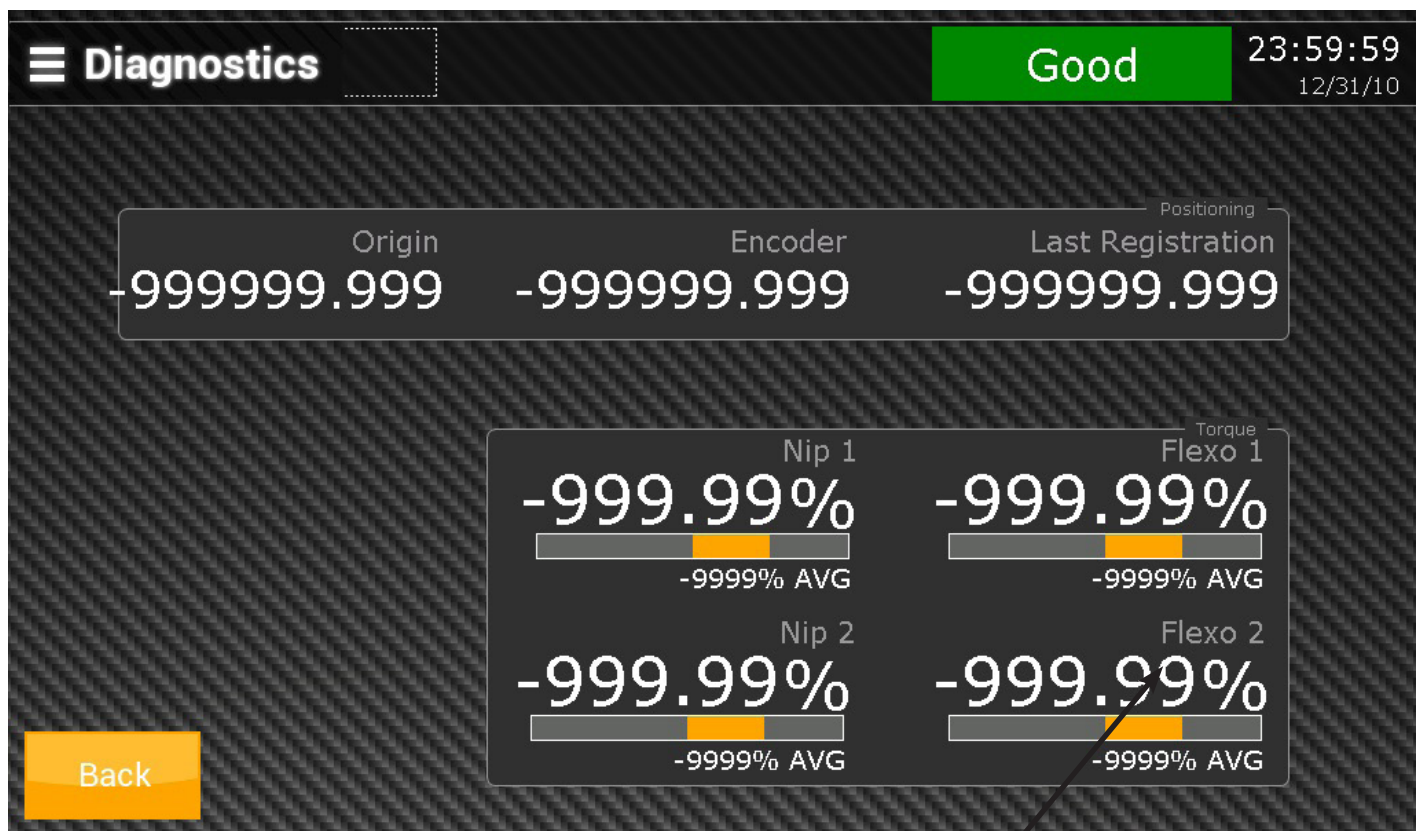
Diagnostics, 1



If an error is generated, the explanation is given here.



Diagnostics, 2



The percent of total output is given here. If regen errors are experienced, they are typically accompanied by high values here. Correct the issue by turning down the overdrive values.



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System Settings

≡ System Settings

Good23:59:59
12/31/10

Die to Nip Ratio

-9999999.9999

Extension Password

999999999999

Velocity Scale

-99.99999999

License Password

999999999999

 Trial Expired

Admin Settings

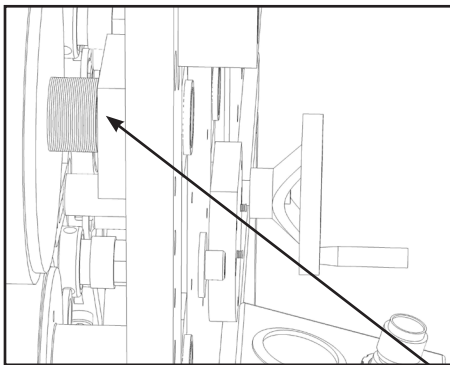
Per terms of delivery, a password is given to license the machine. It is entered here.



4-3: Mounting Rotary Die(s) in Die Station

Recapping the set-up procedures as outlined in Chapter 3, carefully follow the web path diagram in 3.1-2, web the DieMaster, and adjust the web guide if needed (see diagram 3-2).

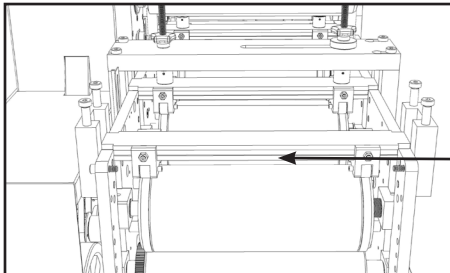
ALWAYS USE CAUTION WHEN HANDLING ROTARY TOOLING AS DAMAGE MAY OCCUR IF MISHANDLED. WHEN LAYING A ROTARY DIE DOWN, ALWAYS MAKE SURE TO SET ON SOFT SURFACE TO HELP AVOID DAMAGE.



To correctly mount a rotary die:

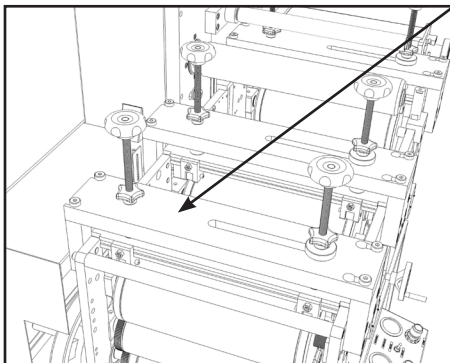
1) Use spacer washer(s) on journal on gear side to assure that the die gear is properly aligned to the anvil roll gear.

2) Slide square bearing block onto gear side journal and slide die into place. If gears are not aligned properly, remove die, and add or remove washers until aligned.



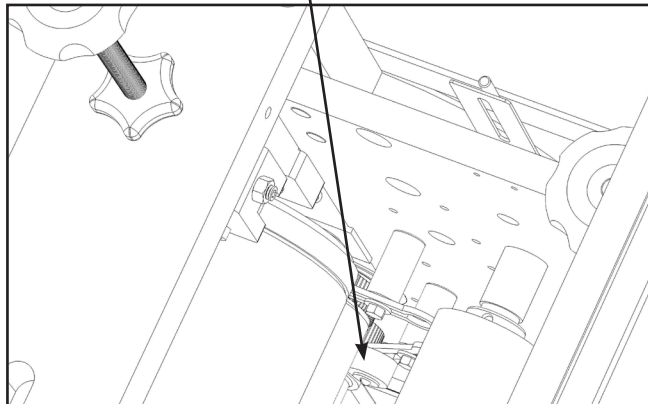
3) Use spacer washer(s) on outboard side, and slide quarter-turn bearing block onto shaft and turn counter-clockwise, making certain that the die is snug and does not slide around.

4) With die in proper position, set die truck onto die making certain the bearings ride against the rotary die bearers.



5) Slide die bridge into place, tighten all 4 hex screws, and turn both assist knobs clockwise until snug. Secure die by turning the lock knobs clockwise until tight.

6) Using the pre-drilled holes near the die station, secure the 4 die wipers against the die bearers and lubricate all 4 with oil to help keep debris away from die.



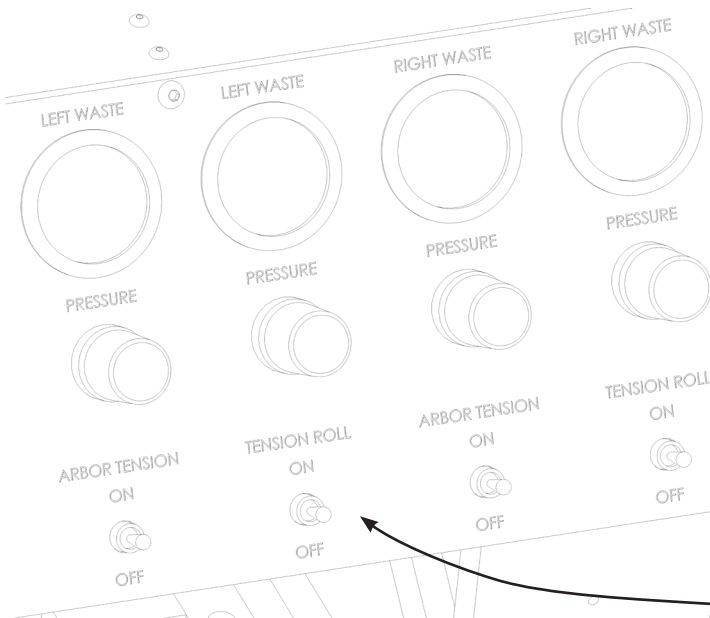


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4-4: Using the Waste-Windup

With die properly positioned, slide a core onto the waste-windup spindle, inflate using the switch and perform the following steps:



1) Jog the machine to briefly begin cutting and then stop.

2) Peel the waste away from the web, using caution by keeping hands away from the die, and hold with one hand while jogging the machine to produce enough length of waste to reach the waste wind-up.

3) Thread the waste by wrapping around the capstan roll, then around the knurled idler roll, before securing to the waste windup spindle.

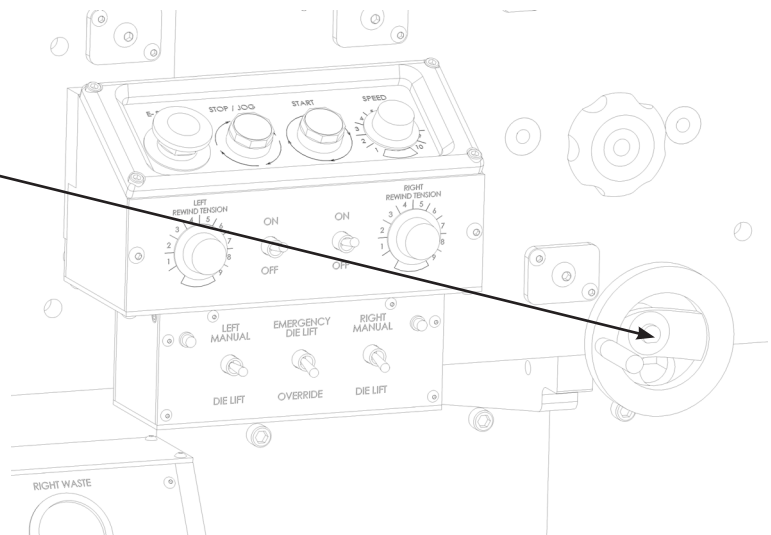
4) Adjust both lower capstan and waste-wind-up spindle tensions using the pneumatic dials.

CAUTION: ALWAYS KEEP HANDS OR LOOSE CLOTHING AWAY FROM THE DIE WHEN THE MACHINE IS IN MOTION TO AVOID THE POTENTIAL FOR SERIOUS PERSONAL INJURY.

4-5: Adjusting the Die Timing

The cranks at the front of the machine may be used to adjust the die timing.

Timing position is shown by the bar and scale are the top rear of the machine.





Chapter 5: Maintenance

The AZTECH web handling unit is rigidly constructed to provide your company many years of reliable productivity, however regular and periodic maintenance is required to keep it running to its full potential and to avoid damage. To assure maximum performance and longevity, the following maintenance is essential:

REGULAR MAINTENANCE:

- Lubricate Die and Anvil Roll bearing blocks by applying oil into holes at the top of the bearing blocks.
- Apply oil to all fiber wiper rolls to keep dies and rollers free of debris.
- Apply heavy viscosity gear grease to all roller gears.
- Apply grease to the die trucks using the (4) fittings and apply oil to the felt pads between the bearings and trucks.
- Clean blades on slitting station.

PERIODIC MAINTENANCE:

- Turn off power and remove back cover to inspect all belts assuring they are tightened sufficiently.
- Clean the web guide sensor to assure that it is free of dust and debris.
- Clean counter sensors inside the machine under the pace roller to assure that they are free of dust and debris.
- Assure that all belts are sufficiently tight and tighten any loose belts.

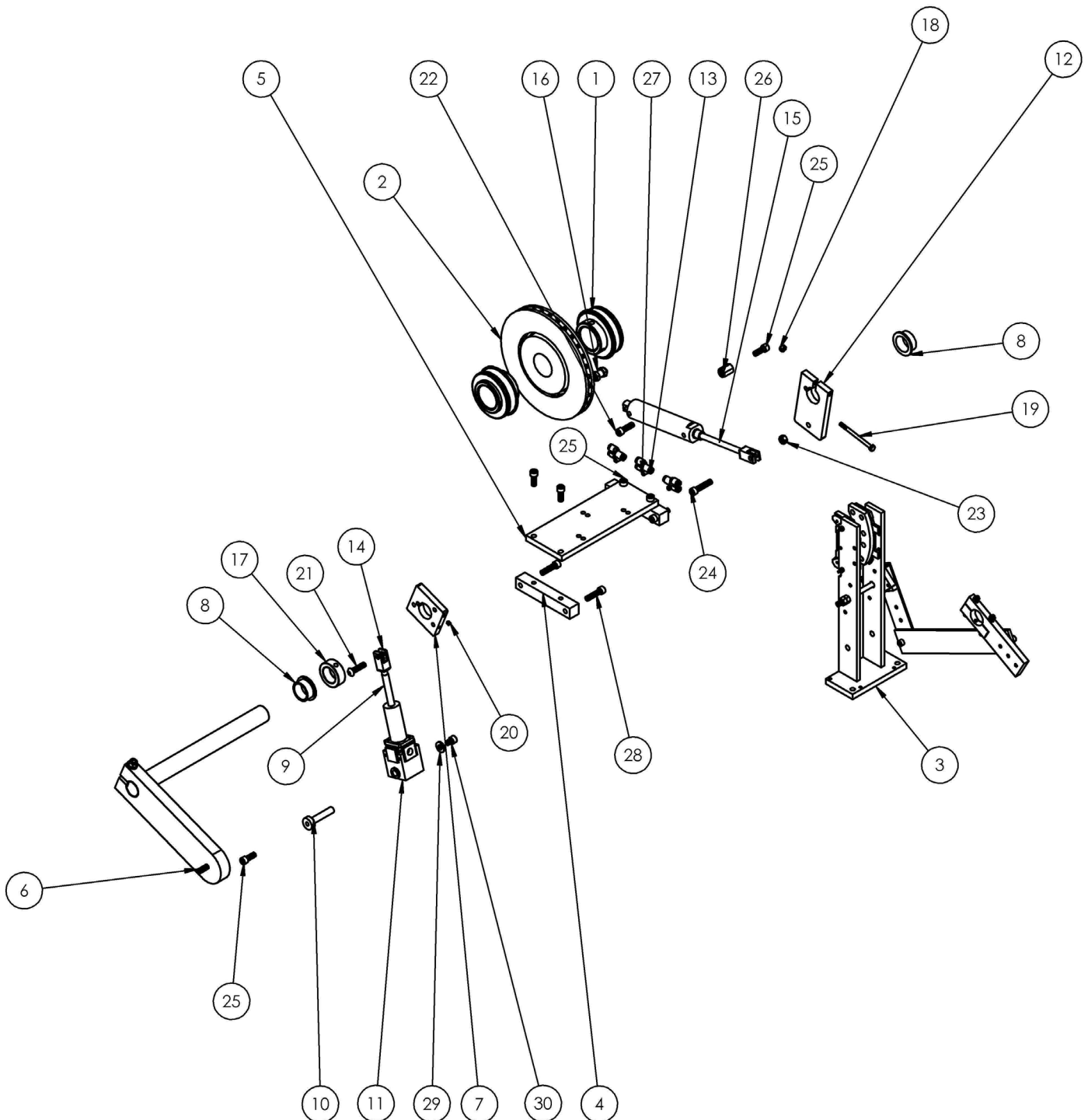


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Chapter 6: Station Detail

UDB Assembly



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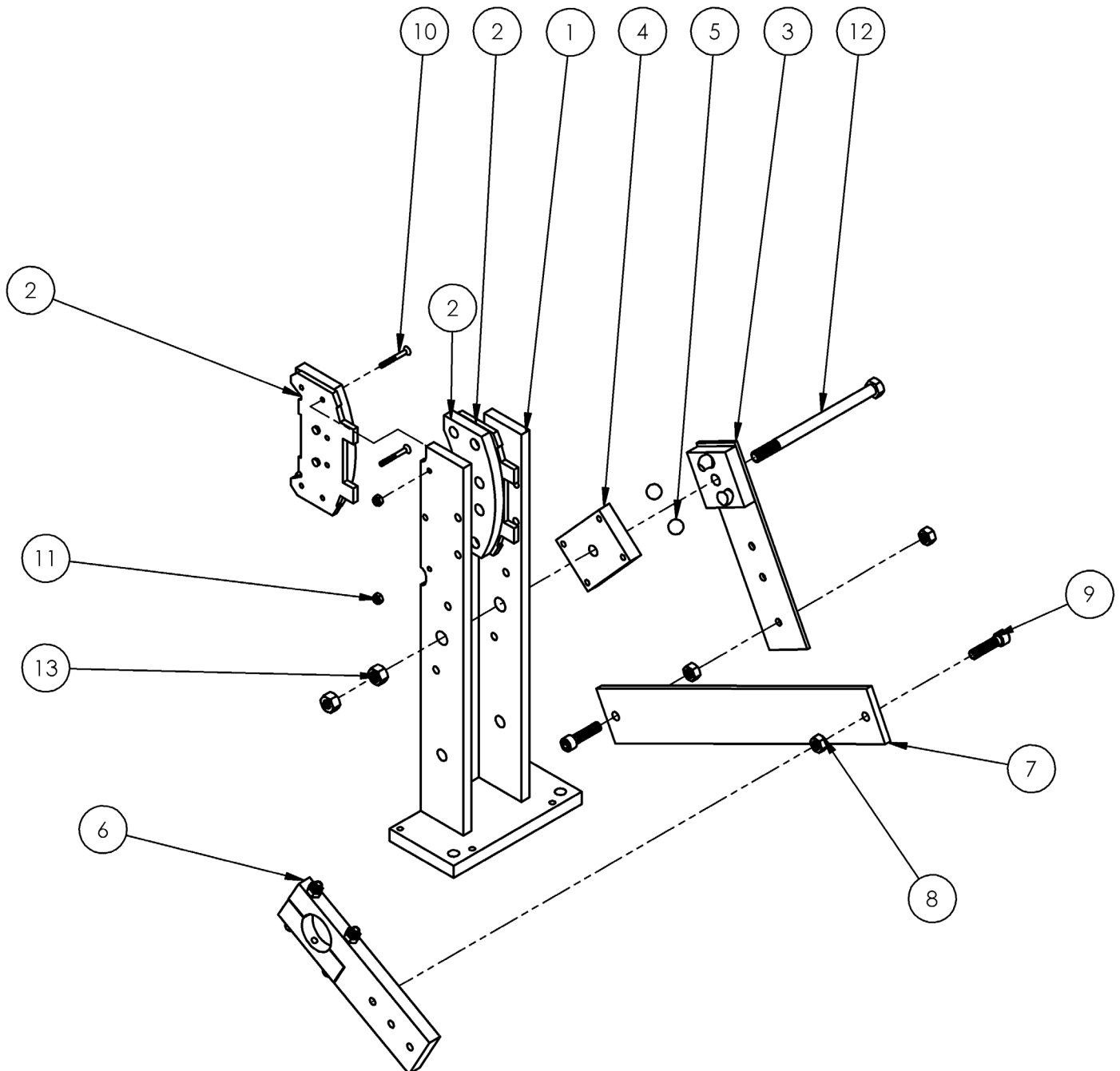
| ITEM NO. | PART NUMBER | DESCRIPTION | INTERNAL VIEW/ QTY. |
|----------|---|--|---------------------|
| 1 | 2.0000er32 | ER-32 BEARING | 2 |
| 2 | 11418 | BRAKE ROTOR ASSEMBLY | 1 |
| 3 | 15928 | UDB2, BRAKE ASSEMBLY | 1 |
| 4 | 16017 | UDB BRAKE SPRT BRACKET FOR BOTTOM PLATE | 2 |
| 5 | 16016 | UDB BRAKE SPRT BOTTOM PLATE | 1 |
| 6 | 10515-C | DANCER ASSEMBLY,ROLL MASTER | 1 |
| 7 | 15884 | REWIND DIE CUTTER DANCER PIVOT AIR LOCK ARM | 1 |
| 8 | 1-38 flanged oilite | KAMFF1618 | 2 |
| 9 | 15389 | AR25-N02H-Z PRESSURE ROD | 1 |
| 10 | 15885 | REWIND DIE CUTTER BRAKE REGULATOR PIVOT SPRT | 1 |
| 11 | 15386 | BSR BRAKE REGULATOR ASSEMBLY AR25 | 1 |
| 12 | 15889 | INSPECTION REWINDER, DANCER PIVOT ARM | 1 |
| 13 | KQ2U07-00 | NAME | 3 |
| 14 | NY-125 | ROD CLEVIS 3/8" CROSS HOLE 7/16-20 END THREAD | 1 |
| 15 | NCMC150-0400 | AIR CYLINDER | 1 |
| 16 | BULK HEAD FITTING 1-4 TO 1-4 ONE TOUCH ASSEMBLY | 1/4 TO 1/4 ONE TOUCH BLK HD FITTING | 1 |
| 17 | 1-3EIGHTS COLLAR | 1-3/8 SET COLLARS | 1 |
| 18 | HEX NUT_.250-20 UNC_0_LOCK | HEX NUT NYLOCK 1/4-20 | 1 |
| 19 | HEX BOLT_~250-20 UNC_3~5_SIMP | HEX BOLT 1/4-20 X 3-1/2" | 1 |
| 20 | SSCR-HEX-CUP_.250-20 UNC_0.25_SIMP | SSCR 1/4-20 X 1/4 | 1 |
| 21 | BTNHD_~375-16 UNC_1~5_SIMP | BUTTON HEAD CAP SCREW 3/8-16 X 1-1/2 | 1 |
| 22 | SCH_~375-16 UNC_1~25_SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1-1/4" | 1 |
| 23 | HEX NUT_.375-16 UNC_0_SIMP | HEX NUT 3/8-16 | 1 |
| 24 | SCH_~375-16 UNC_1~75_SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1-3/4" | 1 |
| 25 | SCH_~375-16 UNC_1_SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1" | 6 |
| 26 | 91034A110 | 11/16 HEX DIA X 1" LONG, 3/8-16 THREADED THRU | 1 |
| 27 | BTNHD_~164-32 UNC_1_SIMP | BUTTON HEAD CAP SCREW GRADE 5, 8-32 X 1" | 3 |
| 28 | SCH_~375-16 UNC_1~5_SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1-1/2" | 4 |
| 29 | WSHR A_.375 HARD | 3/8" HARD WASHER | 1 |
| 30 | SCH_~375-16 UNC_0~5_SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1/2" | 1 |



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UDB Brake Detail



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| ITEM NO. | PART NUMBER | DESCRIPTION | UNLOCKED UDB/QTY. |
|----------|--------------------------------------|---|----------------------|
| 1 | 12043 | BRAKE ASSEMBLY PLATE MOUNT | 1 |
| 2 | brake pad MOVABLE | DISC BRAKE PAD | 2 |
| 3 | 11823 | BRAKE PIVOT ARM ASSEMBLY,BSR,SR,DM | 1 |
| 4 | 11818 | BRAKE RAMP PLATE,FIXED,BSR, SR, RM | 1 |
| 5 | 1_2 BALL | MCMMASTER-CARR# 96455K56 | 2 |
| 6 | 11813 | CAM BRAKE MASTER ARM PIVOT | 1 |
| 7 | 15929 | UDB2, BRAKE TRANSFER LINK | 1 |
| 8 | HEX NUT_~3125-18 UNC_SIMP | HEX NUT 5-16-18 | 3 |
| 9 | SCH_~3125-18 UNC_1~25_SIMP | SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4" | 2 |
| 10 | FLH-SCH-82_~138- 32 UNC_1~25_SIMP | FLAT HEAD CAP SCREW 6-32 X 1-1/4" | 4 |
| 11 | HEX NUT 6-32 LOCK | HEX NUT 6-32 NYLOCK | 4 |
| 12 | HEX BOLT_~375-16 UNC_5~5_SIMP | HEX BOLT GRADE 5, 3/8-16 X 5.5" | 1 |
| 13 | HEX NUT_~375-16 UNC_0_SIMP | HEX NUT 3/8-16 | 2 |

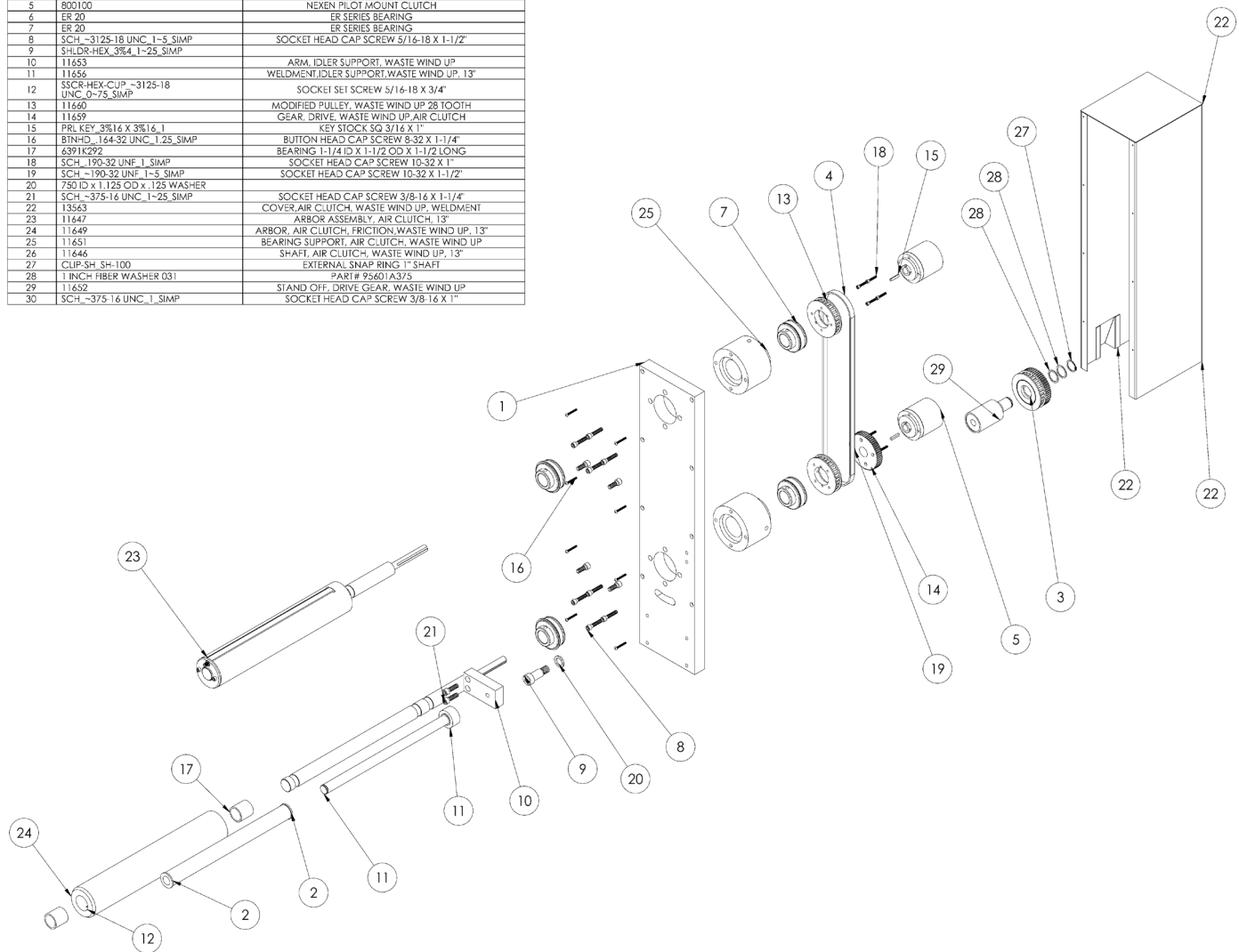


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Waste Windup Assembly

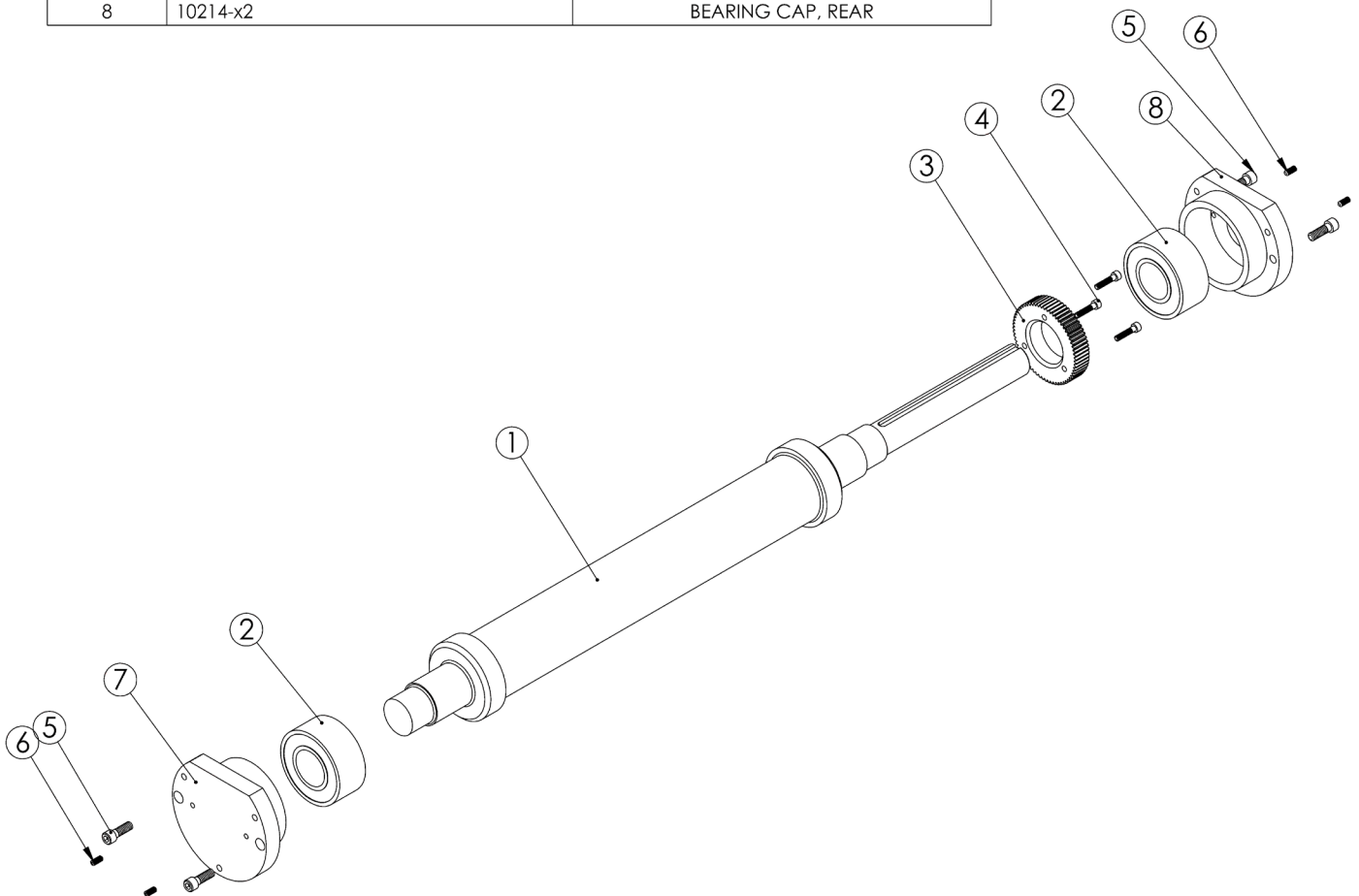
| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|--|---|
| 1 | 11645 | MOUNTING PLATE, WASTE WIND UP, 13", AIR CLUTCH |
| 2 | 10309 | WASTE SMALL IDLER ASSEMBLY, 13" |
| 3 | 11758 | WASTE IDLE GEAR ASSEMBLY, AIR CLUTCH |
| 4 | 21592 | BELT, 45", 3/8" PITCH, 1/2" WIDE |
| 5 | 800100 | NEXEN PILOT MOUNT CLUTCH |
| 6 | ER 20 | ER SERIES BEARING |
| 7 | ER 20 | ER SERIES BEARING |
| 8 | SCH -3125-18 UNC, 1-5, SIMP | SOCKET HEAD CAP SCREW 5/16-18 X 1-1/2" |
| 9 | SHILDR-HEX, 3/4, 1-25, SIMP | |
| 10 | 11653 | ARM, IDLER SUPPORT, WASTE WIND UP |
| 11 | 11656 | WELDMENT, IDLER SUPPORT, WASTE WIND UP, 13" |
| 12 | SSCR-HEX-CUP, -3125-18 UNC, 0-75, SIMP | SOCKET SET SCREW 5/16-18 X 3/4" |
| 13 | 11660 | MODIFIED PULLEY, WASTE WIND UP 28 TOOTH |
| 14 | 11659 | GEAR, DRIVE, WASTE WIND UP, AIR CLUTCH |
| 15 | PRL KEY, 3/16 X 3/16 X 1" | KEY STOCK SQ 3/16 X 1" |
| 16 | BTNHD, 164-32 UNC, 1.25, SIMP | BUTTON HEAD CAP SCREW 8-32 X 1-1/4" |
| 17 | 6391K292 | BEARING 1-1/4 ID X 1-1/2 OD X 1-1/2 LONG |
| 18 | SCH, 190-32 UNF, 1, SIMP | SOCKET HEAD CAP SCREW 10-32 X 1" |
| 19 | SCH, 190-32 UNF, 1-5, SIMP | SOCKET HEAD CAP SCREW 10-32 X 1-1/2" |
| 20 | 750 ID X 1.125 OD X .125 WASHER | |
| 21 | SCH, 375-16 UNC, 1-25, SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1-1/4" |
| 22 | 11563 | COVER, AIR CLUTCH, WASTE WIND UP, WELDMENT |
| 23 | 11647 | ARBOR ASSEMBLY, AIR CLUTCH, 13" |
| 24 | 11649 | ARBOR, AIR CLUTCH, FRICTION, WASTE WIND UP, 13" |
| 25 | 11651 | BEARING SUPPORT, AIR CLUTCH, WASTE WIND UP |
| 26 | 11646 | SHAFT, AIR CLUTCH, WASTE WIND UP, 13" |
| 27 | CLIP-SH, SH-100 | EXTERNAL SNAP RING 1" SHAFT |
| 28 | 1 INCH FIBER WASHER 031 | PART# 95601A375 |
| 29 | 11652 | STAND OFF, DRIVE GEAR, WASTE WIND UP |
| 30 | SCH, 375-16 UNC, 1, SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1" |





Rotary Die Station: Support Roll Assembly

| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|-------------------------------------|--|
| 1 | 10203-x3 | LOWER SUPPORT ROLL, 13" |
| 2 | 5206A2RS1 | BEARING |
| 3 | 10054-x3 | GEAR, 64 TOOTH, 1/8" PITCH |
| 4 | SCH_.164-32 UNC_0.75_SIMP | SOCKET HEAD CAP SCREW 8-32 X 3/4" |
| 5 | SCH_.250-20 UNC_0.75_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 3/4" |
| 6 | SSCR-HEX-CUP_.164-32 UNC_0.375_SIMP | SOCKET SET SCREW CUP POINT 8-32 X 3/8" |
| 7 | 10213x2 | BEARING CAP, FRONT |
| 8 | 10214-x2 | BEARING CAP, REAR |



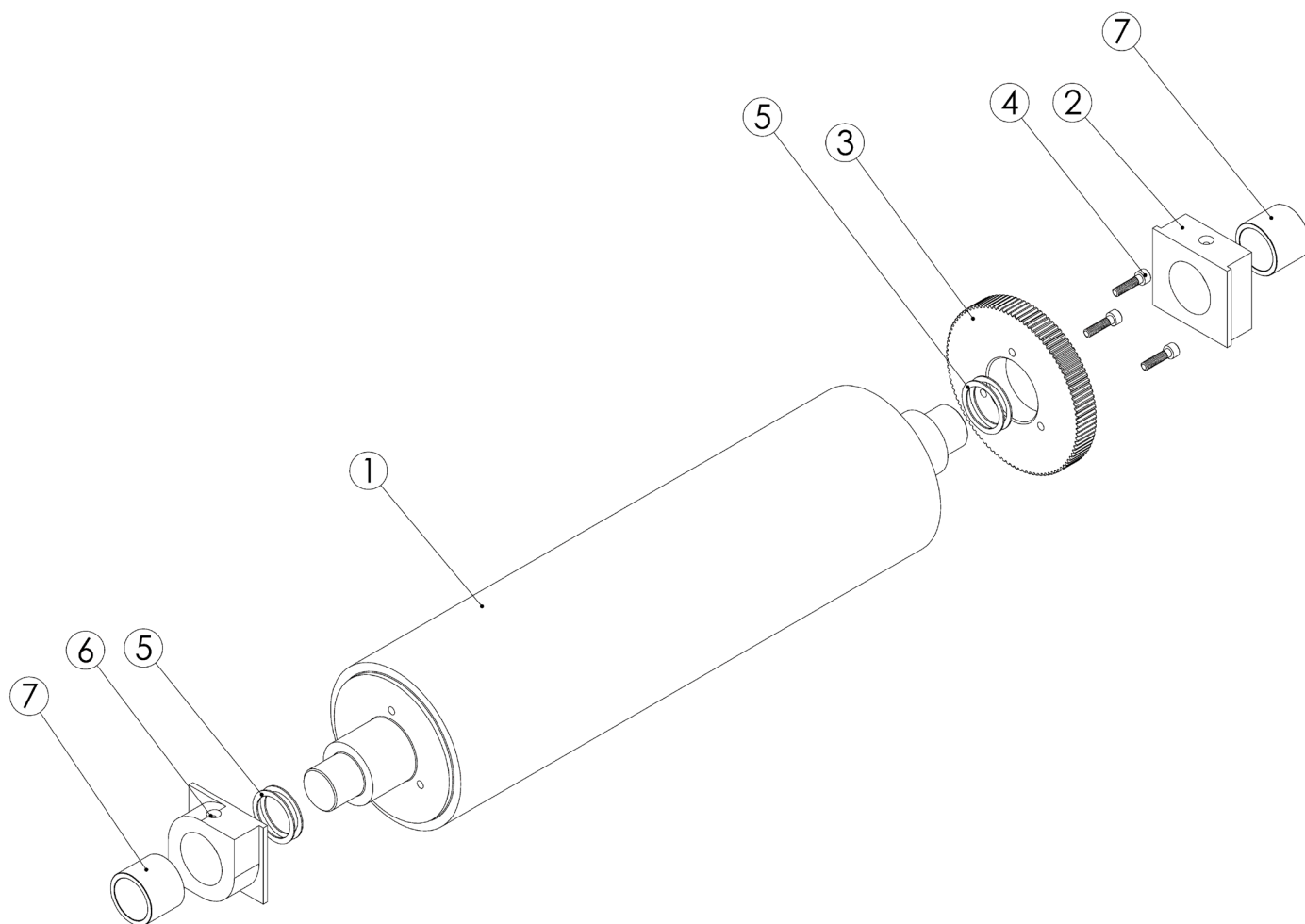


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Rotary Die Station: Anvil Roll Assembly

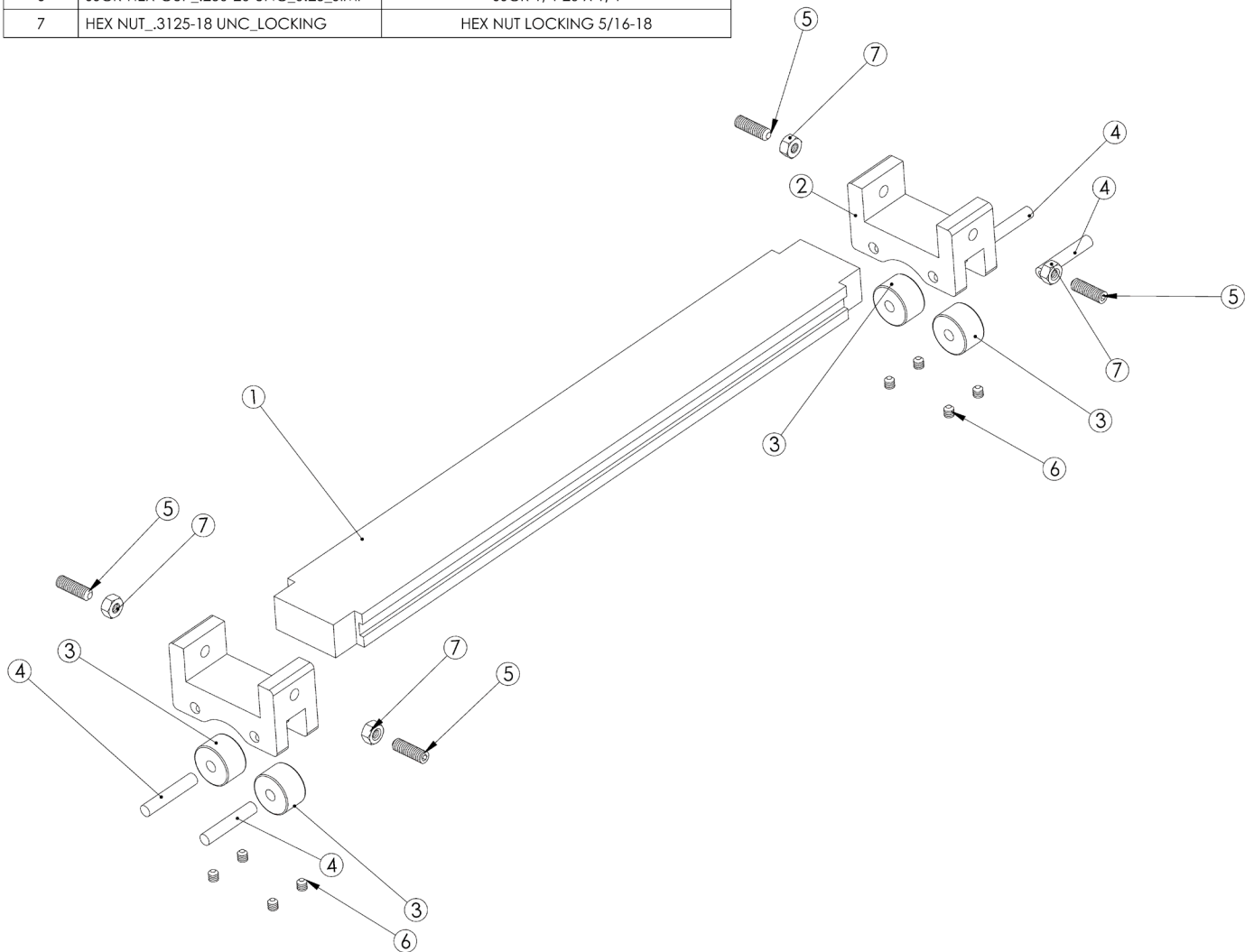
| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|---------------------------|--------------------------------------|
| 1 | 10208-x4 | ANVIL ROLL, DIE MASTER, 13" |
| 2 | 10396 | GIBB BLOCK, SQUARE, 2" |
| 3 | 10191 | GEAR, 99 TOOTH, 1/8" PITCH |
| 4 | SCH_.190-32 UNF_0.75_SIMP | SOCKET HEAD CAP SCREW 10-32 X 3/4" |
| 5 | 95601A420 | WASHER, HARD FIBER, 1" ID .031 THICK |
| 6 | 10397 | GIBB BLOCK, RIGHT TWIST, THIN, 2" |
| 7 | 7965K34 | 1" ID, 1 1/4" OD X 1" LG. BEARING |





Rotary Die Station: Die Truck Assembly

| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|------------------------------------|---|
| 1 | 10272 | CAM FOLLOWER MAIN BRIDGE, 13" |
| 2 | 10028 | CAM FOLLOWER SUPPORT BRIDGE |
| 3 | Y-36-S | BEARING |
| 4 | 10735 | PIN,TRUCK, DIE CUTTER |
| 5 | SSCR-HEX-CUP_.3125-18 UNC_1_SIMP | SOCKET SET SCREW CUP POINT 5/16-18 X 1" |
| 6 | SSCR-HEX-CUP_.250-20 UNC_0.25_SIMP | SSCR 1/4-20 X 1/4 |
| 7 | HEX NUT_.3125-18 UNC_LOCKING | HEX NUT LOCKING 5/16-18 |



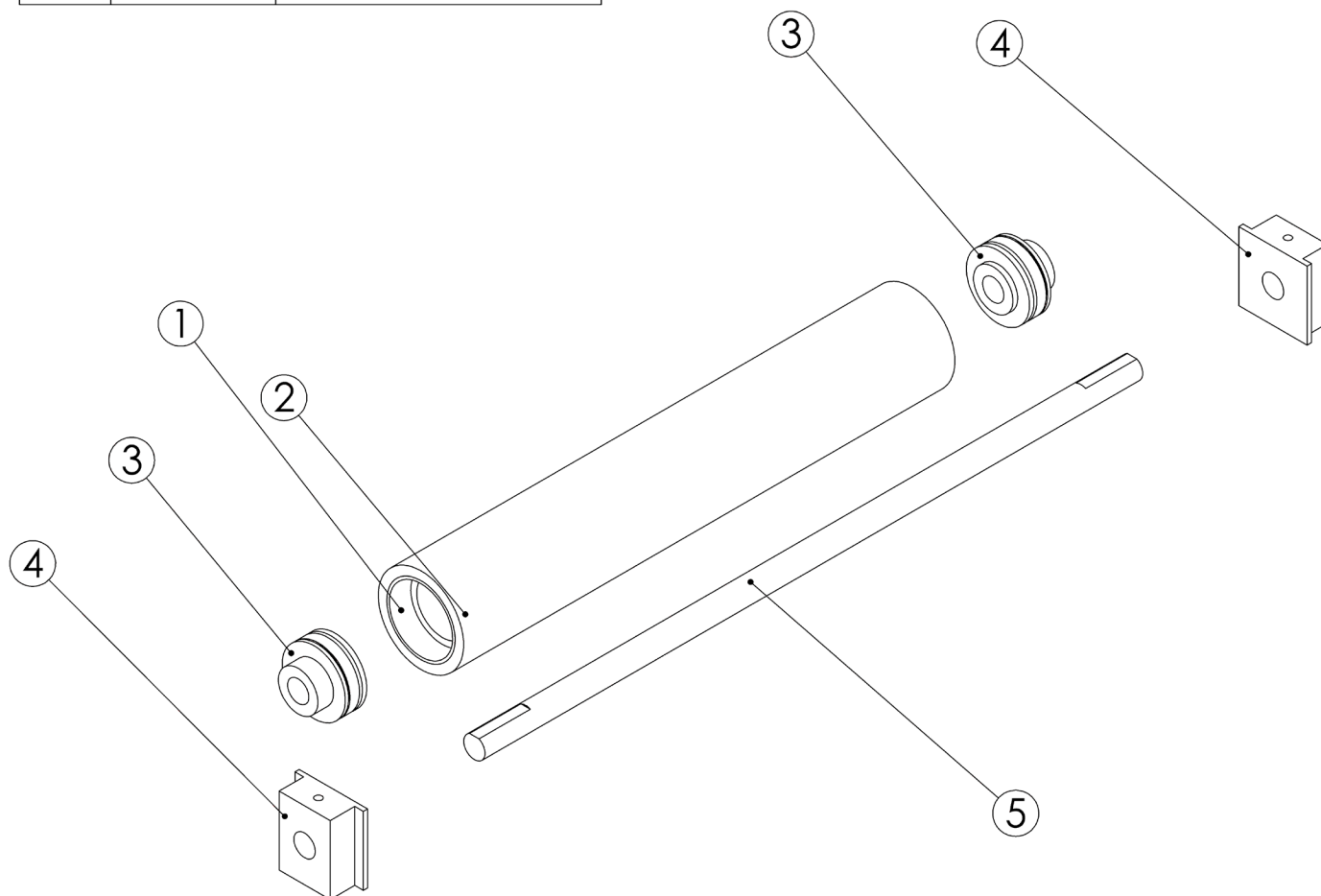


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Main Drive: Nip Roll Assembly

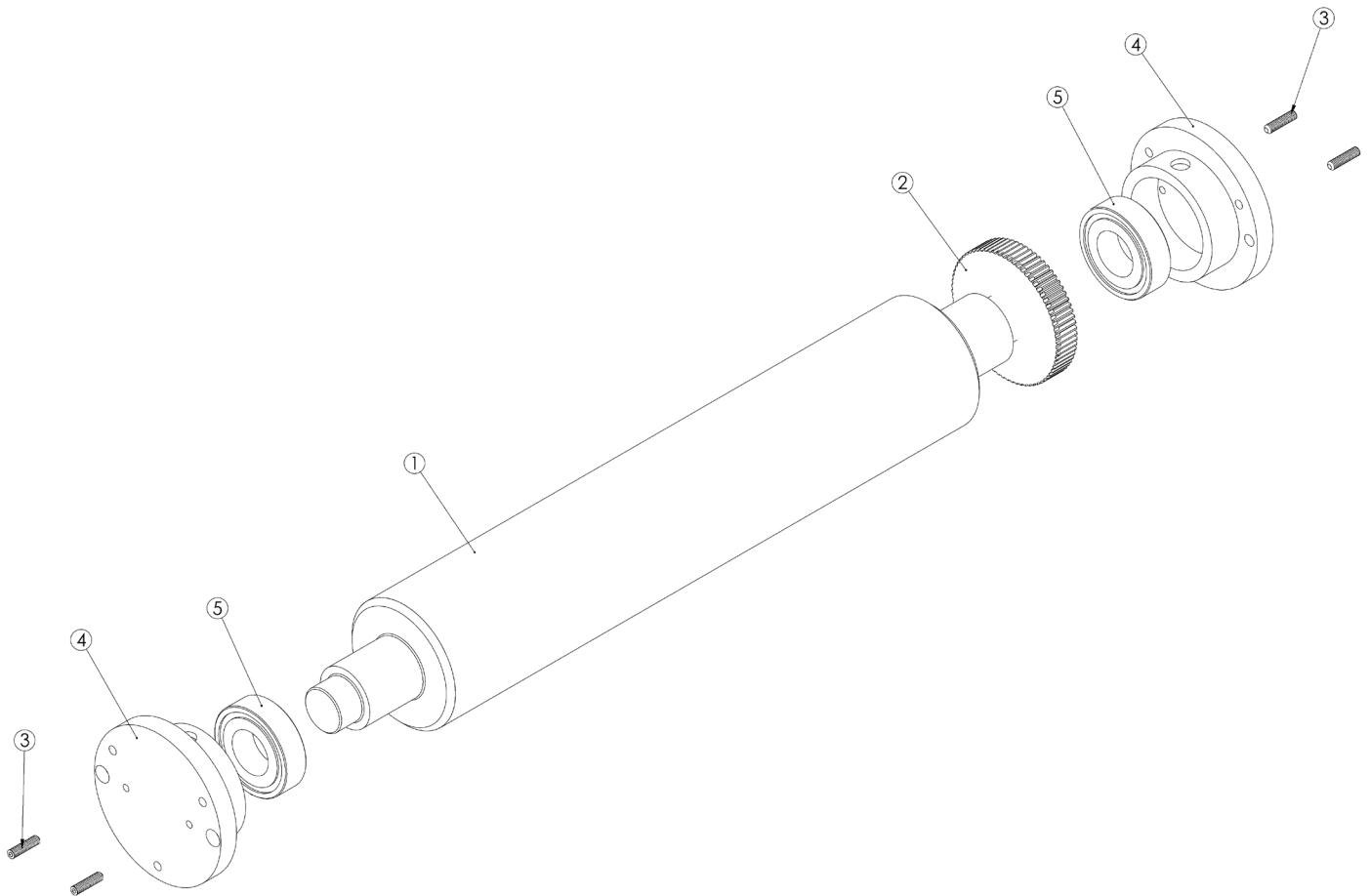
| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|-------------|----------------------------------|
| 1 | 10219 | NIP ROLLER, 13" WEB |
| 2 | NIP RUBBER | RUBBER COATING 65 SHORE D |
| 3 | ER10 | BEARING |
| 4 | 10019 | GIBB BLOCK, NIP ROLL |
| 5 | 10220 | SUPPORT SHAFT, NIP ROLL, 13" WEB |





Main Drive: Pace Roll Assembly

| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|-----------------------------------|--|
| 1 | 10217 | PACE ROLLER, 13" WEB |
| 2 | 10155 | GEAR, 72 TOOTH, 1/8" PITCH |
| 3 | SSCR-HEX-CUP_190-32 UNF_0.75_SIMP | SOCKET SET SCREW 10-32 X 3/4" |
| 4 | 11046 | BEARING CAP, PACE ROLLER, REREGISTRATION |
| 5 | 1641 | 1" ID X 2" OD X .563 WIDE BEARING |



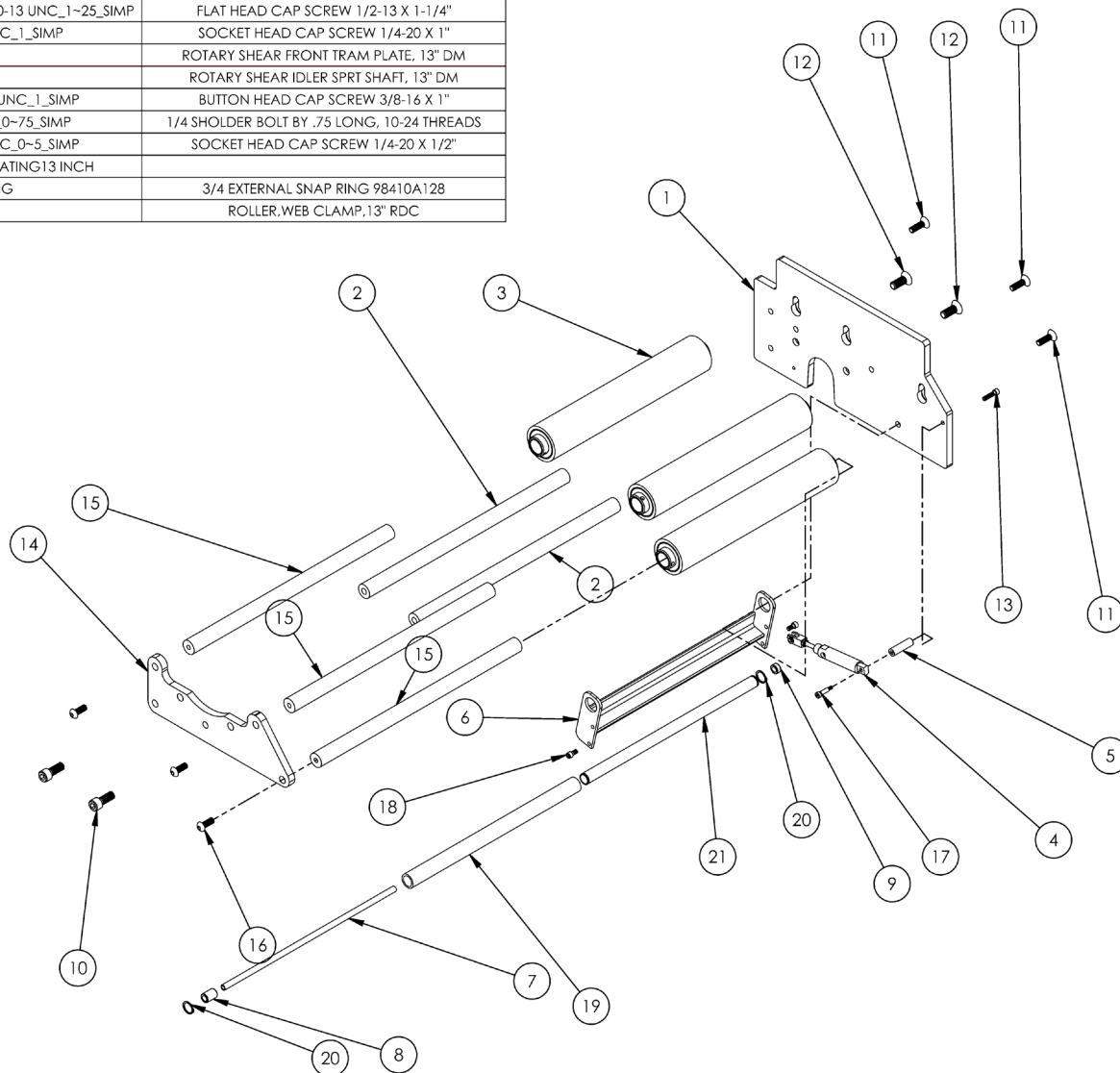


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Slitting Station: Main Assembly

| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|----------------------------------|---|
| 1 | 10284 | PLATE, SLITTER, REAR FRAME MOUNT |
| 2 | 10289 | SLITTER STANDOFF, 13" |
| 3 | 10205 | IDLER ASSEMBLY, 1" BORE, 13" |
| 4 | NCMC075-0100T | 3/4 BORE X 1" STROKE, SPRING EXTEND |
| 5 | 10428 | SPACER, CYLINDER, WEB CLAMP |
| 6 | 10302 | FRAME ASSEMBLY, ONE WAY BRAKE, 13" RDC |
| 7 | 10464 | SHAFT, WEB CLAMP, 13" RDC |
| 8 | RCB-061014 | TORINGTON 1 WAY CLUTCH BEARING |
| 9 | J-65 | TORINGTON NEEDLE BEARING |
| 10 | SCH_-500-13 UNC_1~25_SIMP | |
| 11 | FLH-SCH-82_-375-16 UNC_1~25_SIMP | |
| 12 | FLH-SCH-82_-500-13 UNC_1~25_SIMP | FLAT HEAD CAP SCREW 1/2-13 X 1-1/4" |
| 13 | SCH_-250-20 UNC_1_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1" |
| 14 | 13382 | ROTARY SHEAR FRONT TRAM PLATE, 13" DM |
| 15 | 13383 | ROTARY SHEAR IDLER SPRT SHAFT, 13" DM |
| 16 | BTNHD_-375-16 UNC_1_SIMP | BUTTON HEAD CAP SCREW 3/8-16 X 1" |
| 17 | SHLDR-HEX_1%4_0~75_SIMP | 1/4 SHOLDER BOLT BY .75 LONG, 10-24 THREADS |
| 18 | SCH_-250-20 UNC_0~5_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1/2" |
| 19 | WEB CLAMP COATING13 INCH | |
| 20 | 3-4 EXT SNAP RING | 3/4 EXTERNAL SNAP RING 98410A128 |
| 21 | 10465 | ROLLER.WEB CLAMP, 13" RDC |



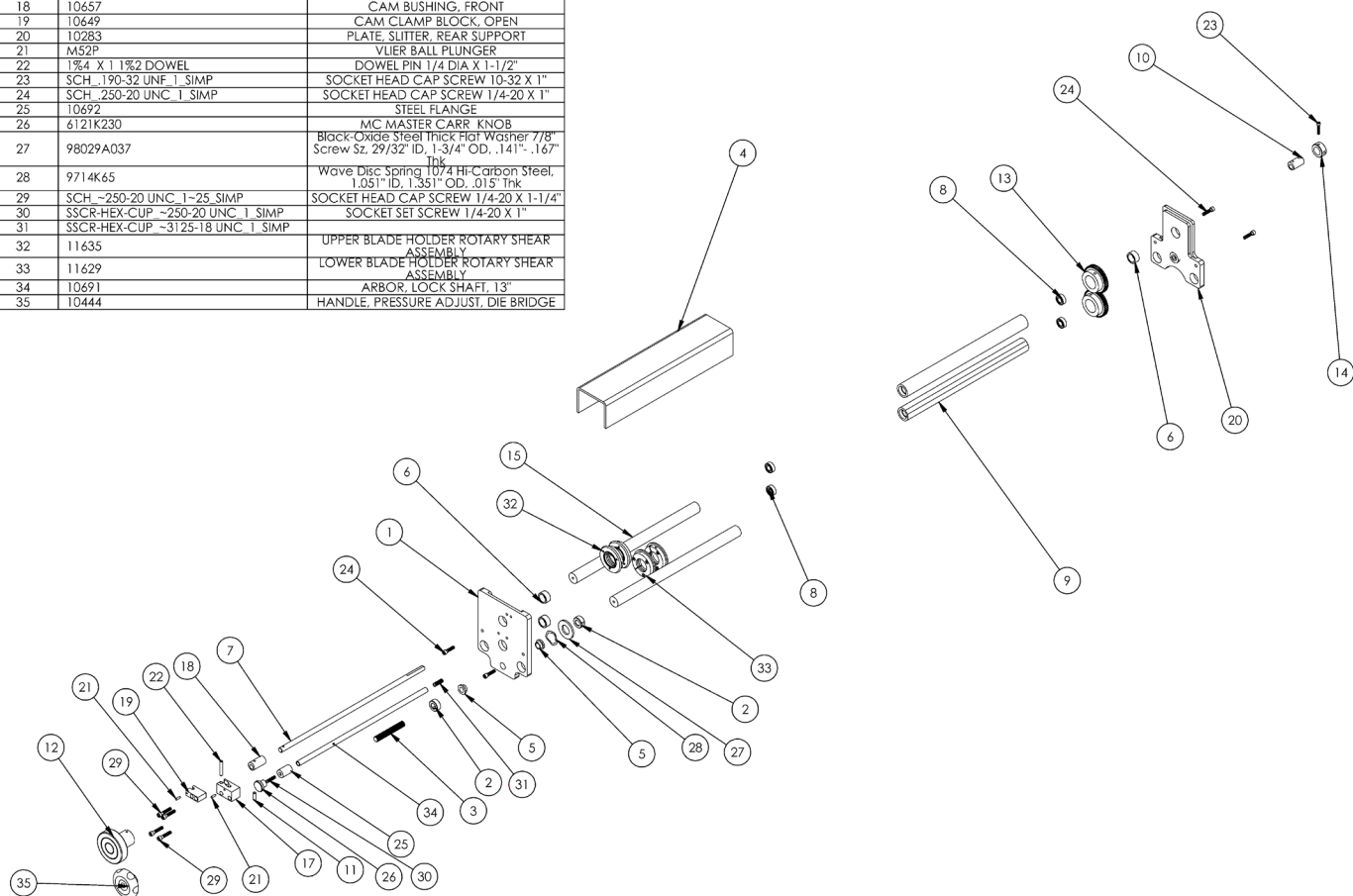
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BIRR-40XX USER MANUAL



Slitting Station: Rotary Shear Assembly

| ITEM NO. | PART NUMBER | DESCRIPTION |
|----------|-----------------------------------|--|
| 1 | 10285 | PLATE, SLITTER, FRONT MOUNT |
| 2 | 10373 | 1/2" SET COLLAR |
| 3 | 10832 | SHAFT, LATERAL ADJUSTMENT |
| 4 | 10373 | COVER, SLITTER, 13" |
| 5 | 6338K417 | 1/2 ID X 5/8 OD X 1/4 L 1/8 FLANGE |
| 6 | 6391K262 | 3/4 ID X 1" OD X 1/2 LONG SAE 841 |
| 7 | 10656 | V-GROOVED CAM SHAFT, 13" |
| 8 | 1607 | BEARING 7/16 ID X .906 OD |
| 9 | 10653 | ROTARY SHEAR SHAFT, 13" |
| 10 | 10659 | CAM BUSHING, REAR |
| 11 | 1" x 3/4" long dowel | DOWEL PIN 1/4 DIA X 3/4" LONG |
| 12 | 10658 | ROTARY SHEAR, CAM CRANK HANDLE |
| 13 | 10654 | S2050 SPUR GEAR 1.25 BORE |
| 14 | 10660 | 3/4 SET COLLAR, MACHINED |
| 15 | 10288 | ROTARY SHEAR STANDOFF, 13" |
| 16 | 10648 | STEEL FLANGE, TAPPED |
| 17 | 10651 | CAM CLAMP BLOCK, LEFT TO RIGHT |
| 18 | 10657 | CAM BUSHING, FRONT |
| 19 | 10649 | CAM CLAMP BLOCK, OPEN |
| 20 | 10283 | PLATE, SLITTER, REAR SUPPORT |
| 21 | M52P | VLIER BALL PLUNGER |
| 22 | 1" x 1 1/2" DOWEL | DOWEL PIN 1/4 DIA X 1-1/2" |
| 23 | SCH. 190-32 UNF. 1 SIMP | SOCKET HEAD CAP SCREW 10-32 X 1" |
| 24 | SCH. 250-20 UNC. 1 SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1" |
| 25 | 10692 | STEEL FLANGE |
| 26 | 6121K230 | MC MASTER CARR. KNOB |
| 27 | 98029A037 | Black-Oxide Steel Thick Flat Washer 7/8" Screw Sz. 29/32" ID, 1-3/4" OD, .141" .167" |
| 28 | 9714K65 | Wave Disc Spring 1074 Hi-Carbon Steel, 1.051" ID, 1.351" OD, .015" Thk |
| 29 | SCH. 250-20 UNC. 1-25 SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1-1/4" |
| 30 | SSCR-HEX-CUP ~250-20 UNC. 1 SIMP | SOCKET SET SCREW 1/4-20 X 1" |
| 31 | SSCR-HEX-CUP ~3125-18 UNC. 1 SIMP | SOCKET SET SCREW 1/4-20 X 1" |
| 32 | 11635 | UPPER BLADE HOLDER ROTARY SHEAR ASSEMBLY |
| 33 | 11629 | LOWER BLADE HOLDER ROTARY SHEAR ASSEMBLY |
| 34 | 10691 | ARBOR, LOCK SHAFT, 13" |
| 35 | 10444 | HANDLE, PRESSURE ADJUST, DIE BRIDGE |





Section 7: Troubleshooting

7-1: Why doesn't the machine turn on?

First check to make sure that the main power switch on the back electrical panel is turned on. Then make sure that the emergency stop button on control panel is disengaged.

7-2: The counter is not counting accurately.

Inspect and clean both counter sensors located in the machine on the gear underneath the pace roller.

7-3: Why is the counter not counting inches?

Make sure that the counter sensor below the web guide is flashing red which assures that it is properly connected to the machine. Be sure that the setting on the PLC is "Distance".

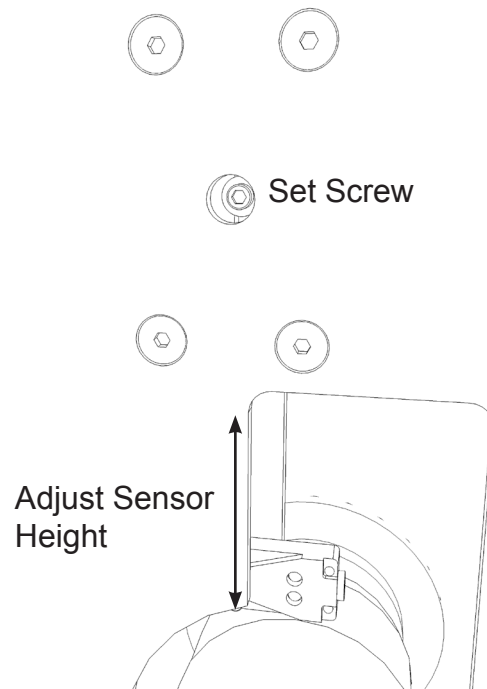
7-4: Why is the counter not counting labels?

If your machine is equipped with the optional label counter and is not doing so, after assuring that the counter sensor below the web guide is flashing red which assures that it is properly connected, assure that the PLC is set to "LABELS".

7-5: Why isn't the end-of-roll sensor working?

If your machine is equipped with the optional end-of-roll shut-down and it is not shutting down the machine when the unwind roll is near the end, or if it is shutting down prematurely, perform the following:

1. Assure that the light on the sensor (see figure 7-B) located near the unwind spindle is illuminated.
2. If not illuminated, check wiring for proper connections or damage. If wiring is set up properly, the sensor may need to be replaced.
3. If illuminated, the sensor may be in need of adjustment. If the machine is shutting down prematurely, the sensor needs to be moved closer to the unwind spindle, where if it is not shutting down the machine at all, the sensor needs to be moved away from the unwind spindle. To adjust the sensor, simply loosen the set screw, slide bracket in either direction, and re-tighten.





Section 8: Warranties and Service

8-1: Warranties & Provisions

WARRANTIES: All equipment manufactured and sold by AZTECH Converting Systems (Seller) is warranted to be free of defective materials and workmanship under normal use and service for a period of one (1) year from the date of delivery to Buyer's premises. All commercial components not manufactured by Seller carry the original manufacturer's warranty. At Seller's discretion, Seller may provide on-site warranty service for a period of ninety (90) days from the aforementioned date.

REMEDIES If within the Warranty Period any such Equipment is proven to Seller's satisfaction to be defective in either material or workmanship, Seller, at its sole discretion, shall (a) repair or replace defective parts on the Equipment at Seller's cost, or (b) grant a reasonable allowance on account of such a breach. If within the Warranty Period the Seller receives notice from Buyer of defects in parts or materials. Seller will ship (ground, prepaid) replacement parts) and invoice Buyer for the full cost of the replacement parts). Buyer will receive a Return Authorization (RA) from seller, and return defective parts or materials to Seller, who at its sole discretion shall determine whether defective parts or materials are or are not subject to exclusion from this warranty as provided herein. Any defective parts or material not excluded from the Warranty Period will then be fully credited to Buyer.

EXCLUSIONS

THE FOLLOWING ITEMS ARE EXCLUDED FROM THIS WARRANTY:

- Defects or damage caused by careless or improper use.
- Parts that need periodic replacement from wear during normal operation.
- Routine maintenance and adjustment.
- Failure or damage caused by improper installation or inadequate maintenance by Buyer.
- Failure or damage caused by equipment modifications by Buyer.
- Equipment damage resulting from an accident, or abnormal conditions of operation.

DISCLAIMER OR WARRANTY

NO OTHER WARRANTY IS EXPRESSED OR IMPLIED INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR ANY PARTICULAR PURPOSE. SELLER IS NOT LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGE SUCH AS, BUT NOT LIMITED TO LOSS IN PROFITS, LOSS OF USE OF EQUIPMENT, OR INCREASED IN OPERATING COSTS OR EXPENSES.

8-2: Technical Service

In the event that your DM is not functioning properly or if you have any technical questions, an AZTECH Technical Service representative is available to assist you. Contact information is as follows:

Phone: 1-480-951-8351
1-800-829-8351
Fax: 1-480-998-5409
E-Mail: techservice@aztechconverting.com