



**AZTECH CONVERTING SYSTEMS**  
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# **SR SERIES**

## **User Manual**

**Rev. 1.5**  
**2017**



# **AZTECH CONVERTING SYSTEMS**

## **SR-SERIES USER MANUAL**

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4:  
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5:  
Maint.

6:  
DWGs

7:  
T.S.

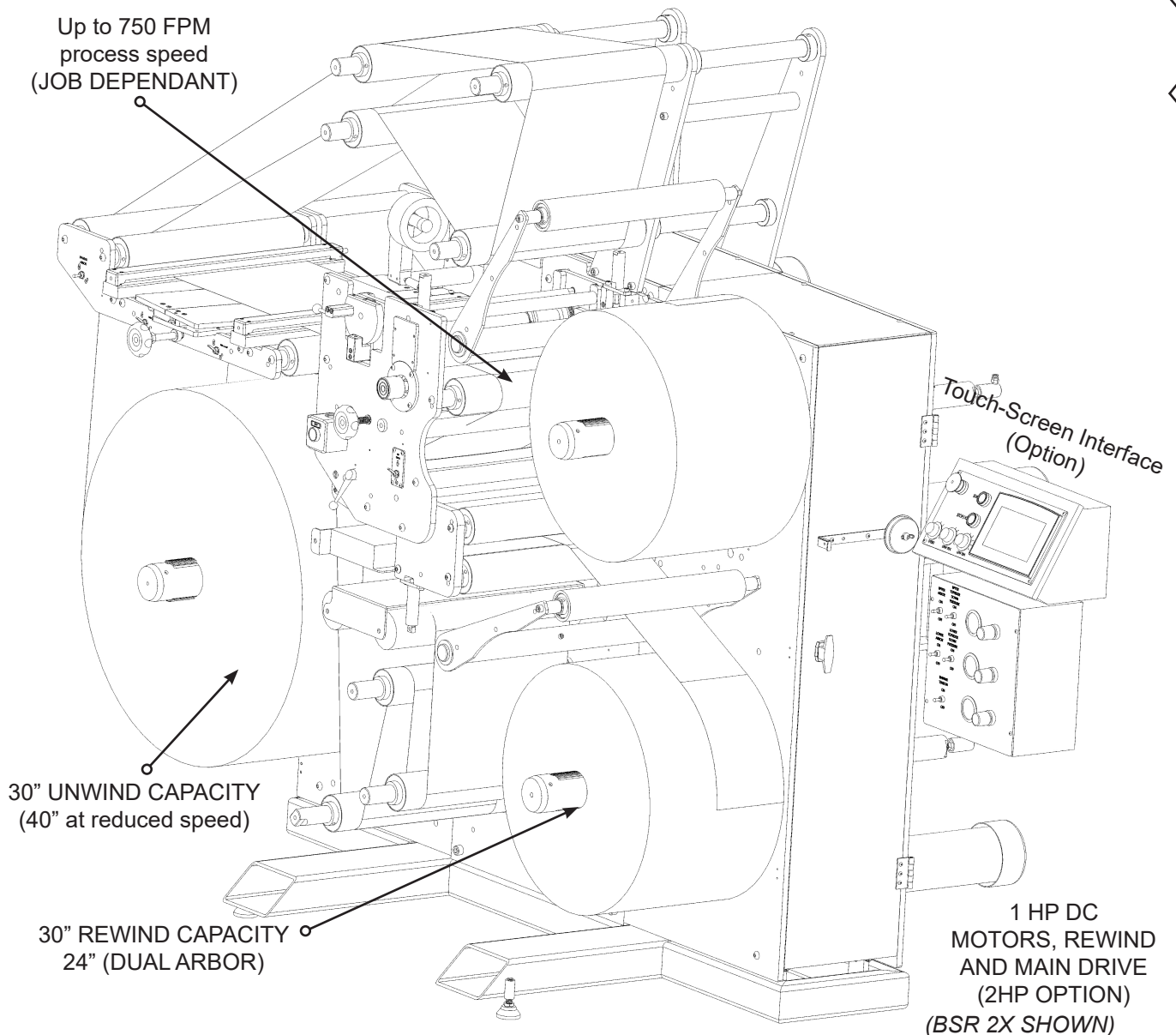
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Warr.

## Section 1: General Information

### 1-1: Introduction

The AZTECH SR-Series Slitter/Rewind Inspector is available in 10 inch (25.4 cm), 13 inch (33.02 cm), 16 inch (40.64 cm), and 18 inch (45.72 cm) widths, and with either single or dual rewind spindles. The SR-Series is designed to be highly productive and versatile, and simple to operate, maintain, or repair with its electronic tension control and clutch-less design. Before operating your new SR-Series, fully read and understand 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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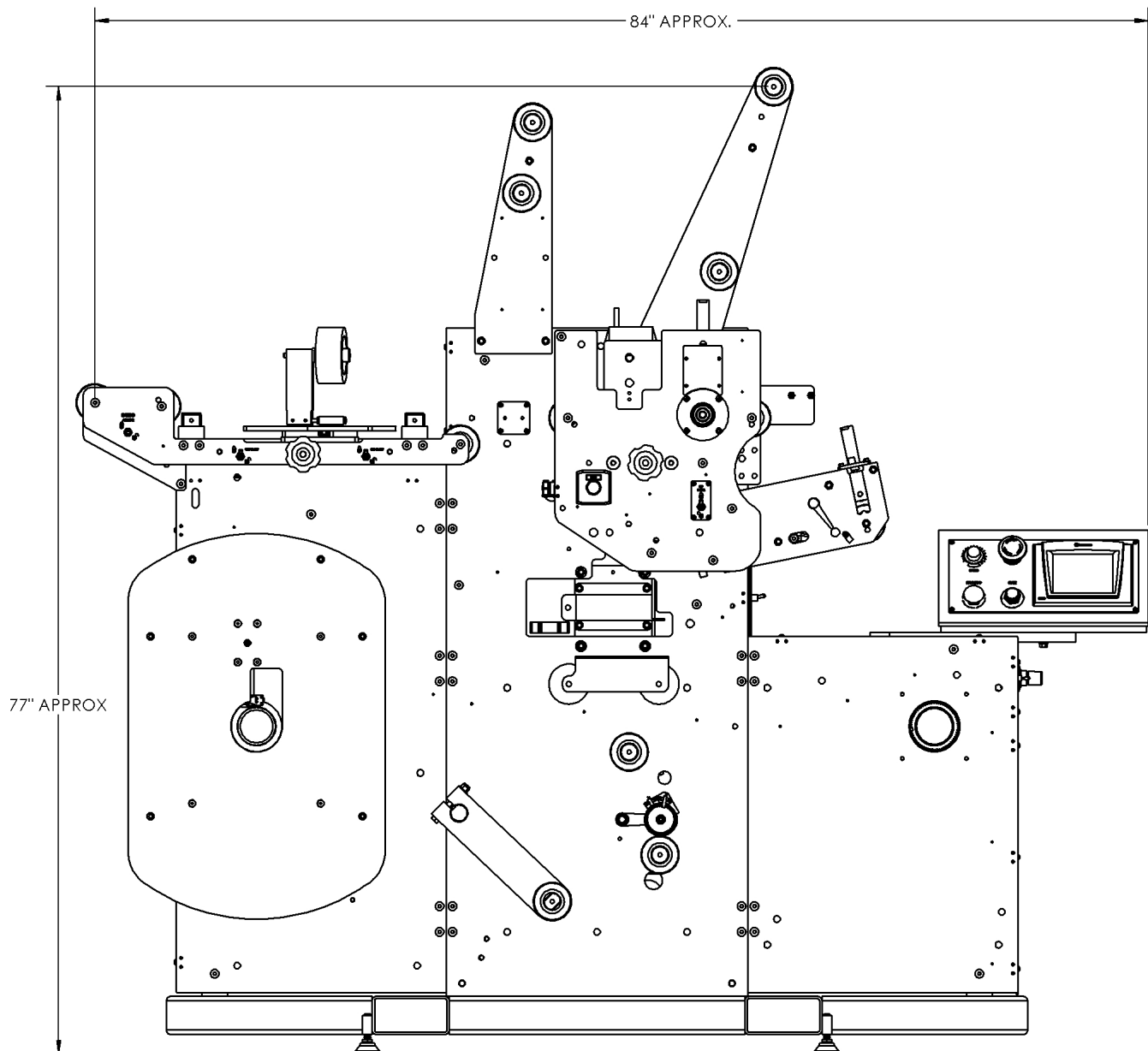


# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

### BSR SINGLE ARBOR

#### FRONT LAYOUT



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



1:  
Gen.  
Info

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Oper.

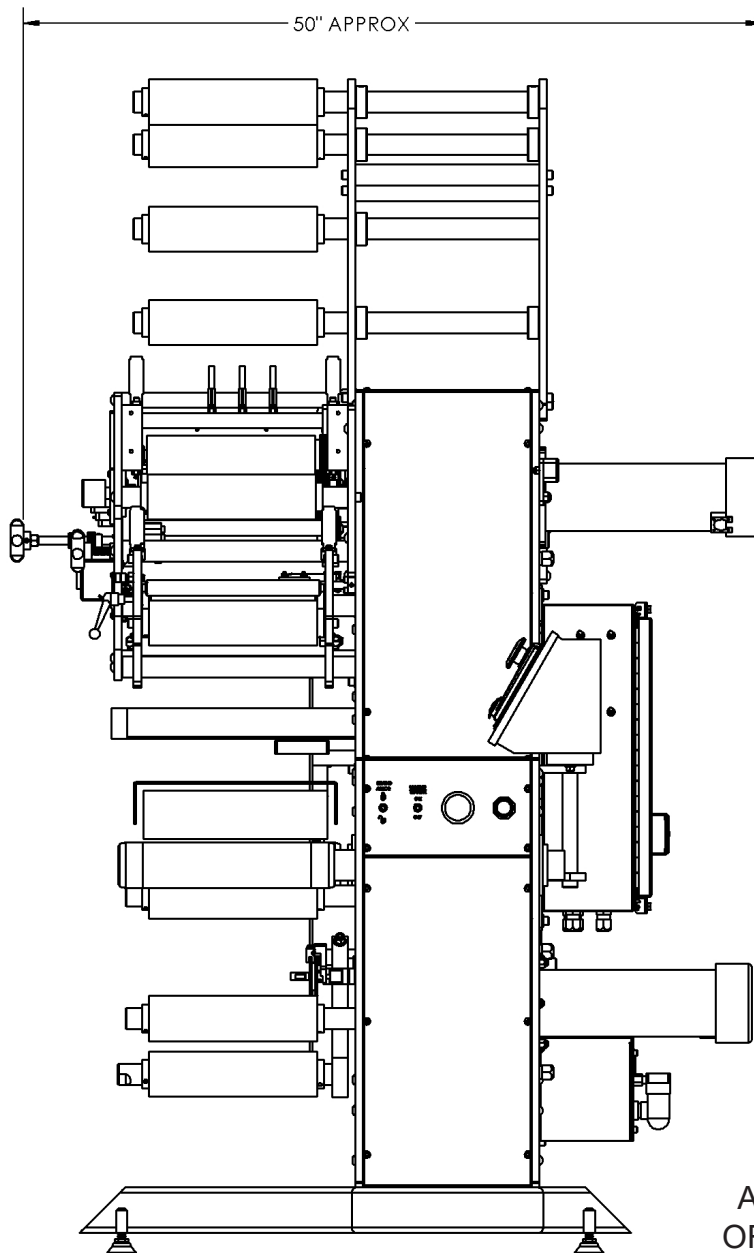
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Maint.

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DWGs

7:  
T.S.

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Warr.

### SIDE LAYOUT



ALLOW AT LEAST 3 FEET  
OF WORKING CLEARANCE  
AROUND THE PERIMETER  
OF THE MACHINE

*Note: DIMENSION MAY CHANGE BASED ON  
SPECIFIED PROCESS WIDTH*

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Info

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T.S.

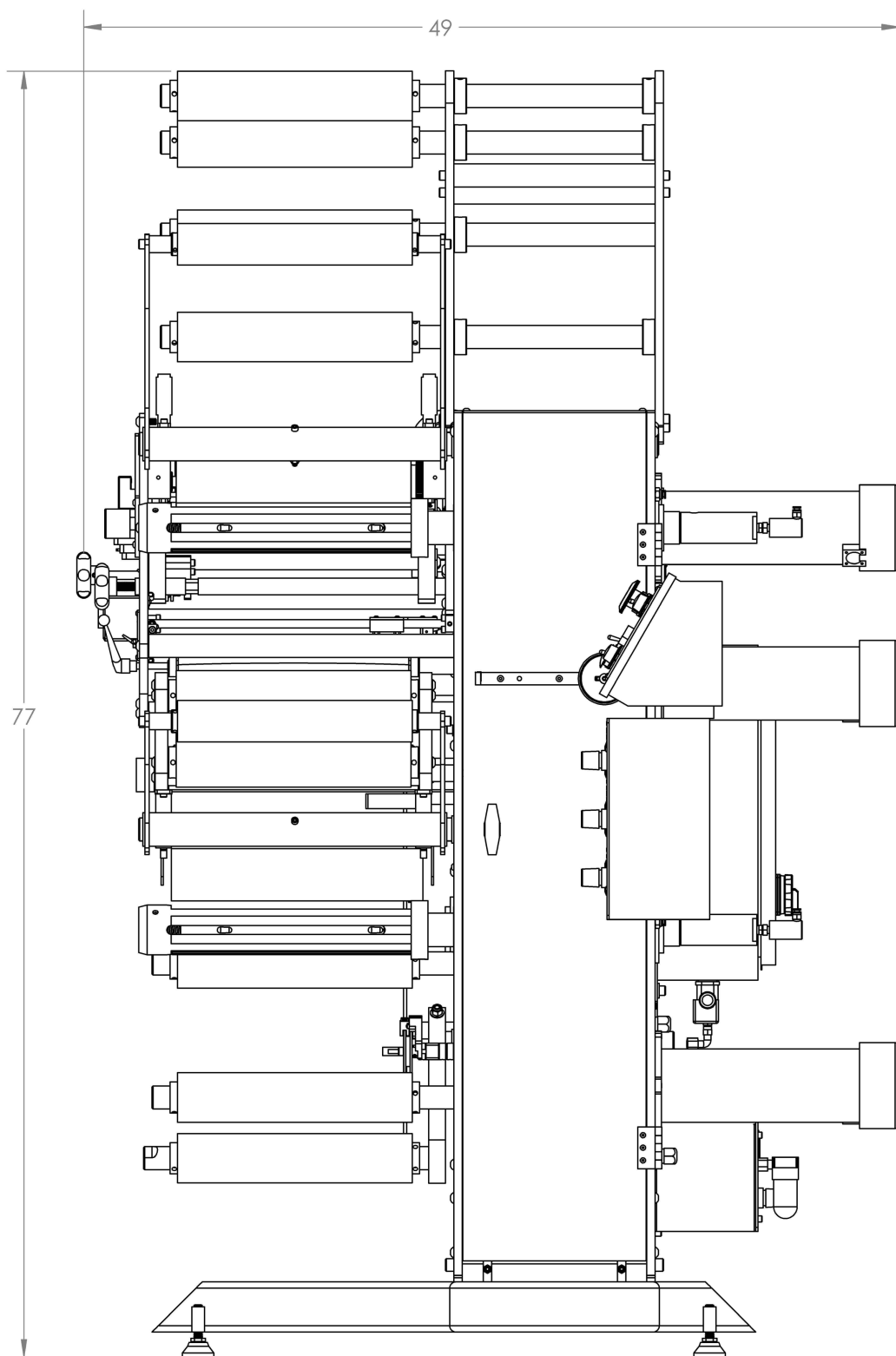
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### BSR DUAL ARBOR SIDE LAYOUT



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1:  
Gen.  
Info

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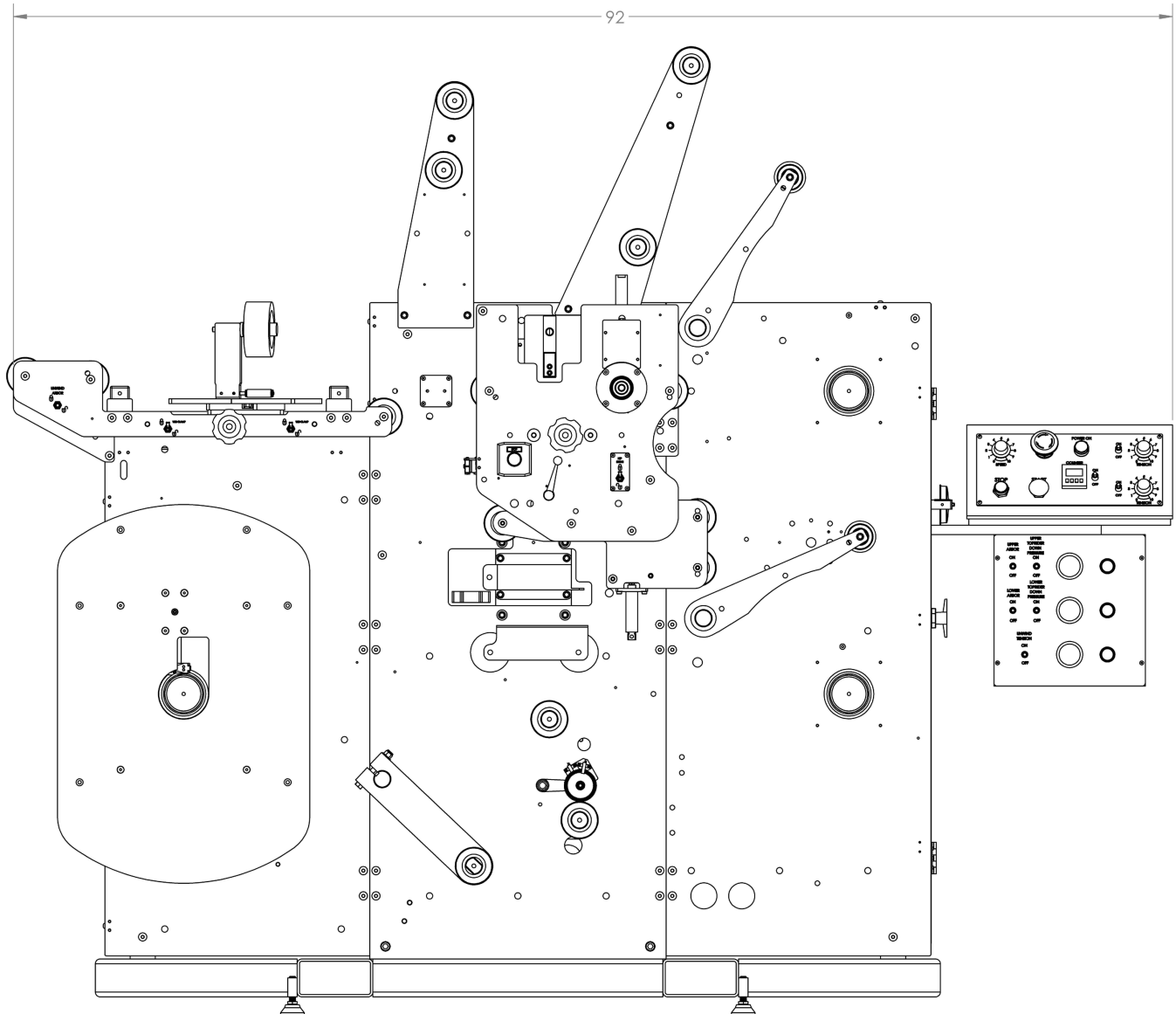
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DWGs

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### FRONT LAYOUT



*Note: DIMENSION MAY CHANGE BASED ON  
SPECIFIED PROCESS WIDTH*

1:  
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Install

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Setup

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Oper.

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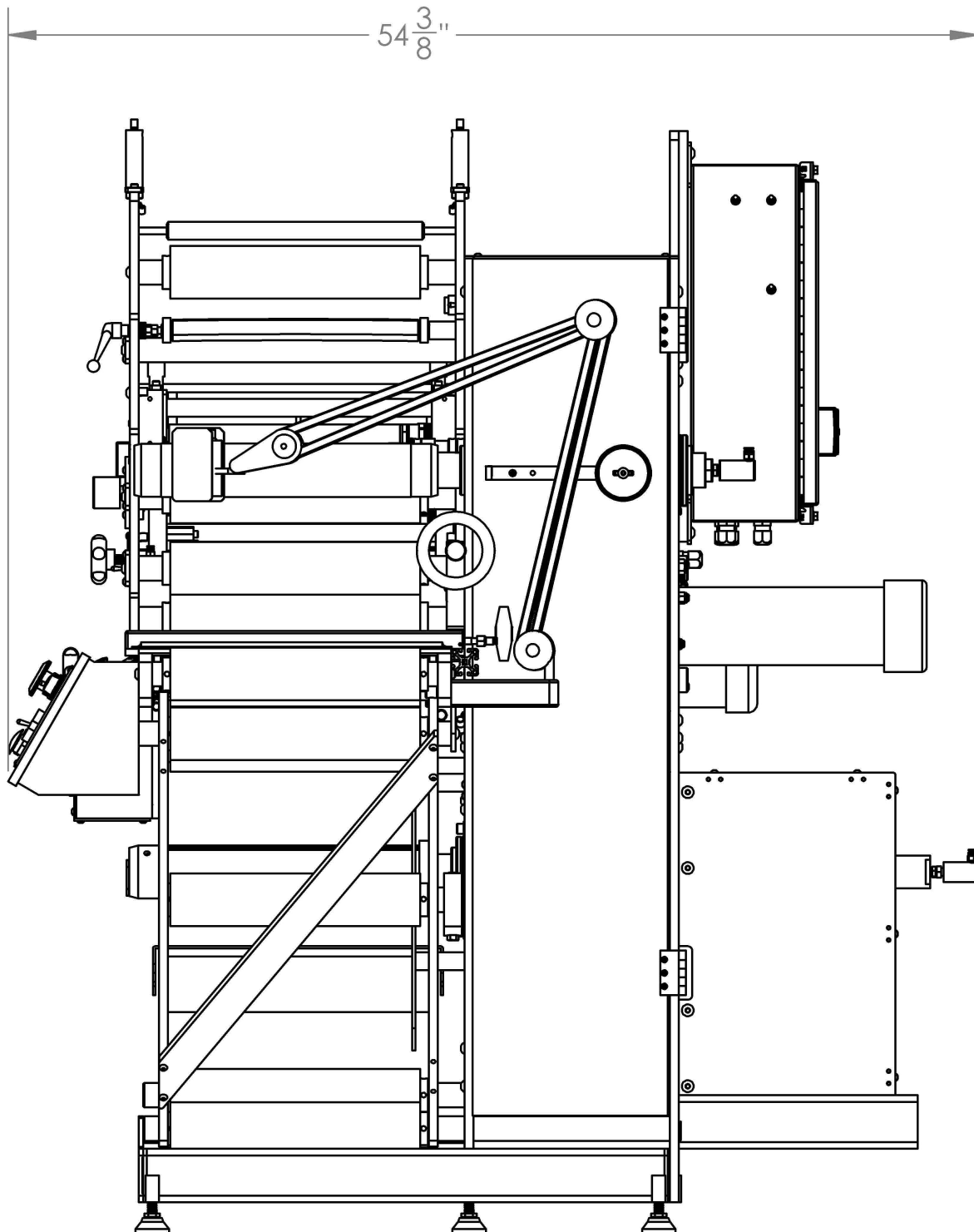
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# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

### ISR SINGLE ARBOR SIDE LAYOUT



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



1:  
Gen.  
Info

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Install

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Setup

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Oper.

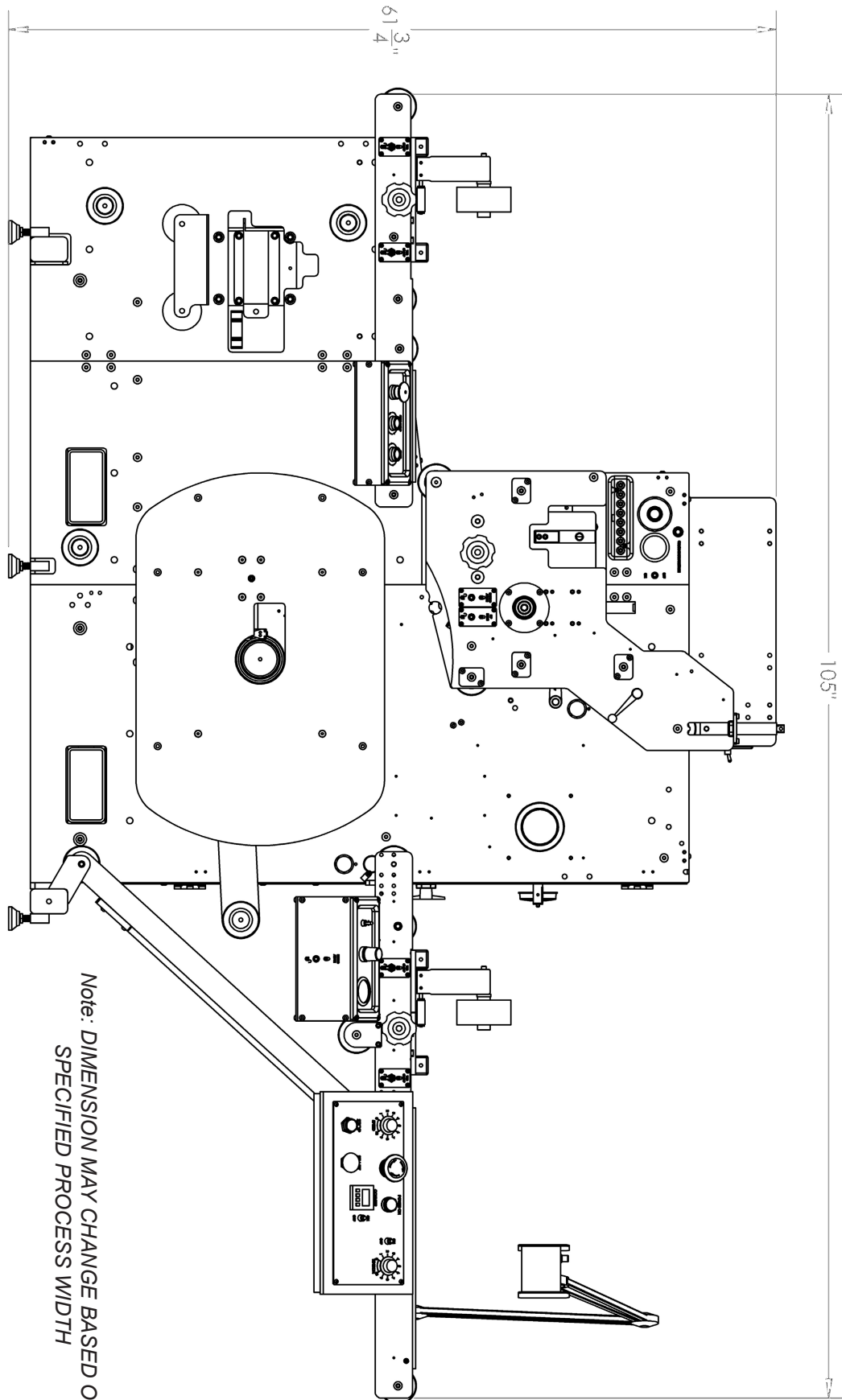
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6:  
DWGs

7:  
T.S.

8:  
Warr.

### FRONT LAYOUT



Note: DIMENSION MAY CHANGE BASED ON  
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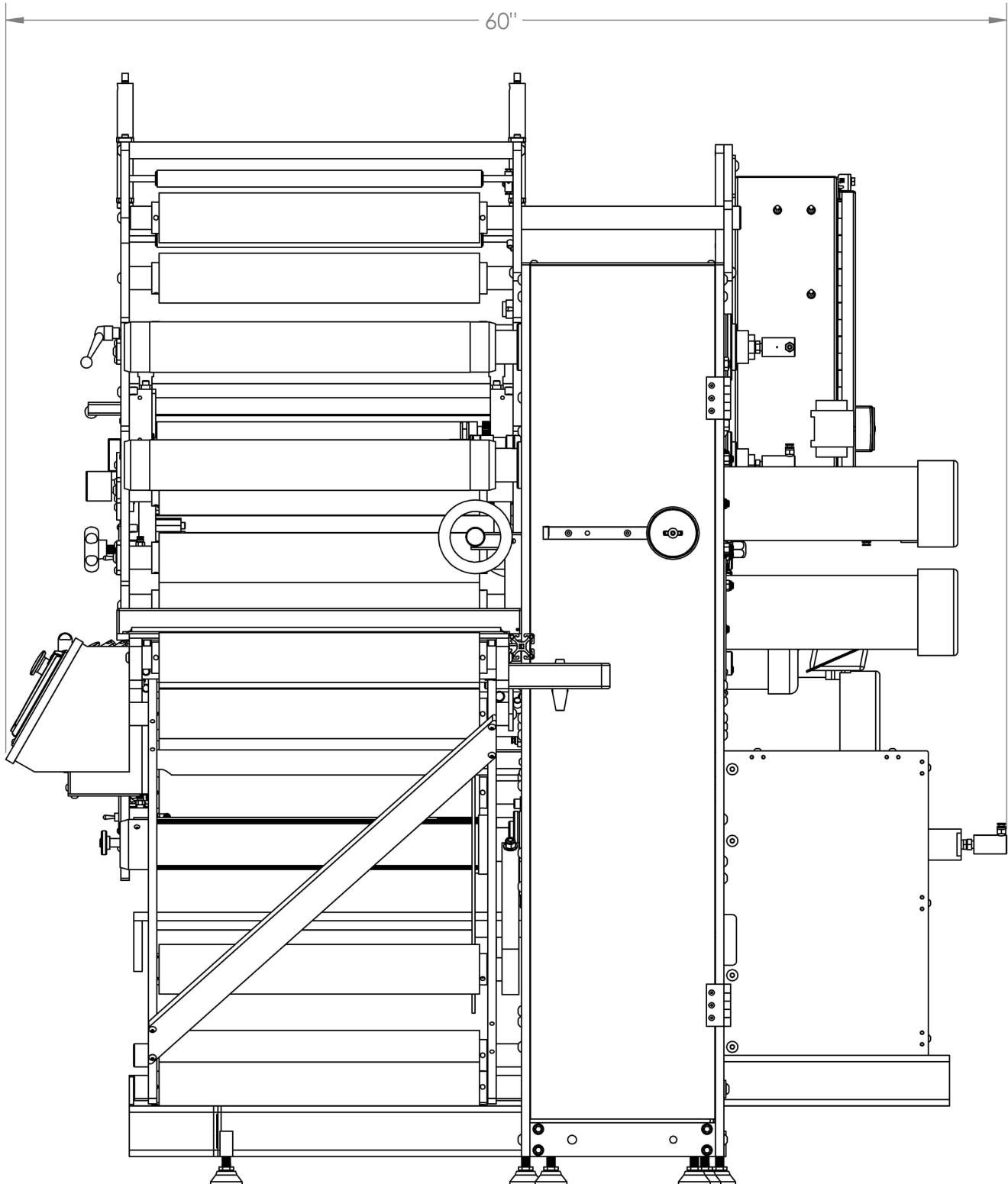
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# AZTECH CONVERTING SYSTEMS

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### ISR DUAL ARBOR SIDE LAYOUT





# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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Oper.

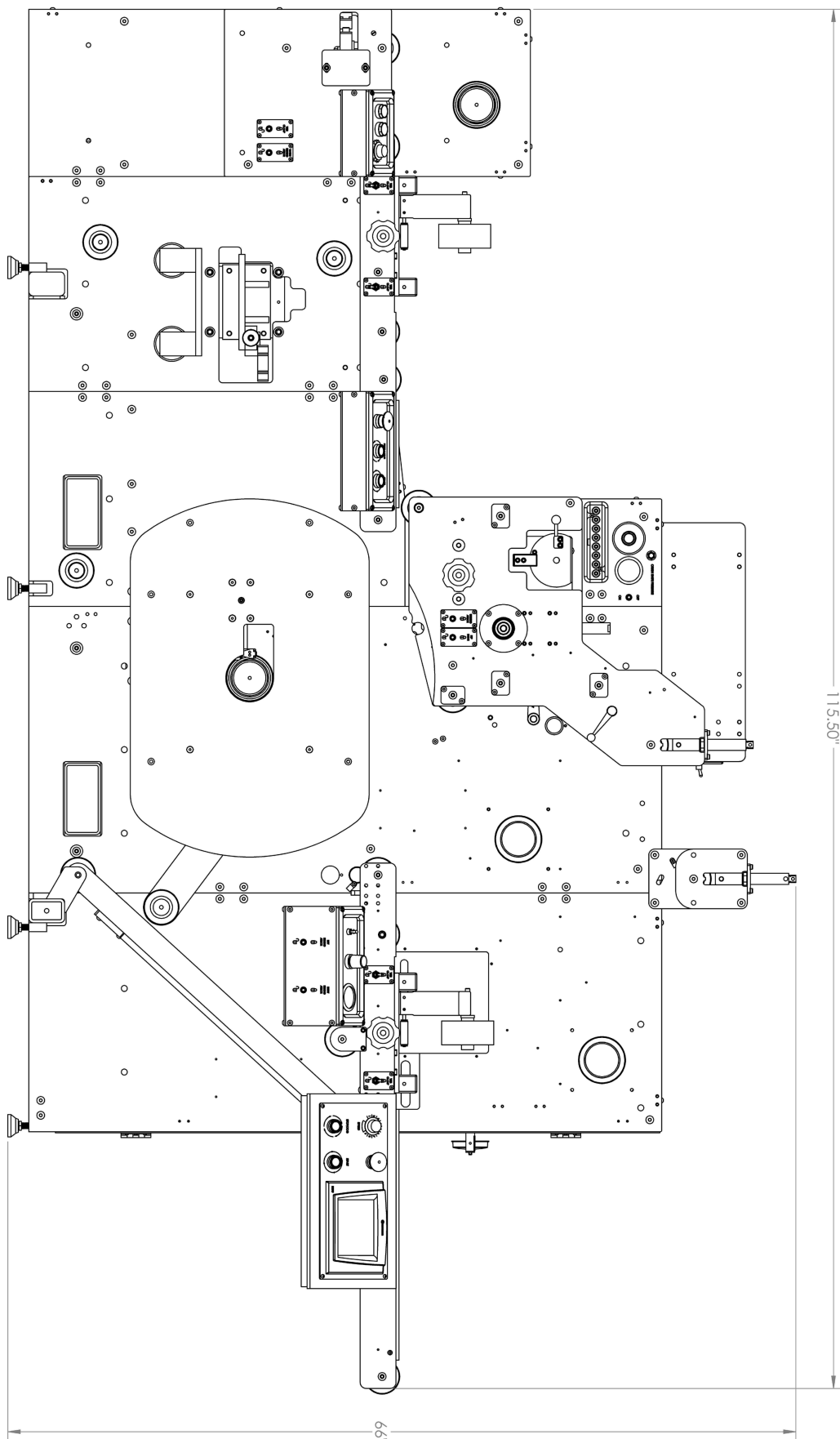
5:  
Maint.

6:  
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T.S.

8:  
Warr.

### FRONT LAYOUT





## 1-4: Safety

The SR-Series Slitter/Rewinder 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 SR-Series Slitter/Rewinder 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 SR-Series Slitter/Rewinder, first remove the cover by removing all screws, then remove one of the 2 long side panels to expose machine. Remove all 4 lag bolts which hold the machine to the base. Remove all boxes and parts inside crate.

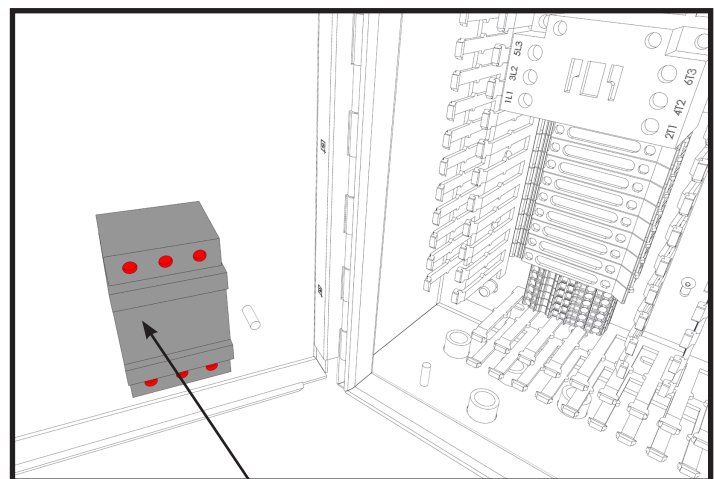
### 2-3: Removal and Positioning

It is critical that the SR-Series Slitter/Rewinder 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 SR-Series Slitter/Rewinder uses a power supply of 220 volts, 20 amps 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.



20A 220VAC  
SINGLE PHASE  
TO DISCONNECT

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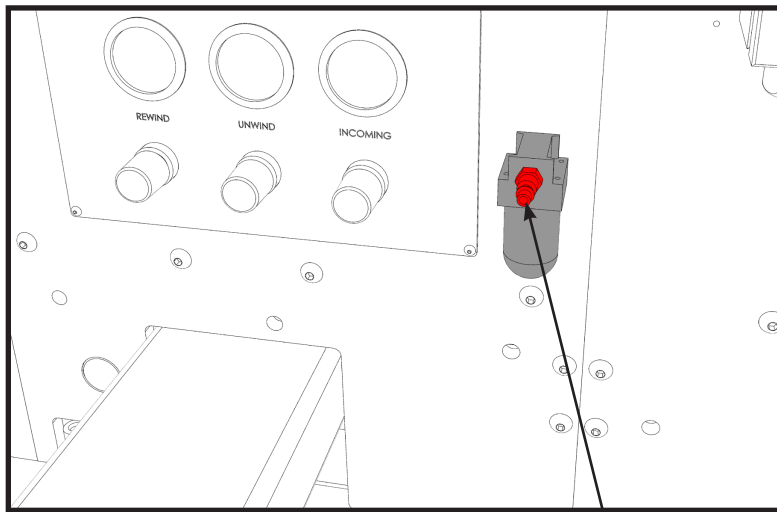
4:  
Oper.

5:  
Maint.

6:  
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7:  
T.S.

8:  
Warr.



90PSI INCOMING HP AIR

**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.



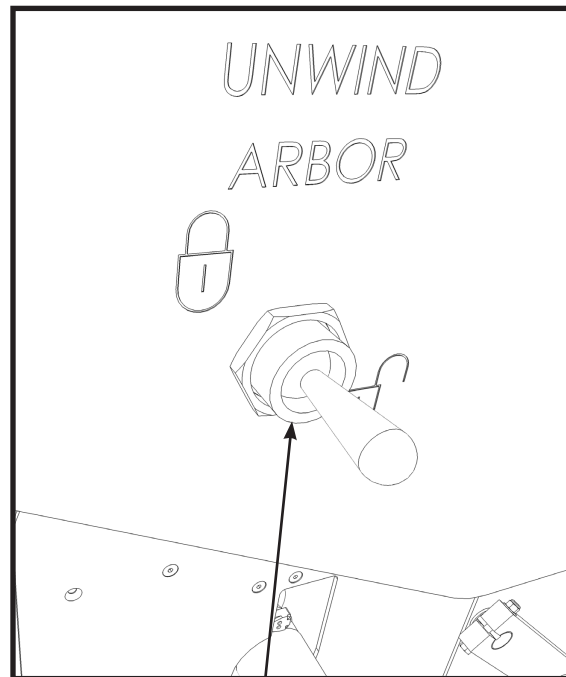
### Section 3: Machine Setup

#### 3-1: Webbing the Machine

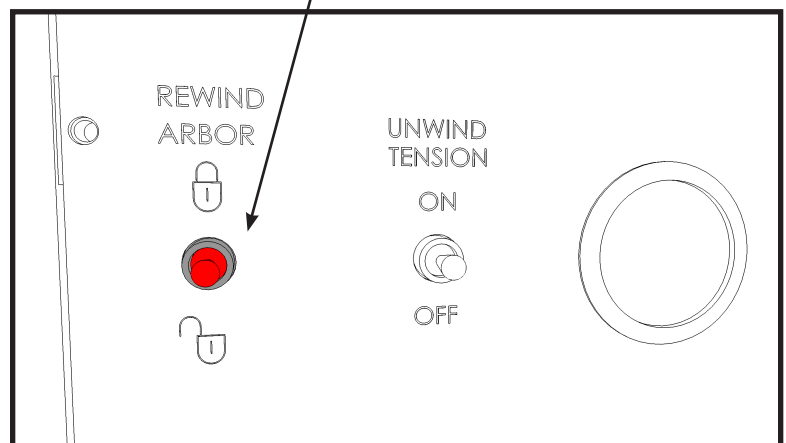
Proper webbing of your SR-Series Slitter/Rewinder is vital to optimal machine performance. The following pages illustrate the proper ways to thread your machine for various substrates. Any improper webbing of the machine may cause tension problems that will impede operation.

##### 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 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.



ARBOR LOCK  
SWITCHES





1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

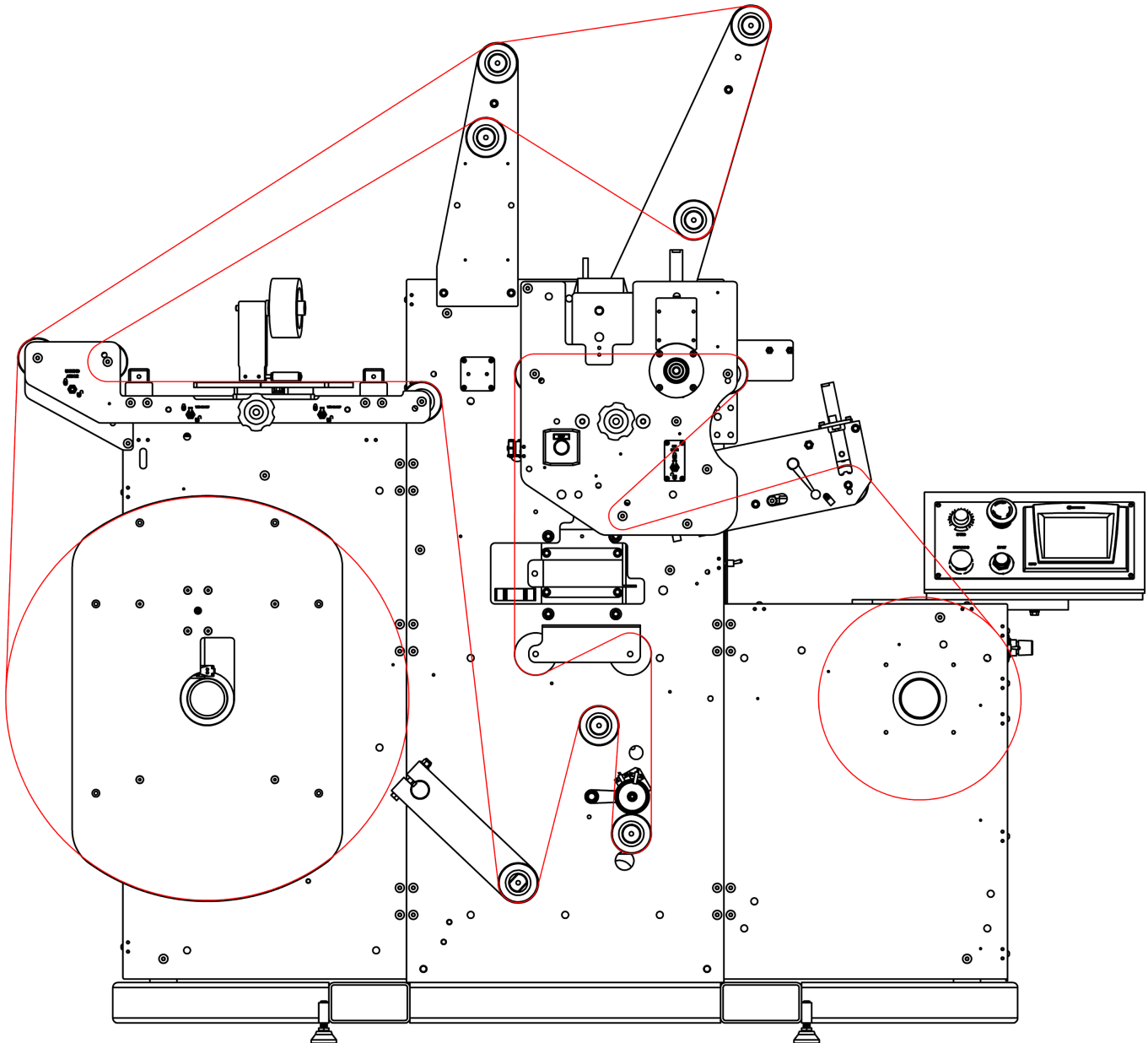
5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

### SR Series Web Path(s)



**BSR Single Arbor**

Proper webbing of your SR-Series Inspection Rewinder is vital to optimal machine performance. Any improper webbing of the machine may cause tension problems that will impede operation.

*NOTE: Web paths are shown in OVERWIND configuration and through optional inspection towers.*

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

1:  
Gen.  
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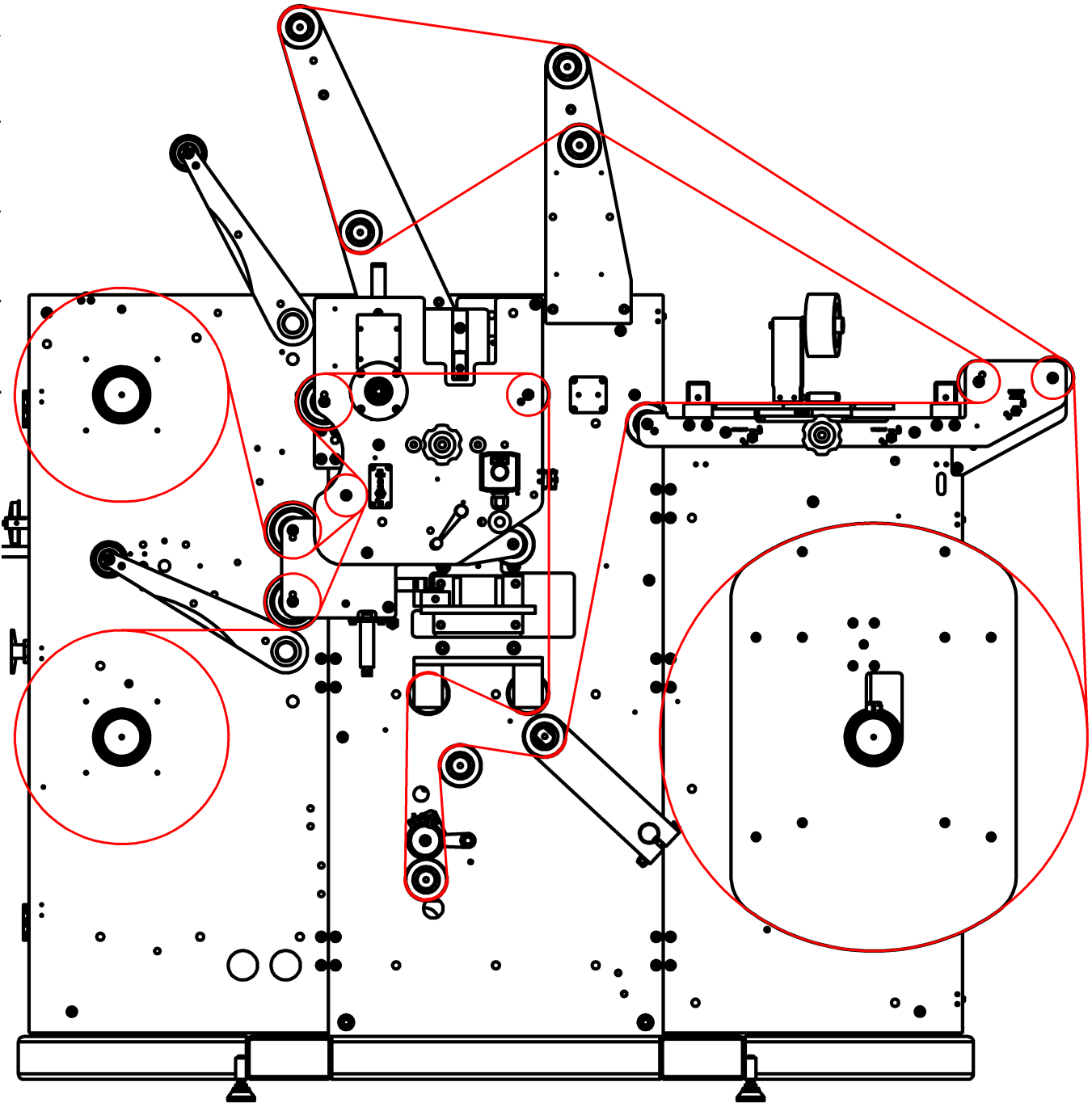
4:  
Oper.

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Maint.

6:  
DWGs

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T.S.

8:  
Warr.



BSR Dual Arbor

# AZTECH CONVERTING SYSTEMS

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Gen.  
Info

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Install

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Setup

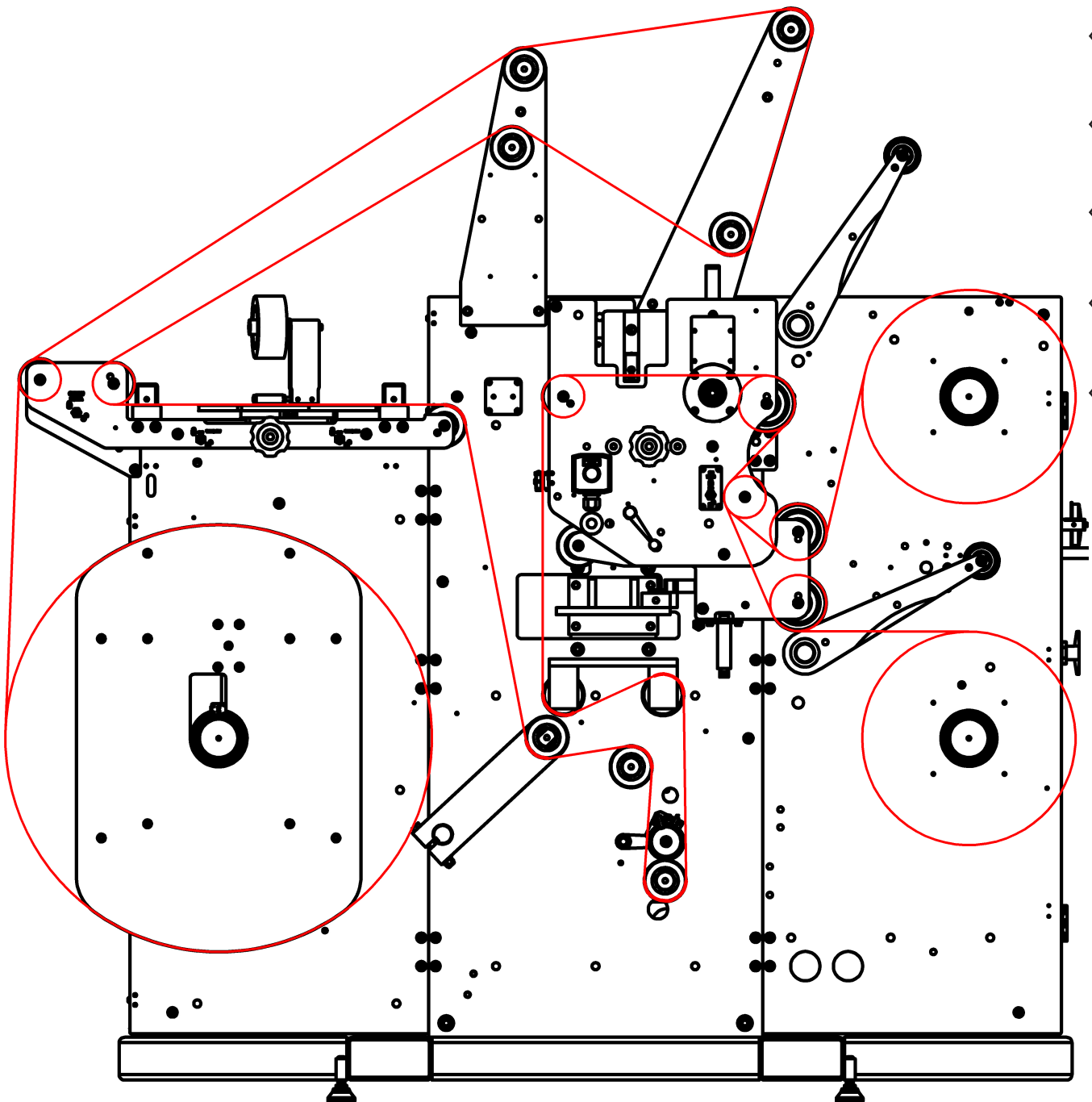
4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



(Both Right-to-Left and Left-to-Right models are available on all ISR and BSR equipment)

# AZTECH CONVERTING SYSTEMS

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1:  
Gen.  
Info

2:  
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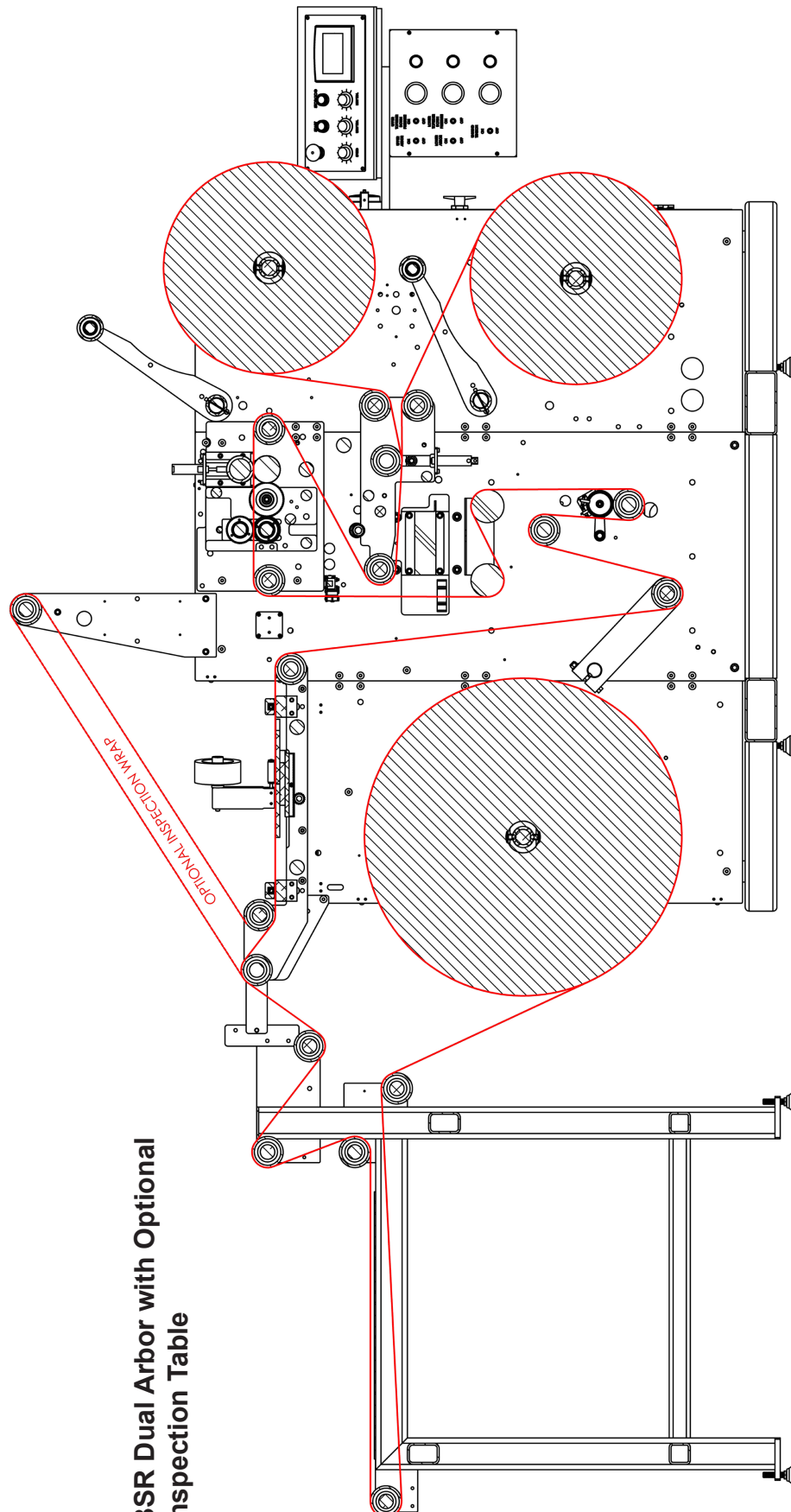
4:  
Oper.

5:  
Maint.

6:  
DWGs

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T.S.

8:  
Warr.



**BSR Dual Arbor with Optional  
Inspection Table**



# AZTECH CONVERTING SYSTEMS

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1:  
Gen.  
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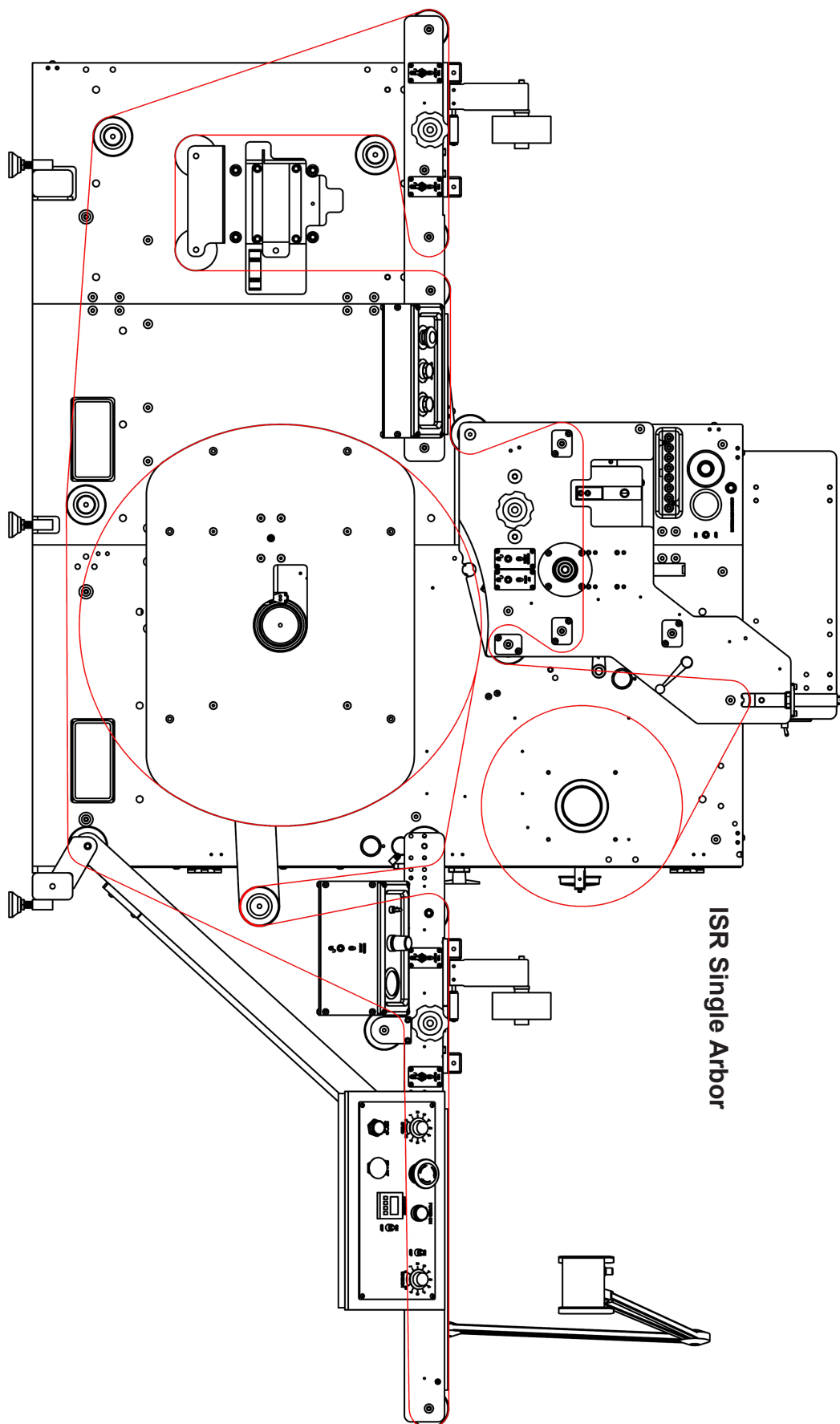
4:  
Oper.

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Maint.

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DWGs

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Warr.



ISR Single Arbor

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1:  
Gen.  
Info

2:  
Install

3:  
Setup

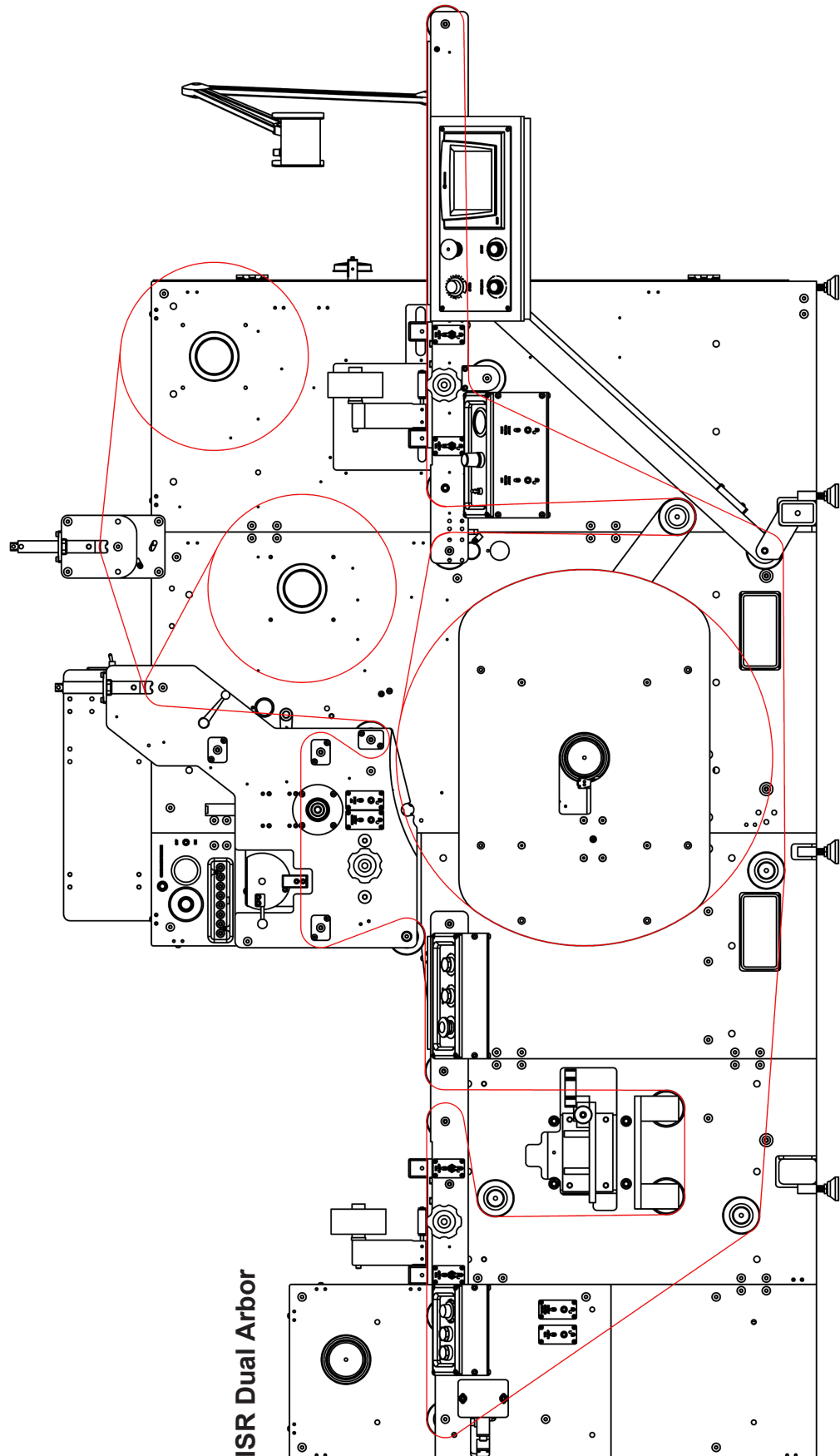
4:  
Oper.

5:  
Maint.

6:  
DWGs

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T.S.

8:  
Warr.



ISR Dual Arbor

# AZTECH CONVERTING SYSTEMS

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1:  
Gen.  
Info

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Maint.

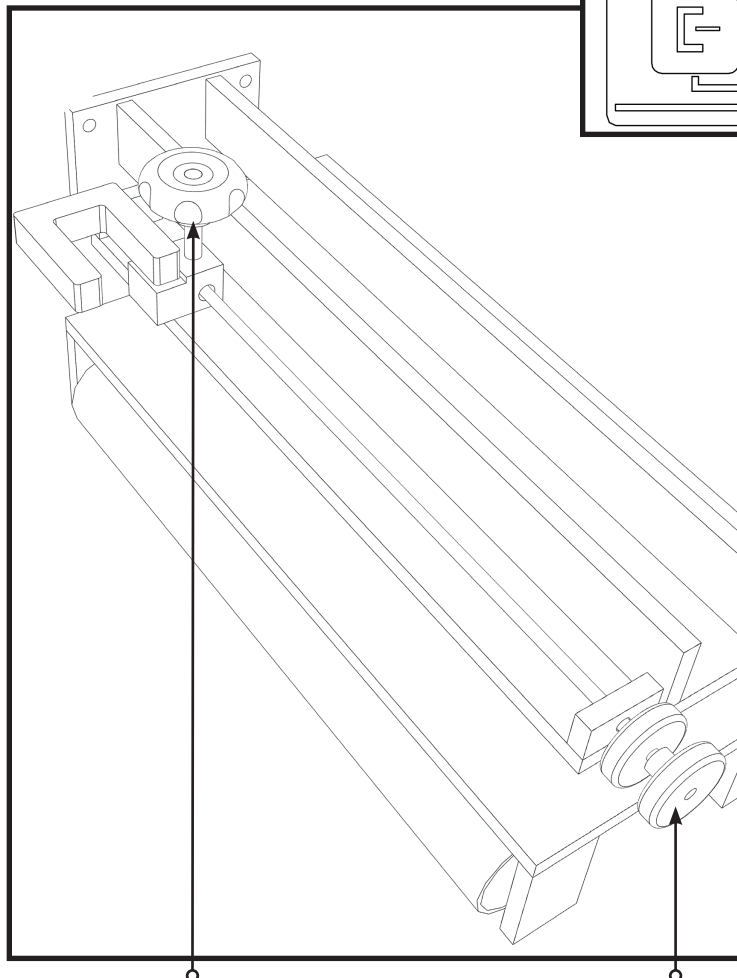
6:  
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Warr.

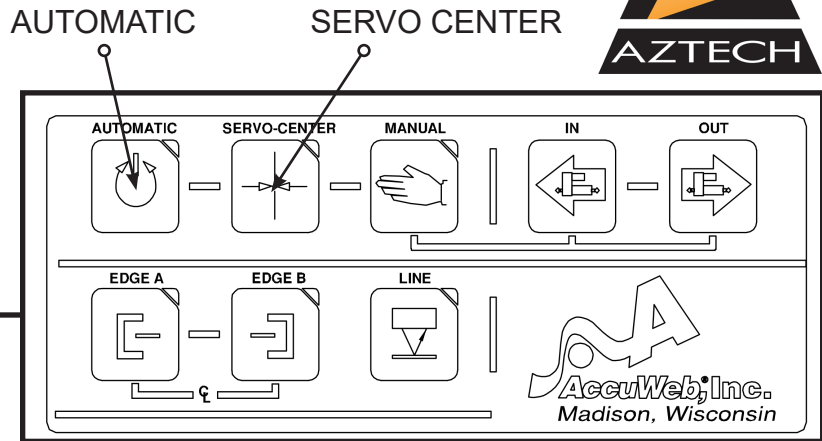
### 3-2 Web Guide Setup

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



COARSE  
SENSOR  
POSITIONING

FINE  
SENSOR  
POSITIONING

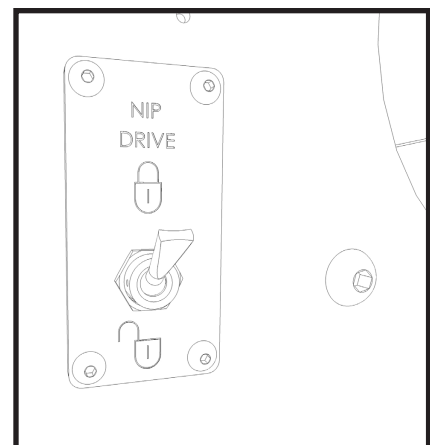


#### Setting the Web Guide:

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

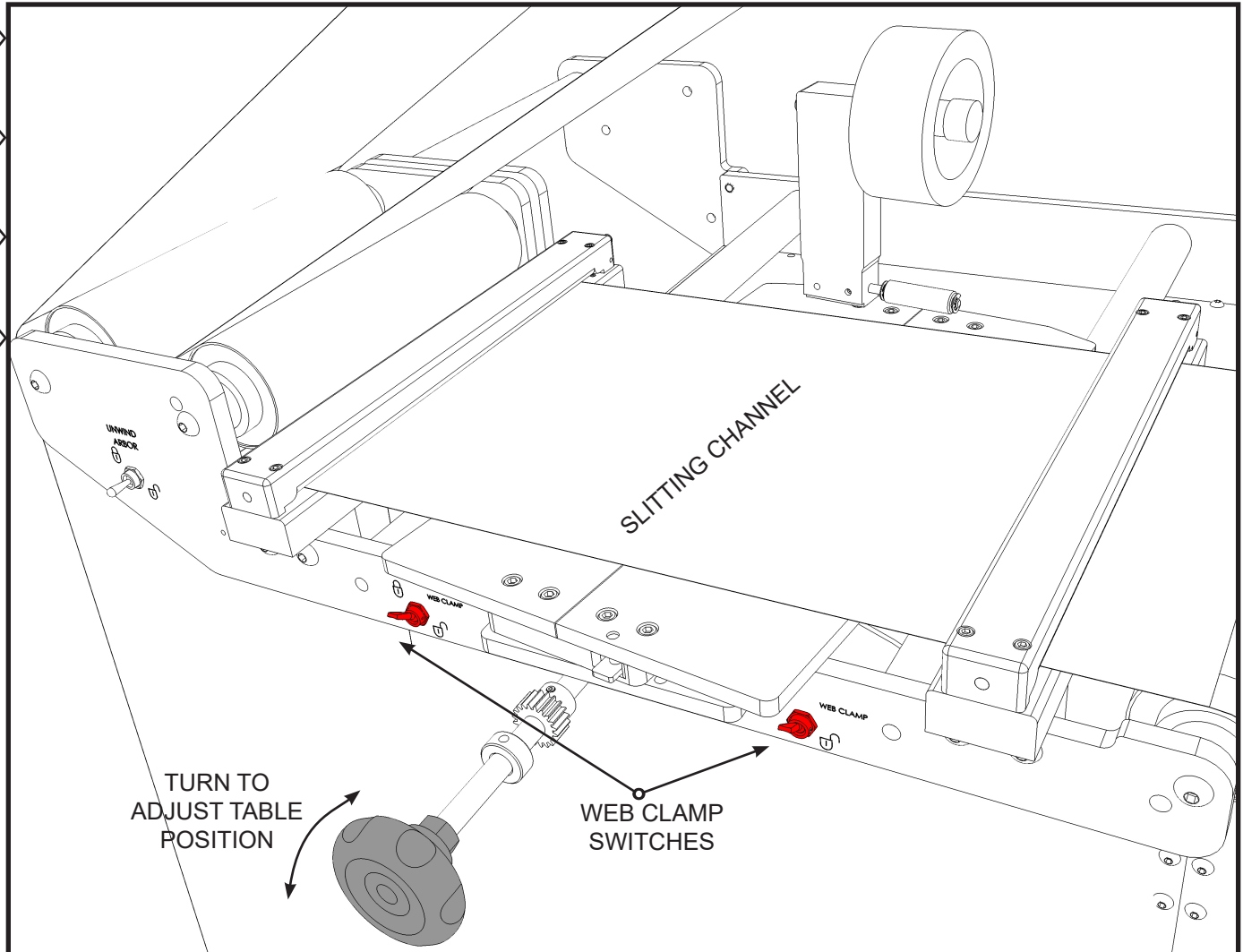
The Nip Roll is pneumatically controlled using control switch (see figure 3-E) and must be in the down position while machine is running, and in the up position when threading machine.





### 3-4: Splice Table Operation

The splice table on your SR-Series is located just above the Unwind Station, just after the optional Inspection Tower. To operate the Splice Table, simply follow the following steps:



1. Turn off machine and engage both web clamp switches.
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 switches to release web clamps.

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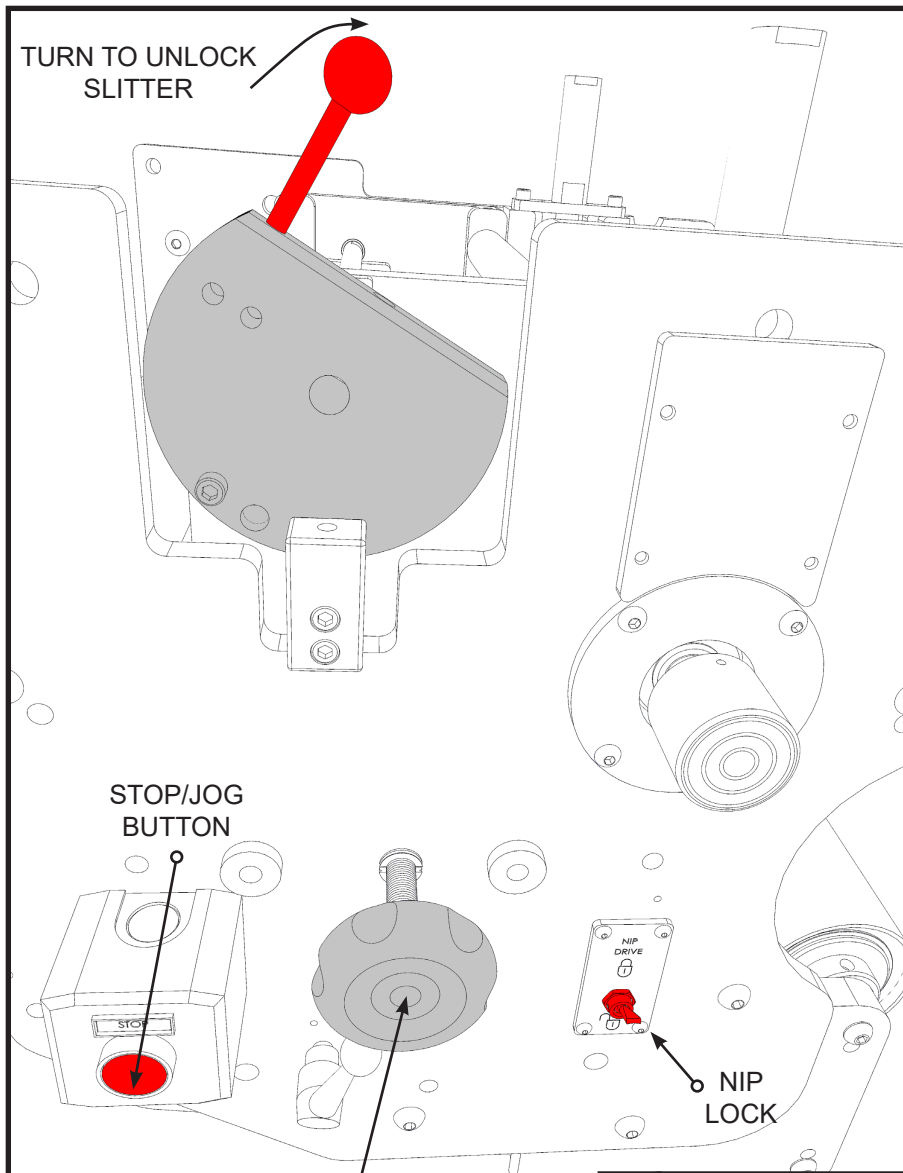
4:  
Oper.

5:  
Maint.

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DWGs

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T.S.

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Warr.



### 3-5: ROTARY SHEAR SET-UP

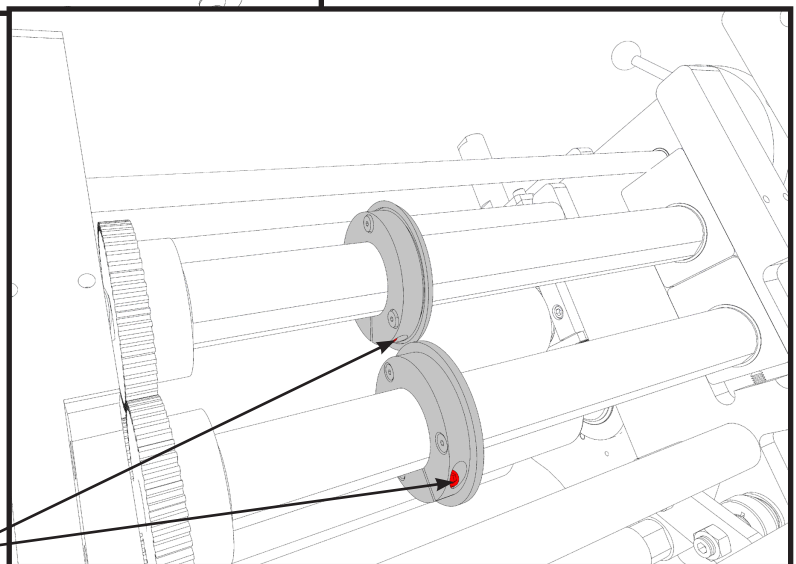
**Step 1** Set lower blades for desired Slit-widths and tighten set-screws, making sure upper blades are up and not in lock position.

**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.

LATERAL SHEAR  
ADJUSTMENT

TIGHTEN SET SCREWS  
TO LOCK BLADES



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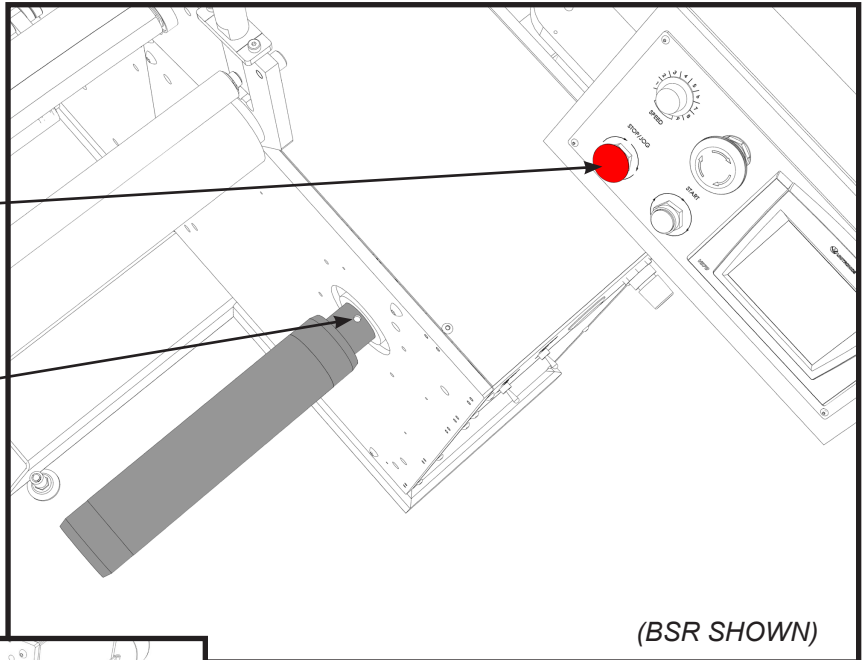
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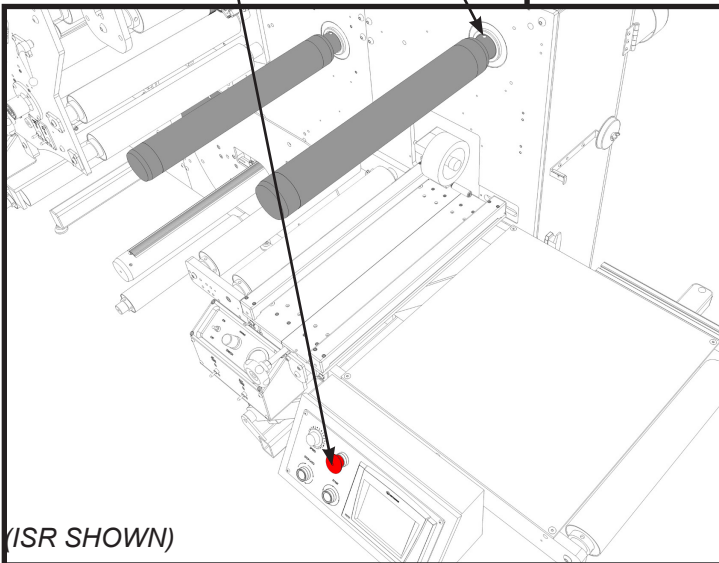


E-STOP  
MACHINE

LOOSEN SET  
SCREW HERE



(BSR SHOWN)



(ISR SHOWN)

### 3-6: Changing Rewind Spindle

Your SR-Series Slitter/Rewind Inspector is equipped with 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.



1:  
Gen.  
Info

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Oper.

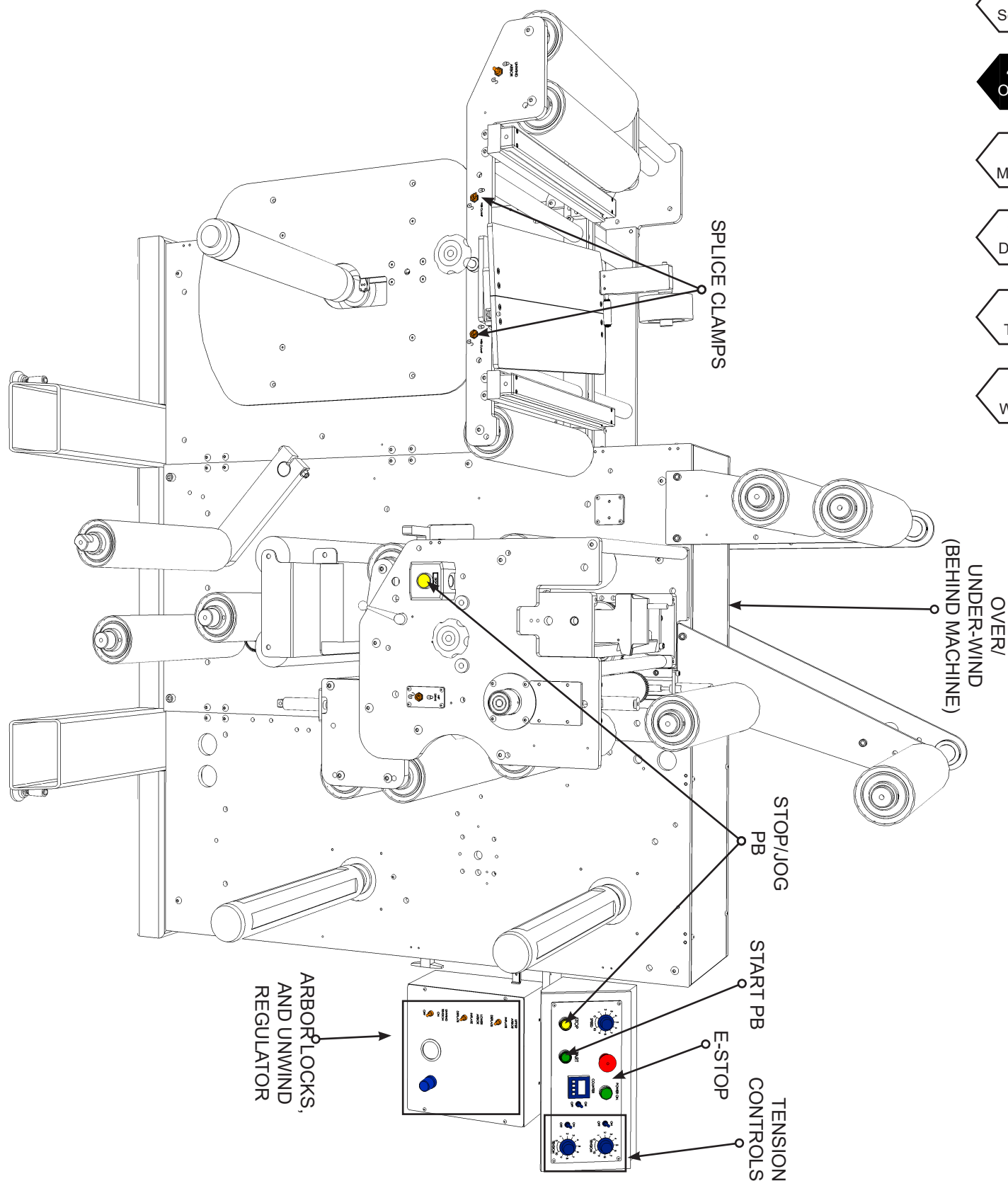
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### Section 4: Machine Operation





# AZTECH CONVERTING SYSTEMS

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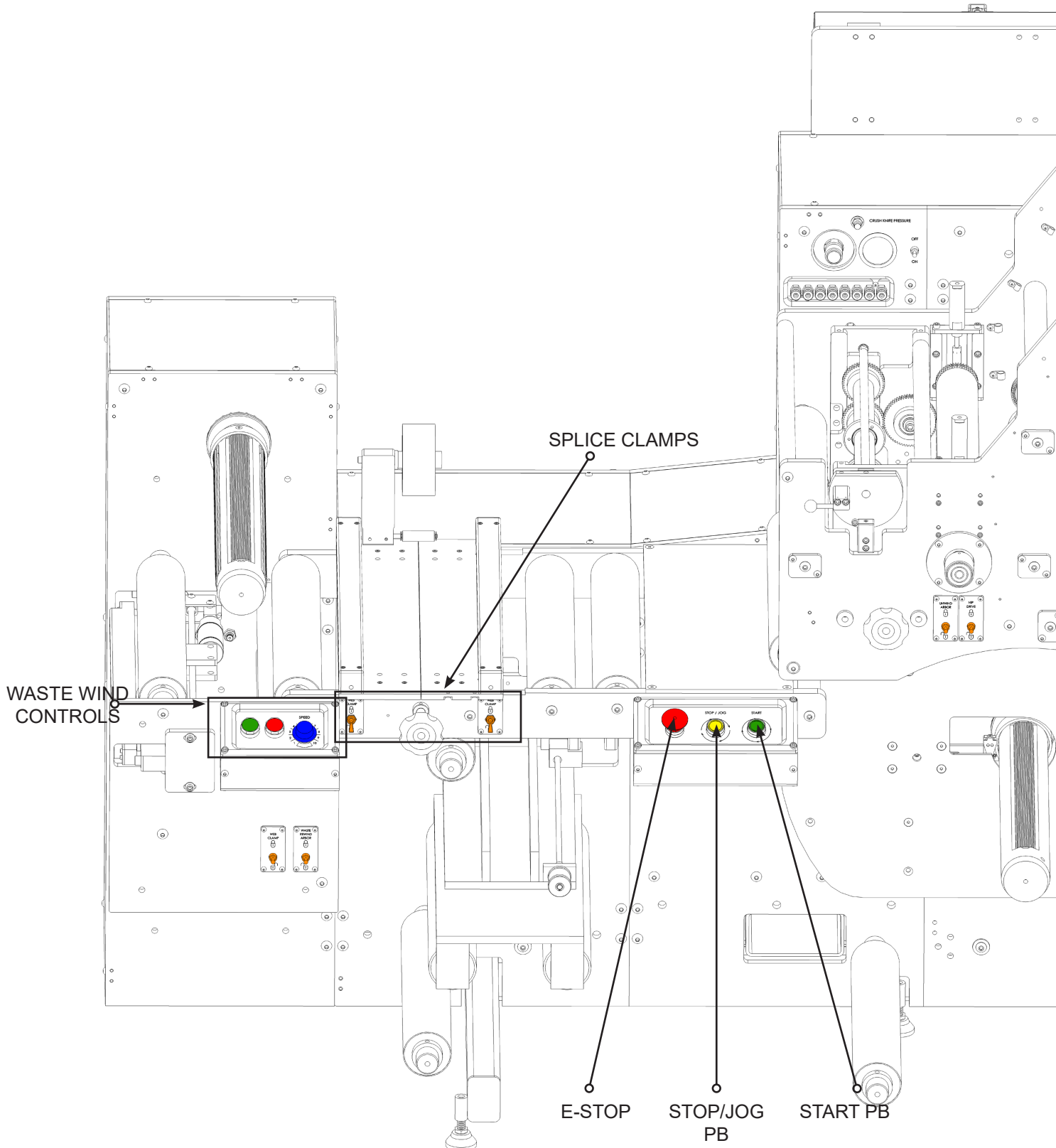
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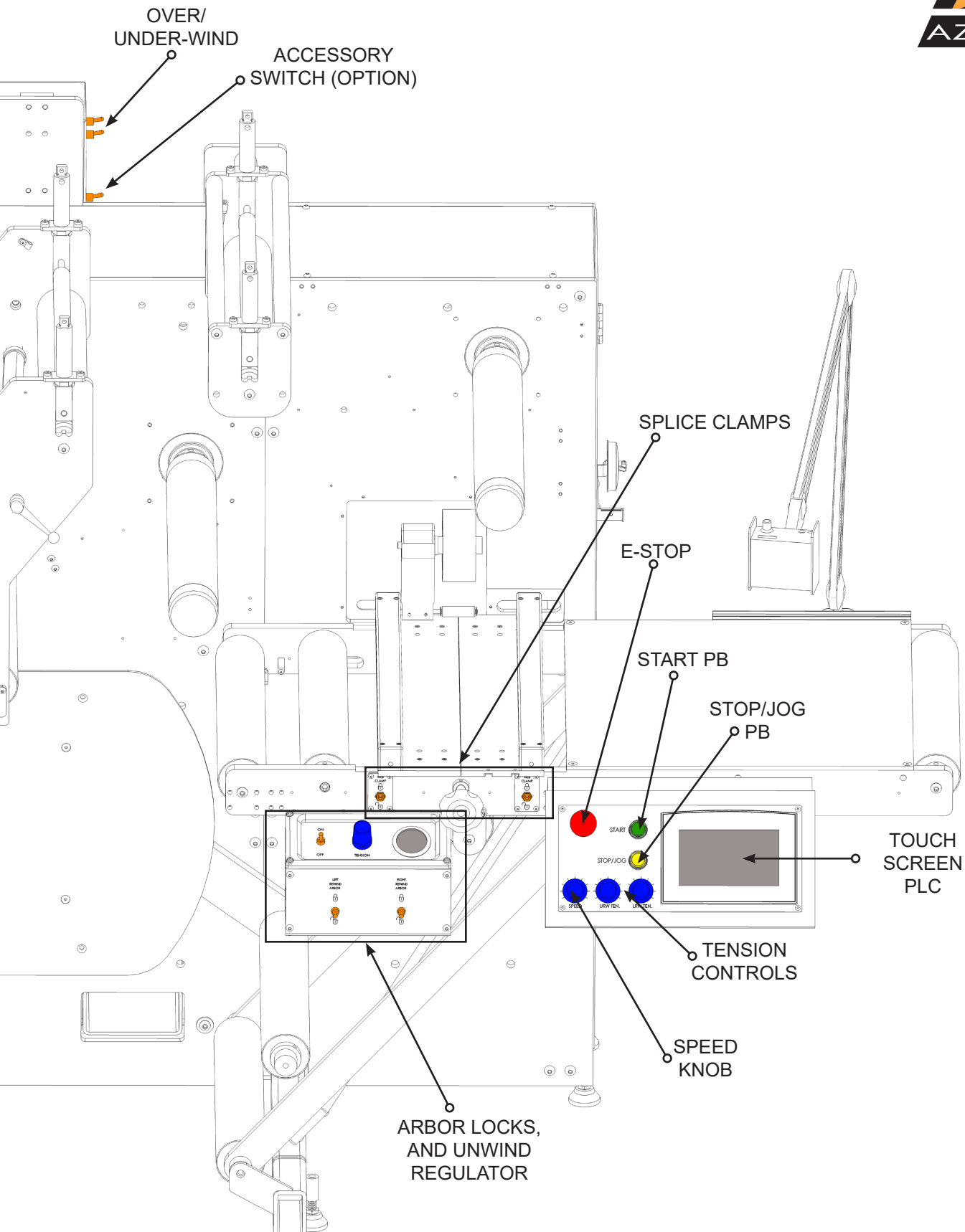
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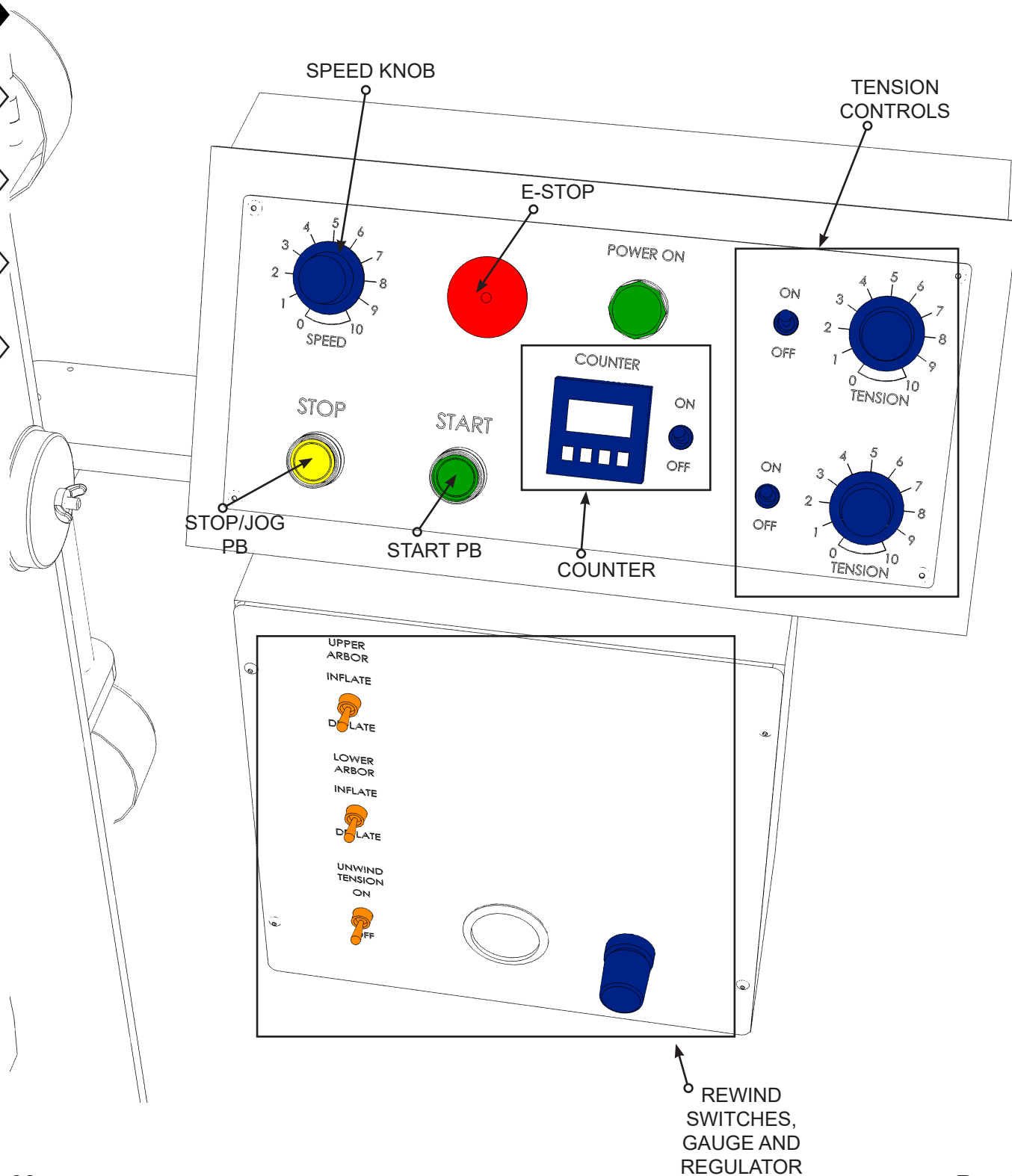
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# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

### 4-1: Operator Control Layout (STD)





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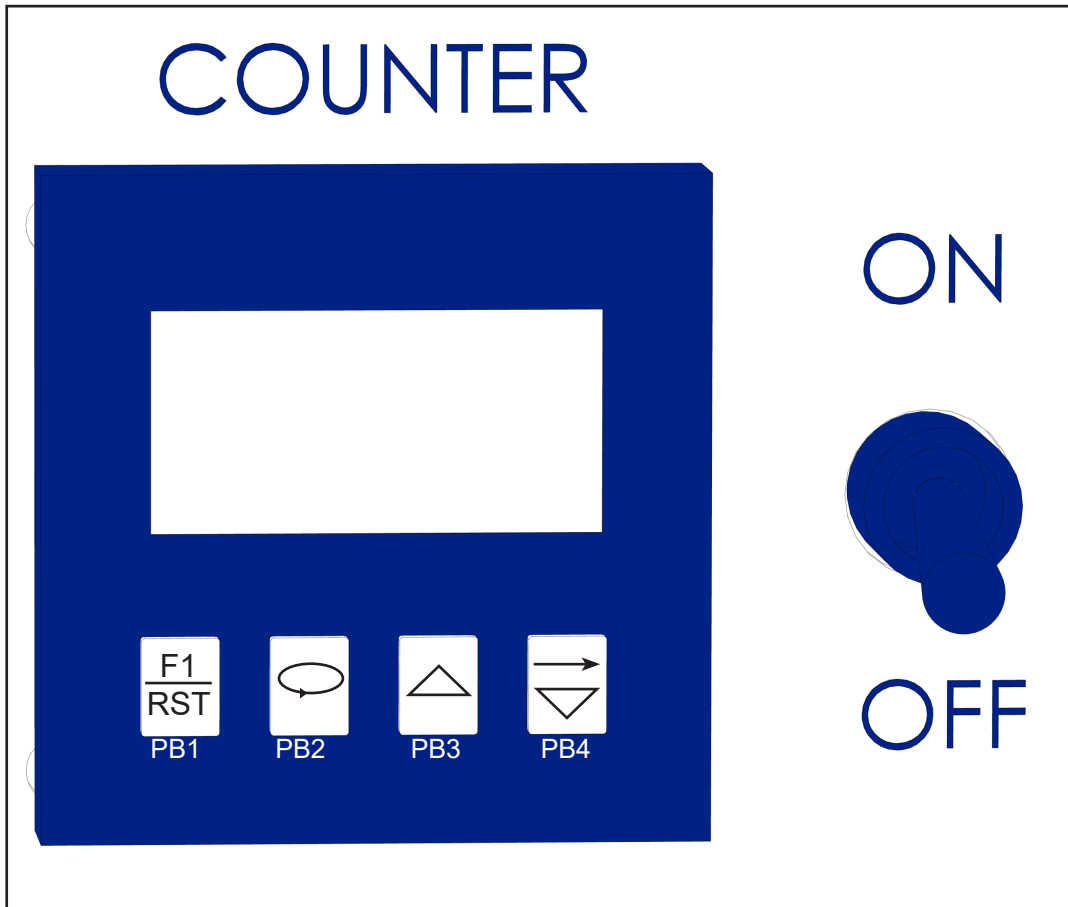
6:  
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### 4-1-1: C48 Counter Operation

#### Counter Operation



To operate the counter, first set the SR to count with the desired sensor using the switch on the main cabinet. Program the set counts using following procedure:

1. Press PB2 to access PRS1 (to begin slowdown), PRS2 (final stop count.)
2. Press PB4 to the digit that you are changing
3. Press PB3 to enter the number
4. Press PB2 to enter normal operating mode

Press "RST" to reset at any time. If you need any further information on the counter, refer to the counter operator manual included with this manual.

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### 4-1-2: Counter Program

<i>Entry</i>	digit
<i>Rc P5c</i>	-L
<i>P5cRLr</i>	1.00000
<i>dEc Pt</i>	-----
<i>Ent In</i>	C1-U5r
<i>OPER 1</i>	11
<i>Rc Pr5</i>	-y -y
<i>PrESEt</i>	670
<i>PrESEt</i>	1000
<i>P ltr Rc</i>	no
<i>Rc Out</i>	-L -L
<i>OutrES</i>	0.10 SEC
<i>OutPut 1t</i>	0.10
<i>OutPut 2t</i>	0.30
<i>rEUOut</i>	-n -n
<i>rEUAnu</i>	-n -n
<i>OutPμP</i>	-F -F
<i>U5r In 1</i>	inhib
<i>U5r In 2</i>	r5t-L
<i>U5r F 1</i>	r5t-L
<i>Code</i>	0
<i>ScroLL</i>	no
<i>FRcSEt</i>	no

To enter the programming mode on the counter, press and hold PB2 for 2 seconds.

Buttons PB3 and PB4 allow the user to change the values of a given parameter.

Once satisfied with the program, press PB2 for 2 seconds to save and exit the programming module.



1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

### 4-1-3: Prescalar Setup



The counter receives pulses in inch increments. To set the counter to count in units other than inches, the “Pre-Scalar” parameter is adjusted. A table of prescalar values is given.

### Prescaler Settings

Inches	1.00000
Inches X10	0.10000
Feet	0.08333
Yards	0.02778
Meters	0.02540

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

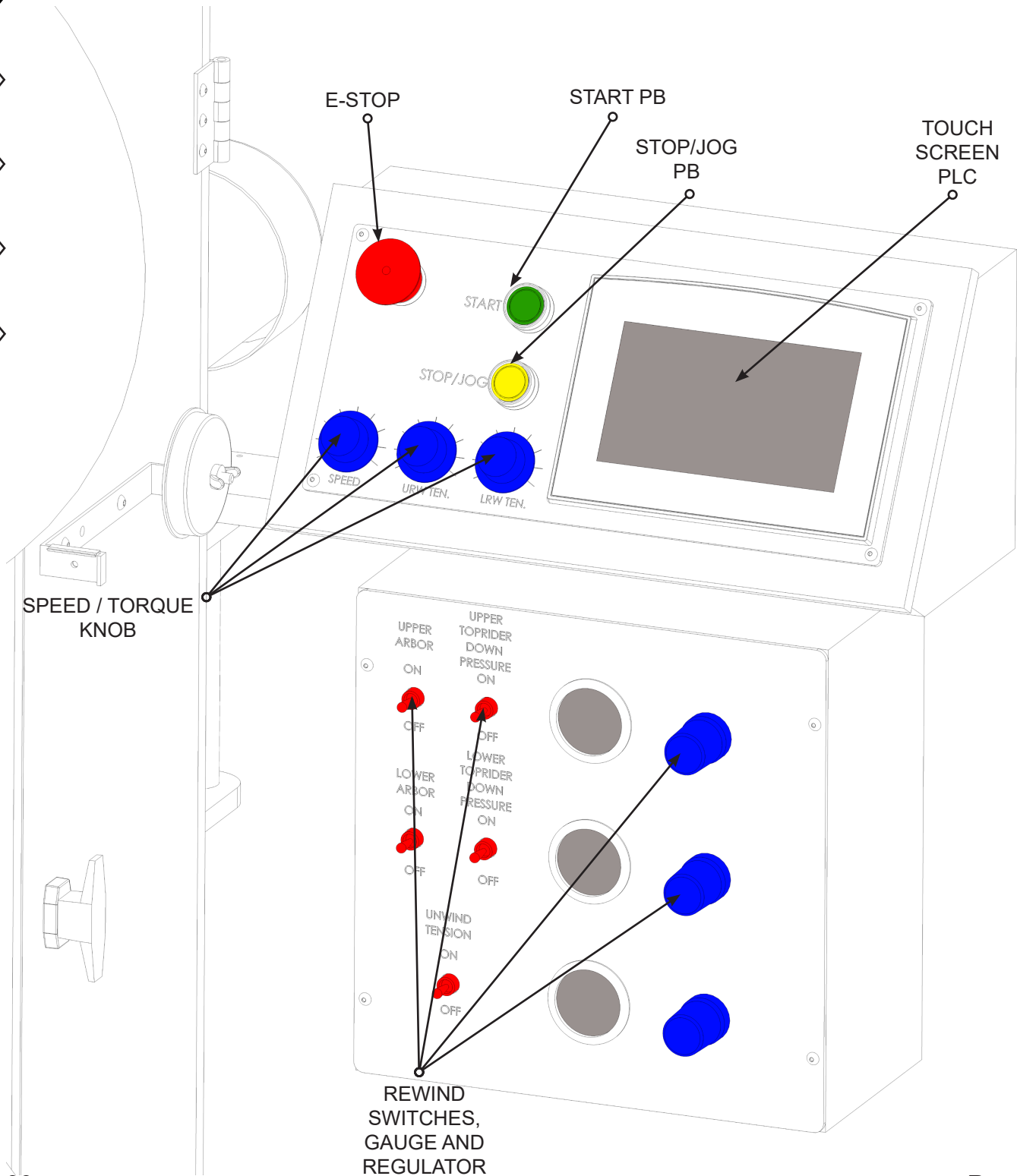
6:  
DWGs

7:  
T.S.

8:  
Warr.



### Operator Control Layout (PLC)





1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

## 4-2: PLC OPERATION

### 4-2-1: THE MAIN MENU



On power-up of the machine, the PLC will boot. This is analogous to a home PC booting. It can be expected to take between 30 and 60 seconds.

When the PLC has finished booting, the MAIN MENU will be displayed.

When the MAIN MENU is displayed, the PLC will lock-out the operator buttons and the machine will not run.

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

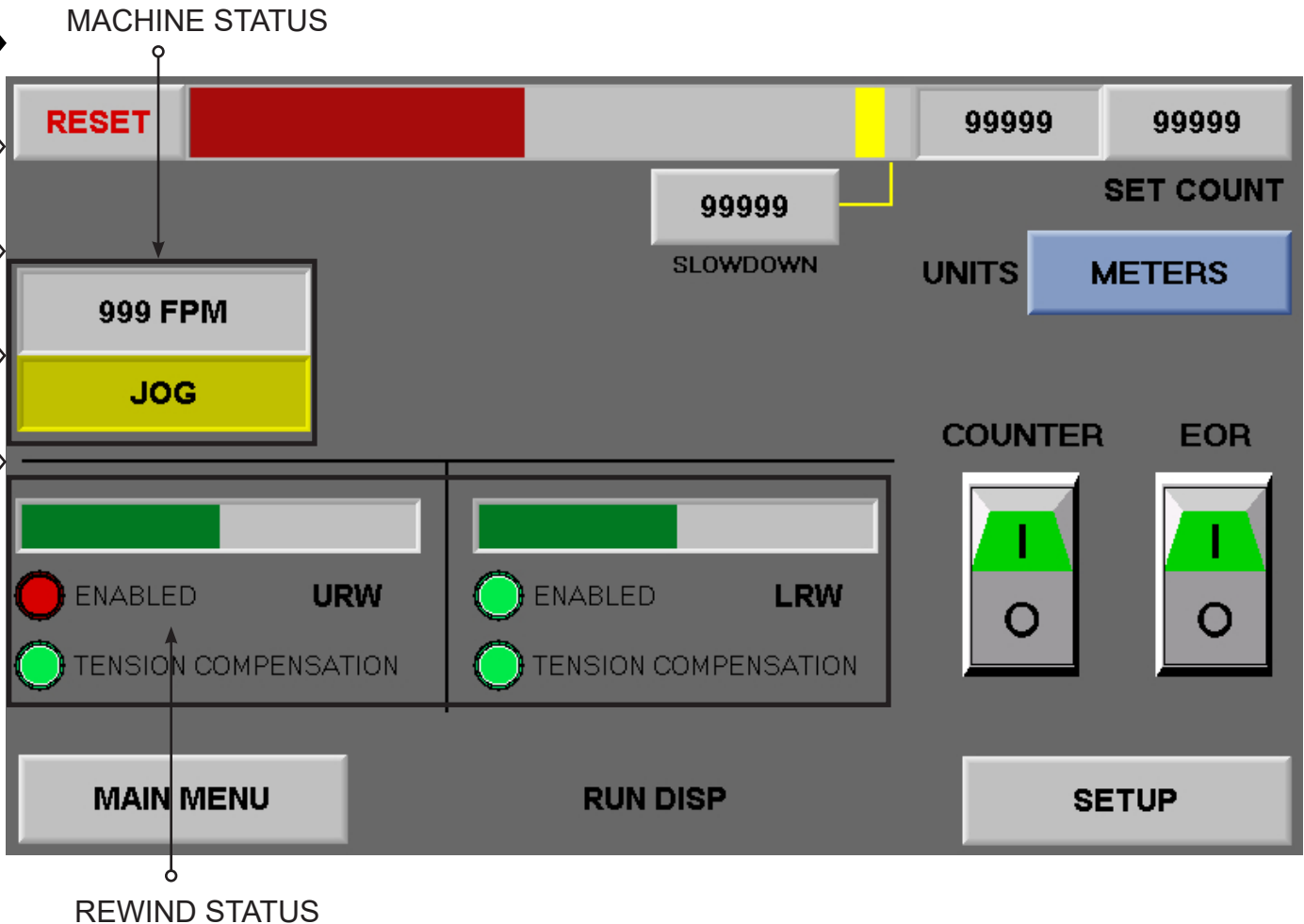
6:  
DWGs

7:  
T.S.

8:  
Warr.



### 4-2-2: THE RUN MANUAL SECTION

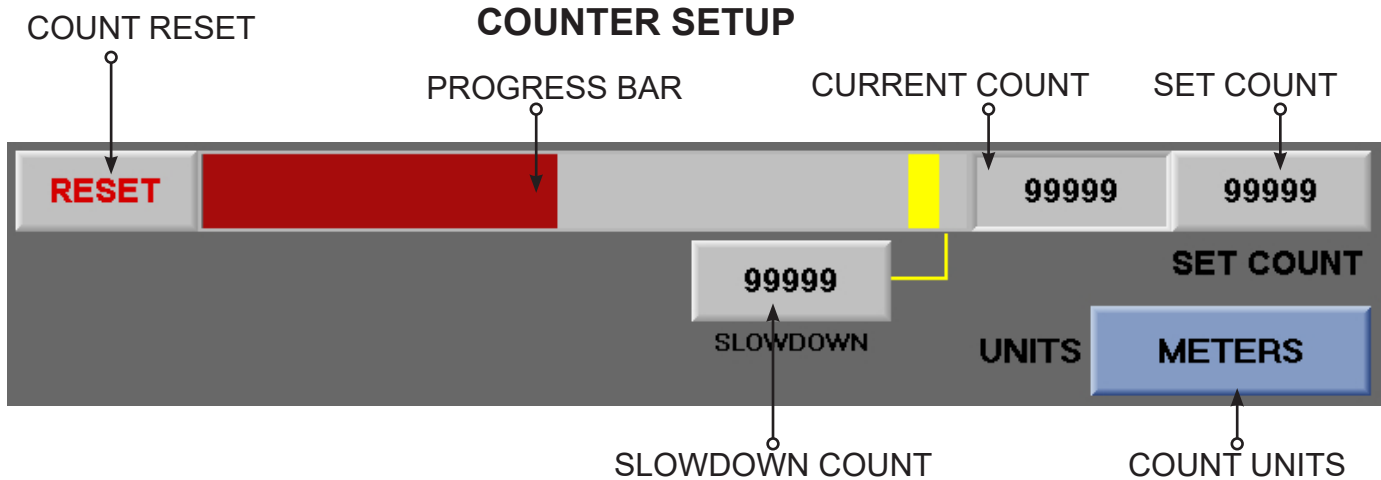


While in the RUN section of the HMI, the user has access to the basic controls for machine operation and status. The user controls will operate the machine to parameters set here while in the RUN section of the HMI.





- 1: Gen. Info
- 2: Install
- 3: Setup
- 4: Oper.
- 5: Maint.
- 6: DWGs
- 7: T.S.
- 8: Warr.



The current state of the counter is shown by the percentage scale bar on the right hand side of the screen. The fill is based on % of the set count. The precise count is shown left of the counter bar. Pressing the RESET button clears the count and toggling the COUNTER I/O switch will prevent the counter from incrementing.

The counter preset points can be modified by using the buttons near the counter. The user programs the SET COUNT and the SLOWDOWN point. While the counter is on, the machine will run at set speed until the SLOWDOWN count is reached. The machine will then travel at JOG speed until the SET COUNT is reached. Both points are programmed by touching the number. Once pressed, a dialogue will open to allow the user to edit the number.

**The SLOWDOWN count cannot be set higher than the SET COUNT. For this reason, it is often easier to program the SET COUNT first.**

## ERROR LIST

<b>END OF ROLL</b>	End of Roll Sensor is active. Machine will not run if "EOR" is on.
<b>COVER OPEN</b>	Slitting cover open. Machine will JOG only.
<b>VISION DEFECT</b>	Vision System detected process error. (If Equipped)
<b>TIMEOUT</b>	Machine stopped, left in RUN mode for 90 sec with no web movement.
<b>WASTE RW</b>	Waste Rewind Arbor active. (If Equipped)
<b>CAN ERROR</b>	CAN communication error. Machine will not run.
<b>WEB BREAK</b>	WEB BREAK error. Press STOP or START to clear.
<b>E-STOP</b>	E-STOP pressed on machine. Machine will not run.

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



### REWIND SETUP

REWIND ARBOR ENABLE

TENSION COMPENSATION  
SETUP

		START DIA	FINISH DIA	%TQ TO ADD
URW	ENABLED	99 in	99 in	999 %
LRW	DISABLED	99 in	99 in	999 %

MAIN MENU      RUN DISP      SETUP

The SETUP screen allows the user to disable a rewind arbor to prevent accidental actuation and to program values for the TENSION COMPENSATION feature.

The TENSION COMPENSATION function allows the user to program the machine to increase tension to the rewind arbors as the roll size increases. This is essential to preventing coning defects in larger rolls.

To use the tension compensation function, set the starting diameter. This is the core size. Then set the finished roll size as the finish diameter. Then set the % to add as a number 0-100. When engaged, the TENSION COMPENSATION function will linearly add that % to the tension output as the roll grows from the core to the finished size.

**NOTE: The tension compensation function will not provide more than 100% total rewind output. That is, if the torque set by the dial and the % to add are greater than 100% combined, output will plateau at 100%.**



1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

### 4-2-3: RUN RECIPE SECTION

RECIPE NAVIGATION

SAVE BUTTON

The recipe section will save the setup parameters for a job so that they can be re-used in the future. Counter Settings, Tension Compensation Settings, and Rewind Enable states can be saved with a Recipe Name entered by the user. When a recipe is changed, the SAVE CHANGES button will activate. If this is not pressed, the states will not be saved. When the recipe has been saved, the SAVE CHANGES button will dim.

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



### 4-2-4: Diagnostics



Enter "1111" when prompted to enter DIAGNOSTICS



1:  
Gen.  
Info

2:  
Install

3:  
Setup

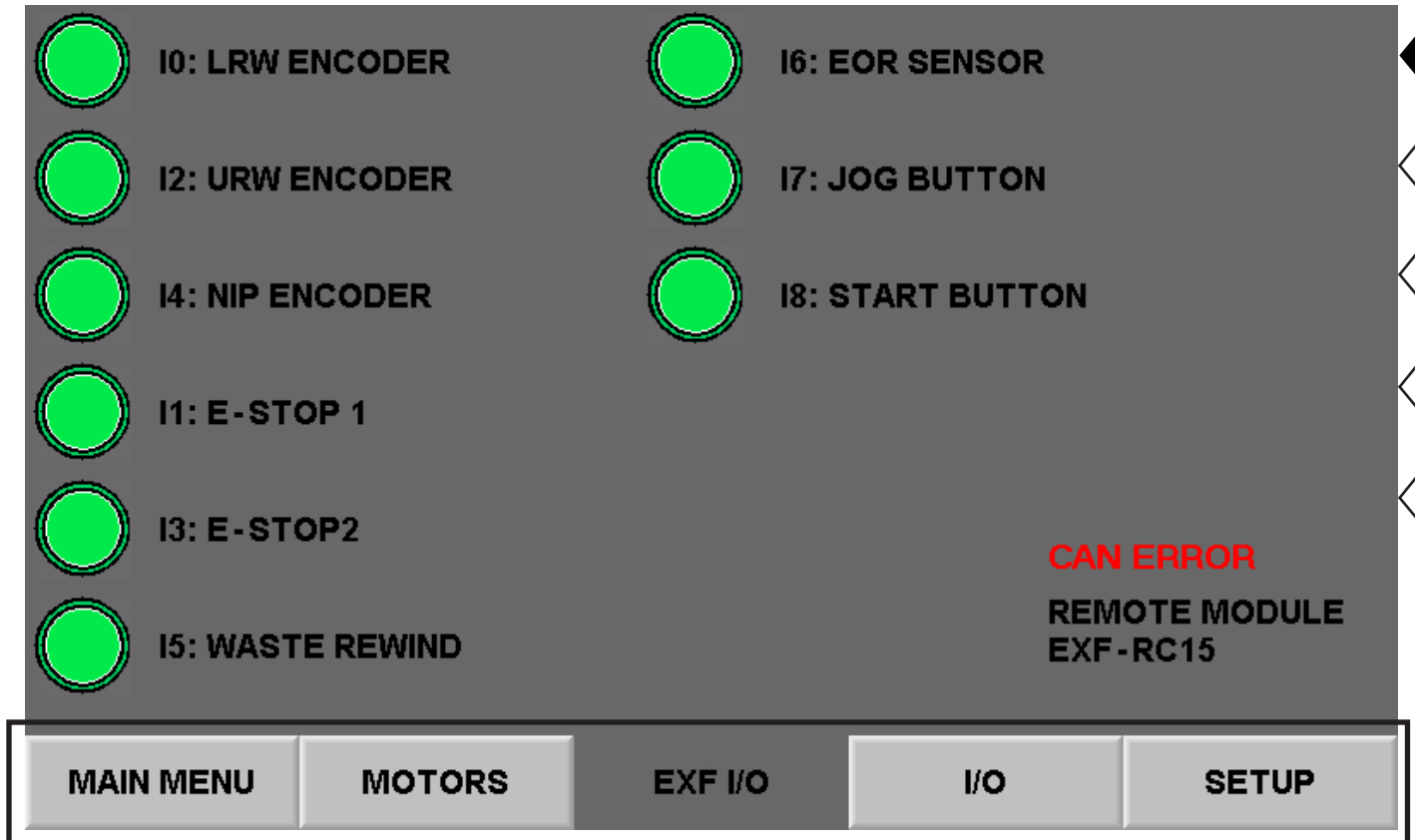
4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



Diagnostic Section Navigation

Inputs and Outputs on the EXF-RC15 PLC located within the main enclosure.

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

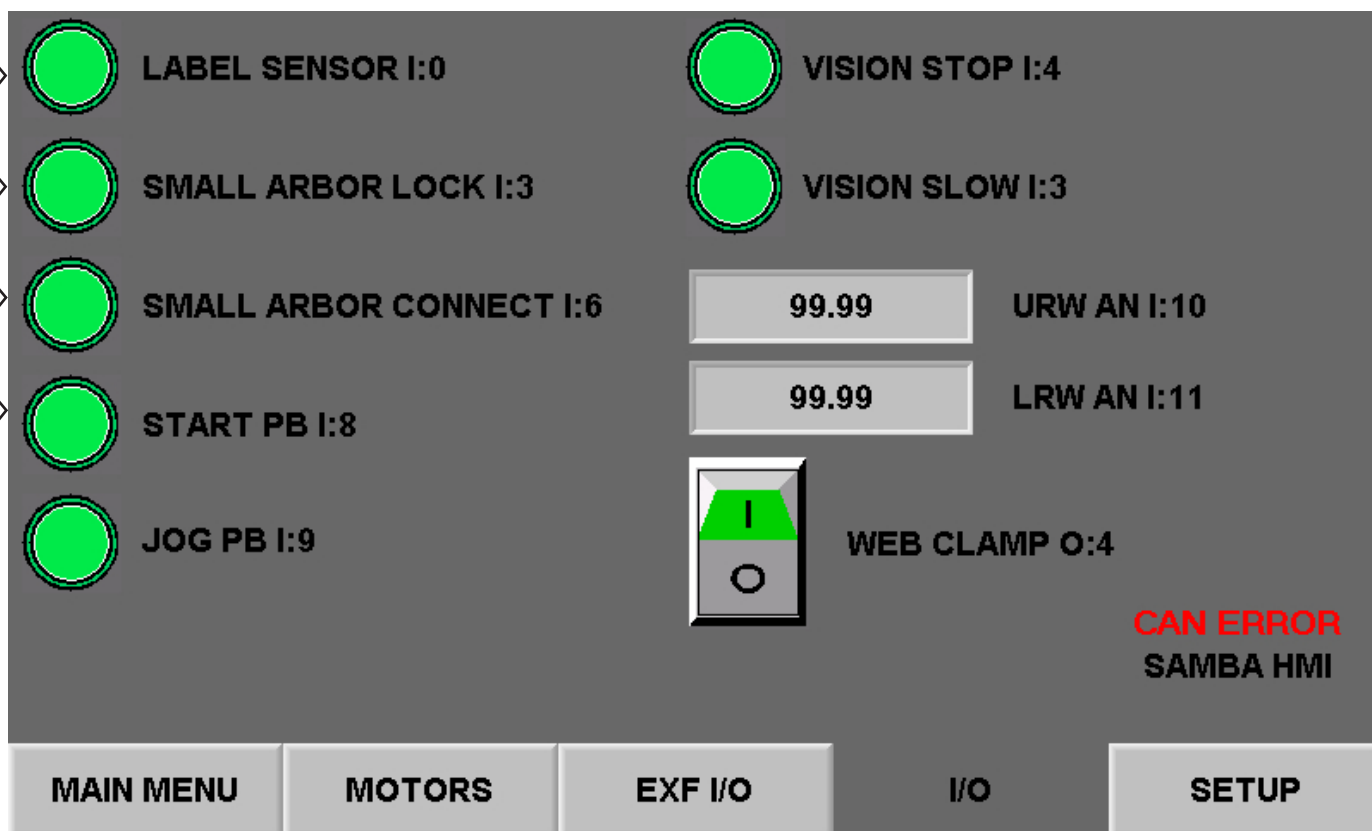
7:  
T.S.

8:  
Warr.



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



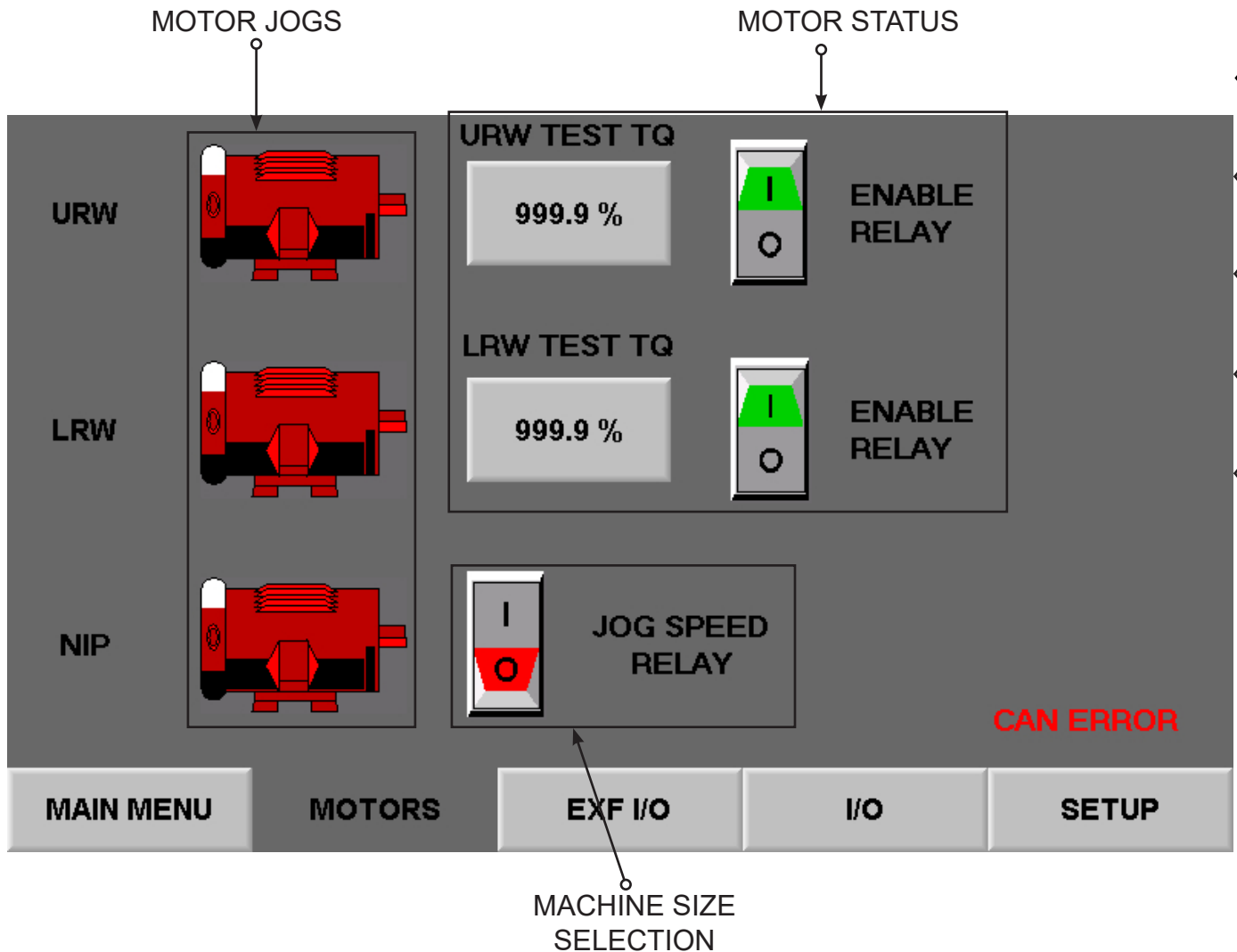
Inputs and Outputs on the SAMBA 7" PLC located on the operator enclosure.

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



- 1: Gen. Info
- 2: Install
- 3: Setup
- 4: Oper.
- 5: Maint.
- 6: DWGs
- 7: T.S.
- 8: Warr.



Diagnostic functions specific to the drive motors.

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

<b>NO LABEL SENS.</b>	<b>Sensor Configuration</b>			
<b>10" MACHINE</b>	<b>Machine Width</b>			
<b>SINGLE ARBOR</b>	<b>Single or Dual Arbor Rewind</b>			
<b>-99999</b>	<b>Hour Meter</b> HOLD TO RESET			
<b>CAN ERROR</b>				
<b>MAIN MENU</b>	<b>MOTORS</b>	<b>EXF I/O</b>	<b>I/O</b>	<b>SETUP</b>

### Sensor Configuration

### Machine Width

### Single or Dual Arbor

### Hour Meter

Enables the HMI for a Label sensor

Small Arbor functions are enabled in the 13"-18" Width selec-

The second arbor functions are hidden with Single Arbor selec-  
tion

An hour meter records amount of time spend in "RUN" for main-  
tenance record keeping.





1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

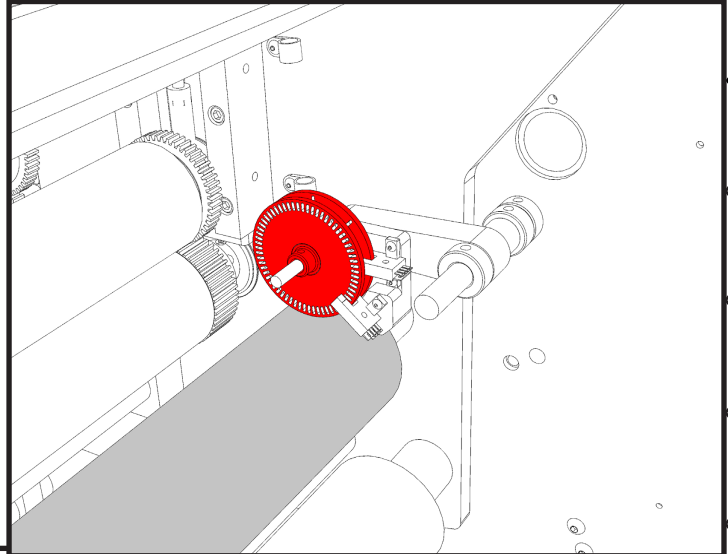
### 4-2-5: WEB BREAK

The SR Series is equipped with a safety routine to stop the machine in the event of web break. (Loss of material moving through the machine.)

The WEB BREAK routine relies on computing the diameter of the rewind roll by comparing the RPMs of the rewind arbor to the linear measurement of web moving through the nip section.

The linear measurement of web is taken from a counter wheel in contact with an idler roller located in the post-process section of the nip assembly. This is a 64 count per rev wheel, and with a diameter of 2.547", it registered 1/8" travel for every encoder pulse.

The RPM measurement of the arbor is taken by a similar encoder mounted inside the machine.



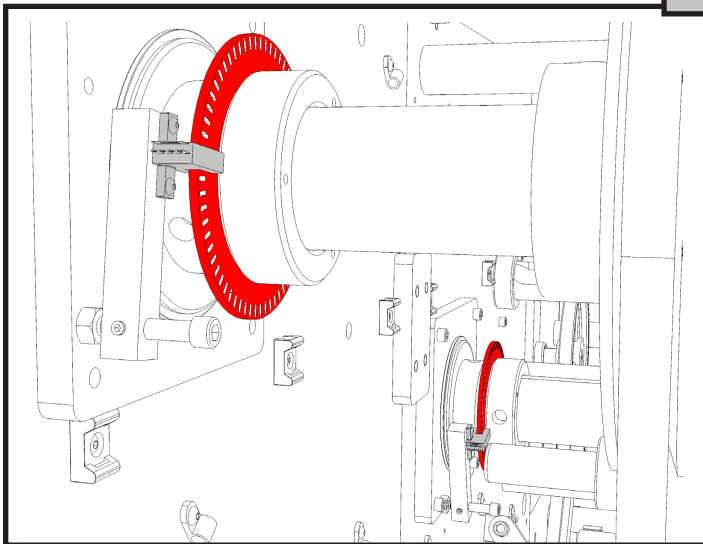
NIP ENCODER

This encoder registers 64 pulses for every revolution of the rewind arbor. Consequently, the amount of material measured per-pulse increases with roll diameter.

From these two frequencies, we have:

$$(NIP \text{ Hz} / RW \text{ Hz}) = \text{ROLL DIAMETER} / 2.547$$

Once the machine is moving, a register containing the last 5 values of calculated roll diameter is maintained. If the average of this register is less than 2" (minimum arbor diameter) a web break is triggered. If the diameter is seen to decrease during the run, a web break is triggered. (The rewind roll should never get smaller...)



REWIND ENCODER

NOTE: Due to the nature of these calculations, various sources of error may result in false web-breaks.

The most common source of error is slipping on the NIP encoder. When the material slips on the NIP encoder, the diameter is seen to be artificially small. This will cause repeated web-breaks and a machine that will seem to not want to run a job.

If this happens, check the contact of the counter wheel to the idle roll to make sure the surface is clean. Secondly, check the tension to make sure the material has adequate "grab" on the idle roller.

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

---

### 4-2-6: PLC RESOURCES

The PLC is manufactured by Unitronics.

866-666-6033  
usa.sales@unitronics.com  
*www.unitronics.com*

The PLC is programmed using:

#### VisiLogic 9.7.44

VisiLogic is available for free download at [www.unitronics.com](http://www.unitronics.com). Consult the Unitronics website for technical details on the PLC.

Motor drives are made by K&B Electronics

Spares, technical support and service are provided by:

**AZTECH Converting Systems Inc**  
212 W Lodge St.  
Phoenix, AZ 85283  
**techservice@aztechconverting.com**  
**(800) 829 - 8351**



1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

### 4-3: Rewinding Large Diameter Rolls

When rewinding large diameter rolls with the SR-Series, it is critical to steadily increase tension as the roll diameter increases and minimize trapped air in the finished rolls. It is recommended that the operator set the rewind tension at a low setting at the beginning of the roll, and gradually increase the rewind tension by either manually entering larger numbers into the re-wind tension field on the PLC as the diameter increases or by selecting the diameter compensation option. (PLC)

To achieve consistent large-diameter rolls, it is critical to use the top-rider assembly to avoid trapping air. If your SR-Series machines not equipped with a top-rider, they are easily installable and may be purchased by contacting AZTECH Machinery.

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

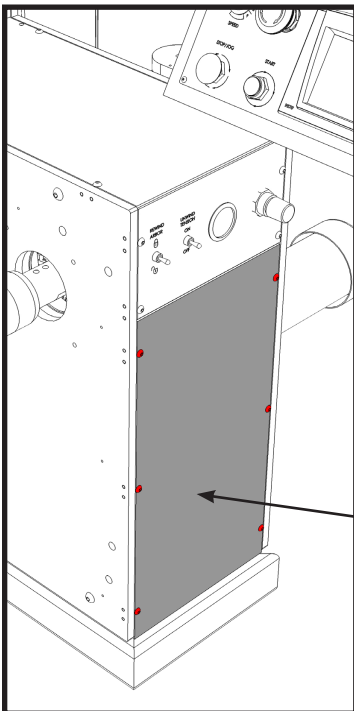
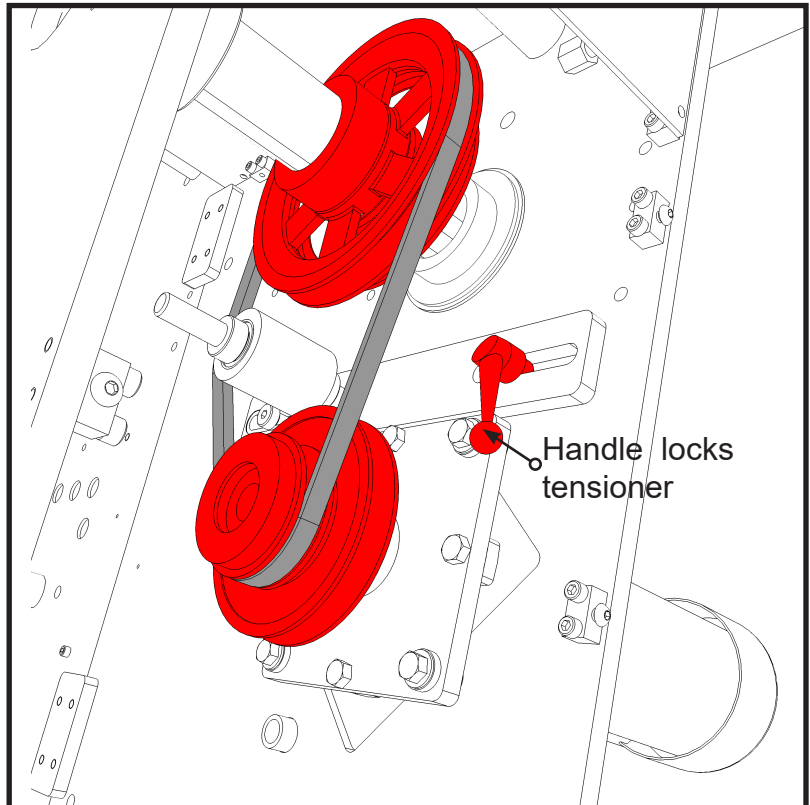
8:  
Warr.



### 4-4: Increasing Web Speed

The comes with default settings (see figure 4-D) that allow for peak performance for slitting and rewinding various substrates and roll sizes. If you wish to increase the web speed, you may at your discretion, switch over the rewind belt(s) which will change the ratio of web speed as follows:

1. Open or remove rewind panel.
2. Loosen handle by turning counter-clockwise and pulling belt-tightener-arm outward.
3. With belt loose, change over to opposite pulleys.
4. Push belt-tightener arm inward and tighten handle clock-wise.
5. Close or replace rewind panel.

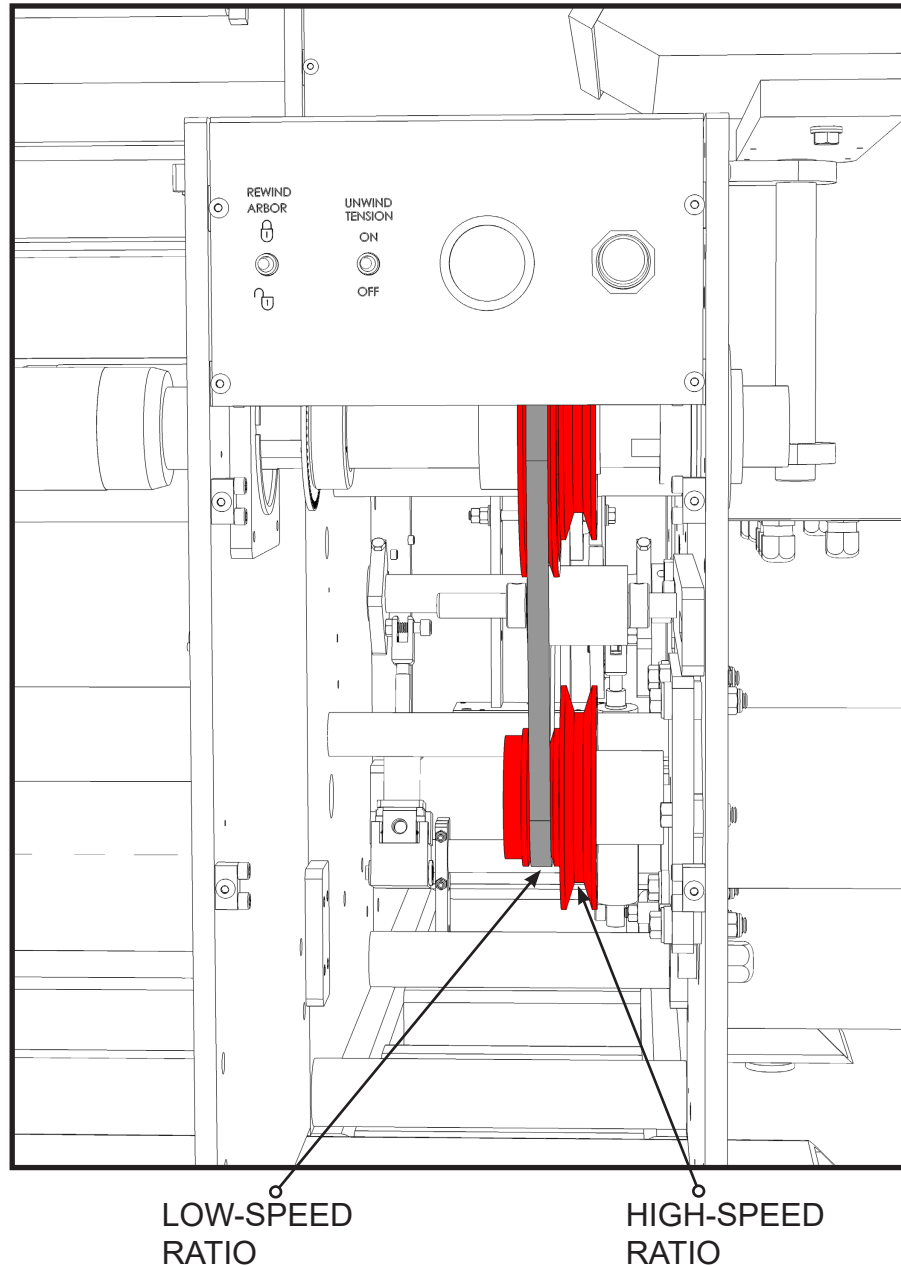


# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



- 1: Gen. Info
- 2: Install
- 3: Setup
- 4: Oper.
- 5: Maint.
- 6: DWGs
- 7: T.S.
- 8: Warr.



**CAUTION: BY SWITCHING BELTS TO INCREASE WEB SPEED, THE SR WILL TAKE LONGER TO STOP, ESPECIALLY WHEN RUNNING AT HIGH SPEED WITH A LARGE OR HEAVY UNWIND ROLL. IF DIFFICULTIES OCCUR, SWITCH BELTS BACK TO THE DEFAULT SETTING.**

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

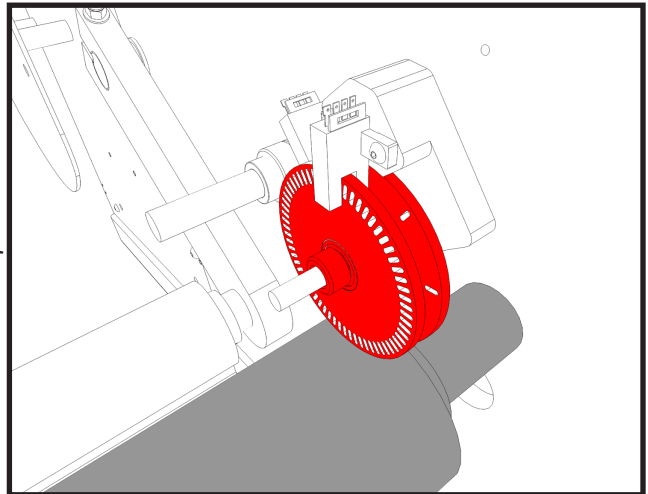


## Section 5: Maintenance

### 5-1: Maintenance

Your SR-Series Slitter Rewinder is rigidly constructed to provide your company years of productivity, while being relatively maintenance free. However, to aid in assuring maximum performance and longevity, the occasional following maintenance is recommended:

- Apply a small amount of clear silicone grease to all gears.
- Inspect belts for tightness and wear and tighten or replace as necessary.
- Clean rubber nip roll using a rag and denatured alcohol. DO NOT USE A RAZOR BLADE OR ABRASIVE PAD AS THEY WILL CAUSE IRREPARABLE DAMAGE TO THE ROLL SURFACE.
- Replace any of the slitting blades if they are noticeably chipped or damaged, or if you notice excess slitting dust or if the blades are not cutting cleanly.
- Clean counter wheel (see figure 5-A) by blowing with air nozzle assuring all holes are free of dust or debris.





1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper

5:  
Maint.

6:  
DWGs

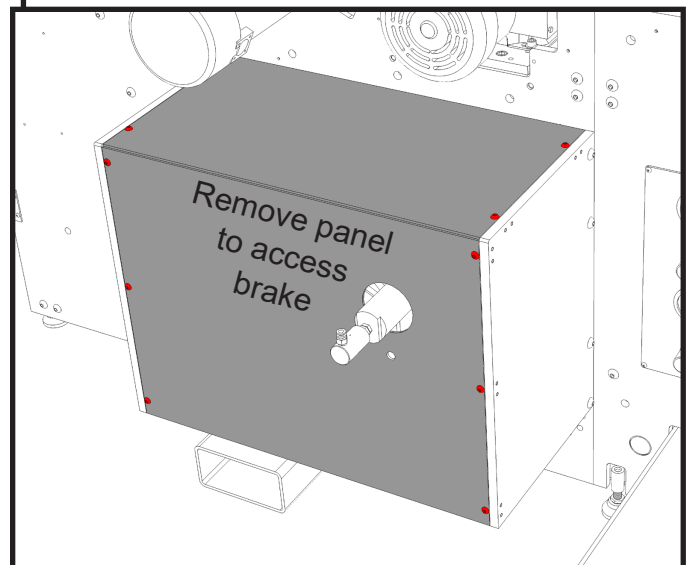
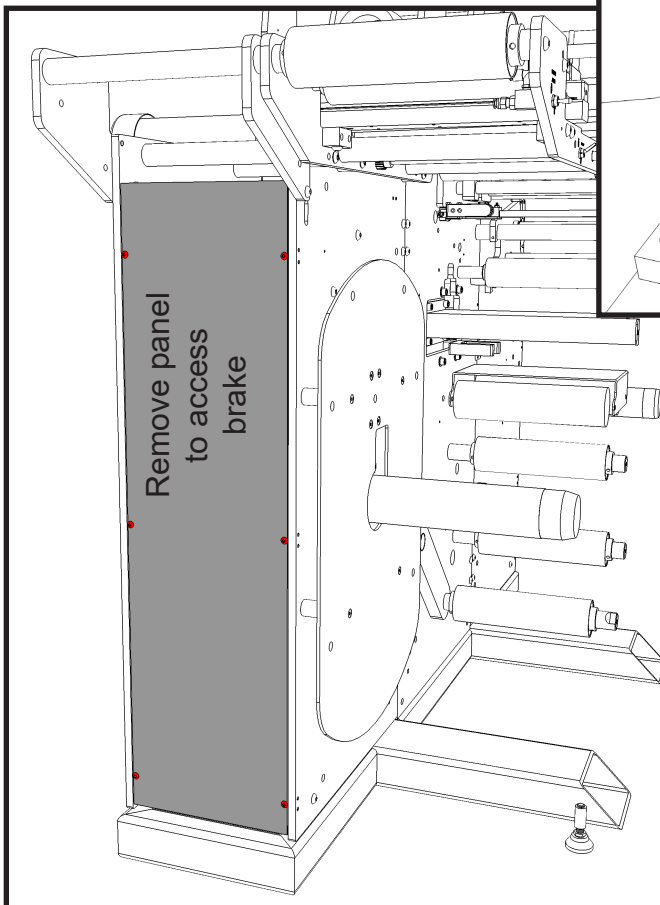
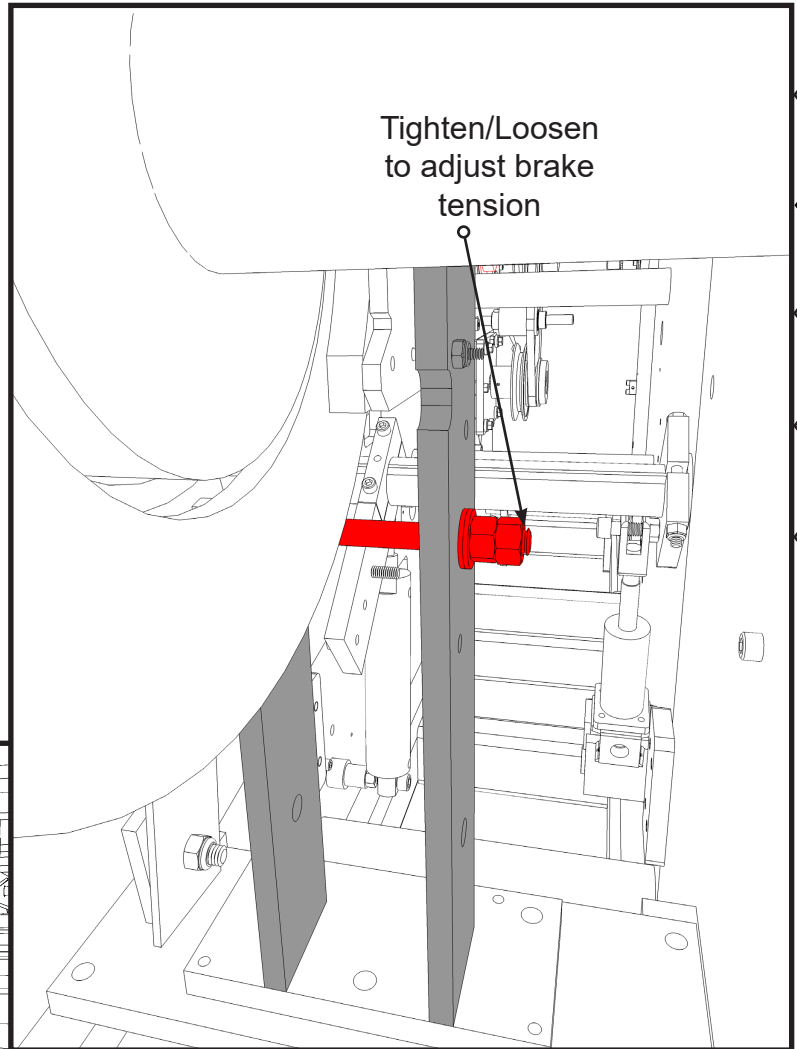
7:  
T.S.

8:  
Warr.

### 5-2: Adjusting the Unwind Brake

The unwind brake on the may require occasional adjustment. To adjust the brake, follow these simple instructions:

1. Remove unwind station cover.
2. Raise and hold dancer arm into a level position and while holding in level position, spin the unwind spindle with other hand. The unwind spindle should spin while feeling some resistance. If the spindle is free moving or unable to move, adjust brake by loosening nut and lock nut on backside of the unwind station, adjust accordingly, tighten nut and re-check. Repeat this procedure until properly adjusted.
3. Replace unwind station cover.



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

1:  
Gen.  
Info

2:  
Install

3:  
Setup

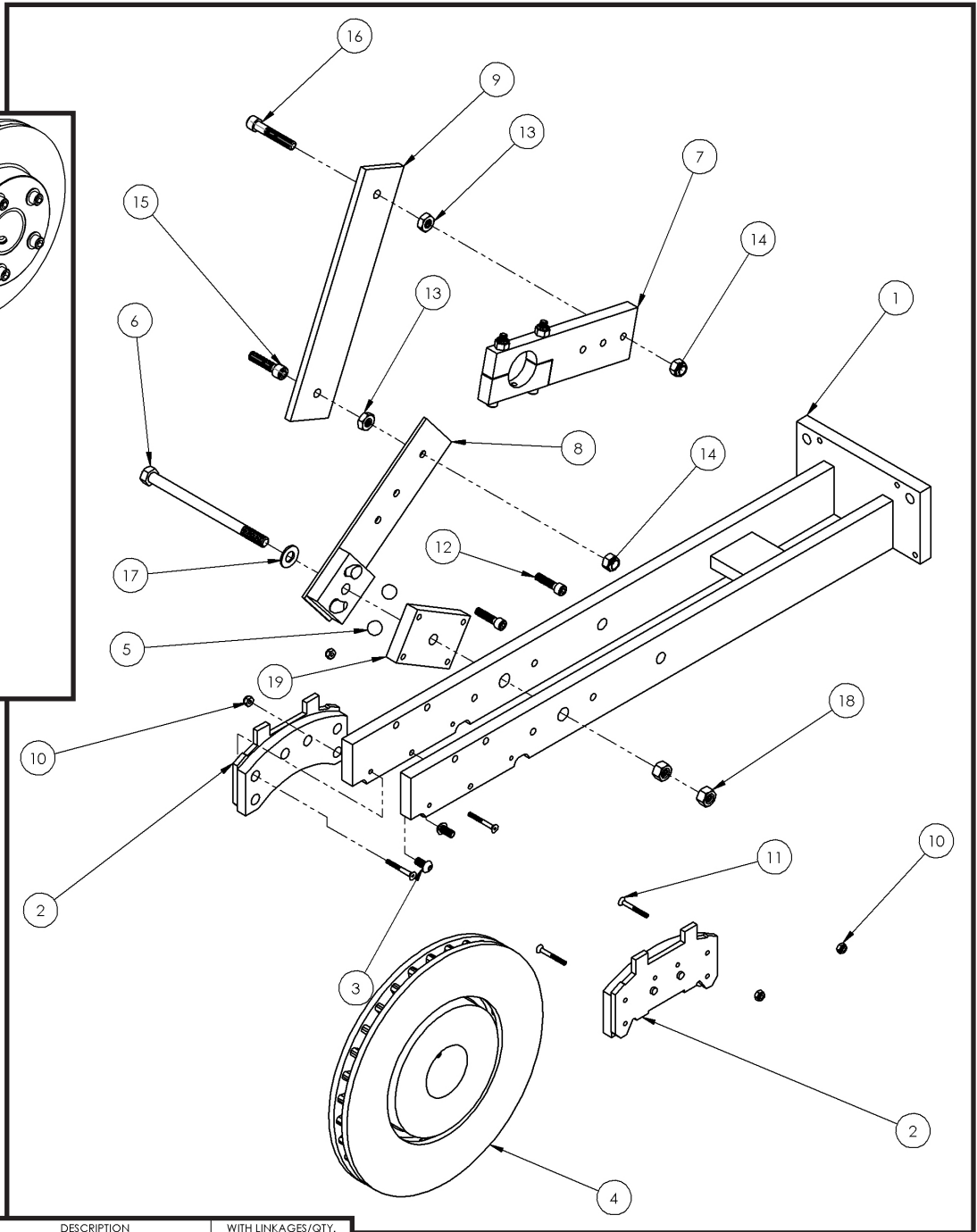
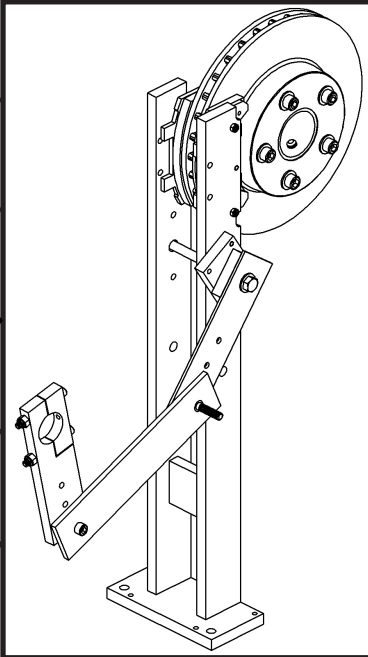
4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



ITEM NO.	PART NUMBER	DESCRIPTION	WITH LINKAGES/QTY.
1	14196	BRAKE FORK WELDMENT, BSR	1
2	brake pad MOVABLE	DISC BRAKE PAD	2
3	BTNHD...250-20 UNC_0.5_SIMP	BUTTON HEAD CAP SCREW 1/4-20 X 1/2"	2
4	11418	BRAKE ROTOR ASSEMBLY	1
5	1_2 BALL	MCMMASTER-CARR# 96455K56	2
6	HEX BOLT...375-16 UNC_5-5_SIMP	HEX BOLT GRADE 5, 3/8-16 X 5.5"	1
7	11813	CAM BRAKE MASTER ARM PIVOT	1
8	11823	BRAKE PIVOT ARM ASSEMBLY, BSR, SR, DM	1
9	11822	BRAKE TRANSFER LINK, NEW REWINDER	1
10	HEX NUT 6-32 LOCK	HEX NUT 6-32 NYLOCK	4
11	FLH SCH...82-138-32 UNC_1-25_SIMP	FLAT HEAD CAP SCREW 6-32 X 1-1/4"	4
12	SCH...250-20 UNC_1_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1"	2
13	HEX MS NUT_0-3125-18 UNC_SIMP	HEX NUT 5/16-18	2
14	HEX NUT...3125-18 UNC_LOCK	NYLOCK NUT 5/16-18	2
15	SCH...3125-18 UNC_1-28_SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4"	1
16	SCH...3125-18 UNC_1-28_SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-3/4"	1
17	WSHR A...375N	WASHER 3/8 N	1
18	HEX NUT...375-16 UNC_0_SIMP	HEX NUT 3/8-16	2
19	11818	BRAKE RAMP PLATE, FIXED, BSR, SR, RM	1

### Unwind Brake Assy

### Section 6: Station Detail



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper

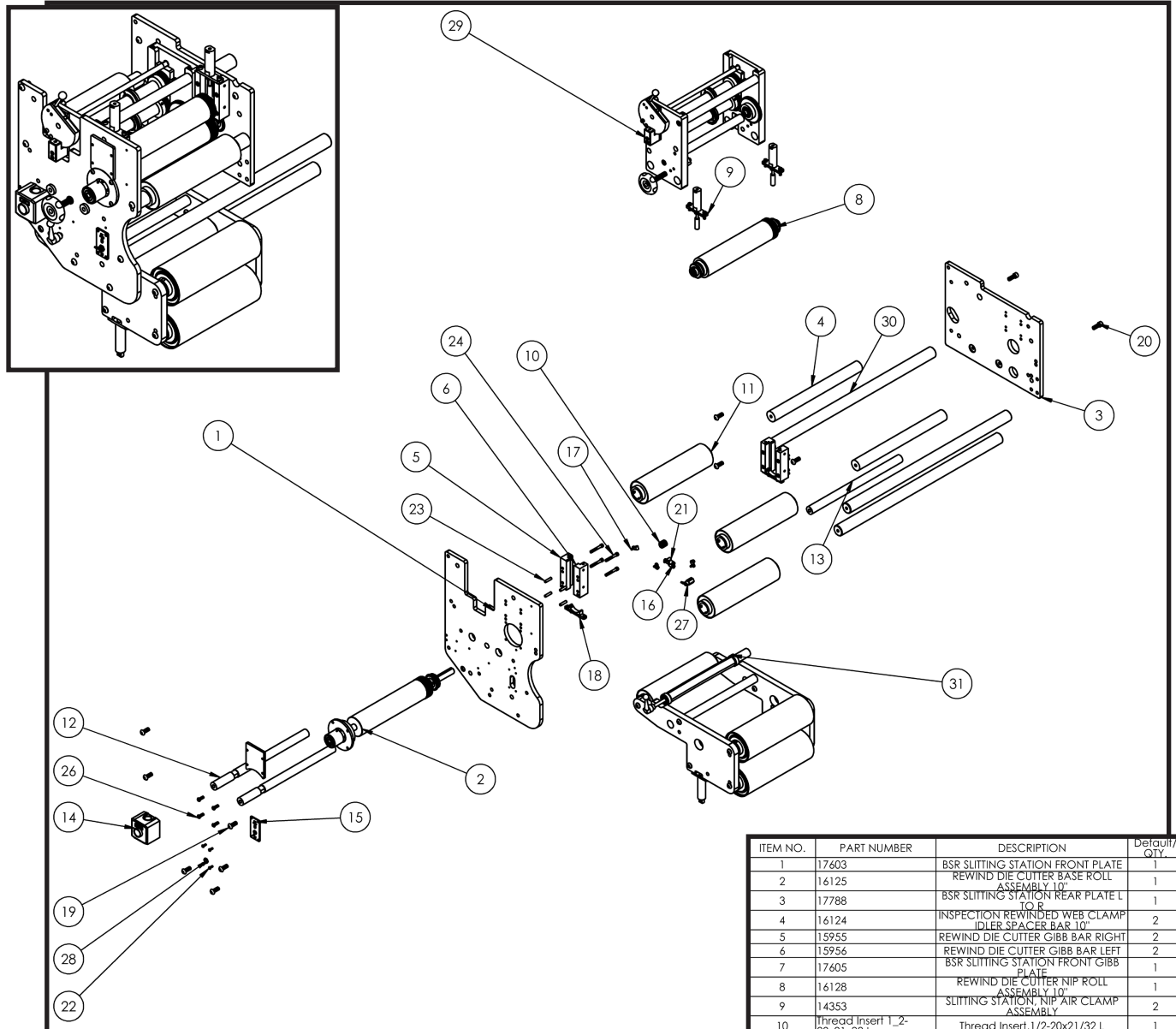
5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.

### Slitting Station, 10" (AZT: 21689)



ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	17603	BSR SLITTING STATION FRONT PLATE	1
2	16125	REWIND DIE CUTTER BASE ROLL ASSEMBLY 10"	1
3	17788	BSR SLITTING STATION REAR PLATE L TO R	1
4	16124	INSPECTION REWINDED WEB CLAMP IDLER SPACER BAR 10"	2
5	15955	REWIND DIE CUTTER GIBB BAR RIGHT	2
6	15956	REWIND DIE CUTTER GIBB BAR LEFT	2
7	17605	BSR SLITTING STATION FRONT GIBB PLATE	1
8	16128	REWIND DIE CUTTER NIP ROLL ASSEMBLY 10"	1
9	14353	SLITTING STATION NIP AIR CLAMP ASSEMBLY	2
10	Thread Insert 1_2-20x21_32 L	Thread Insert 1/2-20x21/32 L	1
11	10787	IDLER ASSEMBLY 1-3/8 BORE 10"	3
12	17934	REWIND DIE CUTTER SUI STATION SPT SHAFT 10"	2
13	17935	DM 4010, MULTILAMINATION, STAND OFF	1
14	6HK25	STOP SWITCH WITH HOUSING	1
15	15977	REWIND DIE CUTTER NIP DRIVE VALVE PLATE	1
16	KQ2U03-00	ONE TO TWO 4MM UNION	1
17	1_4 CORD CLAMP WITH BOLT	1/4 cord clamp with 8-32 x 1/2 button head cap screw	3
18	16143	NIP LIFT ASSEMBLY	2
19	BTNHD ~375-16 UNC 1 SIMP	BUTTON HEAD CAP SCREW 3/8-16 X 1"	9
20	SCH ~375-16 UNC 1 SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1-3/4"	2
21	BTNHD ~164-32 UNC 1 SIMP	BUTTON HEAD CAP SCREW GRADE 5 8-32 X 1"	1
22	BTNHD ~164-32 UNC 0-5 SIMP	BUTTON HEAD CAP SCREW 8-32 X 1/2"	4
23	DWL PIN GRD ~25000 1	DOWEL PIN 1/4" DIA X 1"	8
24	SCH ~250-20 UNC 1 SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4"	4
25	SCH ~250-20 UNC 1 SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-1/2"	4
26	BTNHD ~250-20 UNC 0-75 SIMP	BUTTON HEAD CAP SCREW 1/4-20 X 3/4"	4
27	TV-3F ASSEMBLY	3-Way Toggle Valve, Short (Plastic Toggle)	1
28	MJTV NUT	MJTV SERIES NUT	1
29	16307	REWIND DIE CUTTER SLITTING STATION L TO R 10"	1
30	17936	IDLER SHAFT, 2 7/16" LONG TAPPED ONE END	3
31	17937	BSR DUAL ARBOR WEB CLAMP ASSEMBLY 10"	1

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

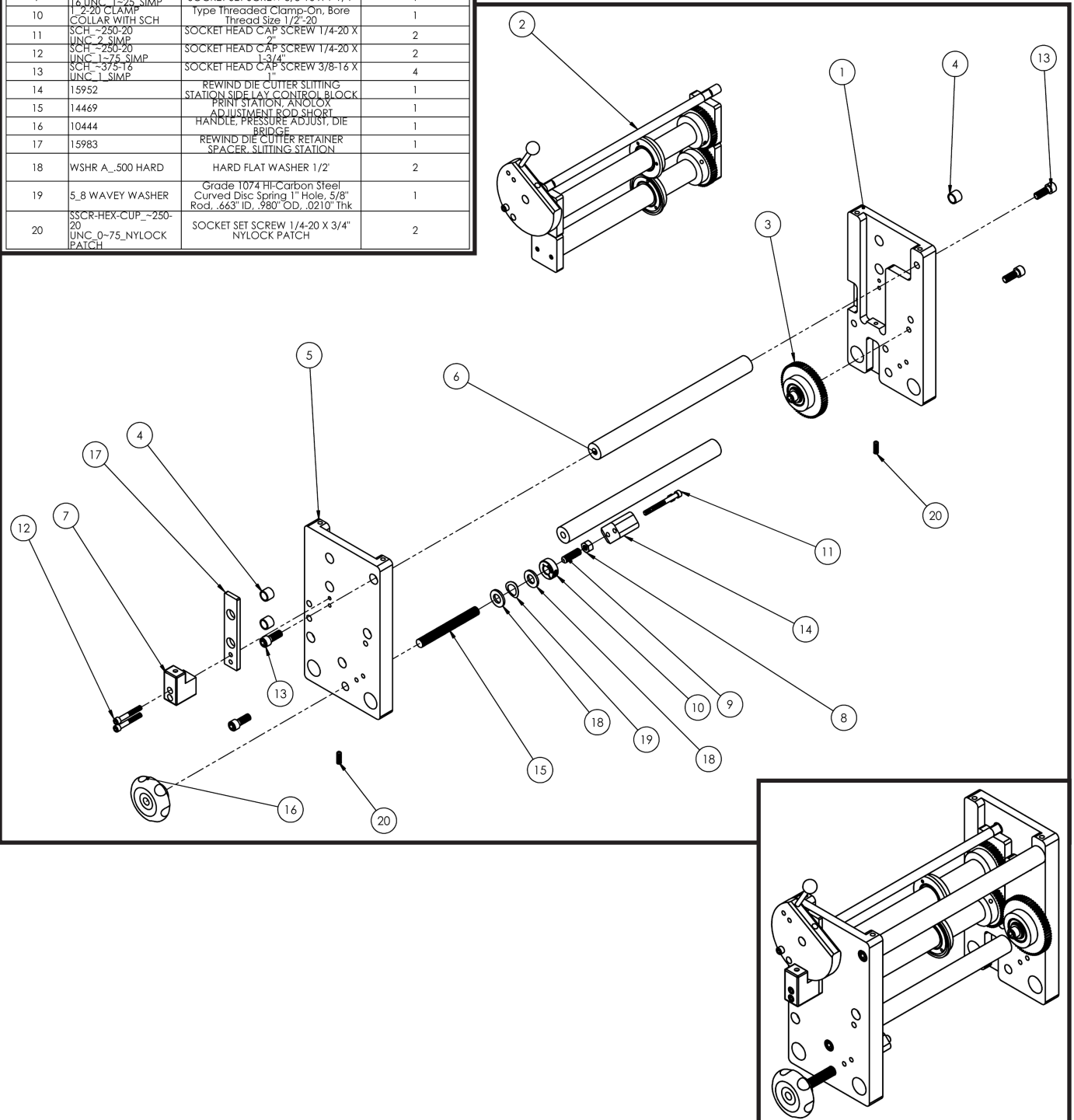
7:  
T.S.

8:  
Warr.



ITEM NO.	PART NUMBER	DESCRIPTION	ROTARY SHEAR/QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	14373	BSR, ROTARY SHEAR ASSEMBLY, 10"	1
3	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
4	1_2 X 5.8 X 1_2 INCH	BUSHING, 6391K211	3
5	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
6	16308	SLITTING STATION ER, STANDOFF 10"	2
7	11778	RETAINER BRACKET, SLITTING STATION, BSR	1
8	HEX NUT _375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
9	SSCR-HEX-CUP_-375-16 UNC_1-25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
10	1_2-20 CLAMP	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
11	SCH_-250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
12	SCH_-250-20 UNC_1-75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
13	SCH_-375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4
14	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
15	14469	PRINT STATION, ANILOX ADJUSTMENT ROD SHORT	1
16	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
17	15983	REWIND DIE CUTTER RETAINER SPACER, SLITTING STATION	1
18	WSHR_A_500 HARD	HARD FLAT WASHER 1/2"	2
19	5_8 WAVY WASHER	Grade 1074 Hi-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
20	SSCR-HEX-CUP_-250-20 UNC_0-75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2

### Slitting Insert, Rotary Shear 10" (AZT: 21626)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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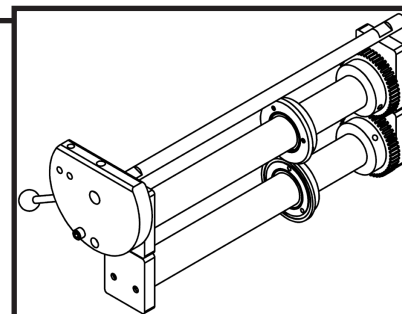
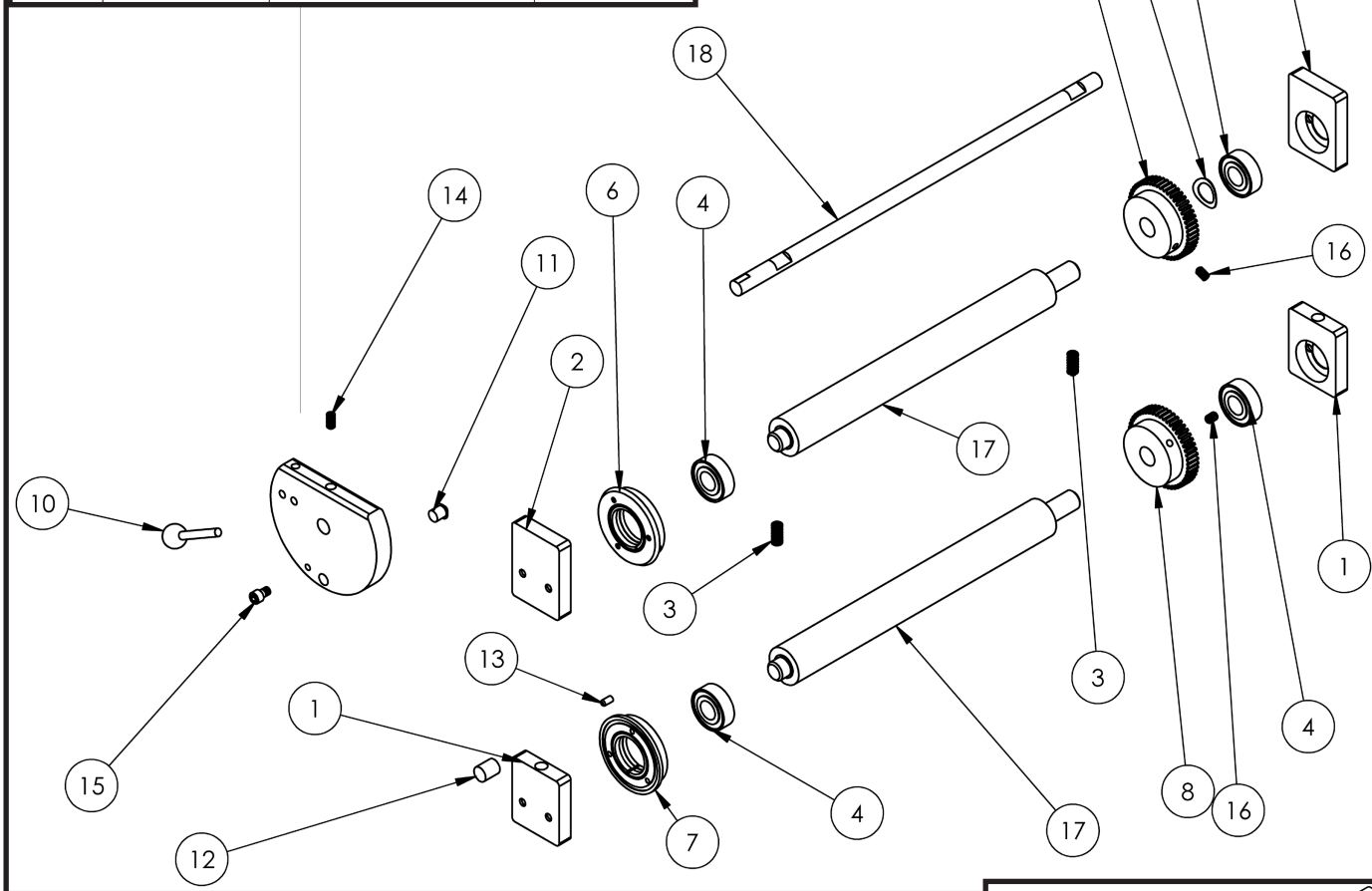
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ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/ QTY.
1	11781	GIBB BLOCK, BLANK, LOWER, SLITTING STATION	2
2	11779	GIBB BLOCK, UPPER	2
3	9657K156	COMPRESSION SPRING, .38 x .048 x 1.5	2
4	18991	1623 BEARING 1 3/8 OD X 5/8 ID SEALED	4
5	5_8 WAVEY WASHER	Grade 1074 Hi-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
6	11635	UPPER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
7	11629	LOWER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
8	10667	GEAR, S2050-14-1/2, 5/8 BORE	2
9	11787	KNOB, ROTARY SHEAR	1
10	6303K23	STEEL LEVER HANDLE	1
11	11786	THRUST BUTTON, ROTARY SHEAR	1
12	11788	PUSH PIN, UPPER SHEAR SHAFT	1
13	SSCR-HEX-CUP -T90-24 UNC, 0-375, NONE		1
14	SSCR-HEX-CUP -250-20 UNC, 0-5, SIMP	SOCKET SET SCREW 1/4-20 X 1/2"	1
15	SCH -250-20 UNC, 0-375, SIMP	SOCKET HEAD CAP SCREW 1"4-20 X 3/8"	1
16	SSCR-HEX-CUP -250-20 UNC, 0-375, SIMP	SOCKET SET SCREW CUP PT 1/4-20 X 3/8"	2
17	12002	BLADE ARBOR, SLITTING STATION 10"	2
18	12005	CAM SHAFT, SLITTING STATION 10"	1

### Slitting Insert, Rotary Shear, 10" (AZT: 14373)



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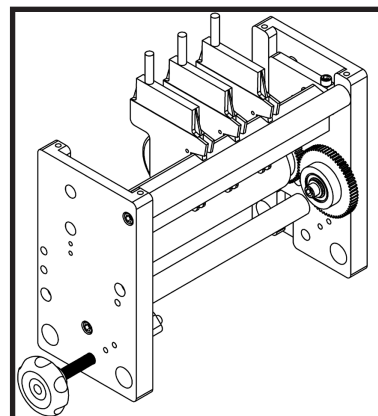
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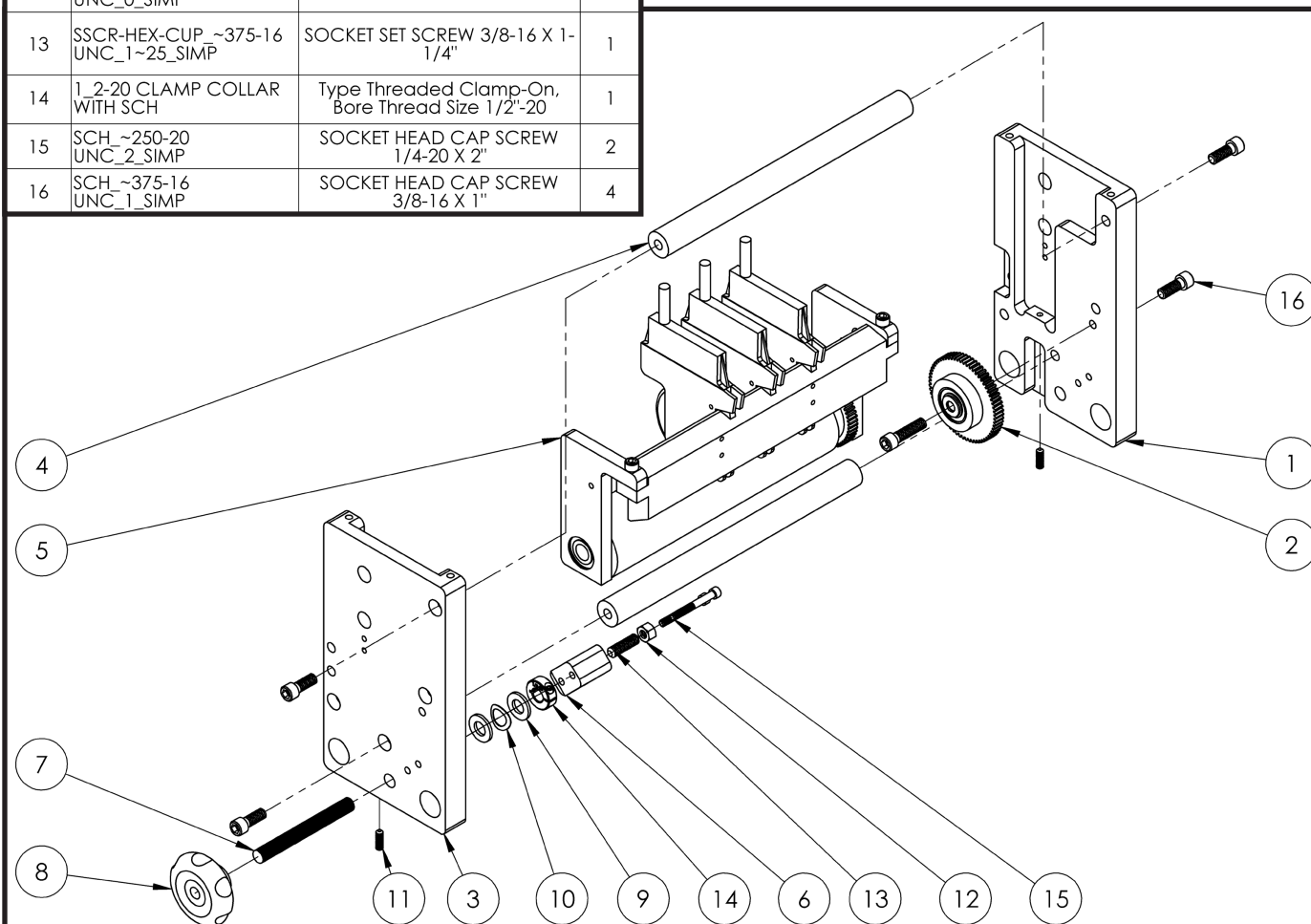
# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
3	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
4	16308	SLITTING STATION ER, STANDOFF 10"	2
5	12634	CRUSH KNIFE ASSEMBLY, 10" BSR, SR	1
6	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
7	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
8	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
9	WSHR A_.500 HARD	HARD FLAT WASHER 1/2"	2
10	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
11	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2
12	HEX NUT_~375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
13	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
14	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
15	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
16	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4



**Crush Knife Assembly, 10" (AZT: 21625)**



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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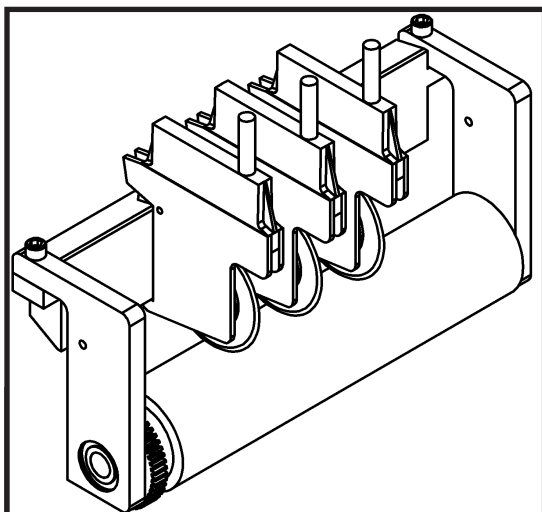
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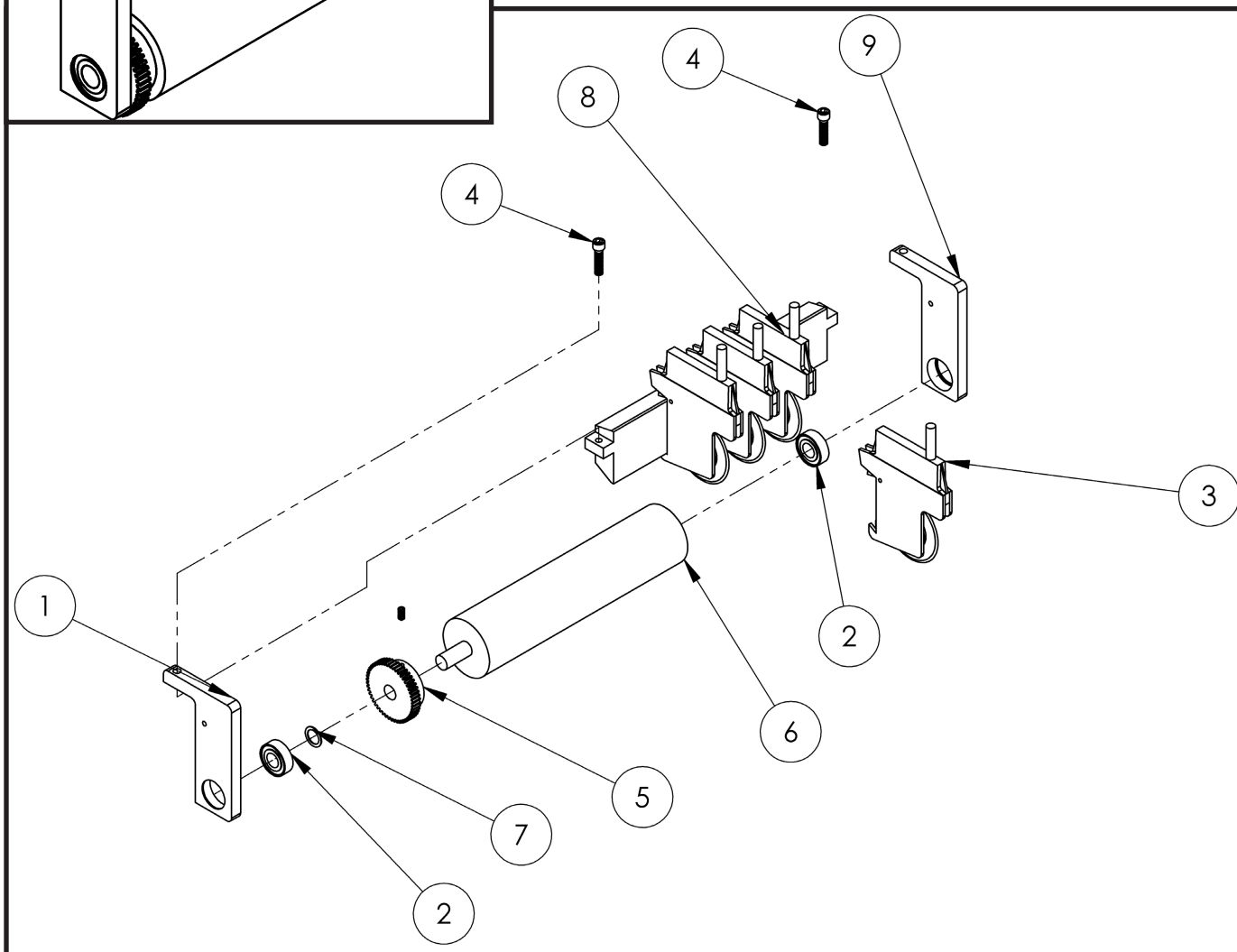
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**Slitting Insert, Crush Knife, 10" (AZT: 12634)**



ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	13380	CHRUSH KNIFE SUPPORT BLOCK, BACK	1
2	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
3	DIE02023-01	CHRUSH KNIFE UNIT	4
4	SCH_~3125-18 UNC_1~25_SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4"	2
5	10667	GEAR,S2050-14-1/2, 5/8 BORE	1
6	12768	CRUSH KNIFE, ANVIL ROLL, 10"	1
7	5_8 FIBER WASHER 031	PART# 95601A375	1
8	12742	CRUSH KNIFE CLAMP BAR, 10"	1
9	13381	CRUSH KNIFE SUPPORT BLOCK, FRONT	1
10	SSCR-HEX-CUP_~250-20 UNC_0~5_SIMP	SOCKET SET SCREW 1/4-20 X 1/2"	1

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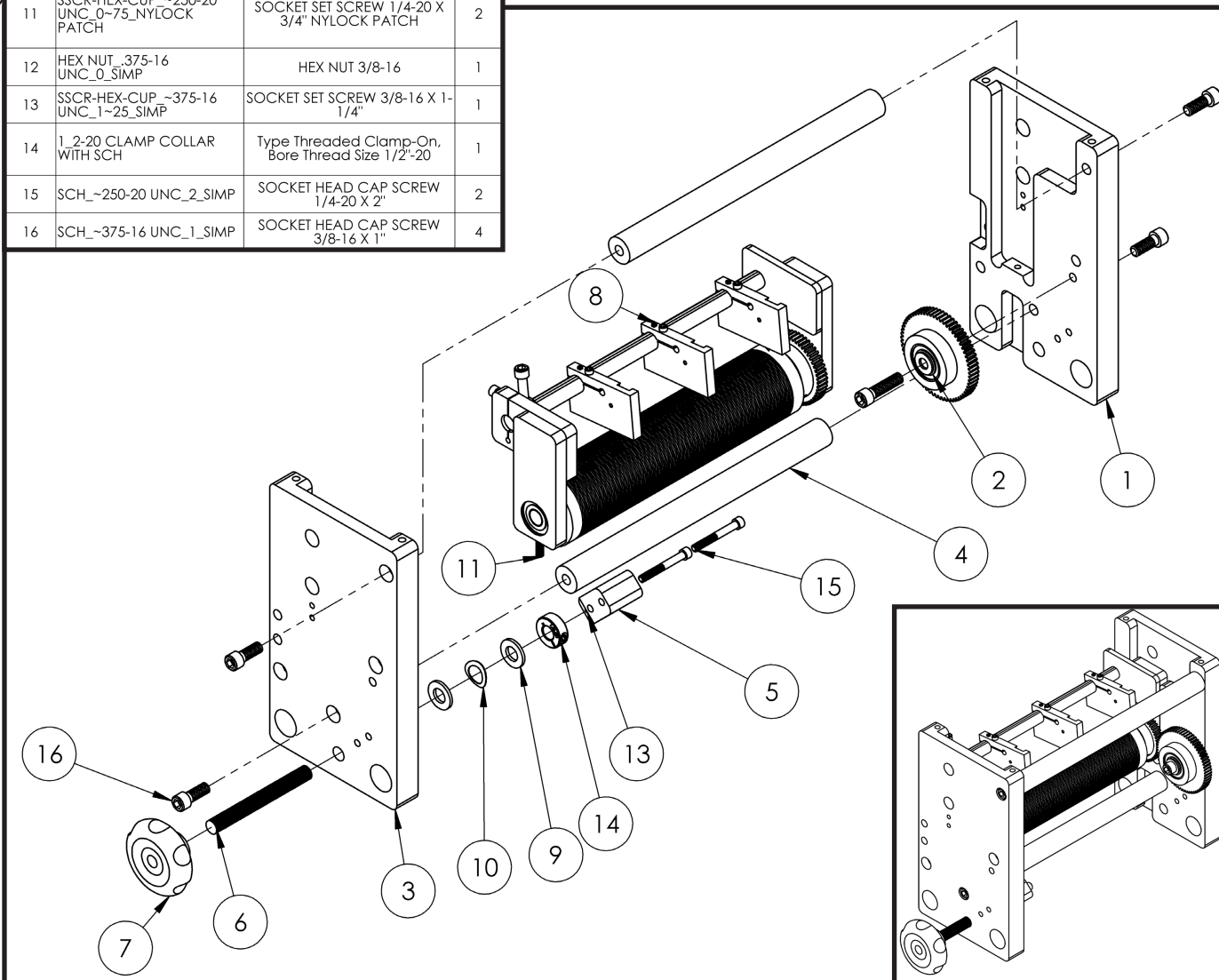


# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
3	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
4	16308	SLITTING STATION ER, STANDOFF 10"	2
5	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
6	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
7	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
8	10470	RAZOR STATION - ASSEMBLY 10"	1
9	WSHR A_500 HARD	HARD FLAT WASHER 1/2"	2
10	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
11	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2
12	HEX NUT_375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
13	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
14	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
15	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
16	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4

### Razor Slitting Assembly, 10" (AZT: 21624)





# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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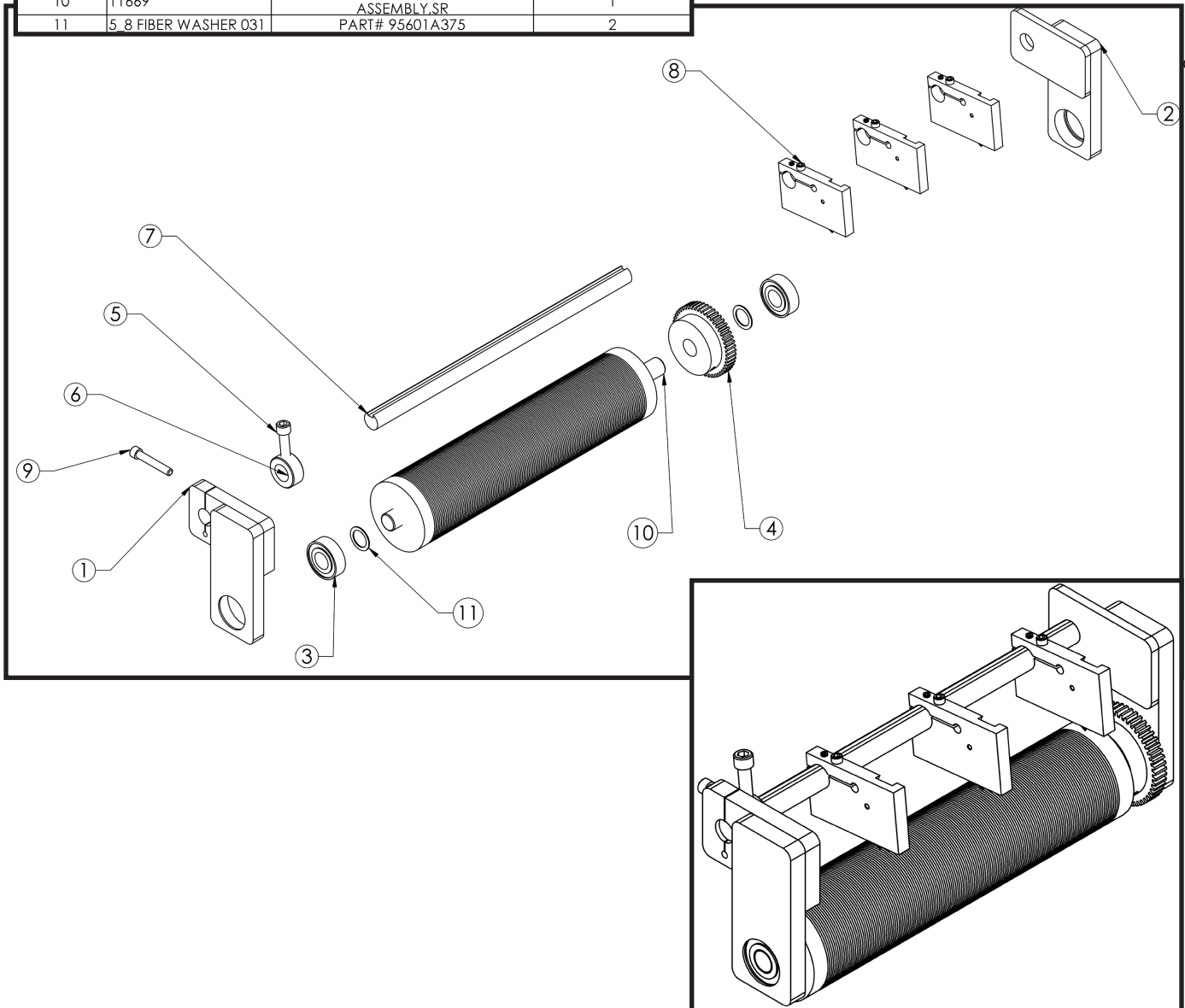
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### Slitting Insert, Razor Slit, 10" (AZT: 10470)

ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	10454	RAZOR STATION - INSIDE GIBB ASSEMBLY	1
2	10453	RAZOR STATION - OUTSIDE GIBB ASSEMBLY	1
3	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
4	10667	GEAR,S2050-14-1/2, 5/8 BORE	1
5	SCH_.3125-18 UNC_1.25_NONE		1
6	58 COLLAR	5/8 SET COLLAR	1
7	10474	RAZOR STATION - BLADE HOLDER SHAFT, 10"	1
8	10458	RAZOR BLADE HOLDER, SLITTING STATION, ASSEMBLY	3
9	SCH_.250-20 UNC_1.5_NONE		1
10	11669	10" RAZOR STATION ROLL ASSEMBLY,SR	1
11	5_8 FIBER WASHER 031	PART# 95601A375	2



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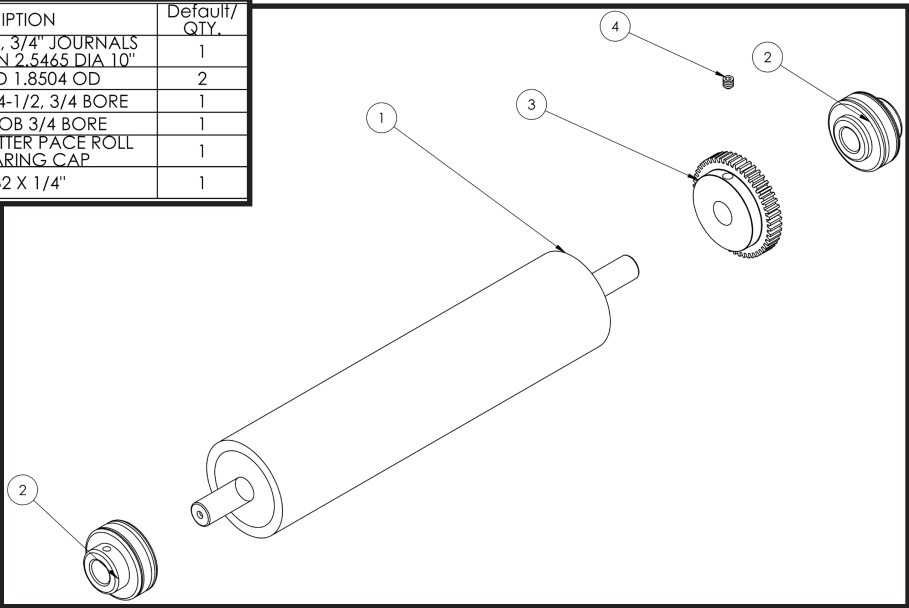
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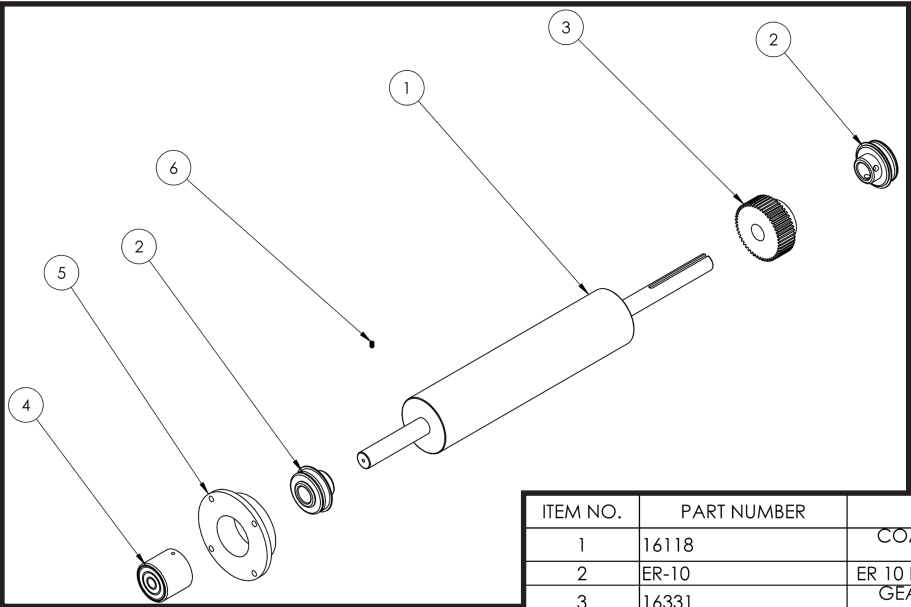
### USER MANUAL

#### Base Roll, 10" (AZT: 16128)

ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	16126	STEEL BASE ROLL, 3/4" JOURNALS SLITTING STATION 2.5465 DIA 10"	1
2	0.7500er-12	ER-12 .750 ID 1.8504 OD	2
3	15988	GEAR ,S2050-14-1/2, 3/4 BORE	1
4	15861	NIP ROLL KNOB 3/4 BORE	1
5	15961	REWIND DIE CUTTER PACE ROLL FRONT BEARING CAP	1
6	SSCR-HEX-CUP ~164- 32 UNC_0~25_SIMP	SCH 8-32 X 1/4"	1



#### Nip Roll, 10" (AZT: 16125)



ITEM NO.	PART NUMBER	DESCRIPTION	INSPECTION REWIND/QTY.
1	16118	COATED NIP ROLL, ER SLITTING STATION, 10"	1
2	ER-10	ER 10 BEARING 1.8504 OD X .625 ID	2
3	16331	GEAR ,S2050-14-1/2, 5/8 BORE RECESSED	1
4	SSCR-HEX-CUP...250- 20 UNC_0.25_SIMP	SSCR 1/4-20 X 1/4	1



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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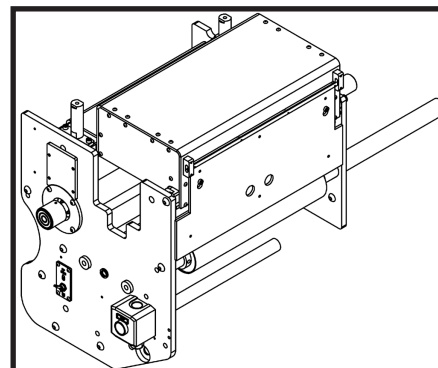
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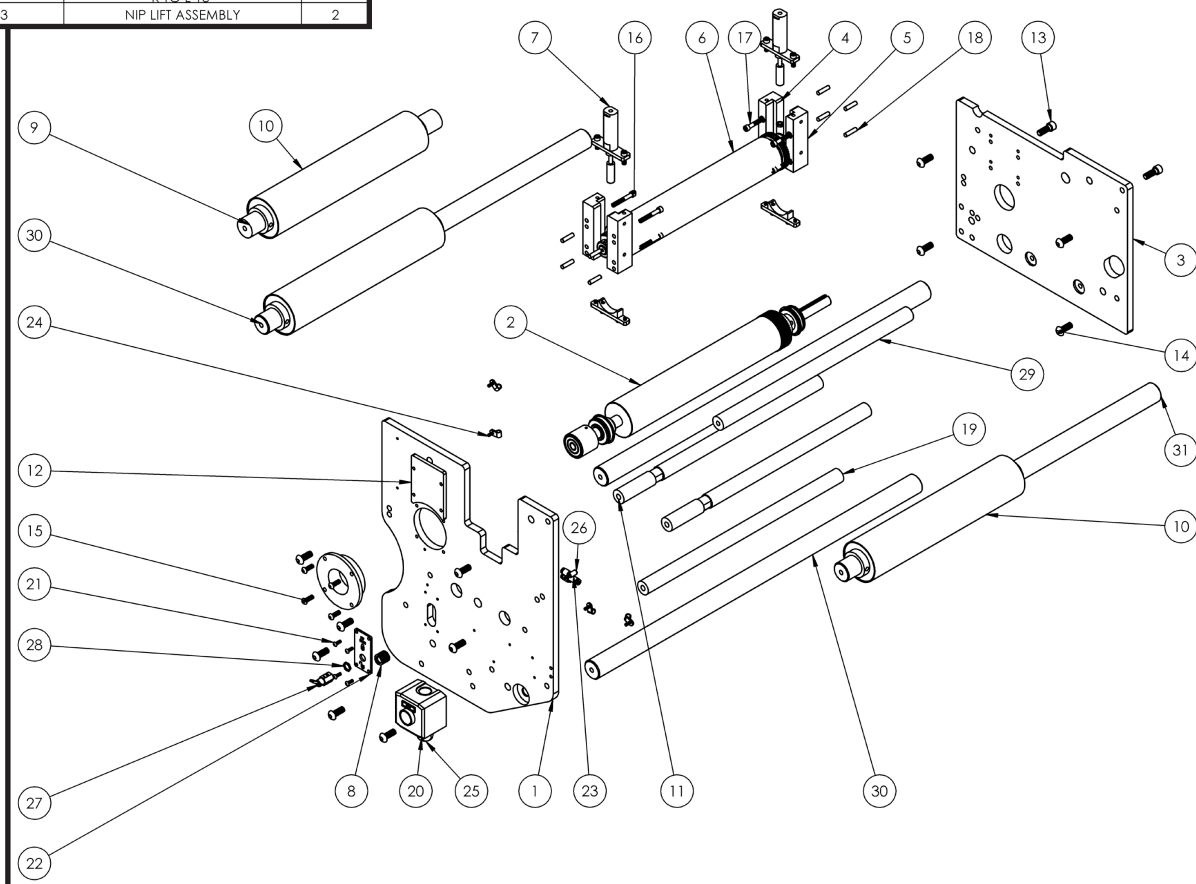
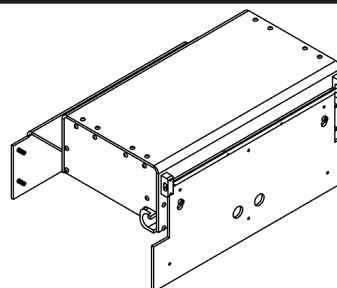
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	17603	BSR SLITTING STATION FRONT PLATE	1
2	16095	REWIND DIE CUTTER BASE ROLL ASSEMBLY 13"	1
3	17604	BSR SLITTING STATION REAR PLATE R T.O.L	1
4	15956	REWIND DIE CUTTER GIBB BAR LEFT	2
5	15955	REWIND DIE CUTTER GIBB BAR RIGHT	2
6	16110	REWIND DIE CUTTER NIP ROLL ASSEMBLY 13"	1
7	14353	SLITTING STATION NIP AIR CLAMP ASSEMBLY	2
8	Thread Insert 1_2-20x21_32 L	Thread Insert 1/2-20x21/32 L	1
9	16104	INSPECTION REWIRED WEB CLAMP IDLER SPACER BAR 13"	1
10	10585	IDLER ASSEMBLY, 1-3/8 BORE, 13"	3
11	16257	REWIND DIE CUTTER SLIT STATION SPRT SHAFT 13"	2
12	17605	BSR SLITTING STATION FRONT GIBB PLATE	1
13	SCH -375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	2
14	BTNHD -375-16 UNC_1_SIMP	BUTTON HEAD CAP SCREW 3/8-16 X 1"	11
15	BTNHD -250-20 UNC_0-75_SIMP	BUTTON HEAD CAP SCREW 1/4-20 X 3/4"	4
16	SCH -250-20 UNC_1-75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4"	4
17	SCH -250-20 UNC_1-5_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-1/2"	4
18	DWL PIN GRD -25000_1	DOWEL PIN 1/4" DIA X 1"	8
19	16146	DM 4013, MULTI LAMINATION, STANDOFF	1
20	6HK25	STOP SWITCH WITH HOUSING	1
21	BTNHD -164-32 UNC_0-5_SIMP	BUTTON HEAD CAP SCREW 8-32 X 1/2"	4
22	15977	REWIND DIE CUTTER NIP DRIVE VALVE PLATE	1
23	KQ2U03-00	ONE TO TWO 4MM UNION	1
24	1_4 CORD CLAMP WITH BOLT	1/4 cord clamp with 8-32 x 1/2 button head cap screw	5
25	1_2 STRAIN RELIEF ASSEMBLY	1/2" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	1
26	BTNHD -164-32 UNC_1_SIMP	BUTTON HEAD CAP SCREW GRADE 5, 8-32 X 1"	1
27	TV-3F ASSEMBLY	3-Way Toggle Valve, Short (Plastic Toggle)	1
28	MJTV NUT	MJTV SERIES NUT	1
29	19608	STAND OFF 1" DIA BY 17.750 LONG 3/8-16 TAPPED ENDS	1
30	17638	IDLER SHAFT, 30-1/4" LONG TAPPED ONE END	3
31	19599	STAND OFF 1-3/8 DIA BY 29.25 LONG 3/8-16 TAPPED ENDS	1
32	21931	BSR CRUSH KNIFE GUARD ASSEMBLY R T.O.L 13"	1
33	16143	NIP LIFT ASSEMBLY	2



Slitting Station, 13" (AZT: 21736)



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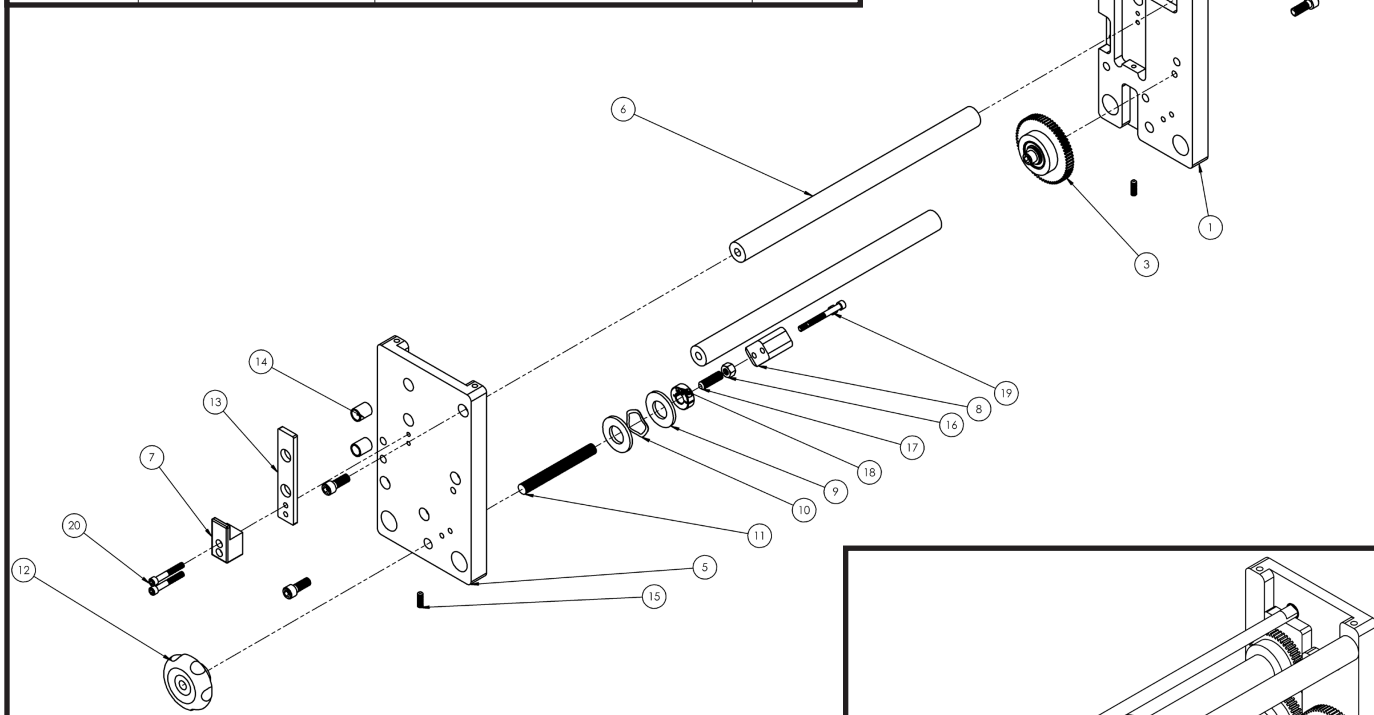


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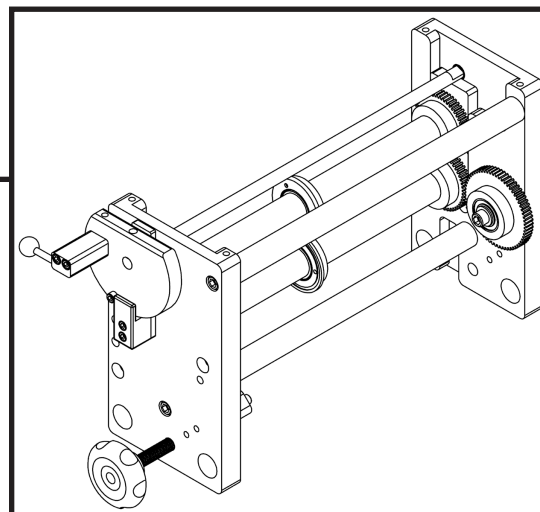
## SR-SERIES

### USER MANUAL

ITEM NO.	PART NUMBER	DESCRIPTION	L TO R/ QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	14374	BSR, ROTARY SHEAR ASSEMBLY, 13"	1
3	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
4	18979	1/2 ID X 5/8 OD X 1/2" LONG BEARING	1
5	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
6	14358	SLITTING STATION ER, STANDOFF 13"	2
7	11778	RETAINER BRACKET, SLITTING STATION, BSR	1
8	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
9	98029A037	Black-Oxide Steel Thick Flat Washer 7/8" Screw Sz. 29/32" ID, 1-3/4" OD, .141"-.167" Thk	2
10	9714K65	Wave Disc Spring 1074 Hi-Carbon Steel, 1.051" ID, 1.351" OD, .015" Thk	1
11	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
12	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
13	15983	REWIND DIE CUTTER RETAINER SPACER, SLITTING STATION	1
14	1_2 X 5_8 X 3_4 INCH	SAE 841 Bronze Sleeve Bearing for 1/2" Shaft Diameter, 5/8" OD, 3/4" Length	2
15	SSCR-HEX-CUP_-250-20 UNC_0-75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2
16	HEX NUT_-375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
17	SSCR-HEX-CUP_-375-16 UNC_1-25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
18	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
19	SCH_-250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
20	SCH_-250-20 UNC_1-75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4"	2
21	SCH_-375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4



**Rotary Shear Insert, 13" (AZT: 21621)**



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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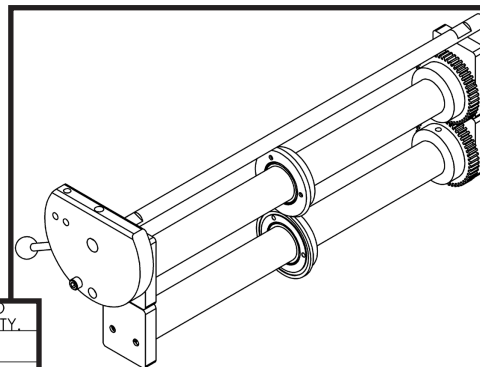
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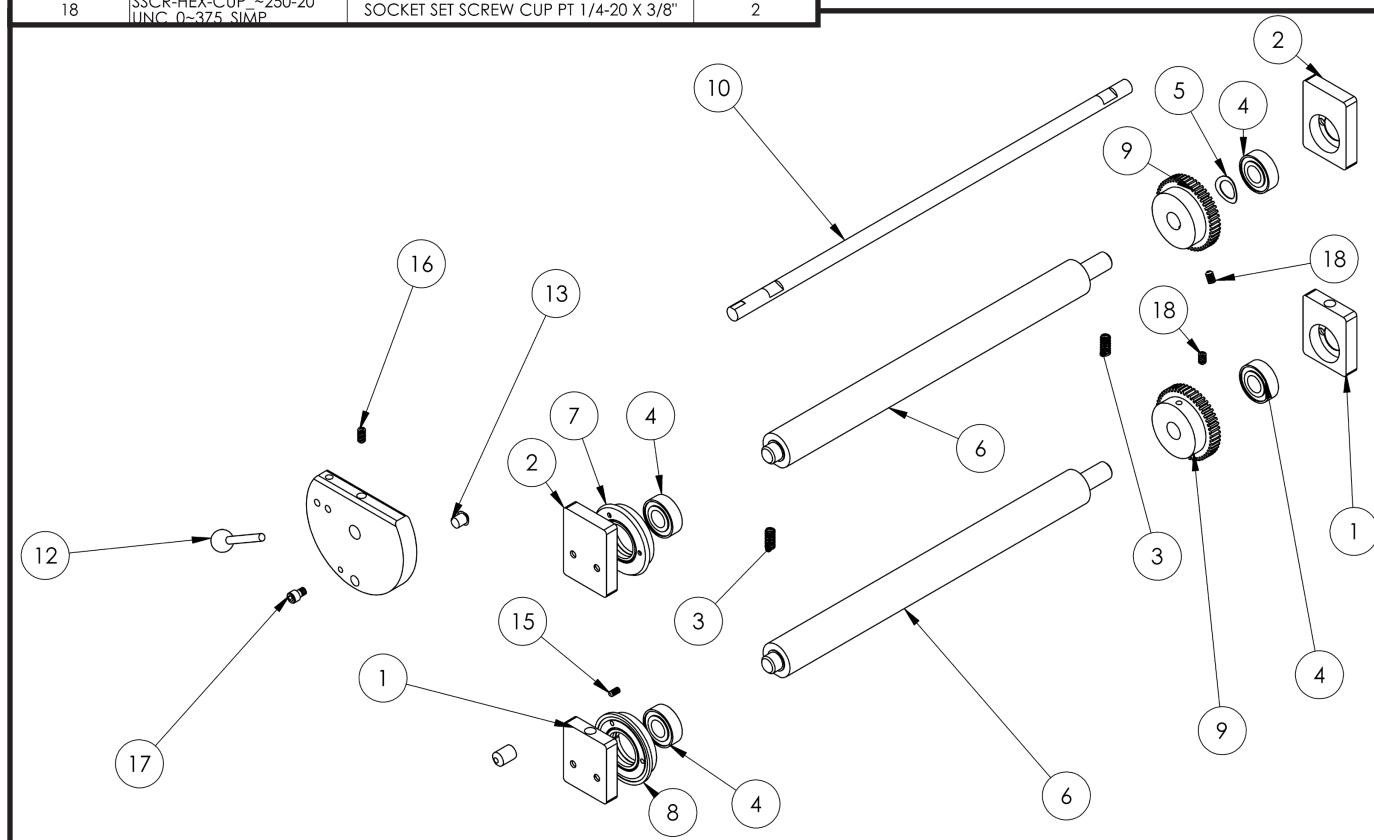
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ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/ QTY.
1	11781	GIBB BLOCK,BLANK, LOWER, SLITTING STATION	2
2	11779	GIBB BLOCK, UPPER	2
3	9657K156	COMPRESSION SPRING .38 x .048 x 1.5	2
4	18991	1623 BEARING 1 3/8 OD X 5/8 ID SEALED	4
5	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
6	11807	BLADE ARBOR,SLITTING STATION 13"	2
7	11635	UPPER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
8	11629	LOWER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
9	10667	GEAR,S2050-14-1/2, 5/8 BORE	2
10	11808	CAM SHAFT, SLITTING STATION 13"	1
11	11787	KNOB, ROTORY SHEAR	1
12	6303K23	STEEL LEVER HANDLE	1
13	11786	THRUST BUTTON,ROTARY SHEAR	1
14	11788	PUSH PIN, UPPER SHEAR SHAFT	1
15	SSCR-HEX-CUP .190-32 UNF 0.375 SIMP	SOCKET SET SCREW 10-32 X 3/8"	1
16	SSCR-HEX-CUP ~250-20 UNC 0~5 SIMP	SOCKET SET SCREW 1/4-20 X 1/2"	1
17	SCH ~250-20 UNC 0~375 SIMP	SOCKET HEAD CAP SCREW 1*4-20 X 3/8"	1
18	SSCR-HEX-CUP ~250-20 UNC 0~375 SIMP	SOCKET SET SCREW CUP PT 1/4-20 X 3/8"	2

**Slitting Insert, Rotary Shear, 13"**  
**(AZT: 14374)**



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

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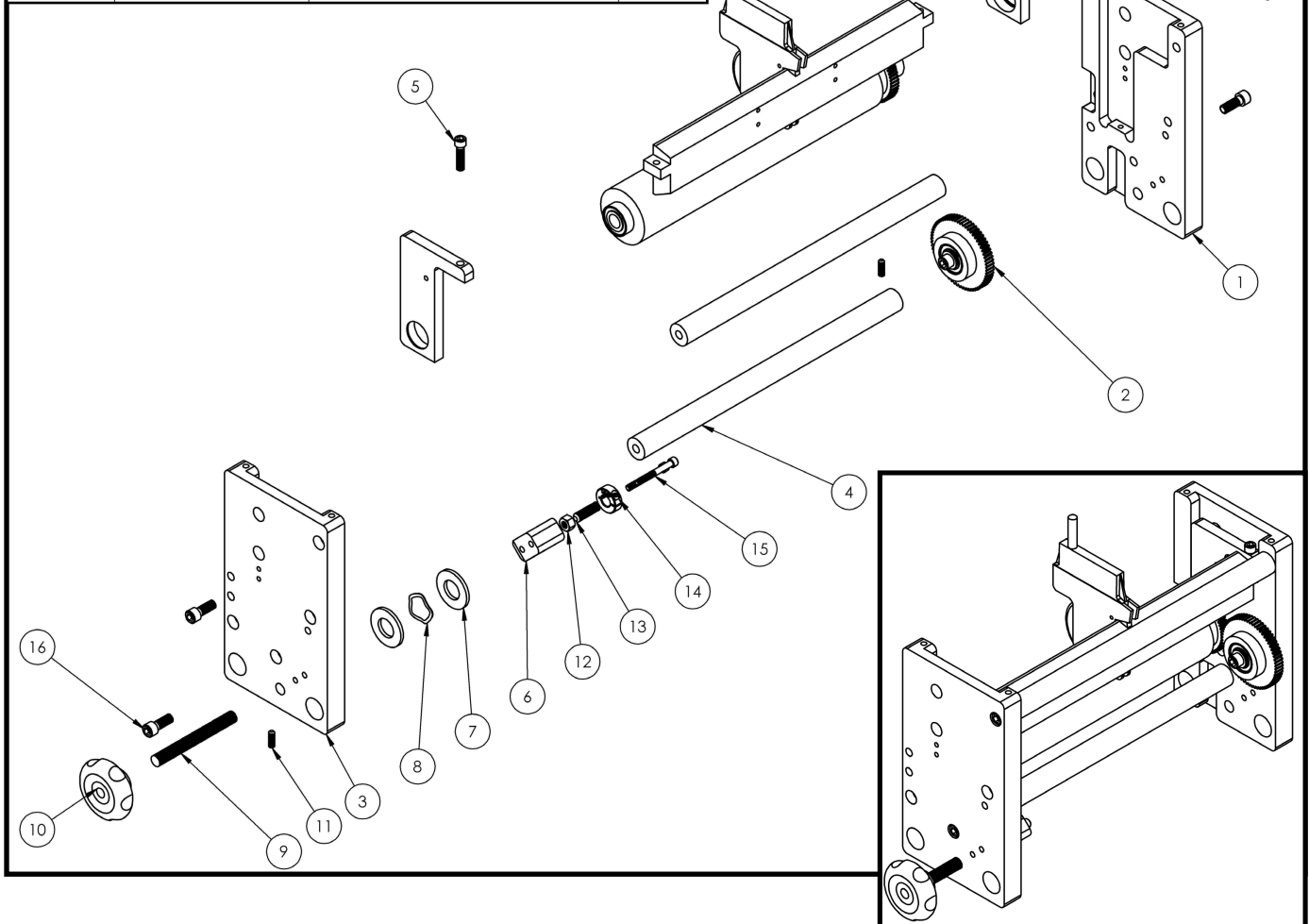
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
3	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
4	14358	SLITTING STATION ER, STANDOFF 13"	2
5	12635	CRUSH KNIFF ASSEMBLY, 13" BSR, SR	1
6	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
7	98029A037	Black-Oxide Steel Thick Flat Washer 7/8" Screw Sz, 29/32" ID, 1-3/4" OD, .141"- .167" Thk	2
8	9714K65	Wave Disc Spring 1074 Hi-Carbon Steel, 1.051" ID, 1.351" OD, .015" Thk	1
9	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
10	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
11	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2
12	HEX NUT_~375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
13	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
14	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
15	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
16	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4

### Slitting Insert, Crush Knife, 10" (AZT: 21620)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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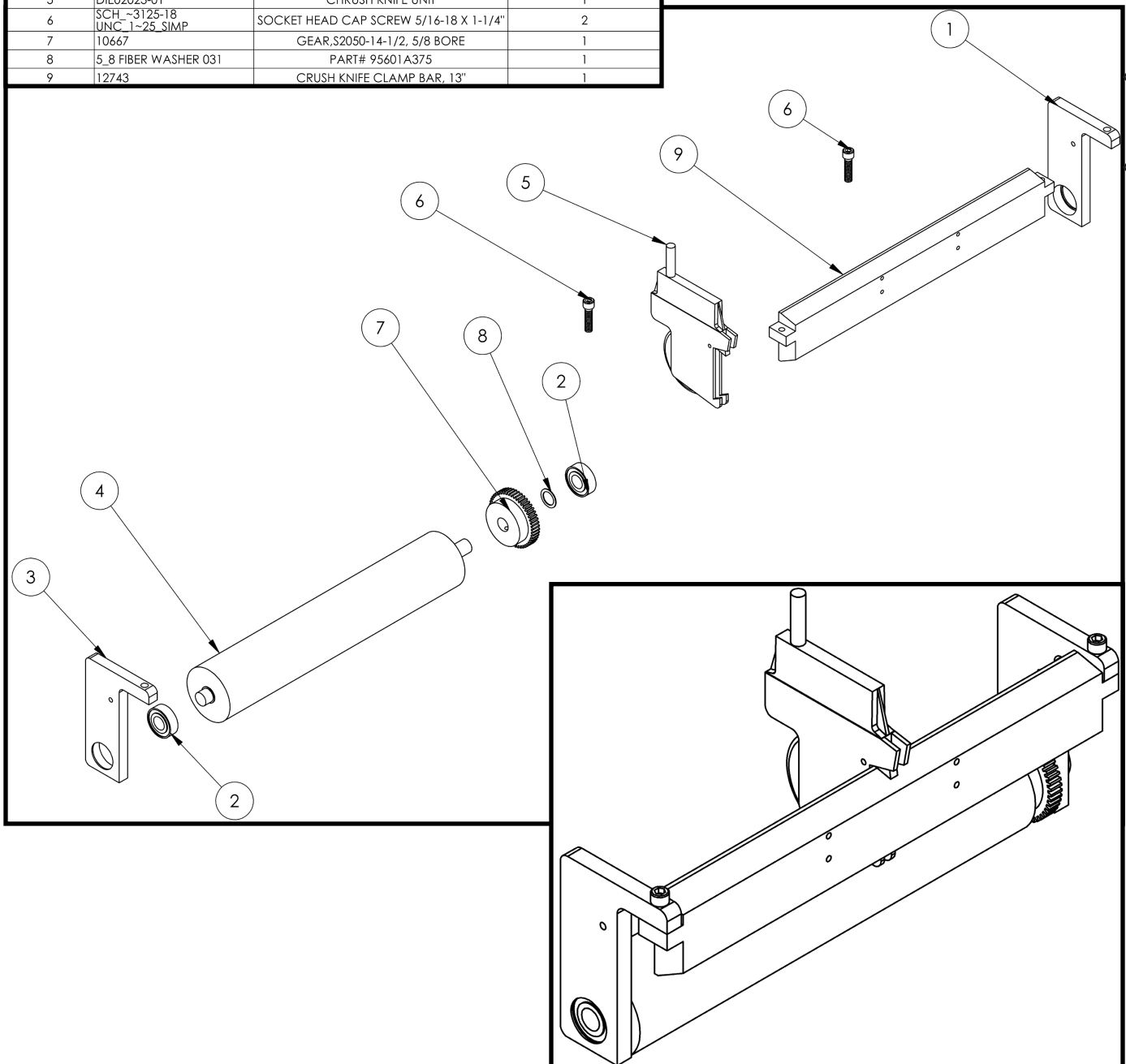
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ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	13380	CHRUSH KNIFE SUPPORT BLOCK, BACK	1
2	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
3	13381	CRUSH KNIFE SUPPORT BLOCK, FRONT	1
4	12769	CRUSH KNIFE, ANVIL ROLL, 13"	1
5	DIE02023-01	CHRUSH KNIFE UNIT	1
6	SCH. ~3125-18 UNC. 1~25 SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4"	2
7	10667	GEAR, S2050-14-1/2, 5/8 BORE	1
8	5.8 FIBER WASHER 031	PART# 95601A375	1
9	12743	CRUSH KNIFE CLAMP BAR, 13"	1

### Slitting Insert, Crush Knife, 10" (AZT: 12635)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

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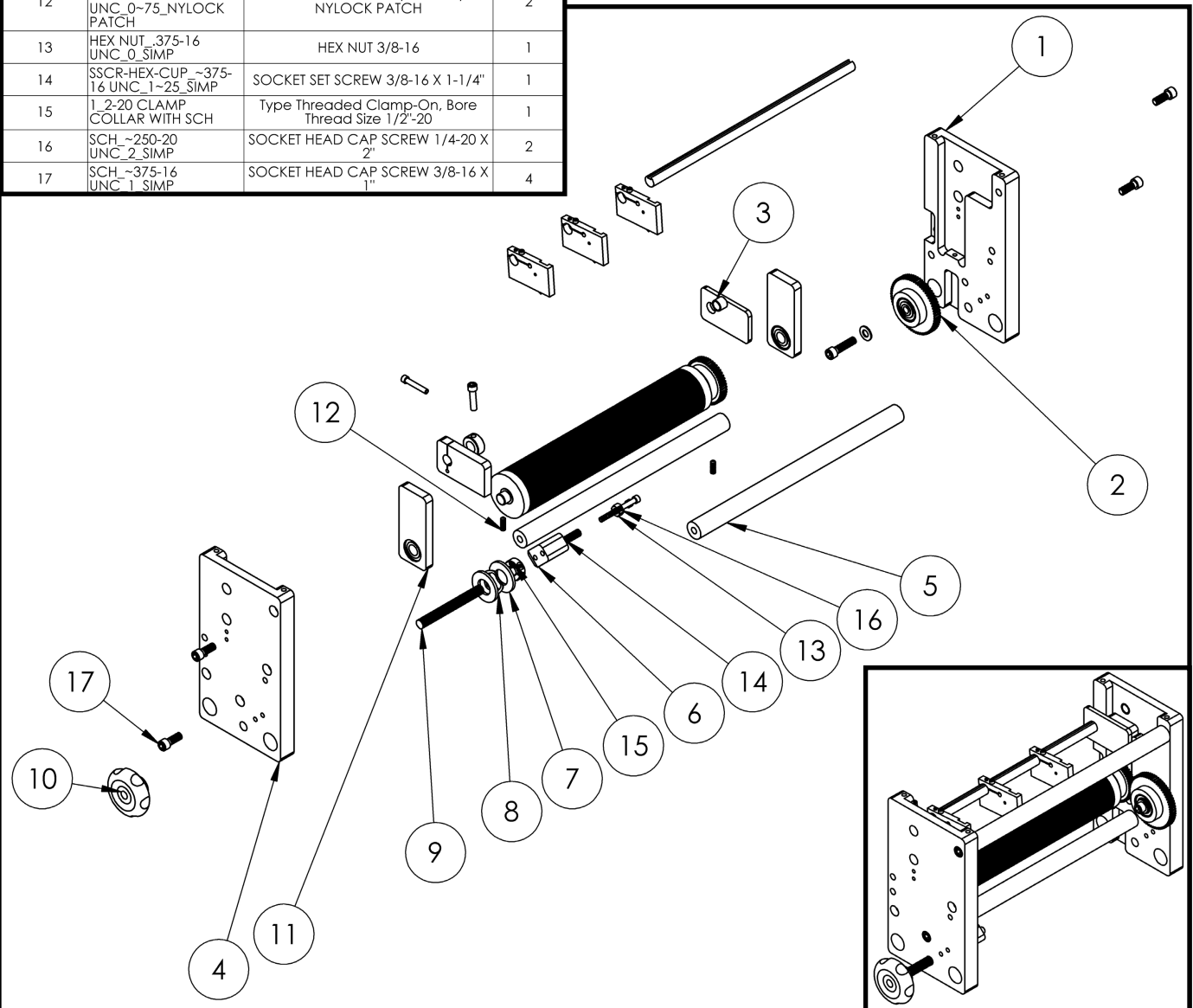
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ITEM NO.	PART NUMBER	DESCRIPTION	RAZOR STATION/ QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
3	1_2 X 5.8 X 1_2 INCH	BUSHING 6391K211	1
4	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
5	14358	SLITTING STATION ER, STANDOFF 13"	2
6	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
7	98029A037	Black-Oxide Steel Thick Flat Washer 7/8" Screw Sz. 29/32" ID, 1-3/4" OD, .141"- .167" Thk	2
8	9714K65	Wave Disc Spring 1074 Hi-Carbon Steel, 1.051" ID, 1.351" OD, .015" Thk	1
9	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
10	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
11	10471	RAZOR STATION - ASSEMBLY 13"	1
12	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2
13	HEX NUT _375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
14	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
15	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
16	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
17	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4

### Slitting Insert - Razor Slitting, 13" (AZT: 21619)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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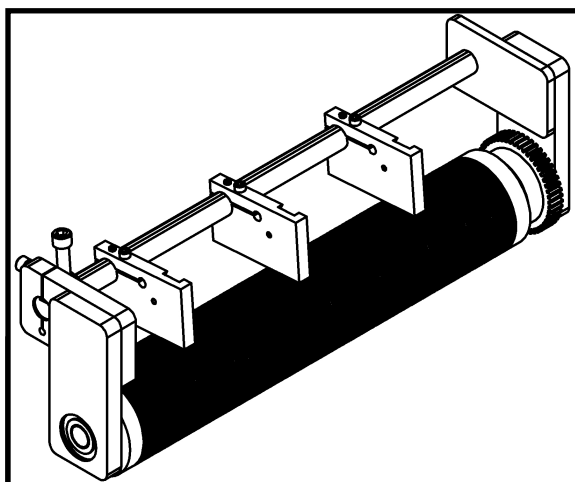
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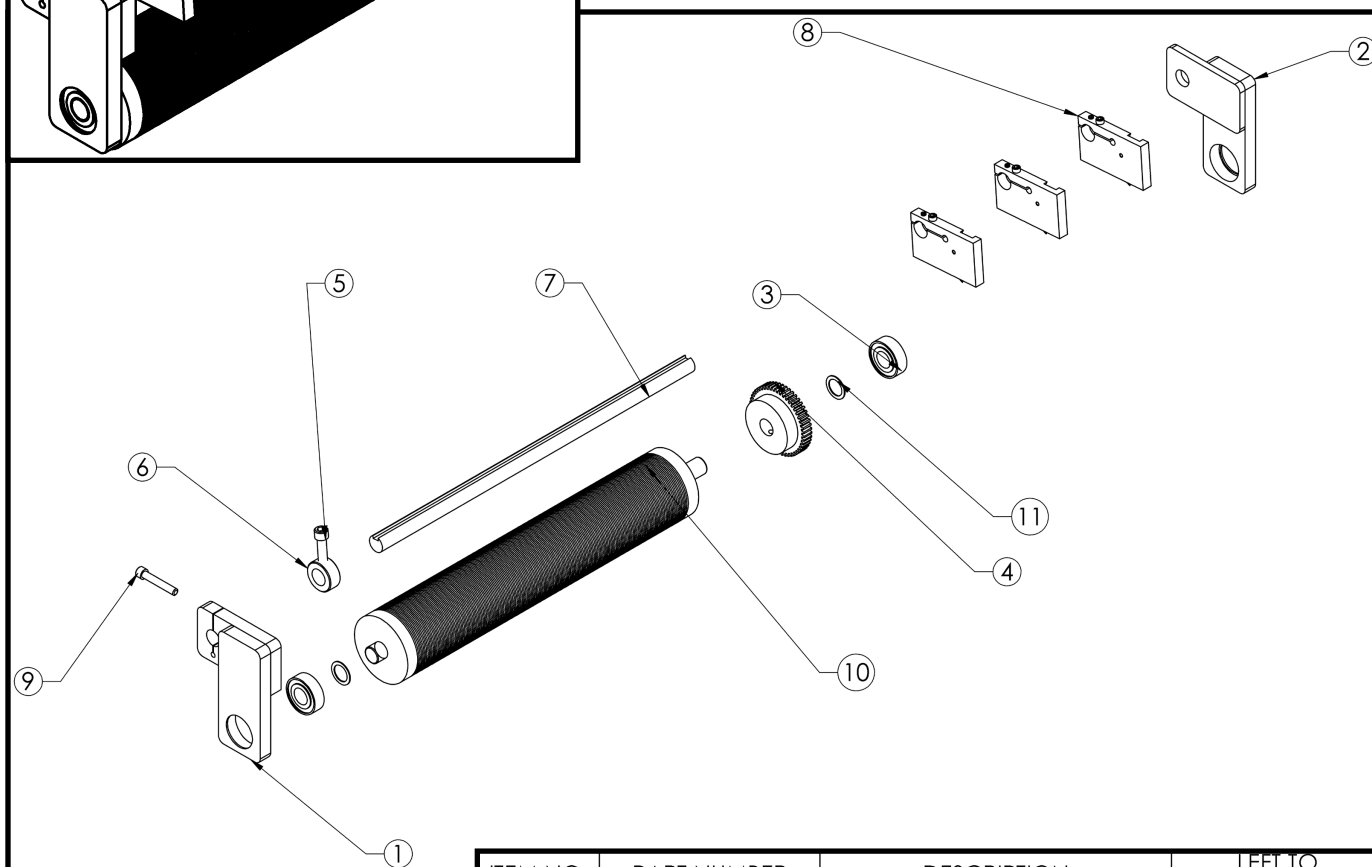
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**Slitting Insert, Razor Slitting, 13"  
(AZT: 10471)**



ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QT.
1	10454	RAZOR STATION - INSIDE GIBB ASSEMBLY	1
2	10453	RAZOR STATION - OUTSIDE GIBB ASSEMBLY	1
3	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
4	10667	GEAR,S2050-14-1/2, 5/8 BORE	1
5	SCH_.3125-18 UNC_1.25_NONE		1
6	58 COLLAR	5/8 SET COLLAR	1
7	10475	RAZOR STATION - BLADE HOLDER SHAFT_13"	1
8	10458	RAZOR BLADE HOLDER, SLITTING STATION, ASSEMBLY	3
9	SCH_.250-20 UNC_1.5_NONE		1
10	11670	13" RAZOR STATION ROLL ASSEMBLY,SR	1
11	5_8 FIBER WASHER 031	PART# 95601A375	2



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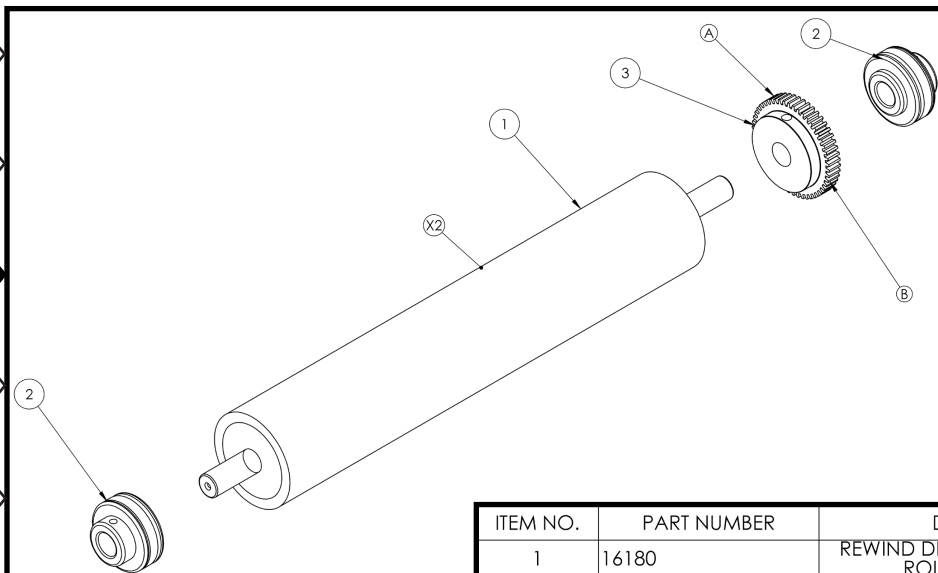
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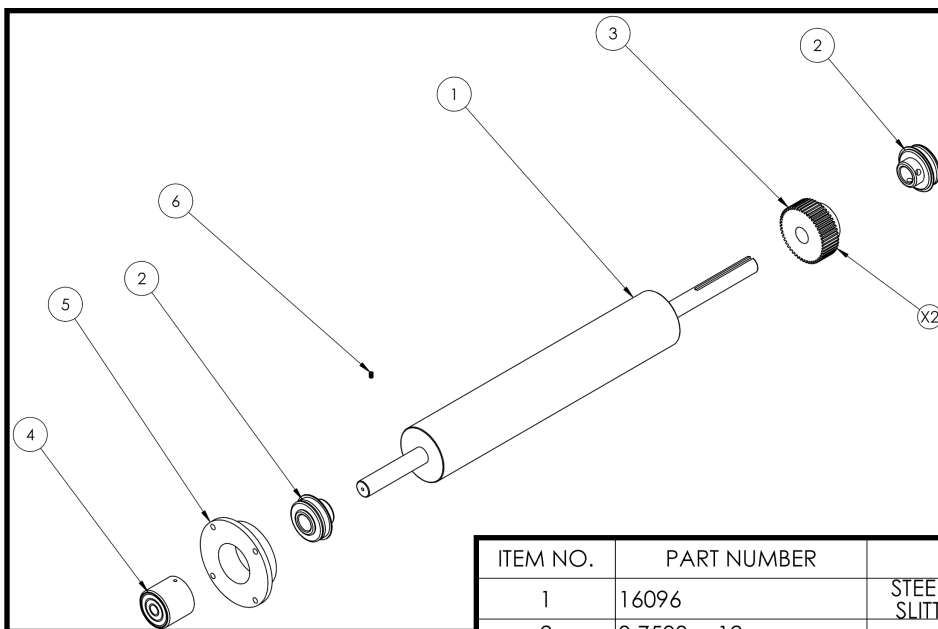
# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



**Base Roll, 13" (AZT: 16095)**

ITEM NO.	PART NUMBER	DESCRIPTION	INSPECTION REWIND/QTY.
1	16180	REWIND DIE CUTTER COATED NIP ROLL ASSEMBLY 13"	1
2	ER-10	ER 10 BEARING 1.8504 OD X .625 ID	2
3	16331	GEAR ,S2050-14-1/2, 5/8 BORE RECESSED	1



**Nip Roll, 13" (AZT: 16110)**

ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	16096	STEEL BASE ROLL, 3/4" JOURNALS SLITTING STATION 2.5465 DIA 13"	1
2	0.7500er-12	ER-12 .750 ID 1.8504 OD	2
3	15988	GEAR ,S2050-14-1/2, 3/4 BORE	1
4	15861	NIP ROLL KNOB 3/4 BORE	1
5	15961	REWIND DIE CUTTER PACE ROLL FRONT BEARING CAP	1
6	SSCR-HEX-CUP ~164- 32 UNC. 0~25 SIMP	SCH 8-32 X 1/4"	1



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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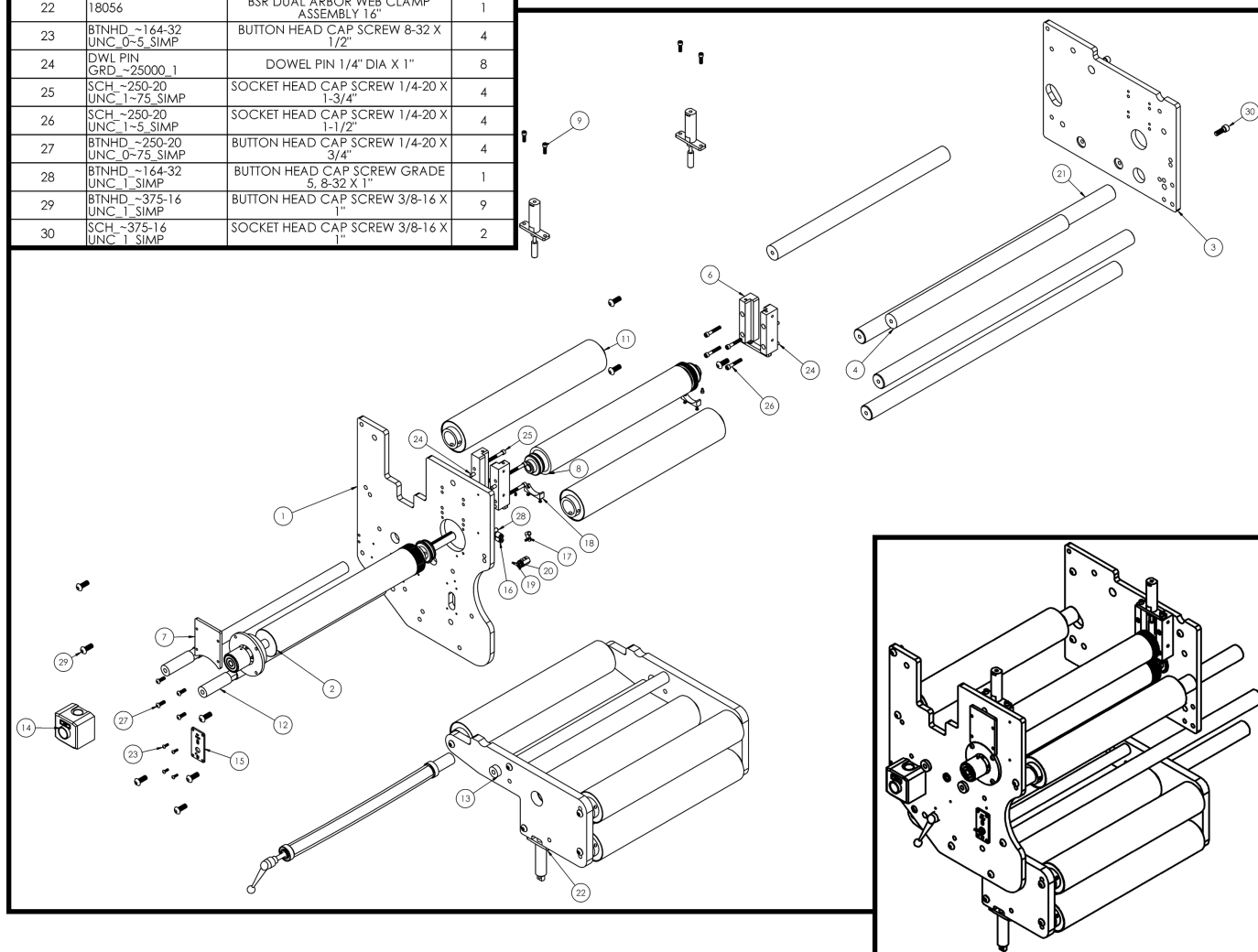
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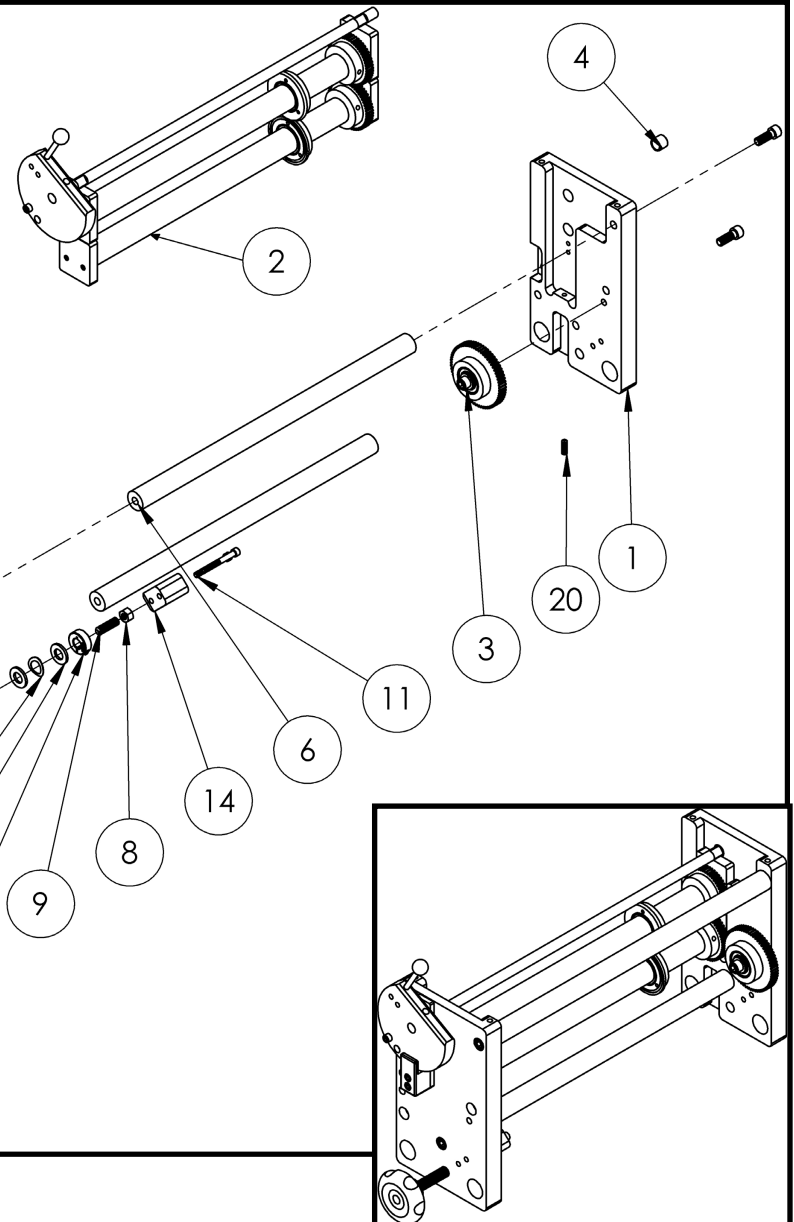
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	17603	BSR SLITTING STATION FRONT PLATE	1
2	16321	REWIND DIE CUTTER BASE ROLL ASSEMBLY 16"	1
3	17788	BSR SLITTING STATION REAR PLATE L TO R	1
4	16318	INSPECTION REWINDED WEB CLAMP IDLER SPACER BAR 16"	2
5	15955	REWIND DIE CUTTER GIBB BAR RIGHT	2
6	15956	REWIND DIE CUTTER GIBB BAR LEFT	2
7	17605	BSR SLITTING STATION FRONT GIBB PLATE	1
8	16324	REWIND DIE CUTTER NIP ROLL ASSEMBLY 16"	1
9	14353	SLITTING STATION, NIP AIR CLAMP ASSEMBLY	2
10	Thread Insert 1_2-20x21_32 L	Thread Insert, 1/2-20x21/32 L	1
11	10592	IDLER ASSEMBLY, 1-3/8 BORE, 16"	3
12	17184	REWIND DIE CUTTER SLIT STATION SPRT SHAFT 16"	2
13	16146	DM 4013, MULTI LAMINATION, STANDOFF	1
14	6HK25	STOP SWITCH WITH HOUSING	1
15	15977	REWIND DIE CUTTER NIP DRIVE VALVE PLATE	1
16	KQ2U03-00	ONE TO TWO 4MM UNION	1
17	1_4 CORD CLAMP WITH BOLT	1/4 cord clamp with 8-32 x 1/2 button head cap screw	3
18	16143	NIP LIFT ASSEMBLY	2
19	TV-3F ASSEMBLY	3-Way Toggle Valve, Short (Plastic Toggle)	1
20	MJTV NUT	MJTV SERIES NUT	1
21	17638	IDLER SHAFT, 30-1/4" LONG TAPPED ONE END	3
22	18056	BSR DUAL ARBOR WEB CLAMP ASSEMBLY 16"	1
23	BTNHD ~164-32 UNC_0-5_SIMP	BUTTON HEAD CAP SCREW 8-32 X 1/2"	4
24	DWL PIN GRD ~25000_1	DOWEL PIN 1/4" DIA X 1"	8
25	SCH ~250-20 UNC_1-75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4"	4
26	SCH ~250-20 UNC_1-5_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-1/2"	4
27	BTNHD ~250-20 UNC_0-75_SIMP	BUTTON HEAD CAP SCREW 1/4-20 X 3/4"	4
28	BTNHD ~164-32 UNC_1_SIMP	BUTTON HEAD CAP SCREW GRADE 5, 8-32 X 1"	1
29	BTNHD ~375-16 UNC_1_SIMP	BUTTON HEAD CAP SCREW 3/8-16 X 1"	9
30	SCH ~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	2

### Slitting Insert - Rotary Shear, 16" (AZT: 21682)





# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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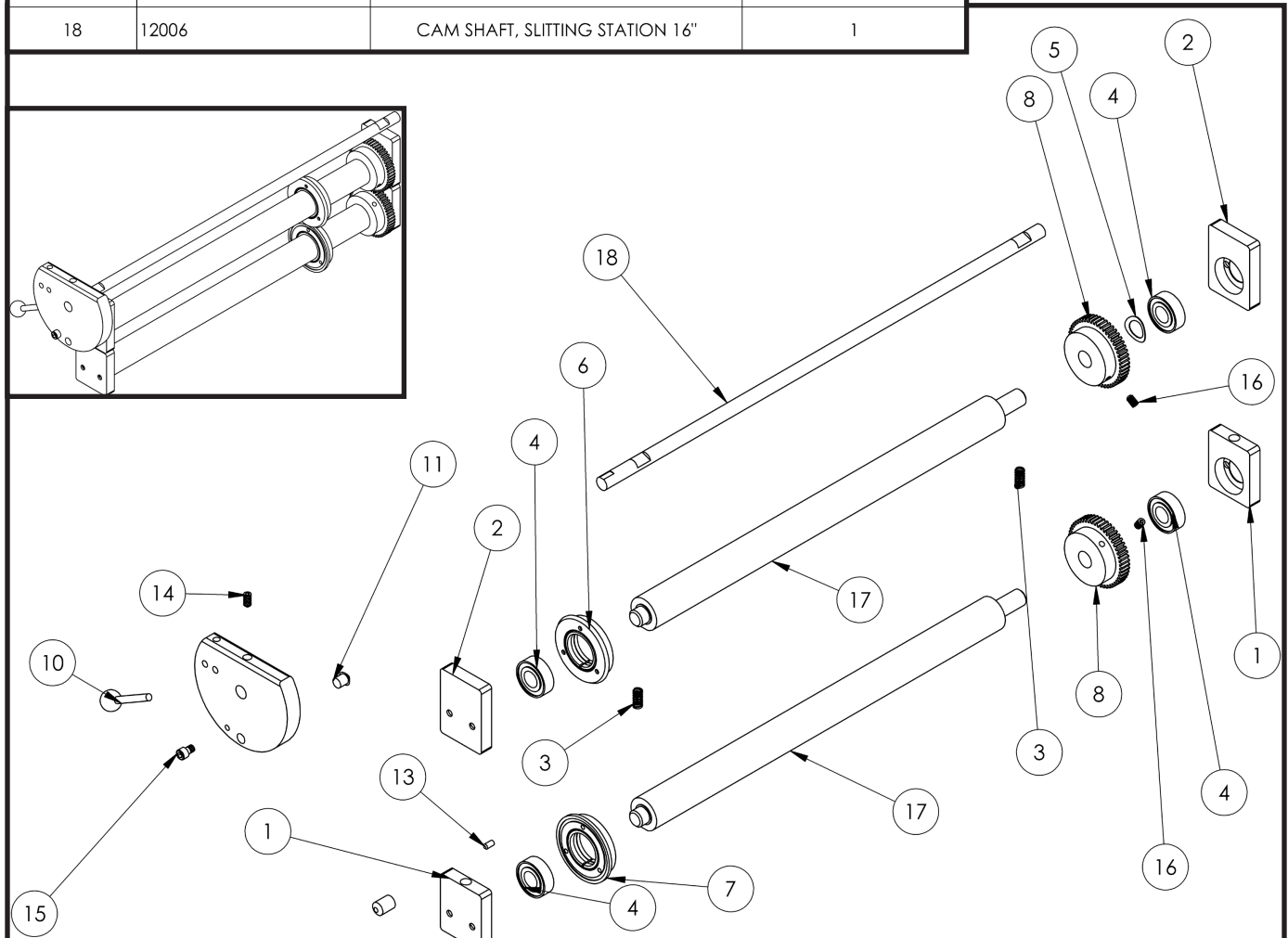
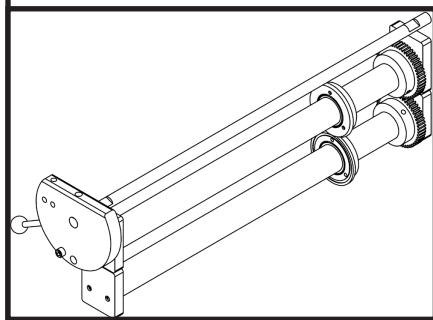
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### Slitting Insert - Rotary Shear, 16" (AZT: 14375)

ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	11781	GIBB BLOCK,BLANK, LOWER, SLITTING STATION	2
2	11779	GIBB BLOCK, UPPER	2
3	9657K156	COMPRESSION SPRING .38 x .048 x 1.5	2
4	18991	1623 BEARING 1 3/8 OD X 5/8 ID SEALED	4
5	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
6	11635	UPPER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
7	11629	LOWER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
8	10667	GEAR,S2050-14-1/2, 5/8 BORE	2
9	11787	KNOB, ROTARY SHEAR	1
10	6303K23	STEEL LEVER HANDLE	1
11	11786	THRUST BUTTON,ROTARY SHEAR	1
12	11788	PUSH PIN, UPPER SHEAR SHAFT	1
13	SSCR-HEX-CUP_.190-24 UNC 0.375 NONE		1
14	SSCR-HEX-CUP_~250-20 UNC 0~5 SIMP	SOCKET SET SCREW 1/4-20 X 1/2"	1
15	SCH_~250-20 UNC 0~375 SIMP	SOCKET HEAD CAP SCREW 1*4-20 X 3/8"	1
16	SSCR-HEX-CUP_~250-20 UNC 0~375 SIMP	SOCKET SET SCREW CUP PT 1/4-20 X 3/8"	2
17	12003	BLADE ARBOR,SLITTING STATION 16"	2
18	12006	CAM SHAFT, SLITTING STATION 16"	1



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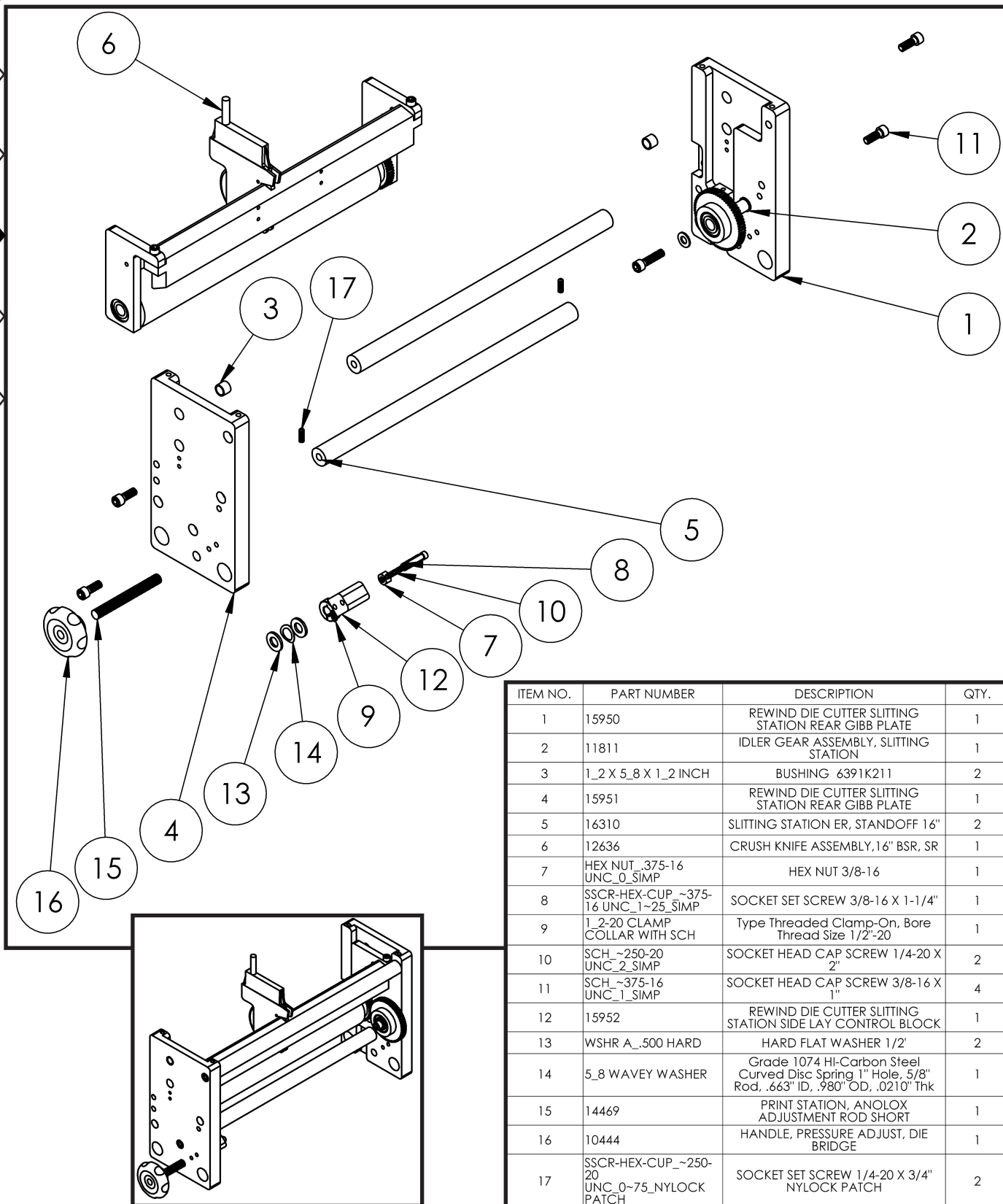
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# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

### Slitting Insert - Crush Knife, 16" (AZT: 21628)



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
3	1_2 X 5_8 X 1_2 INCH	BUSHING 6391K211	2
4	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
5	16310	SLITTING STATION ER, STANDOFF 16"	2
6	12636	CRUSH KNIFE ASSEMBLY, 16" BSR, SR	1
7	HEX NUT_375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
8	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
9	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
10	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
11	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4
12	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
13	WSHR A_500 HARD	HARD FLAT WASHER 1/2"	2
14	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
15	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
16	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
17	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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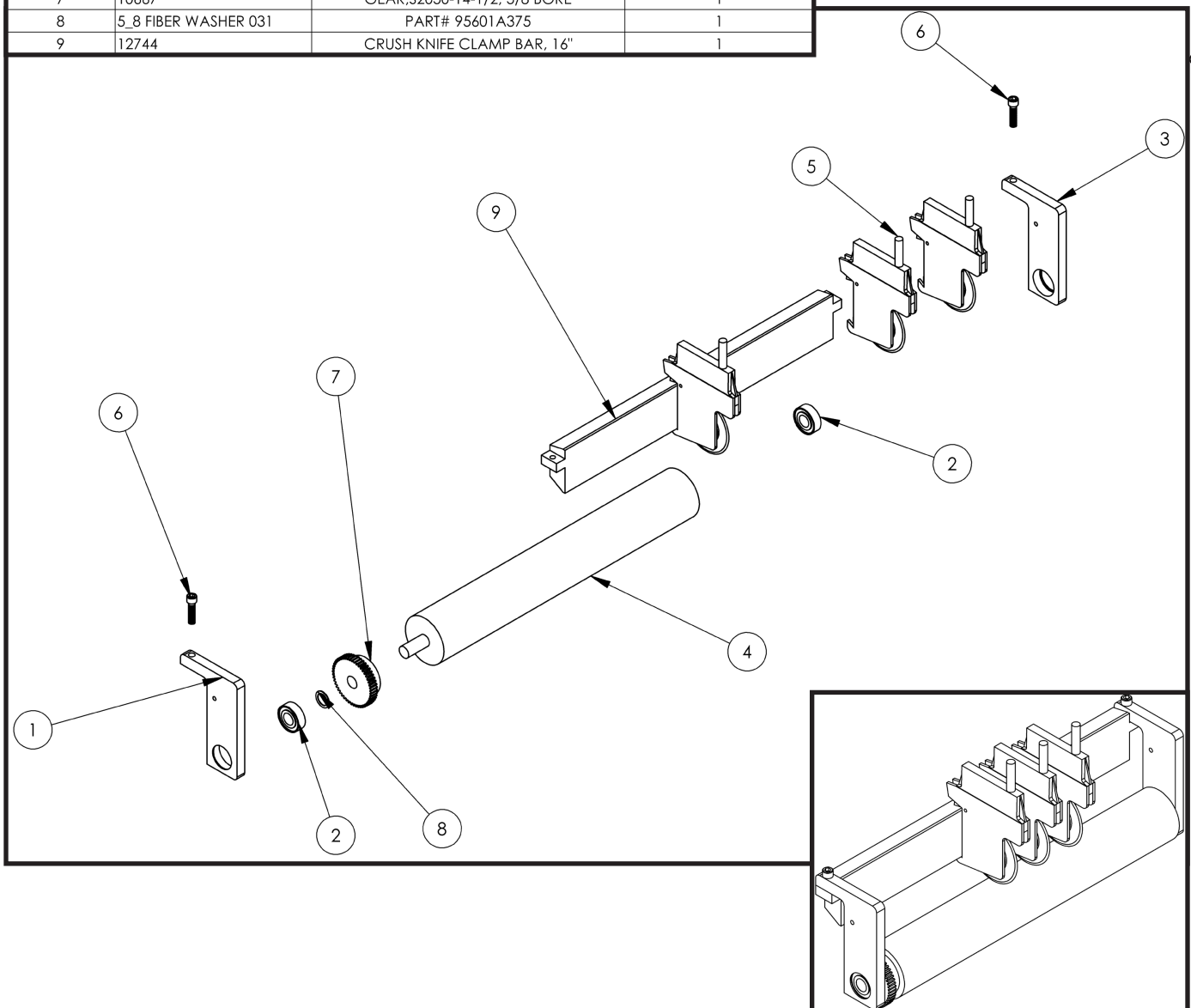
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### Slitting Insert - Crush Knife, 16" (AZT: 12636)

ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	13380	CHRUH KNIFE SUPPORT BLOCK, BACK	1
2	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
3	13381	CRUSH KNIFE SUPPORT BLOCK, FRONT	1
4	12770	CRUSH KNIFE, ANVIL ROLL, 16"	1
5	DIE02023-01	CHRUH KNIFE UNIT	3
6	SCH_~3125-18 UNC_1~25_SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4"	2
7	10667	GEAR,S2050-14-1/2, 5/8 BORE	1
8	5_8 FIBER WASHER 031	PART# 95601A375	1
9	12744	CRUSH KNIFE CLAMP BAR, 16"	1



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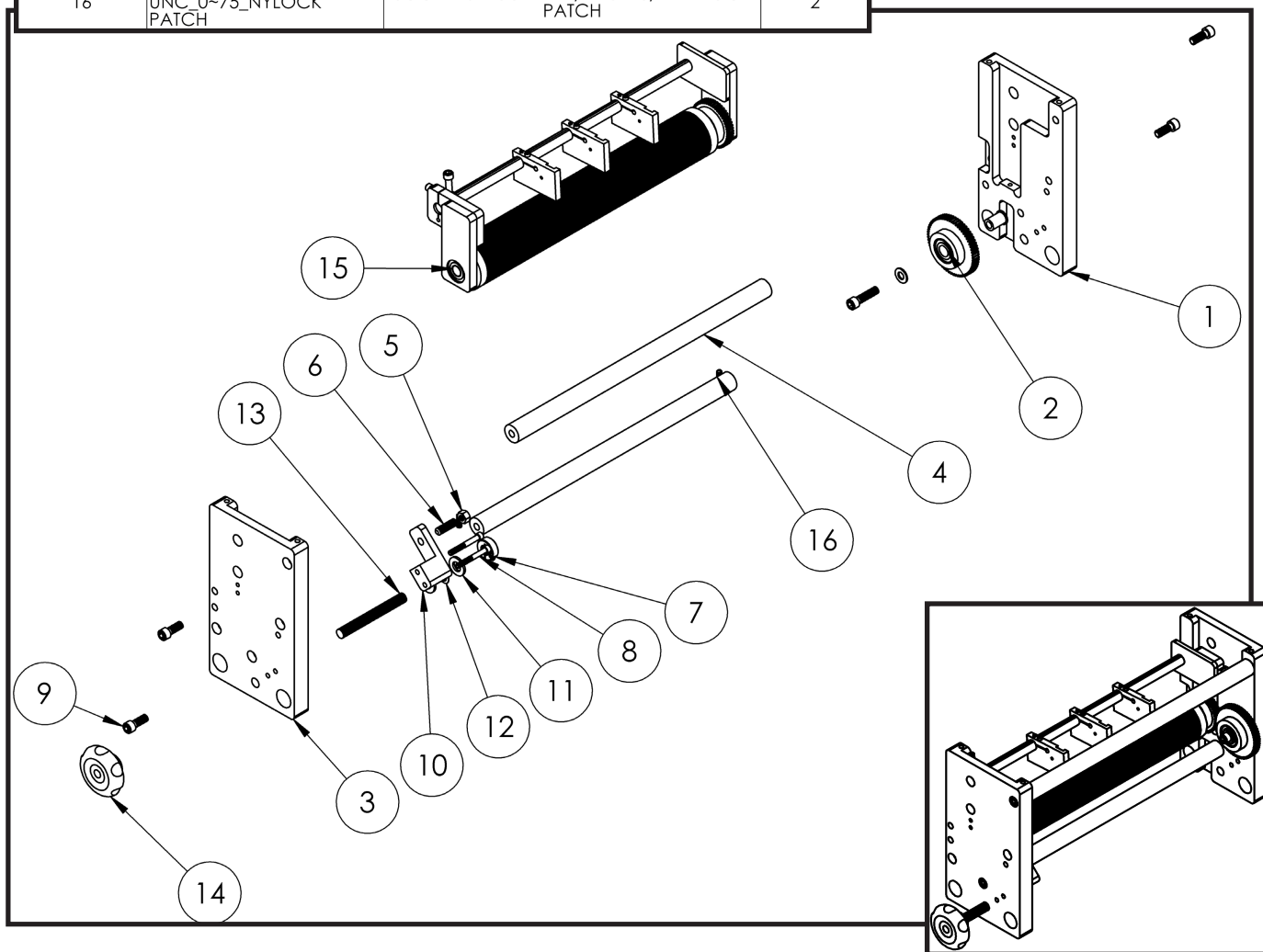


# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

### Slitting Insert - Razor Slitting, 16" (AZT: 21627)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
3	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
4	16310	SLITTING STATION ER, STANDOFF 16"	2
5	HEX NUT_~375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
6	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
7	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
8	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
9	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4
10	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
11	WSHR A_~500 HARD	HARD FLAT WASHER 1/2"	2
12	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
13	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
14	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
15	10472	RAZOR STATION - ASSEMBLY 16"	1
16	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2



# AZTECH CONVERTING SYSTEMS

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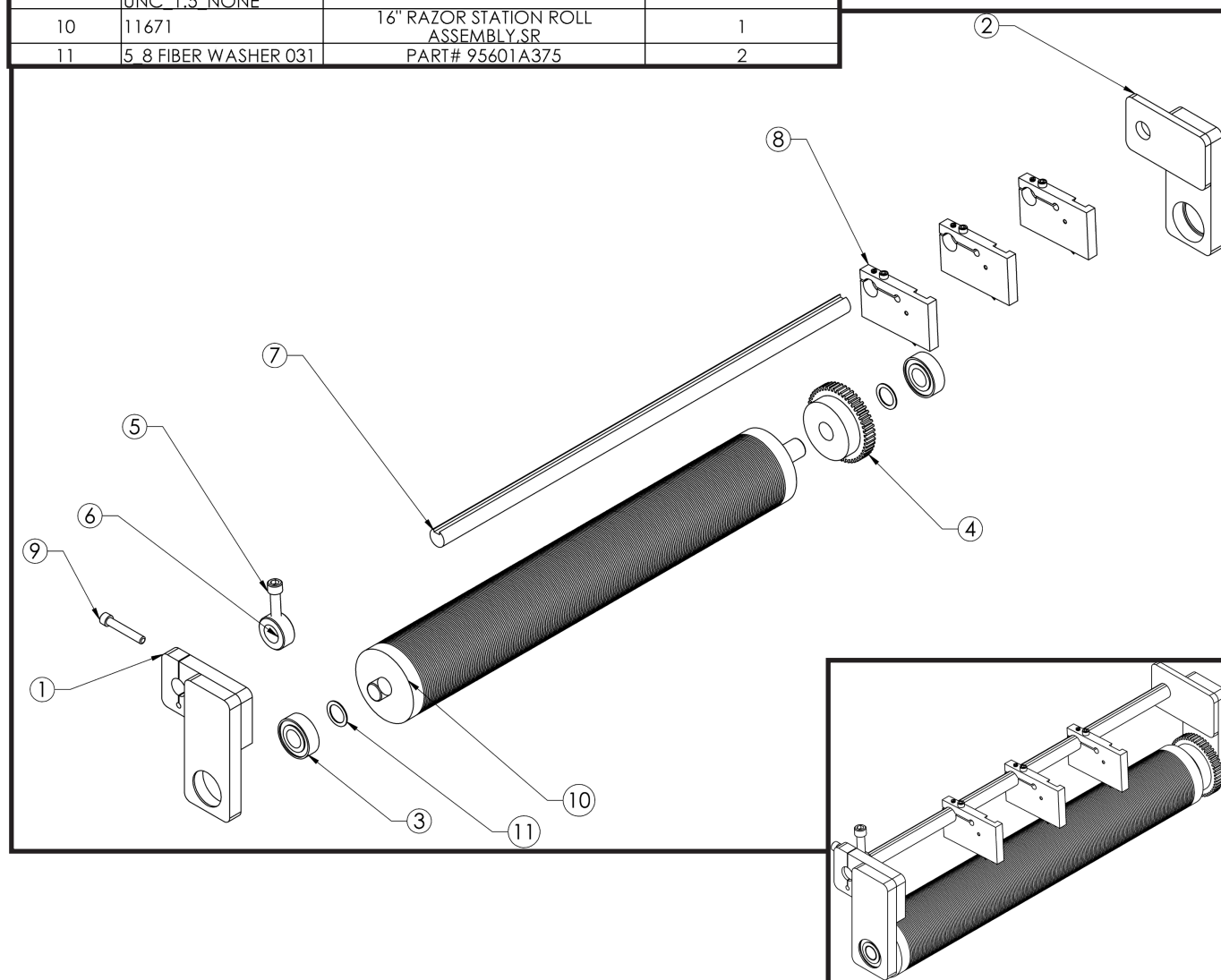
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### Slitting Insert - Razor Slitting, 16" (AZT: 10472)

ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	10454	RAZOR STATION - INSIDE GIBB ASSEMBLY	1
2	10453	RAZOR STATION - OUTSIDE GIBB ASSEMBLY	1
3	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
4	10667	GEAR,S2050-14-1/2, 5/8 BORE	1
5	SCH_.3125-18 UNC 1.25 NONE		1
6	58 COLLAR	5/8 SET COLLAR	1
7	10476	RAZOR STATION - BLADE HOLDER SHAFT, 16"	1
8	10458	RAZOR BLADE HOLDER, SLITTING STATION, ASSEMBLY	3
9	SCH_.250-20 UNC 1.5 NONE		1
10	11671	16" RAZOR STATION ROLL ASSEMBLY.SR	1
11	5 8 FIBER WASHER 031	PART# 95601A375	2





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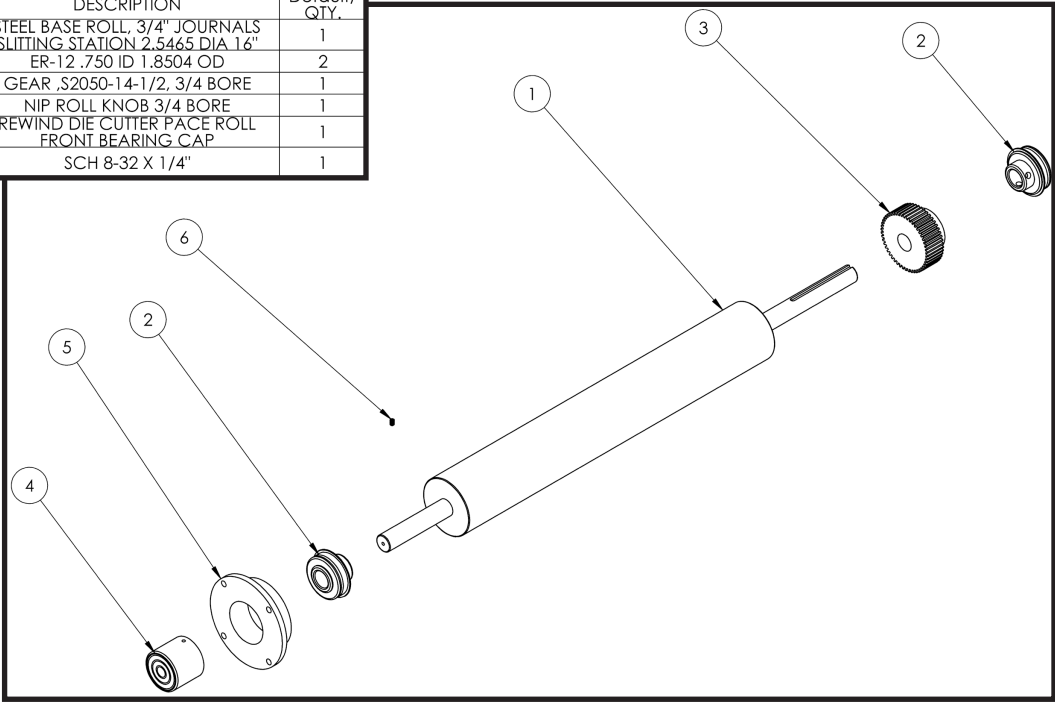
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## SR-SERIES

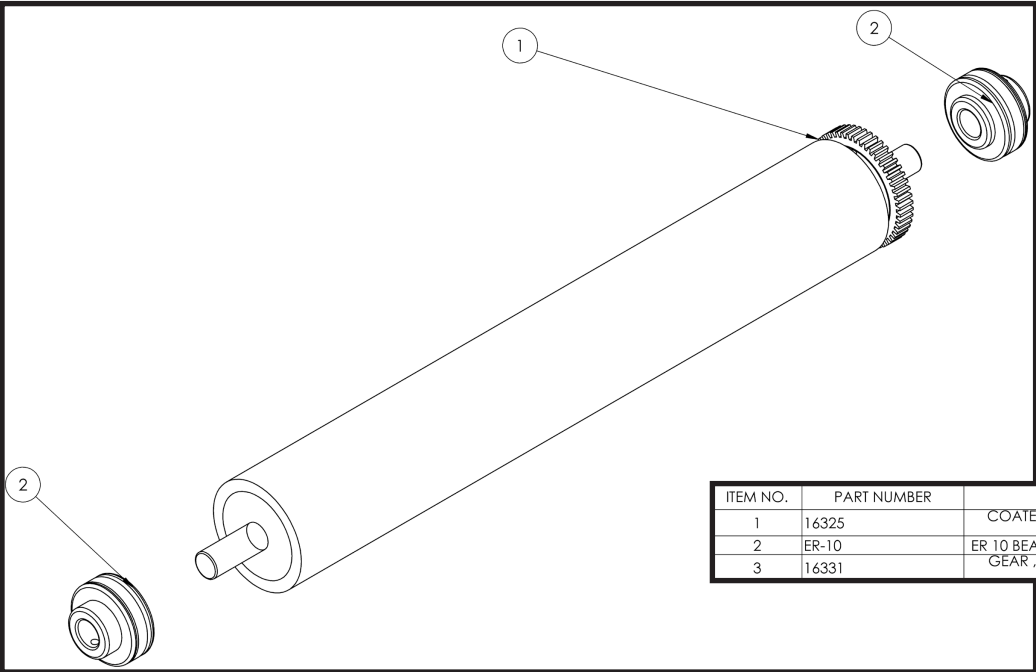
### USER MANUAL

### Base Roll, 16" (AZT: 16321)

ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	16322	STEEL BASE ROLL, 3/4" JOURNALS SLITTING STATION 2.5465 DIA 16"	1
2	0.7500er-12	ER-12 .750 ID 1.8504 OD	2
3	15988	GEAR .S2050-14-1/2, 3/4 BORE	1
4	15861	NIP ROLL KNOB 3/4 BORE	1
5	15961	REWIND DIE CUTTER PACE ROLL FRONT BEARING CAP	1
6	SSCR-HEX-CUP ~164- 32 LINC 0~25 SIMP	SCH 8-32 X 1/4"	1



### Nip Roll, 16" (AZT: 16324)



ITEM NO.	PART NUMBER	DESCRIPTION	INSPECTION REWIND/QTY.
1	16325	COATED NIP ROLL, ER SLITTING STATION, 16"	1
2	ER-10	ER 10 BEARING 1.8504 OD X .625 ID	2
3	16331	GEAR .S2050-14-1/2, 5/8 BORE RECESSED	1



# AZTECH CONVERTING SYSTEMS

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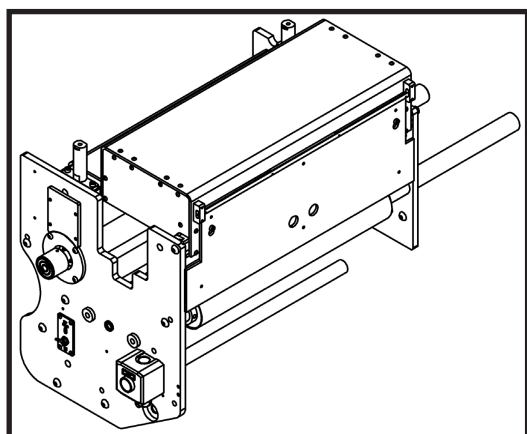
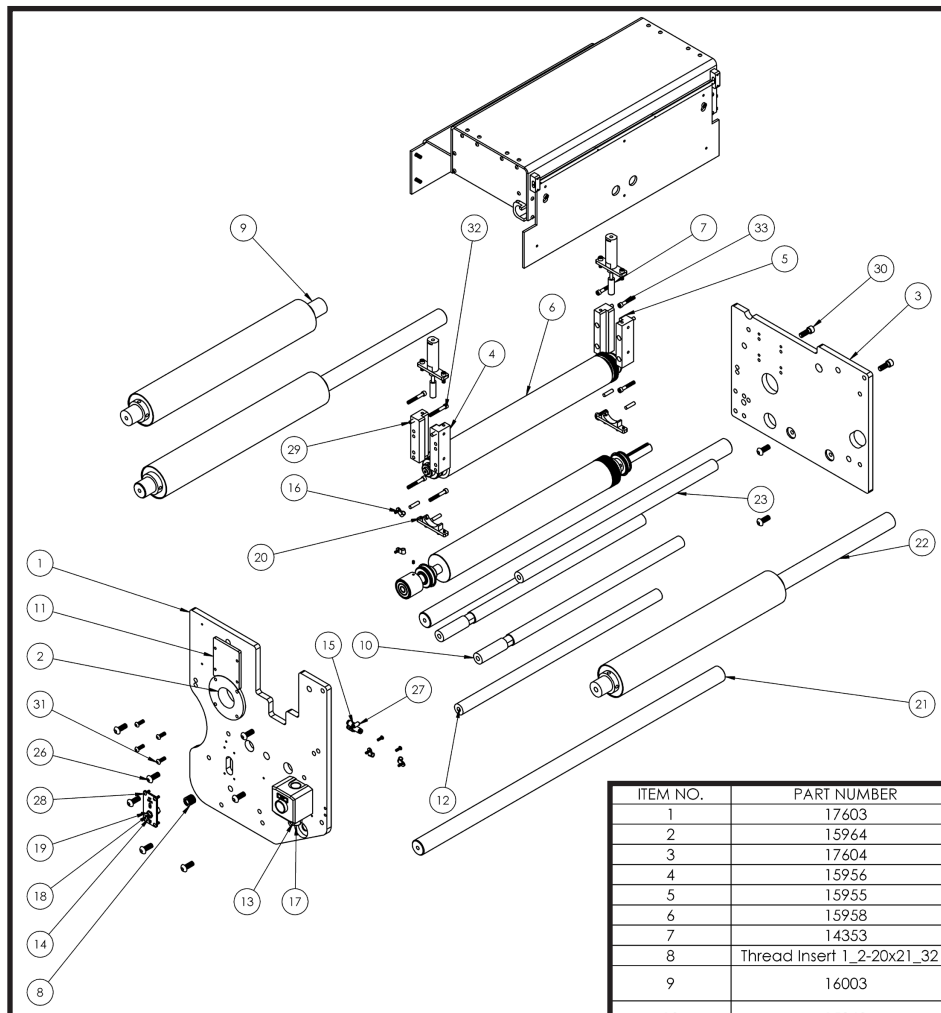
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### Slitting Station, 18" (AZT: 21997)



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	17603	BSR SLITTING STATION FRONT PLATE	1
2	15964	REWIND DIE CUTTER BASE ROLL ASSEMBLY 18"	1
3	17604	BSR SLITTING STATION REAR PLATE R TO L	1
4	15956	REWIND DIE CUTTER GIBB BAR LEFT	2
5	15955	REWIND DIE CUTTER GIBB BAR RIGHT	2
6	15958	REWIND DIE CUTTER NIP ROLL ASSEMBLY 18"	1
7	14353	SLITTING STATION, NIP AIR CLAMP ASSEMBLY	2
8	Thread Insert 1_2-20x21_32 L	Thread Insert, 1/2-20x21/32 L	1
9	16003	STANDOFF 1-3/8 DIA X 22.75" TAPPED 3/8-16 BOTH ENDS	1
10	15960	REWIND DIE CUTTER SLIT STATION SPRT SHAFT 18"	2
11	17605	BSR SLITTING STATION FRONT GIBB PLATE	1
12	18051	DM 4013, MULTI LAMINATION, STANDOFF 18"	1
13	6HK25	STOP SWITCH WITH HOUSING	1
14	15977	REWIND DIE CUTTER NIP DRIVE VALVE PLATE	1
15	KQ2U03-00	ONE TO TWO 4MM UNION	1
16	1_4 CORD CLAMP WITH BOLT	1/4 cord clamp with 8-32 x 1/2 button head cap screw	4
17	1_2 STRAIN RELIEF ASSEMBLY	1/2" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	1
18	TV-3F ASSEMBLY	3-Way Toggle Valve, Short (Plastic Toggle	1
19	MJTV NUT	MJTV SERIES NUT	1
20	16143	NIP LIFT ASSEMBLY	2
21	18050	IDLER SHAFT, 35-1/4" LONG TAPPED ONE END	3
22	20042	STANDOFF 1-3/8 DIA X 34.25" TAPPED 1/2-13 BOTH ENDS	1
23	18525	STANDOFF 1" DIA X 22.75, 3/8-16 TAPPED ENDS	1
24	22000	BSR SLITTING GUARD ASSEMBLY R TO L 18"	1
25	12061	IDLER ASSEMBLY, 1-3/8 BORE, 18"	3
26	BTNHD_~375-16 UNC_1_SIMP	BUTTON HEAD CAP SCREW 3/8-16 X 1"	11
27	BTNHD_~164-32 UNC_1_SIMP	BUTTON HEAD CAP SCREW GRADE 5, 8-32 X 1"	1
28	BTNHD_~164-32 UNC_0~5_SIMP	BUTTON HEAD CAP SCREW 8-32 X 1/2"	6
29	DWL PIN GRD_~25000_1	DOWEL PIN 1/4" DIA X 1"	8
30	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	2
31	BTNHD_~250-20 UNC_0~75_SIMP	BUTTON HEAD CAP SCREW 1/4-20 X 3/4"	4
32	SCH_~250-20 UNC_1~75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4"	4
33	SCH_~250-20 UNC_1~5_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-1/2"	4

# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

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Info

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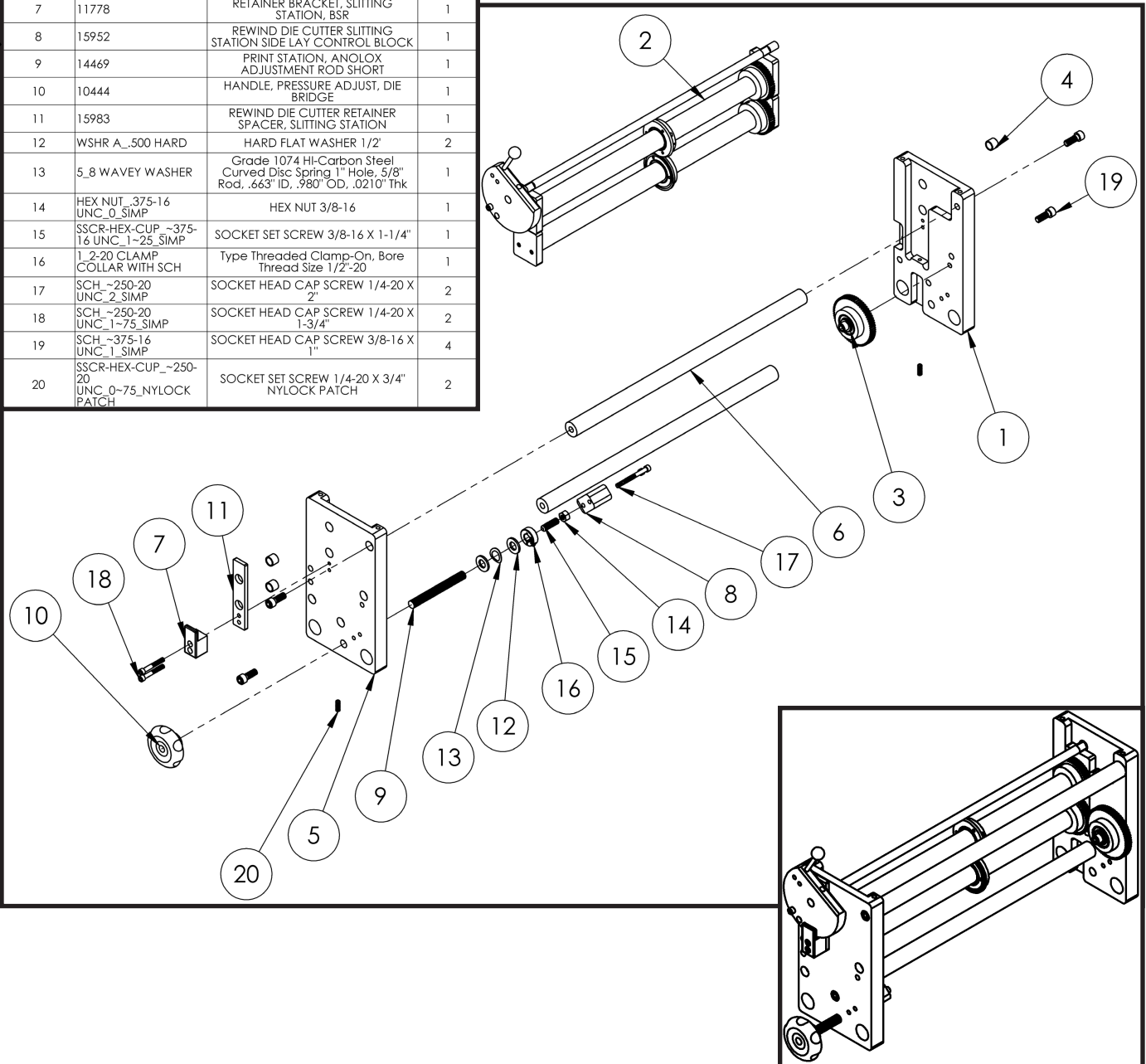
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	14376	BSR, ROTARY SHEAR ASSEMBLY, 18"	1
3	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
4	1_2 X 5_8 X 1_2 INCH	BUSHING 6391K211	3
5	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
6	15497	SLITTING STATION ER, STANDOFF 18"	2
7	11778	RETAINER BRACKET, SLITTING STATION, BSR	1
8	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
9	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
10	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
11	15983	REWIND DIE CUTTER RETAINER SPACER, SLITTING STATION	1
12	WSHR A_500 HARD	HARD FLAT WASHER 1/2"	2
13	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
14	HEX NUT_375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
15	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
16	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
17	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
18	SCH_~250-20 UNC_1~75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4"	2
19	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4
20	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2

### Rotary Shear Assembly, 18" (AZT: 21633)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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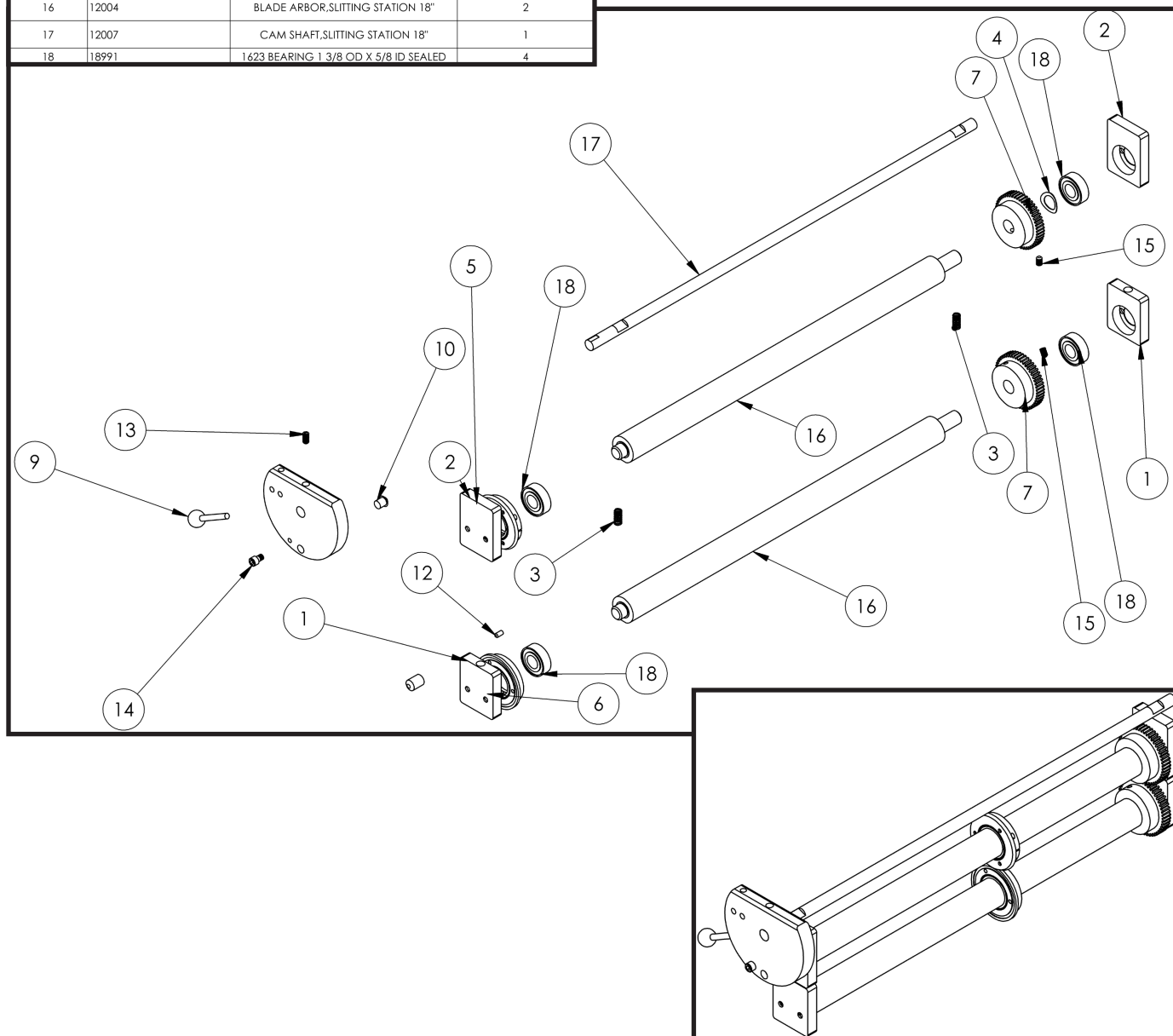
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ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	11781	GIBB BLOCK, BLANK, LOWER, SLITTING STATION	2
2	11779	GIBB BLOCK, UPPER	2
3	9657K156	COMPRESSION SPRING .38 x .048 x 1.5	2
4	5_8 WAVEY WASHER	Grade 1074 Hi-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Trk	1
5	11635	UPPER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
6	11629	LOWER BLADE HOLDER ROTARY SHEAR ASSEMBLY	1
7	10667	GEAR, S2050-14-1/2, 5/8 BORE	2
8	11787	KNOB, ROTARY SHEAR	1
9	6303K23	STEEL LEVER HANDLE	1
10	11786	THRUST BUTTON, ROTARY SHEAR	1
11	11788	PUSH PIN, UPPER SHEAR SHAFT	1
12	SSCR-HEX-CUP -190-24 UNC, 0.375, NONE		1
13	SSCR-HEX-CUP -250-20 UNC, 0-5, SIMP	SOCKET SET SCREW 1/4-20 X 1/2"	1
14	SCHL -250-20 UNC, 0-375, SIMP	SOCKET HEAD CAP SCREW 1"4-20 X 3/8"	1
15	SSCR-HEX-CUP -250-20 UNC, 0-375, SIMP	SOCKET SET SCREW CUP PT 1/4-20 X 3/8"	2
16	12004	BLADE ARBOR, SLITTING STATION 18"	2
17	12007	CAM SHAFT, SLITTING STATION 18"	1
18	18991	1623 BEARING 1 3/8 OD X 5/8 ID SEALED	4

### Slitting Insert - Rotary Shear, 18" (AZT: 14376)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

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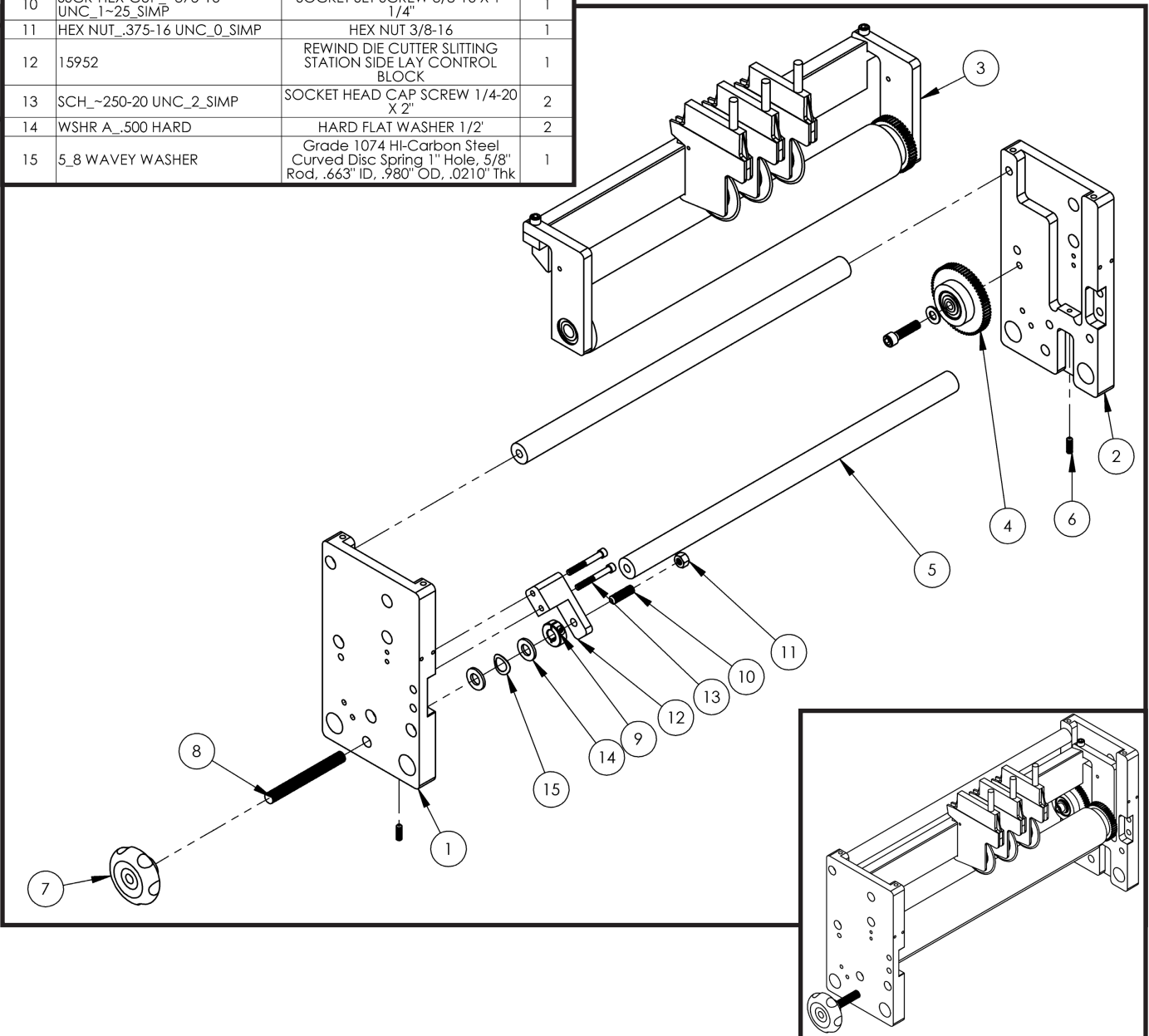
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
3	12637	CRUSH KNIFE ASSEMBLY, 18" BSR, SR	1
4	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
5	15497	SLITTING STATION ER, STANDOFF 18"	2
6	SSCR-HEX-CUP ~250-20 UNC_0-75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2
7	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
8	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
9	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
10	SSCR-HEX-CUP ~375-16 UNC_1-25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
11	HEX NUT ~375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
12	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
13	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
14	WSHR A_~500 HARD	HARD FLAT WASHER 1/2"	2
15	5_8 WAVEY WASHER	Grade 1074 Hi-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1

### Crush Knife Station, 18" (AZT: 21632)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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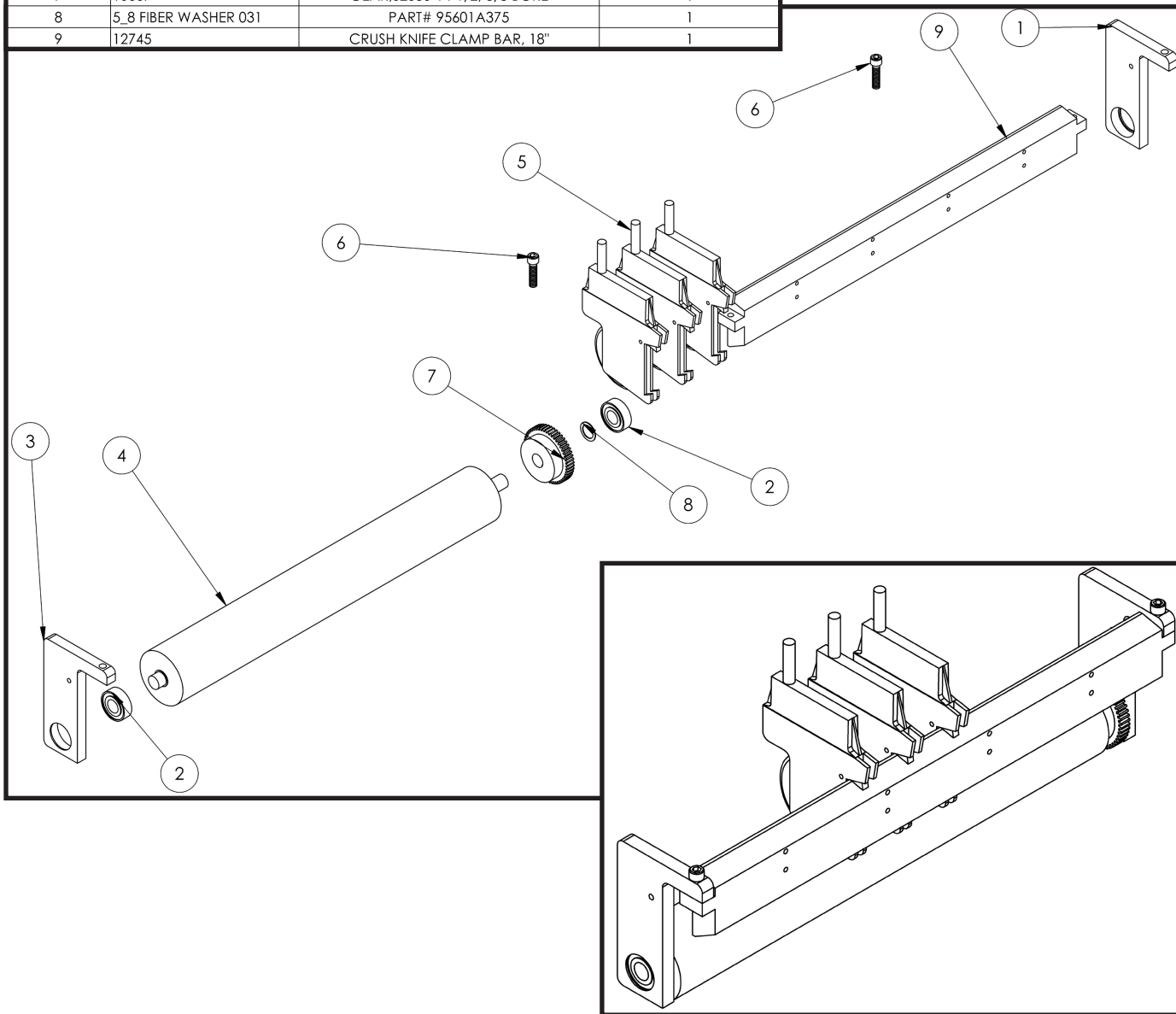
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### Slitting Insert - Crush Knife, 18" (AZT: 12637)

ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	13380	CHRUSH KNIFE SUPPORT BLOCK, BACK	1
2	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
3	13381	CRUSH KNIFE SUPPORT BLOCK, FRONT	1
4	12771	CRUSH KNIFE, ANVIL ROLL, 18"	1
5	DIE02023-01	CHRUSH KNIFE UNIT	3
6	SCH ~3125-18 UNC 1~25_SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4"	2
7	10667	GEAR,S2050-14-1/2, 5/8 BORE	1
8	5_8 FIBER WASHER 031	PART# 95601A375	1
9	12745	CRUSH KNIFE CLAMP BAR, 18"	1



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

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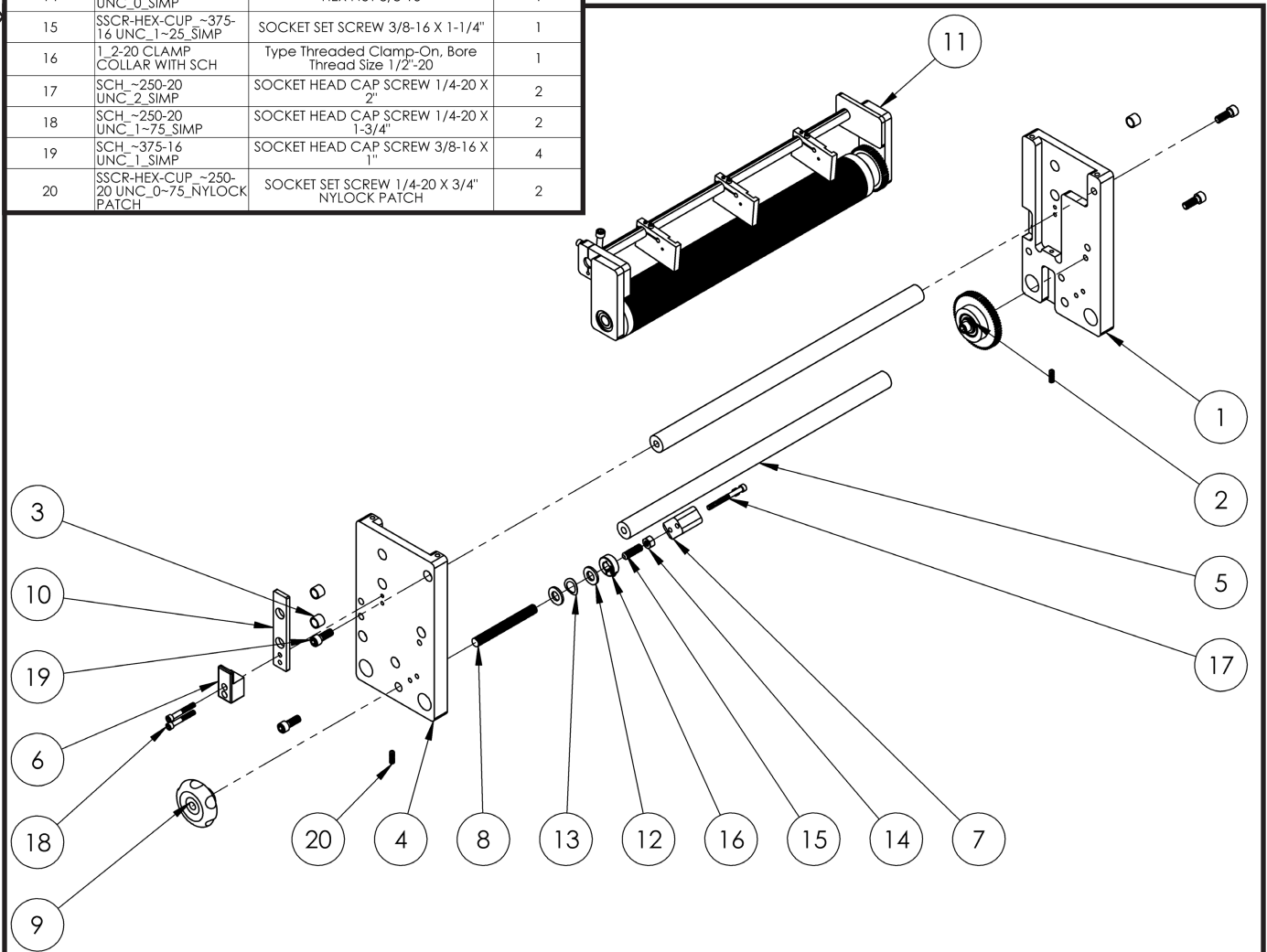
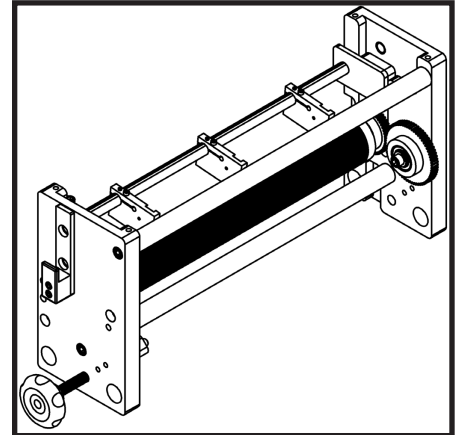
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15950	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
2	11811	IDLER GEAR ASSEMBLY, SLITTING STATION	1
3	1_2 X 5.8 X 1_2 INCH	BUSHING 6391K211	3
4	15951	REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE	1
5	15497	SLITTING STATION ER, STANDOFF 18"	2
6	11778	RETAINER BRACKET, SLITTING STATION, BSR	1
7	15952	REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK	1
8	14469	PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT	1
9	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE	1
10	15983	REWIND DIE CUTTER RETAINER SPACER, SLITTING STATION	1
11	10473	RAZOR STATION - ASSEMBLY 18"	1
12	WSHR A_500 HARD	HARD FLAT WASHER 1/2"	2
13	5_8 WAVEY WASHER	Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk	1
14	HEX NUT_375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
15	SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP	SOCKET SET SCREW 3/8-16 X 1-1/4"	1
16	1_2-20 CLAMP COLLAR WITH SCH	Type Threaded Clamp-On, Bore Thread Size 1/2"-20	1
17	SCH_~250-20 UNC_2_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 2"	2
18	SCH_~250-20 UNC_1~75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4"	2
19	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	4
20	SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH	SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH	2

### Razor Slitting Station, 18" (AZT: 21631)



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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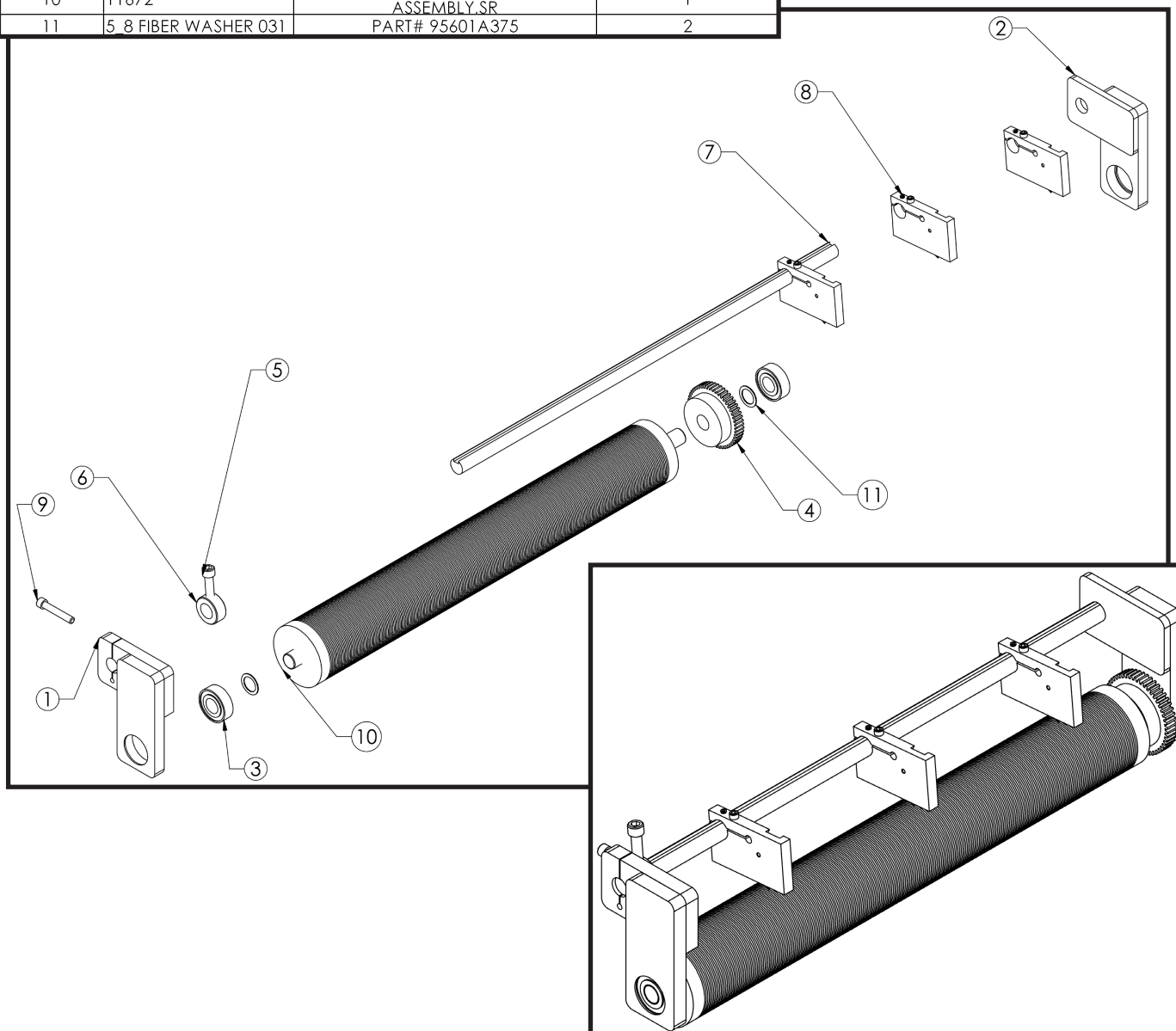
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### Slitting Insert - Razor Slitting, 18" (AZT: 10473)

ITEM NO.	PART NUMBER	DESCRIPTION	LEFT TO RIGHT/QTY.
1	10454	RAZOR STATION - INSIDE GIBB ASSEMBLY	1
2	10453	RAZOR STATION - OUTSIDE GIBB ASSEMBLY	1
3	18973	1623 BEARING 1 3/8 OD X 5/8 ID SHIELDED	2
4	10667	GEAR,S2050-14-1/2, 5/8 BORE	1
5	SCH_.3125-18 UNC_1.25_NONE		1
6	58 COLLAR	5/8 SET COLLAR	1
7	10477	RAZOR STATION - BLADE HOLDER SHAFT, 18"	1
8	10458	RAZOR BLADE HOLDER, SLITTING STATION, ASSEMBLY	3
9	SCH_.250-20 UNC_1.5_NONE		1
10	11672	18" RAZOR STATION ROLL, 1/16, ASSEMBLY, SR	1
11	5 8 FIBER WASHER 031	PART# 95601A375	2





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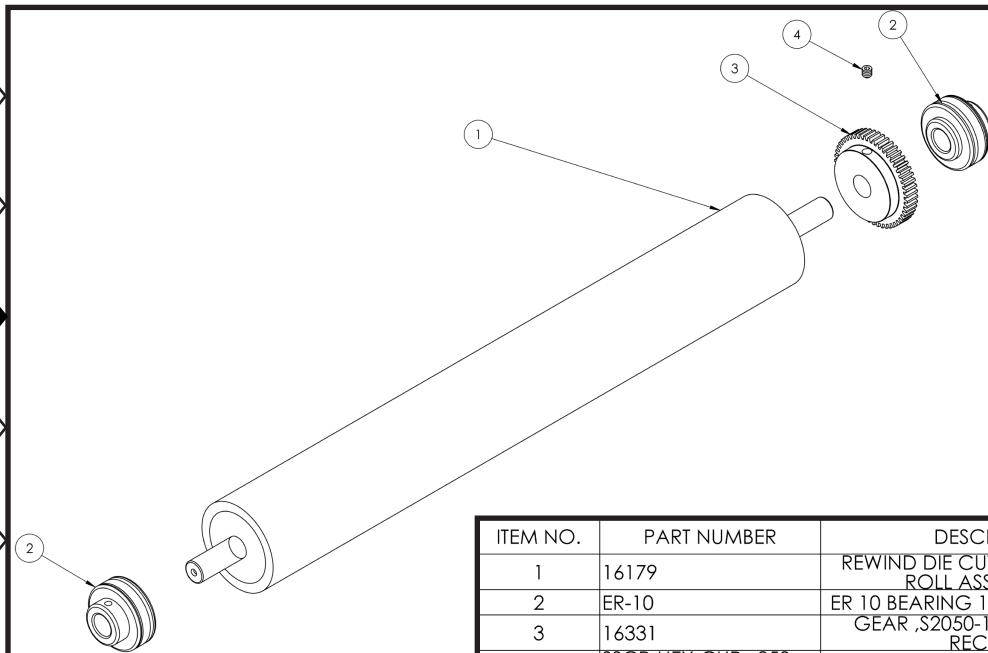
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# AZTECH CONVERTING SYSTEMS

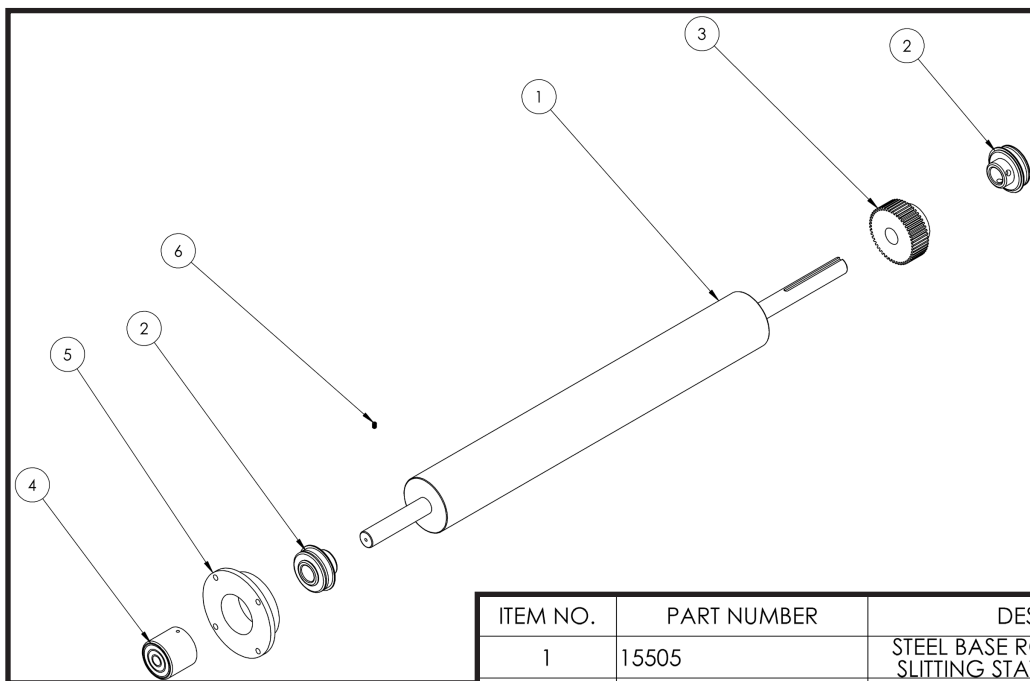
## SR-SERIES USER MANUAL

### Base Roll, 18" (AZT: 15964)



ITEM NO.	PART NUMBER	DESCRIPTION	INSPECTION REWIND/QTY.
1	16179	REWIND DIE CUTTER COATED NIP ROLL ASSEMBLY 18"	1
2	ER-10	ER 10 BEARING 1.8504 OD X .625 ID	2
3	16331	GEAR ,S2050-14-1/2, 5/8 BORE RECESSED	1
4	SSCR-HEX-CUP...250- 20 UNC. 0.25 SIMP	SSCR 1/4-20 X 1/4	1

### Nip Roll, 18" (AZT: 15958)



ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	15505	STEEL BASE ROLL, 3/4" JOURNALS SLITTING STATION 2.5465 DIA 18"	1
2	0.7500er-12	ER-12 .750 ID 1.8504 OD	2
3	15988	GEAR ,S2050-14-1/2, 3/4 BORE	1
4	15861	NIP ROLL KNOB 3/4 BORE	1
5	15961	REWIND DIE CUTTER PACE ROLL FRONT BEARING CAP	1
6	SSCR-HEX-CUP ~164- 32 UNC. 0~25 SIMP	SCH 8-32 X 1/4"	1



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL



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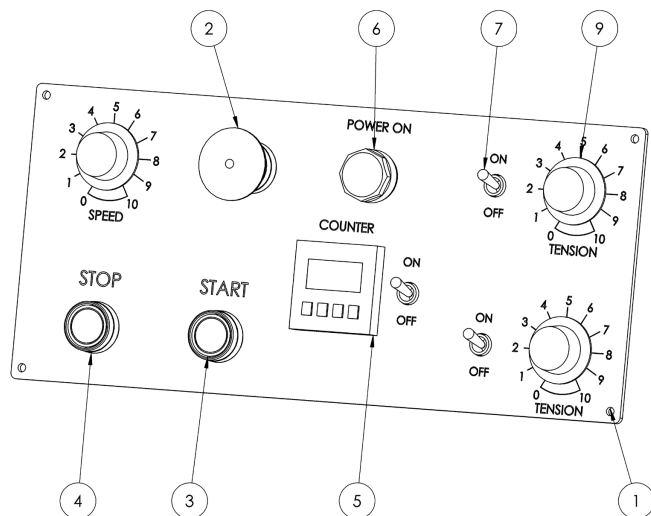
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### Electrical Details (STD MACHINE)

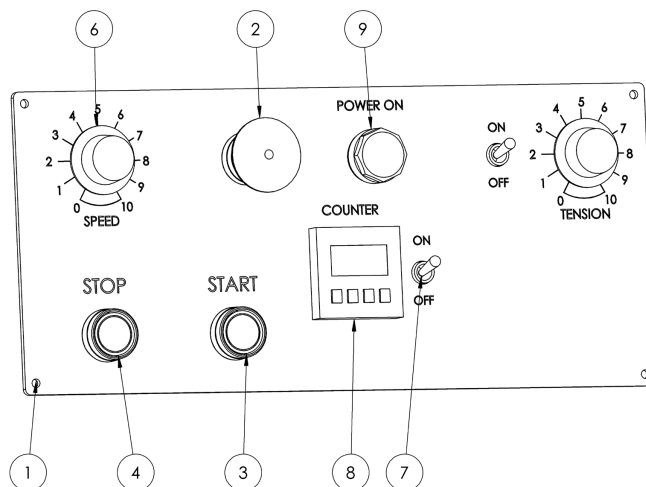
#### 21600 Operator Panel (DUAL ARBOR)



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	12489	DUAL ARBOR ET CONTROL PANEL, FACE PLATE	1
2	20712	IDEC E-STOP BUTTON ASSY (NC)	1
3	20428	IDEC START BUTTON ASSY	1
4	20429	IDEC JOG BUTTON ASSY	1
5	C48CD012-20115	RED LION COUNTER	1
6	E22H3 LITE ASSEMBLY	GREEN LITE ASSEMBLY	1
7	SPST ASSEMBLY	PART# 2FA54-73	3
8	SPEED POT	10K SPEED POT	3
9	ROTARY KNOB	PART# 6094K57	3

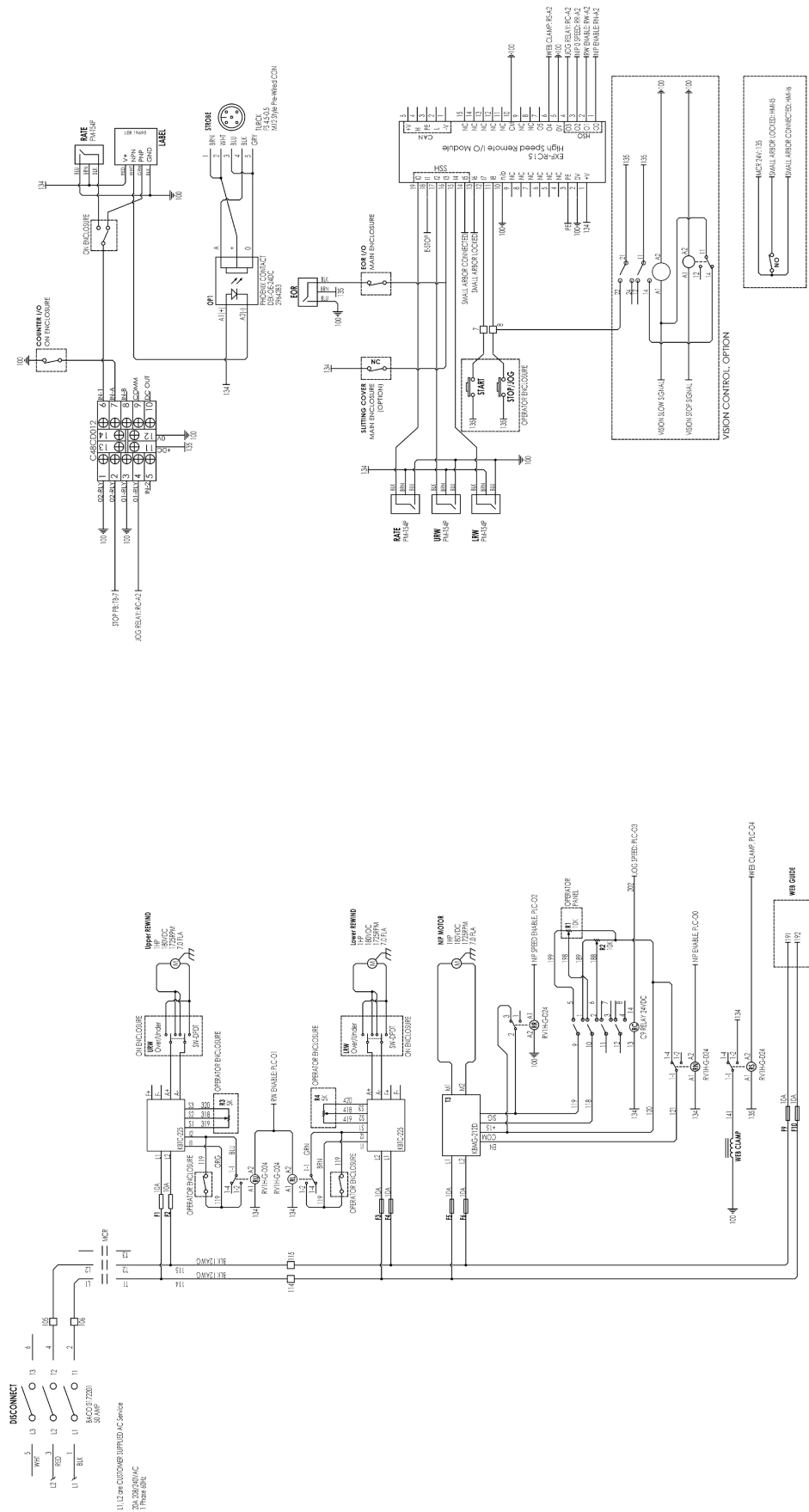
#### 21599 Operator Panel (SINGLE ARBOR)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	19216	SINGLE ARBOR ET CONTROL PANEL, FACE PLATE	1
2	20712	IDEC E-STOP BUTTON ASSY (NC)	1
3	20428	IDEC START BUTTON ASSY	1
4	20429	IDEC JOG BUTTON ASSY	1
5	SPEED POT	10K SPEED POT	2
6	ROTARY KNOB	PART# 6094K57	2
7	SPST ASSEMBLY	PART# 2FA54-73	2
8	C48CD012-20115	RED LION COUNTER	1
9	E22H3 LITE ASSEMBLY	GREEN LITE ASSEMBLY	1



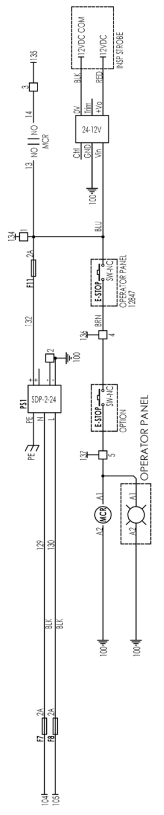


## ELECTRICAL SCHEMATIC (STANDARD)



14 CON CABLE 30U <= 13MM (UO)		10 CON CABLE 30U <= 13MM (RW CONTROL)	
14	BLU/WHI	30	BLU
13	GRN/WHI	30	GRG
12	GRN/WHI	30	GRN
11	GRN/WHI	30	GRN
10	GRN/WHI	30	GRN
9	GRN/WHI	30	GRN
8	GRN/WHI	30	GRN
7	GRN/WHI	30	GRN
6	GRN/WHI	30	GRN
5	GRN/WHI	30	GRN
4	GRN/WHI	30	GRN
3	GRN/WHI	30	GRN
2	GRN/WHI	30	GRN
1	GRN/WHI	30	GRN

14 CON CABLE 21011 <-->12847 (U/O)	BLU 24VDC	24VDC
134	BLU/WHI	24V COMA
140	GRN/WHI	LABEL SENSOR
504	GRN/WHI	PF
	GRN/WHI	ESTOP
136	BRN	MCR 24VDC
135	BRN/WHI	
20	BLK	
198	RED	SPD PT
199	WHI	
142	YEL	STOP/OG
	VIO	START
140	PUR	
202	ORG	RC-RELAY





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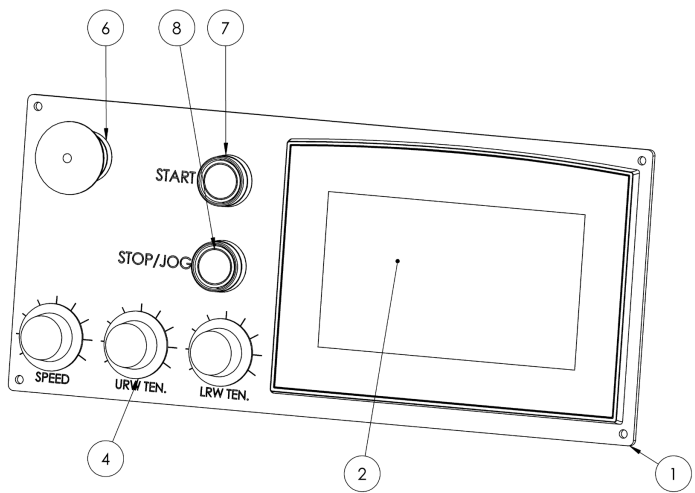
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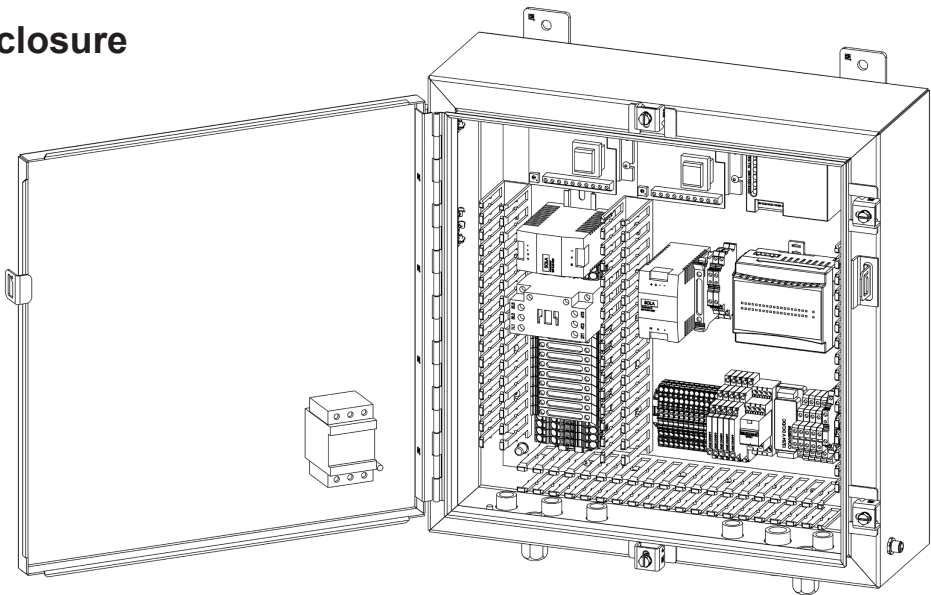
### Electrical Details (PLC)

#### 21017 Operator Enclosure



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	21016	SR SERIES OPERATOR PANEL, SAMBA 70	1
2	SM70	SM70-J-T20 HMI/PLC	1
3	SPEED POT	10K SPEED POT	1
4	ROTARY KNOB	PART# 6094K57	3
5	SPEED POT 5K	5K SPEED POT	2
6	20712	IDEC E-STOP BUTTON ASSY (NC)	1
7	20428	IDEC START BUTTON ASSY	1
8	20429	IDEC JOG BUTTON ASSY	1

#### 21011 Main Enclosure



# AZTECH CONVERTING SYSTEMS

## SR-SERIES USER MANUAL

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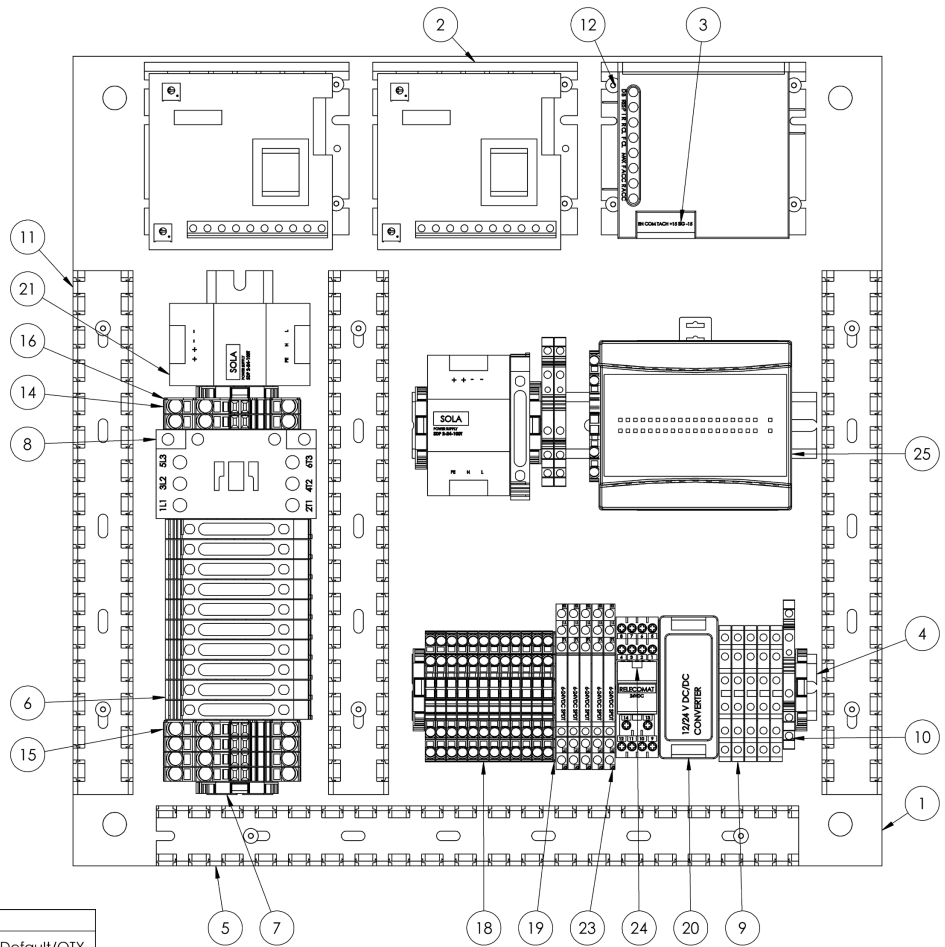
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### 21011 Main Enclosure

BOM Table			
ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
1	20x20 ENC PLATE	20x20 Enclosure Plate	1
2	KBTC-225	DC Motor Drive	2
3	KBMG-212D	KB Regen Reversing 1HP Drive	1
4	Din Rail 8.5in	DIN RAIL, 8.5in	2
5	13in WIREWAY		1
6	3004171 FUSE BLOCK	Midget Fuse Block, Press In, DIN RAIL MOUNT	11
7	DIN RAIL 11in	DIN RAIL 11in	1
8	DILM32-10	EATON 32A Contactor	1
9	2715979	Sensor Terminal Block, 3-Tier	5
10	2964283_DEK_OE_24DC_24DC_100K_HZ-select	Opto-Coupler 2964283	3
11	11in WIREWAY		3
12	BTNHD_164-32 UNC_0.375_SIMP	BUTTON HEAD CAP SCREW 8-32 X 3/8"	26
13	249-116	End Stop 7mm	6
14	2006-1307	WAGO 2006-1307	2
15	2006-1301	WAGO 2006-1301	4
16	2006-1392	End Plate 1mm	2
17	WAGO 2002-1407	Terminal Block, 4-Conn, DIN Rail, 14-22AWG	2
18	WAGO 2002-1401	Terminal Block, 4-Conn, DIN Rail, 14-22AWG	11
19	2002-1492	End Plate 2002, 1mm	1
20	PYB20-Q24-S12-DIN	Isolated DC/DC Converter 12/24VDC	1
21	SDP-2-100T	SPD 100W Power Supply	2
23	RV8H Relay	SPDT RELAY, 6-24VDC COIL	5
24	RELAY ASSY, 4PDT, DIN MOUNT S9&C9	4PDT ICE CUBE RELAY ASSEMBLY	1
25	EXF-RC15	EXF-RC15 I/O EXPANSION MODULE	1

# SR-SERIES USER MANUAL



## ELECTRICAL SCHEMATIC (PLC)

NOTES: III WIDES ARE 10A11/C III 1155 01/06/01/02/03/04/05/06/07/08/09/10/11/12/13/14/15/16/17/18/19/20/21/22/23/24/25/26/27/28/29/30/31/32/33/34/35/36/37/38/39/40/41/42/43/44/45/46/47/48/49/50/51/52/53/54/55/56/57/58/59/60/61/62/63/64/65/66/67/68/69/70/71/72/73/74/75/76/77/78/79/80/81/82/83/84/85/86/87/88/89/90/91/92/93/94/95/96/97/98/99/100/101/102/103/104/105/106/107/108/109/110/111/112/113/114/115/116/117/118/119/120/121/122/123/124/125/126/127/128/129/130/131/132/133/134/135/136/137/138/139/140/141/142/143/144/145/146/147/148/149/150/151/152/153/154/155/156/157/158/159/160/161/162/163/164/165/166/167/168/169/170/171/172/173/174/175/176/177/178/179/180/181/182/183/184/185/186/187/188/189/190/191/192/193/194/195/196/197/198/199/200/201/202/203/204/205/206/207/208/209/210/211/212/213/214/215/216/217/218/219/220/221/222/223/224/225/226/227/228/229/230/231/232/233/234/235/236/237/238/239/240/241/242/243/244/245/246/247/248/249/250/251/252/253/254/255/256/257/258/259/260/261/262/263/264/265/266/267/268/269/270/271/272/273/274/275/276/277/278/279/280/281/282/283/284/285/286/287/288/289/290/291/292/293/294/295/296/297/298/299/300/301/302/303/304/305/306/307/308/309/310/311/312/313/314/315/316/317/318/319/320/321/322/323/324/325/326/327/328/329/330/331/332/333/334/335/336/337/338/339/340/341/342/343/344/345/346/347/348/349/350/351/352/353/354/355/356/357/358/359/360/361/362/363/364/365/366/367/368/369/370/371/372/373/374/375/376/377/378/379/380/381/382/383/384/385/386/387/388/389/390/391/392/393/394/395/396/397/398/399/400/401/402/403/404/405/406/407/408/409/410/411/412/413/414/415/416/417/418/419/420/421/422/423/424/425/426/427/428/429/430/431/432/433/434/435/436/437/438/439/440/441/442/443/444/445/446/447/448/449/450/451/452/453/454/455/456/457/458/459/460/461/462/463/464/465/466/467/468/469/470/471/472/473/474/475/476/477/478/479/480/481/482/483/484/485/486/487/488/489/490/491/492/493/494/495/496/497/498/499/500/501/502/503/504/505/506/507/508/509/510/511/512/513/514/515/516/517/518/519/520/521/522/523/524/525/526/527/528/529/530/531/532/533/534/535/536/537/538/539/540/541/542/543/544/545/546/547/548/549/550/551/552/553/554/555/556/557/558/559/560/561/562/563/564/565/566/567/568/569/570/571/572/573/574/575/576/577/578/579/580/581/582/583/584/585/586/587/588/589/590/591/592/593/594/595/596/597/598/599/600/601/602/603/604/605/606/607/608/609/610/611/612/613/614/615/616/617/618/619/620/621/622/623/624/625/626/627/628/629/630/631/632/633/634/635/636/637/638/639/640/641/642/643/644/645/646/647/648/649/650/651/652/653/654/655/656/657/658/659/660/661/662/663/664/665/666/667/668/669/670/671/672/673/674/675/676/677/678/679/680/681/682/683/684/685/686/687/688/689/690/691/692/693/694/695/696/697/698/699/700/701/702/703/704/705/706/707/708/709/710/711/712/713/714/715/716/717/718/719/720/721/722/723/724/725/726/727/728/729/730/731/732/733/734/735/736/737/738/739/740/741/742/743/744/745/746/747/748/749/750/751/752/753/754/755/756/757/758/759/760/761/762/763/764/765/766/767/768/769/770/771/772/773/774/775/776/777/778/779/780/781/782/783/784/785/786/787/788/789/790/791/792/793/794/795/796/797/798/799/800/801/802/803/804/805/806/807/808/809/810/811/812/813/814/815/816/817/818/819/820/821/822/823/824/825/826/827/828/829/830/831/832/833/834/835/836/837/838/839/840/841/842/843/844/845/846/847/848/849/850/851/852/853/854/855/856/857/858/859/860/861/862/863/864/865/866/867/868/869/870/871/872/873/874/875/876/877/878/879/880/881/882/883/884/885/886/887/888/889/890/891/892/893/894/895/896/897/898/899/900/901/902/903/904/905/906/907/908/909/910/911/912/913/914/915/916/917/918/919/920/921/922/923/924/925/926/927/928/929/930/931/932/933/934/935/936/937/938/939/940/941/942/943/944/945/946/947/948/949/950/951/952/953/954/955/956/957/958/959/960/961/962/963/964/965/966/967/968/969/970/971/972/973/974/975/976/977/978/979/980/981/982/983/984/985/986/987/988/989/990/991/992/993/994/995/996/997/998/999/1000/1001/1002/1003/1004/1005/1006/1007/1008/1009/1010/1011/1012/1013/1014/1015/1016/1017/1018/1019/1020/1021/1022/1023/1024/1025/1026/1027/1028/1029/1030/1031/1032/1033/

### Section 7: Troubleshooting

1:  
Gen.  
Info

2:  
Install

3:  
Setup

4:  
Oper.

5:  
Maint.

6:  
DWGs

7:  
T.S.

8:  
Warr.



#### 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.

Make sure the counter wheel below the web guide is riding against the idler roller, and is free of dust or debris (see chapter 5) and is not visibly damaged.

#### 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".

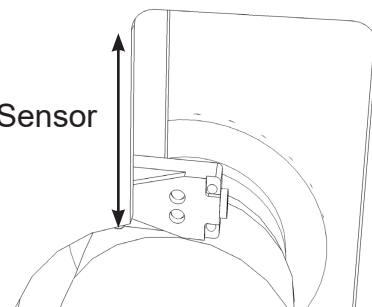
#### 7-5: Why isn't the end-of-roll sensor working?

If your 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.



Adjust Sensor  
Height





## 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 machine 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