



**AZTECH CONVERTING SYSTEMS**

212 W Lodge Drive

TEMPE, AZ 85283

PHONE (480) 951-8351

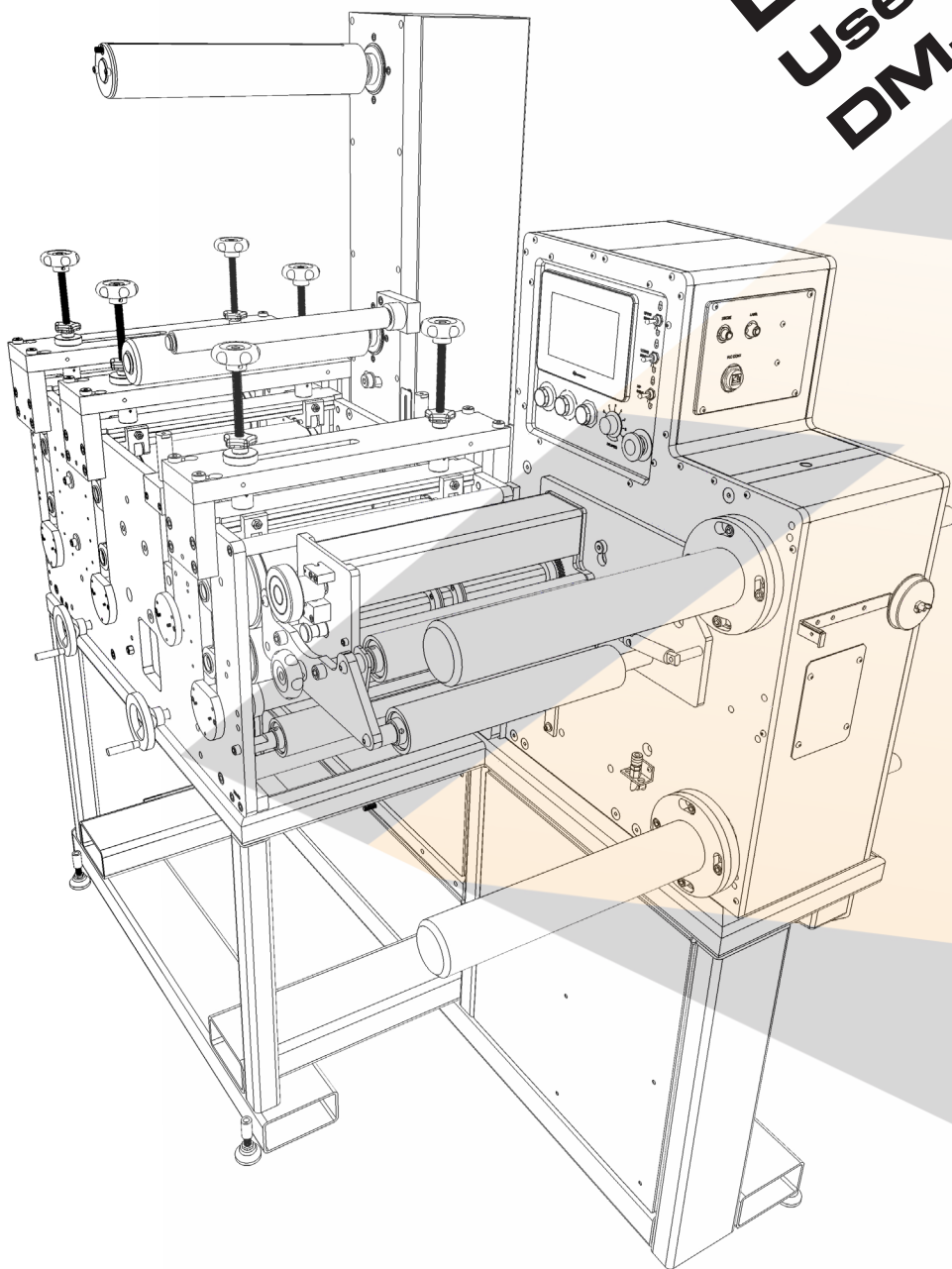
FAX (480) 998-5409

[www.aztechconverting.com](http://www.aztechconverting.com)

# **DIE MASTER**

## **User Manual**

### **DM-40XX**



**Ver 1.3**



# **AZTECH CONVERTING SYSTEMS**

## **DM-40XX USER MANUAL**

---

### **TABLE OF CONTENTS**

<b>SECTION 1: GENERAL INFORMATION</b>	<b>1-4</b>
<b>SECTION 2: MACHINE INSTALLATION</b>	<b>4-5</b>
<b>SECTION 3: MACHINE SETUP</b>	<b>6-18</b>
<b>SECTION 4: MACHINE OPERATION</b>	<b>19-28</b>
<b>SECTION 5: MAINTENANCE</b>	<b>29</b>
<b>SECTION 6: STATION DETAIL</b>	<b>30-52</b>
<b>SECTION 7: TROUBLESHOOTING</b>	<b>53</b>
<b>SECTION 8: WARRANTIES AND SERVICE</b>	<b>54</b>

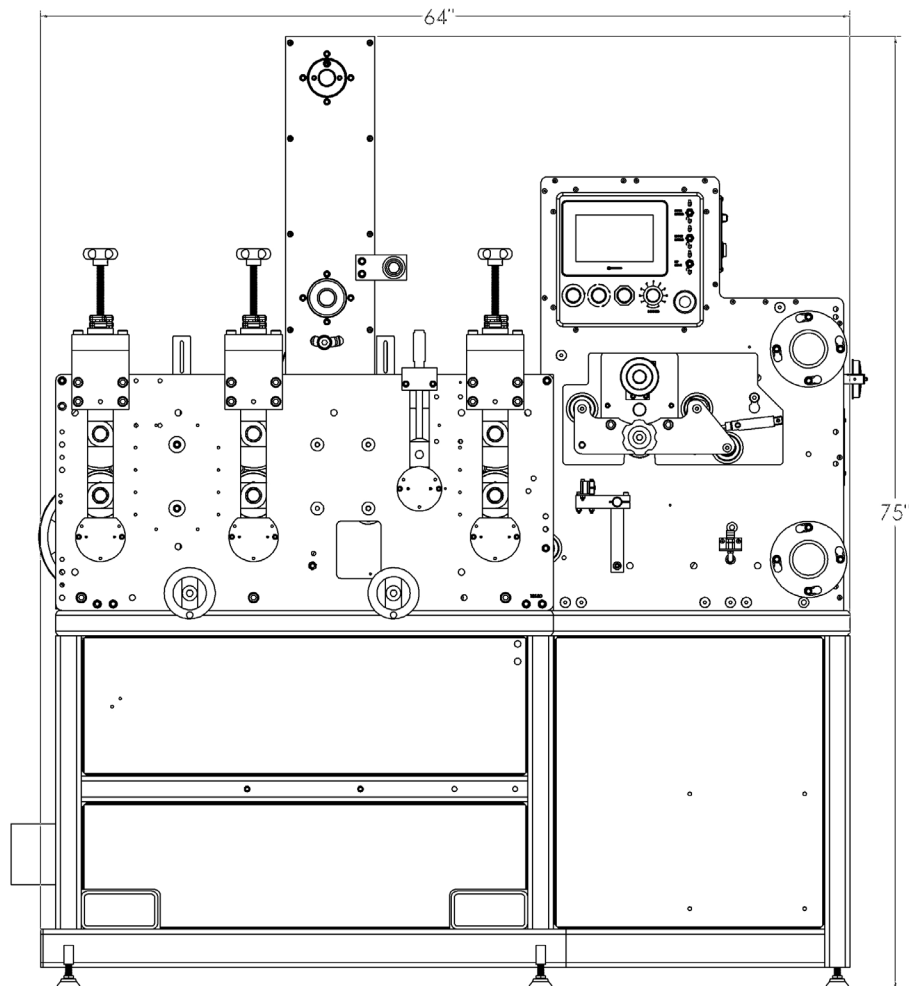


## Section 1: General Information

### 1-1: Introduction

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

### 1-2: Machine Information and Specifications

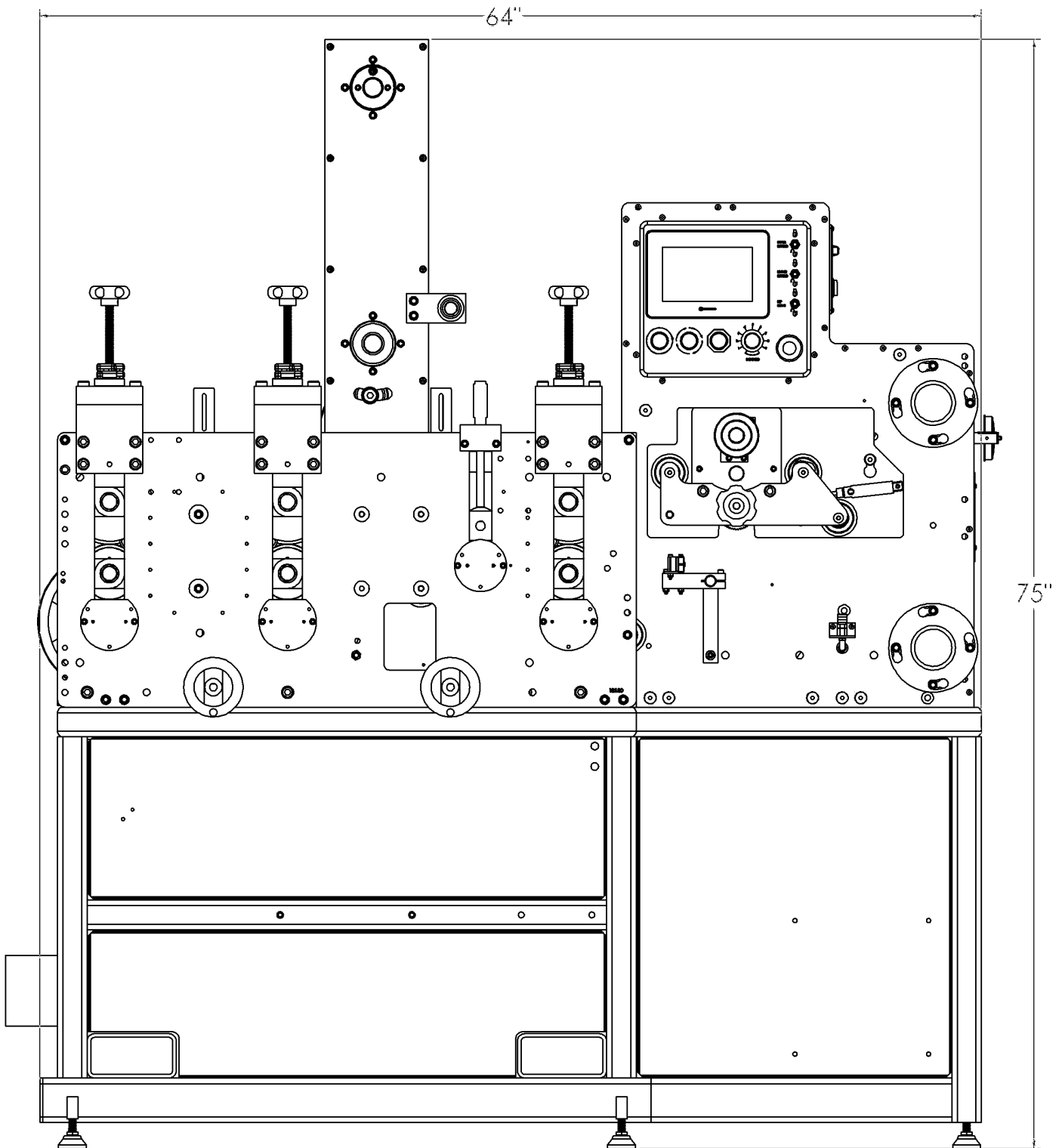




# AZTECH CONVERTING SYSTEMS

DM-40XX  
USER MANUAL

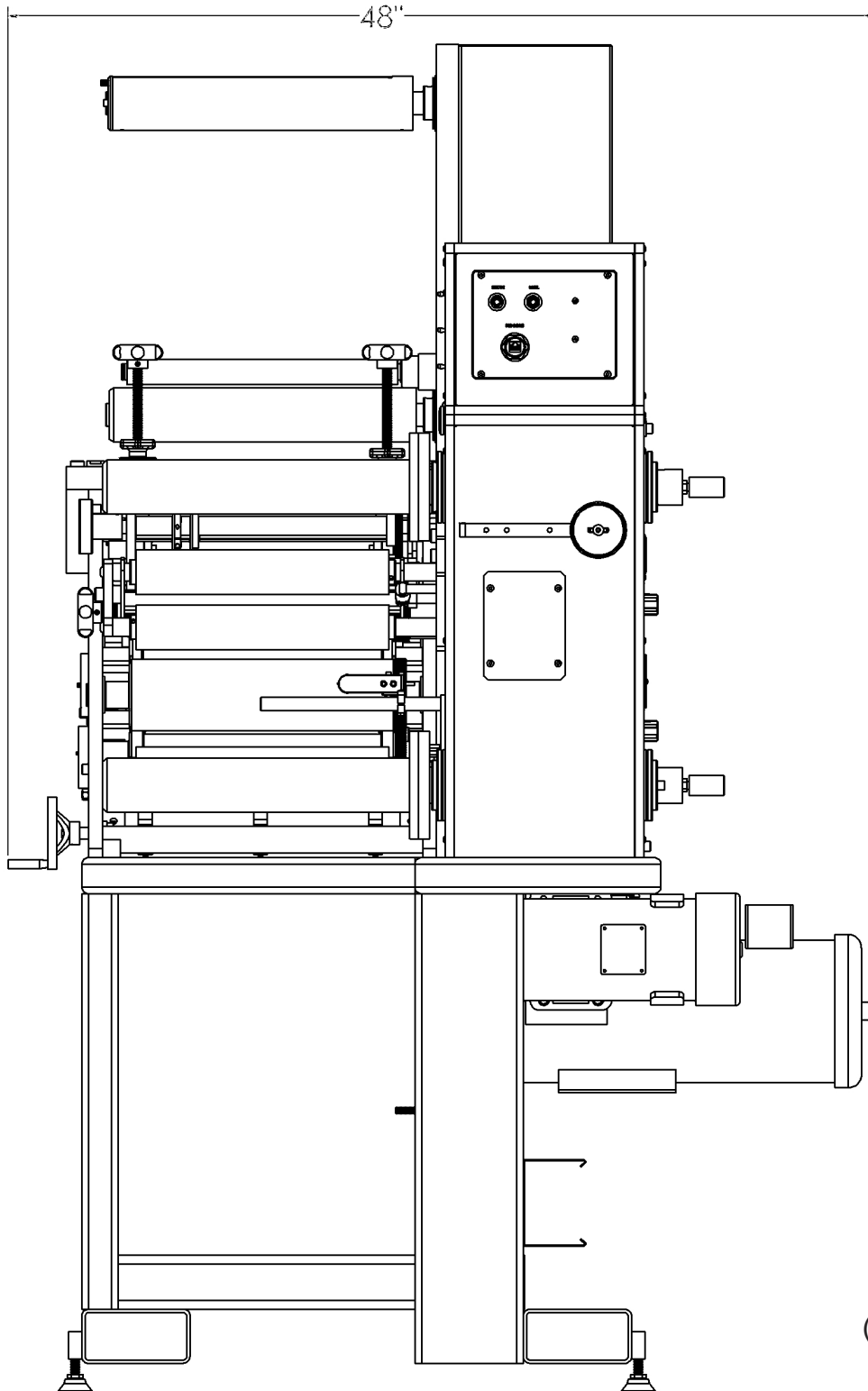
## FRONT LAYOUT (DIE MASTER ONLY)







## SIDE LAYOUT (DIE MASTER ONLY)



(13" Shown, 18" and 20" are similar)



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### 1-3: Care and Maintenance

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

### 1-4: Safety

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

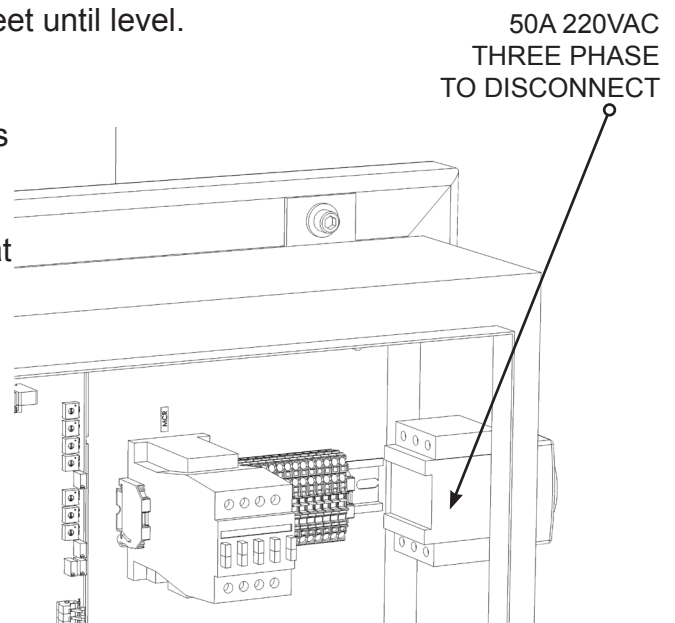
### 2-3: Removal and Positioning

It is critical that the DieMaster 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

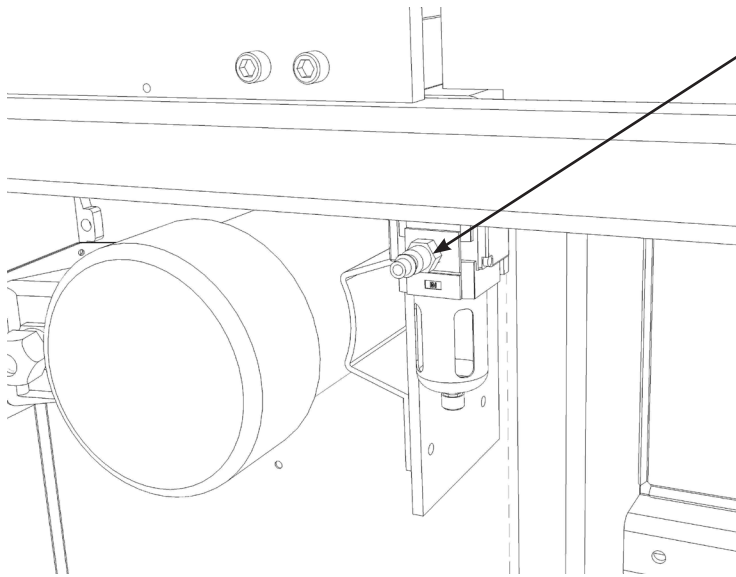
**ELECTRICAL CONNECTIONS:** Your DieMaster uses a power supply of 220 volts, 50 amps AC 3PH. Improper connections or mishandling may cause serious personal injury. AZTECH highly recommends that electrical service be performed only by a qualified electrician.

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.



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



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.



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

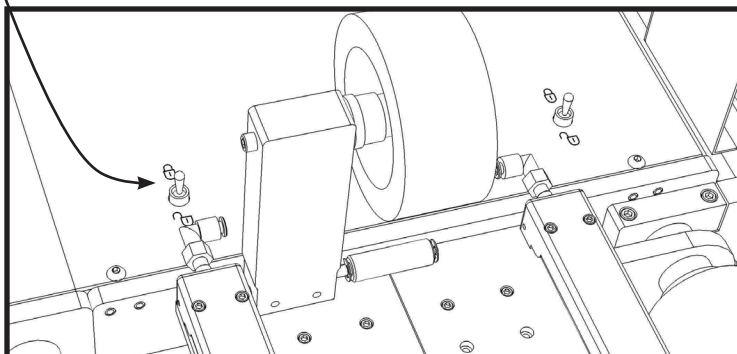
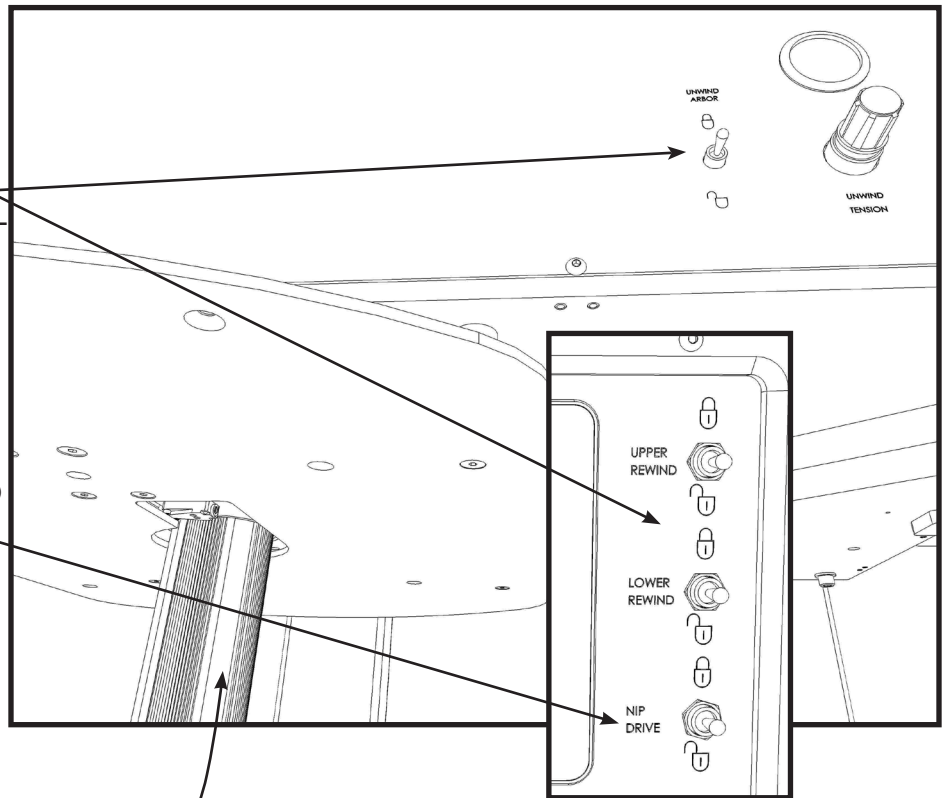
### Section 3: Machine Setup

#### 3-1: Webbing the Machine

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

##### To web the machine:

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



#### Modular Design

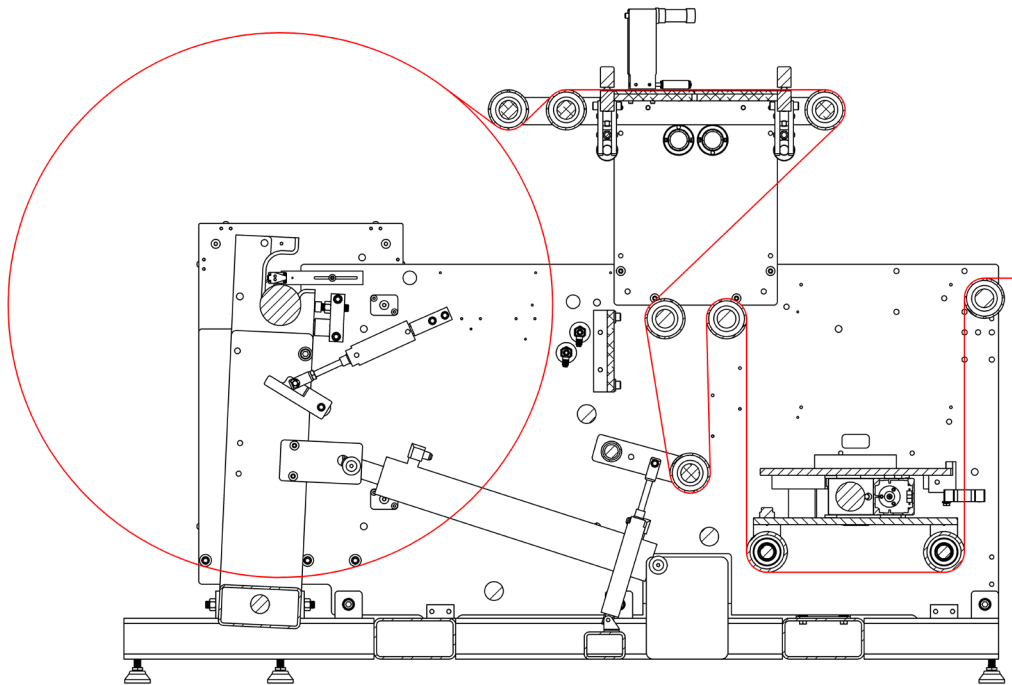
The Die Master press is designed in modular sections to allow a press to be tailored for an application. The various sections are shown on the following pages.

# AZTECH CONVERTING SYSTEMS

DM-40XX  
USER MANUAL

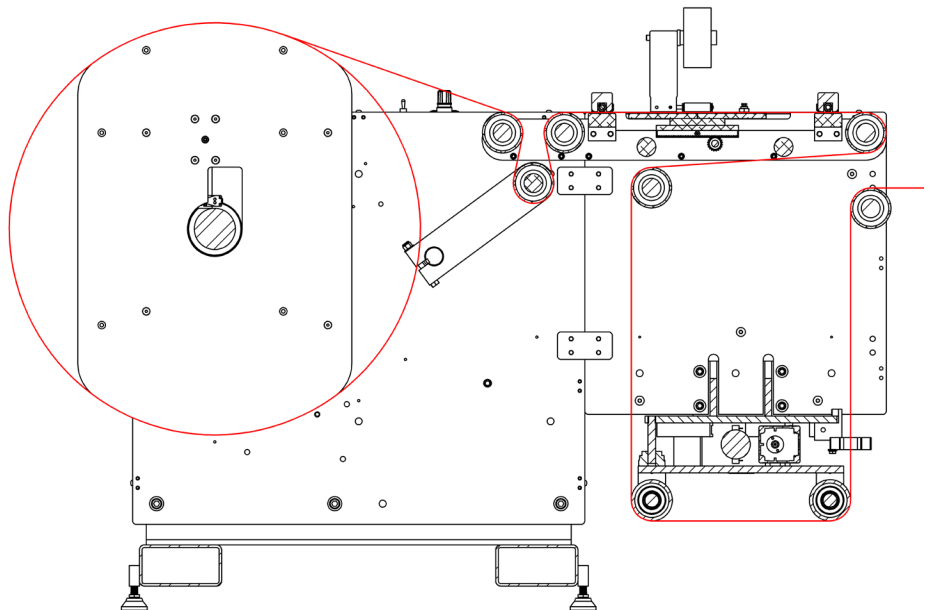


## Unwind Sections



Cradle Mount  
Unwind  
**CMU**

Unwind Disc Brake  
**UDB**

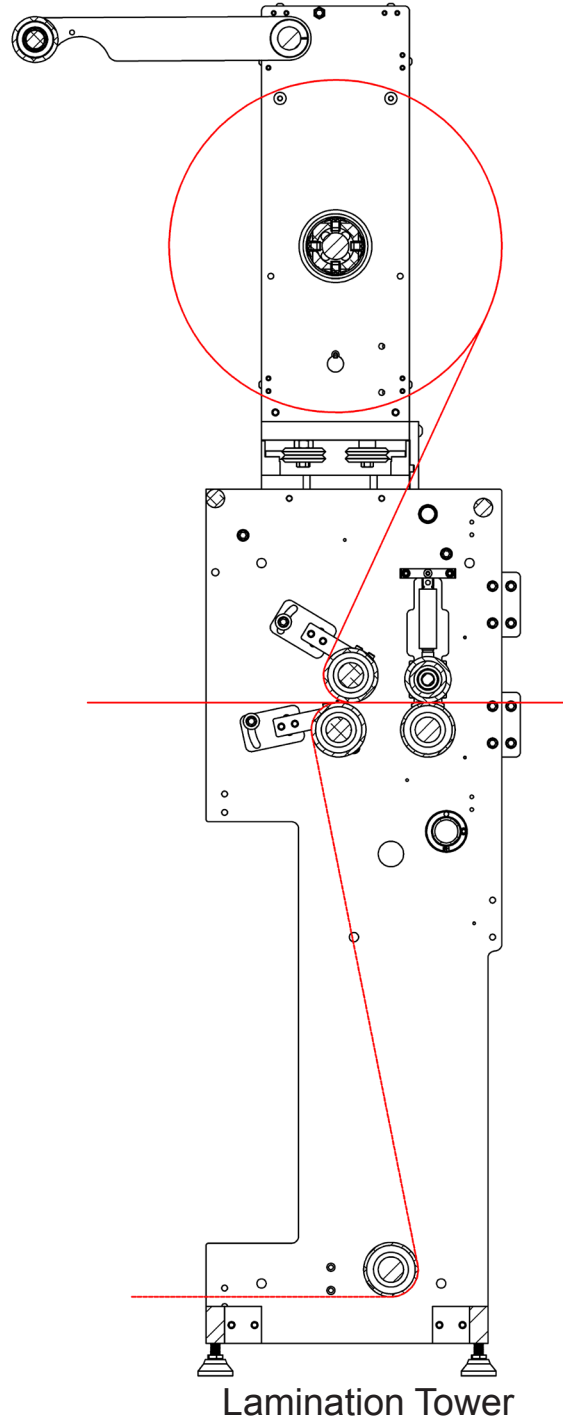




# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

Flexo Print Station



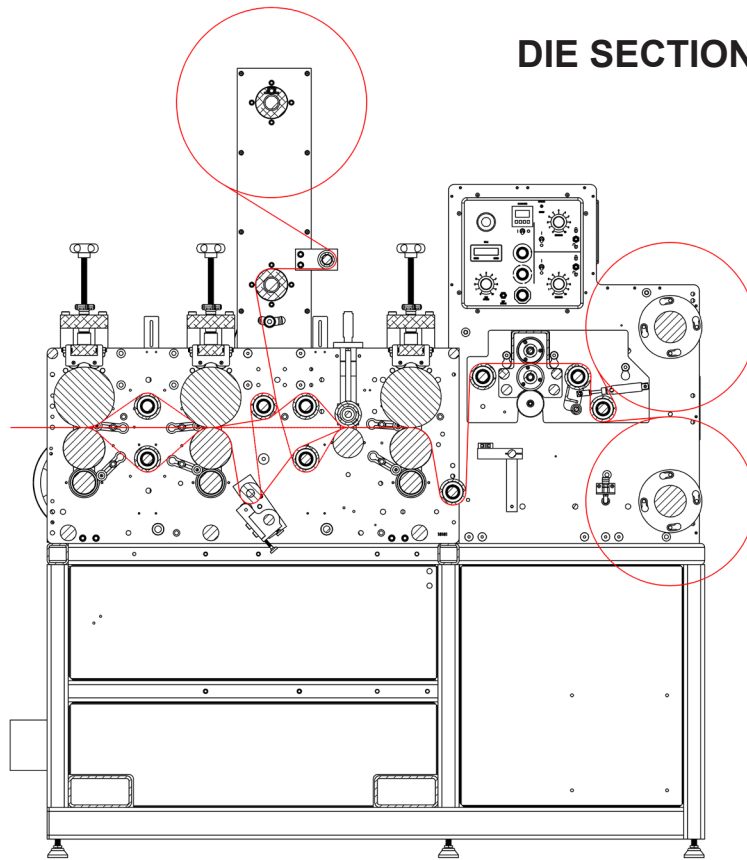
### ACCESSORY MODULES

# AZTECH CONVERTING SYSTEMS

DM-40XX  
USER MANUAL

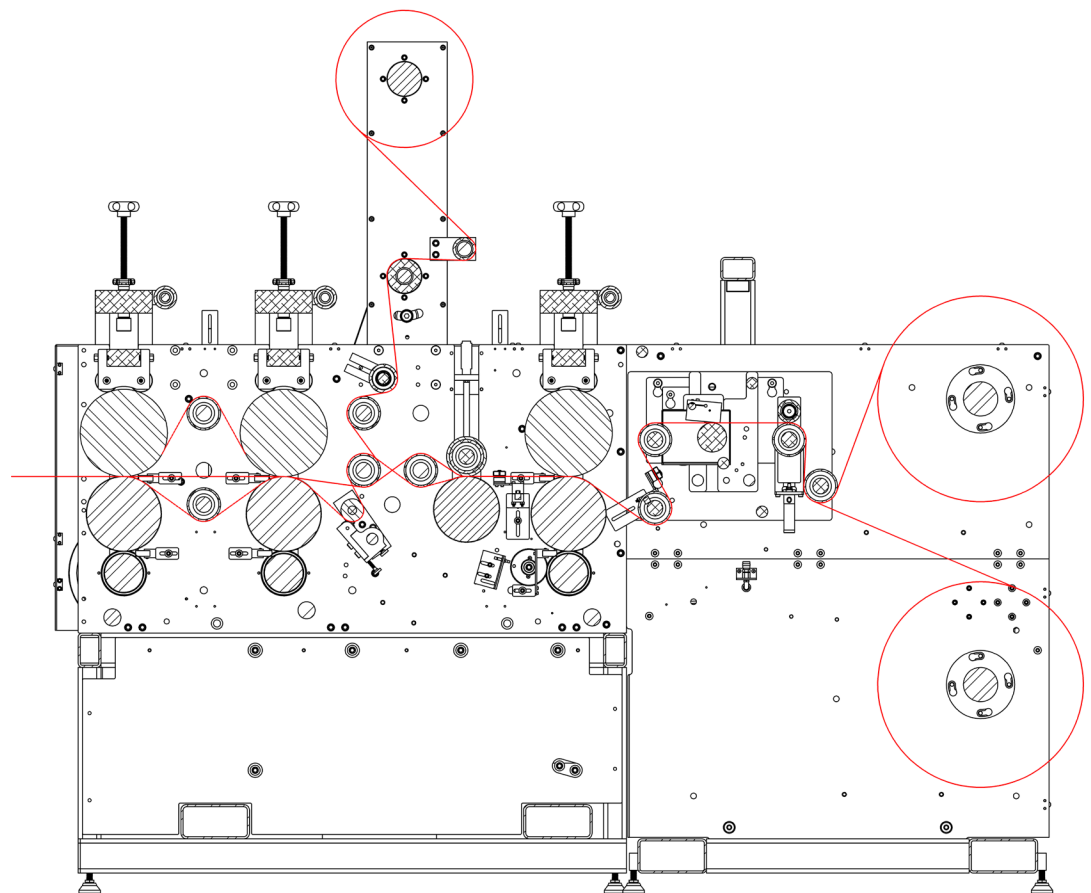


## DIE SECTIONS



13" - 18" DIE MASTER

20" DIE MASTER





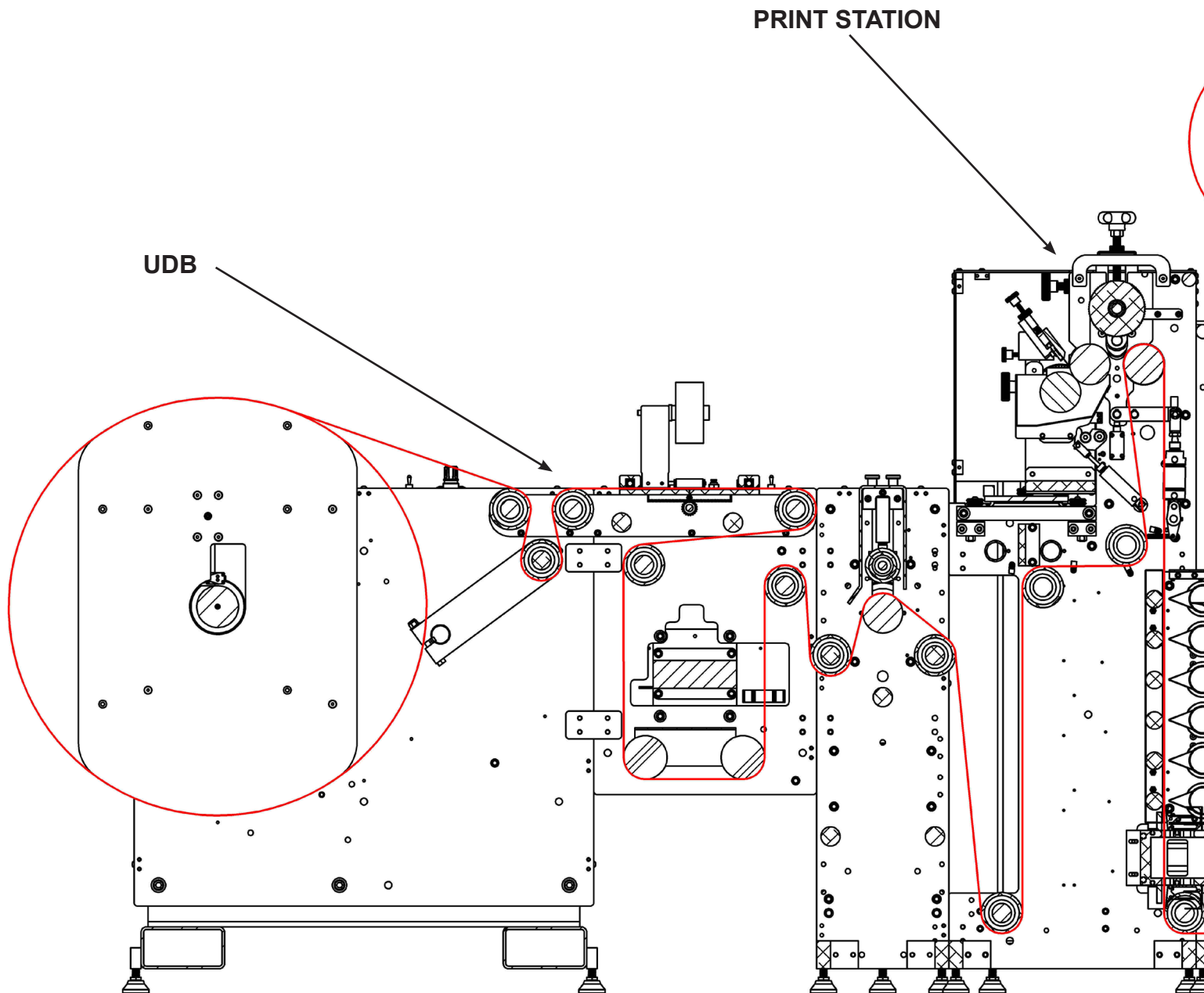
# AZTECH CONVERTING SYSTEMS

DM-40XX  
USER MANUAL

## DieMaster w/ UDB Web Path

### 13" Die Master Shown

- UDB
- Print Station
- Lamination Tower
- 13" Die Section



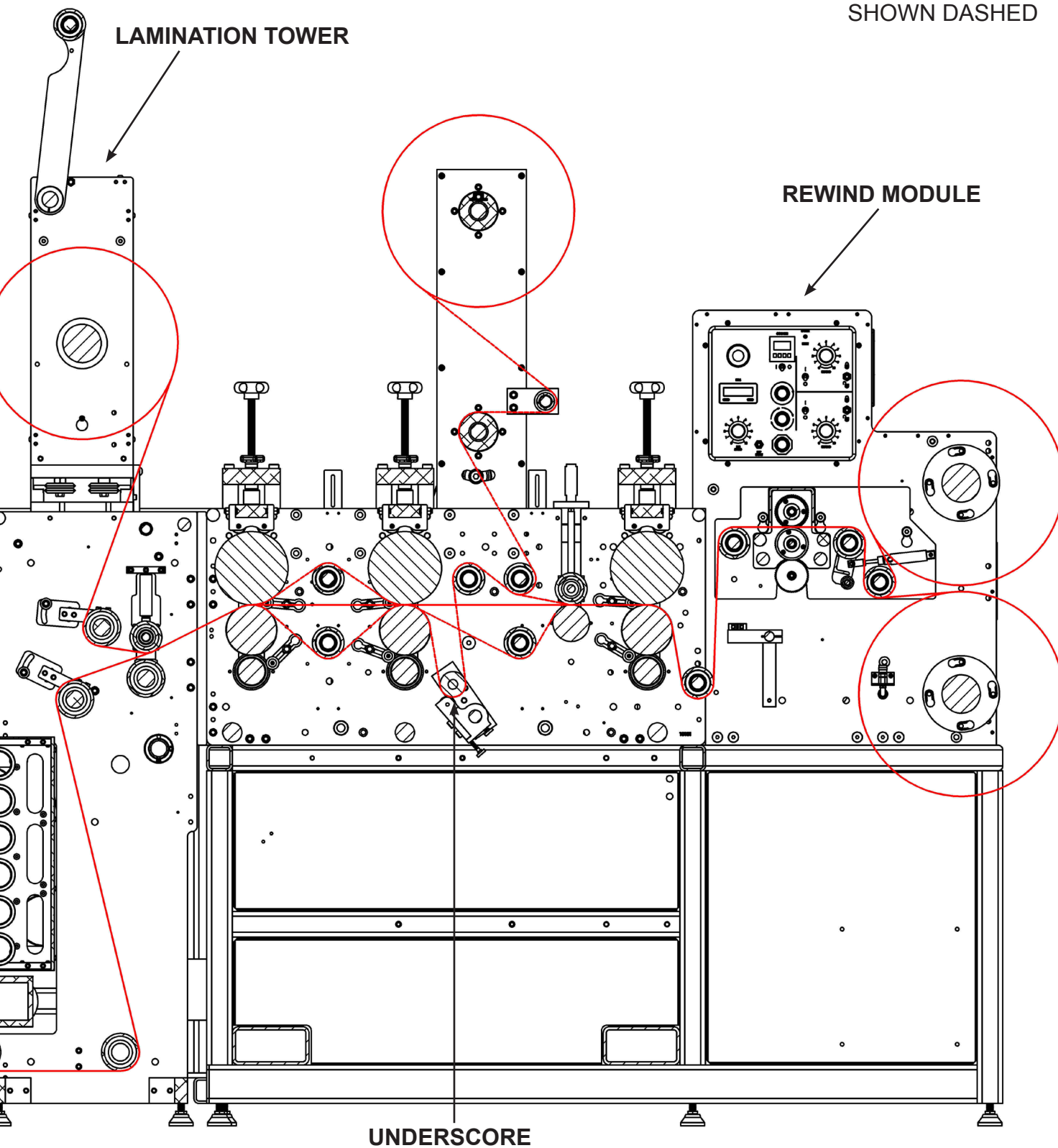


# AZTECH CONVERTING SYSTEMS

DM-40XX  
USER MANUAL



OPTIONAL WEB PATHS  
SHOWN DASHED



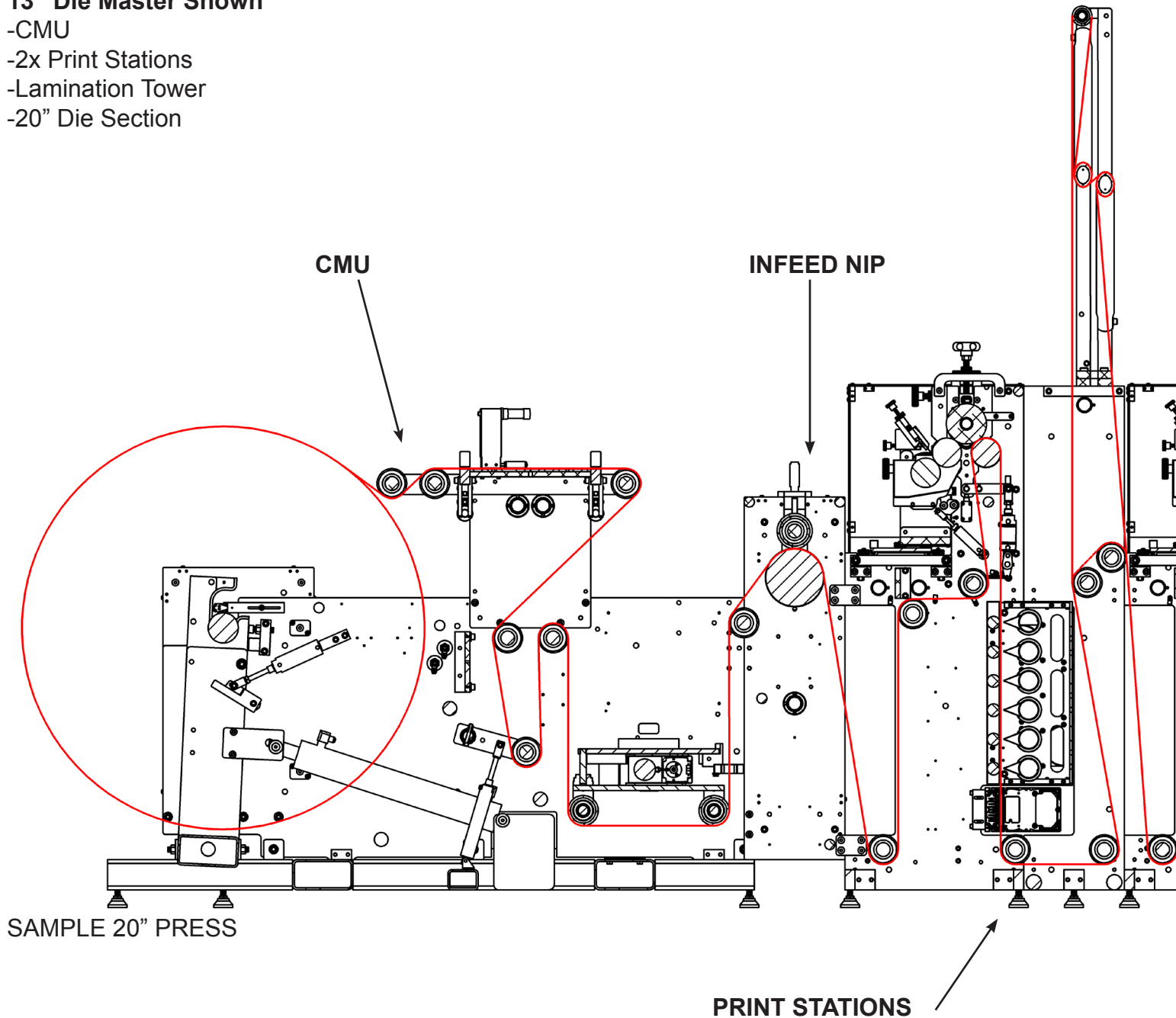


# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### 13" Die Master Shown

- CMU
- 2x Print Stations
- Lamination Tower
- 20" Die Section

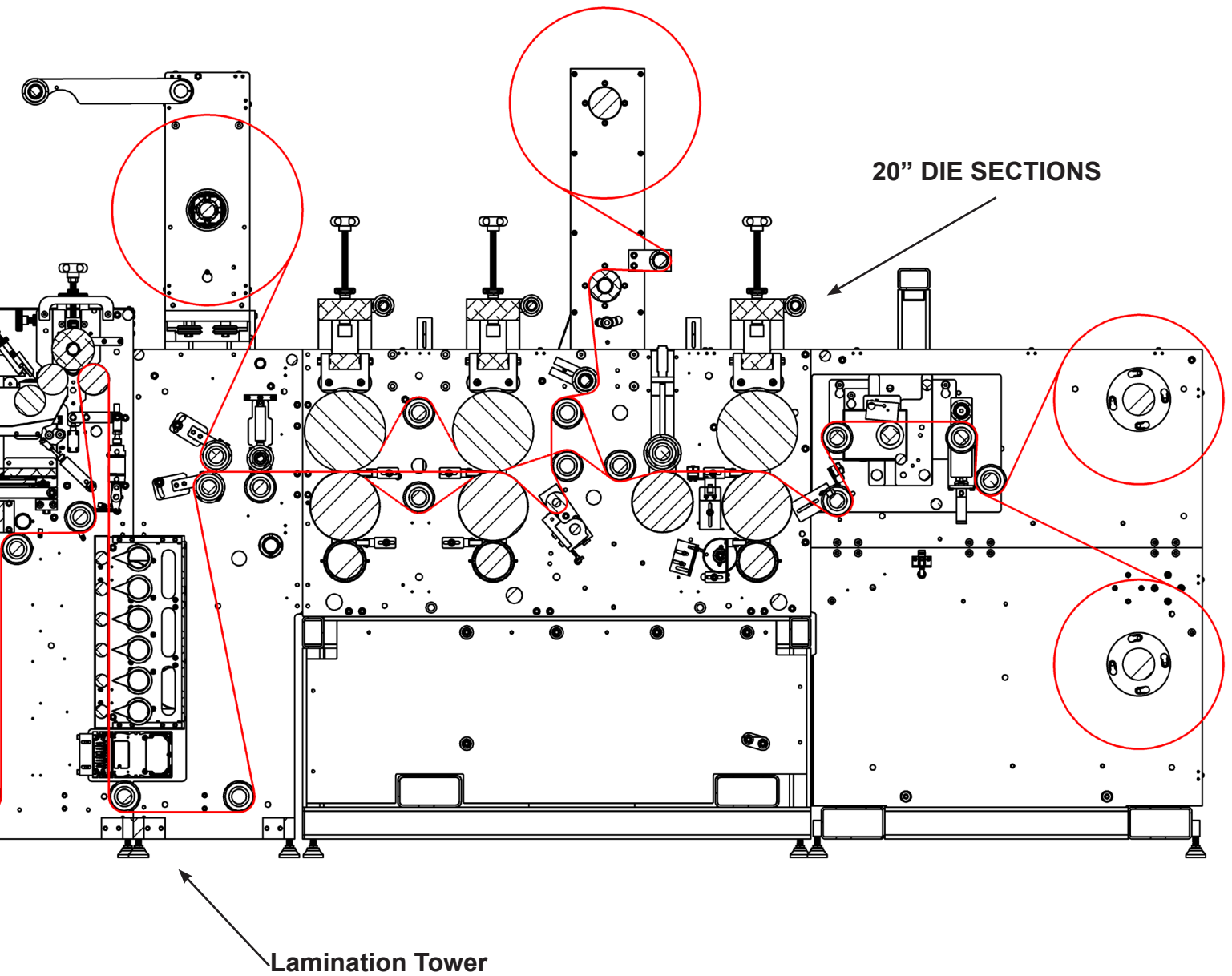


# AZTECH CONVERTING SYSTEMS

DM-40XX  
USER MANUAL



OPTIONAL WEB PATHS  
SHOWN DASHED



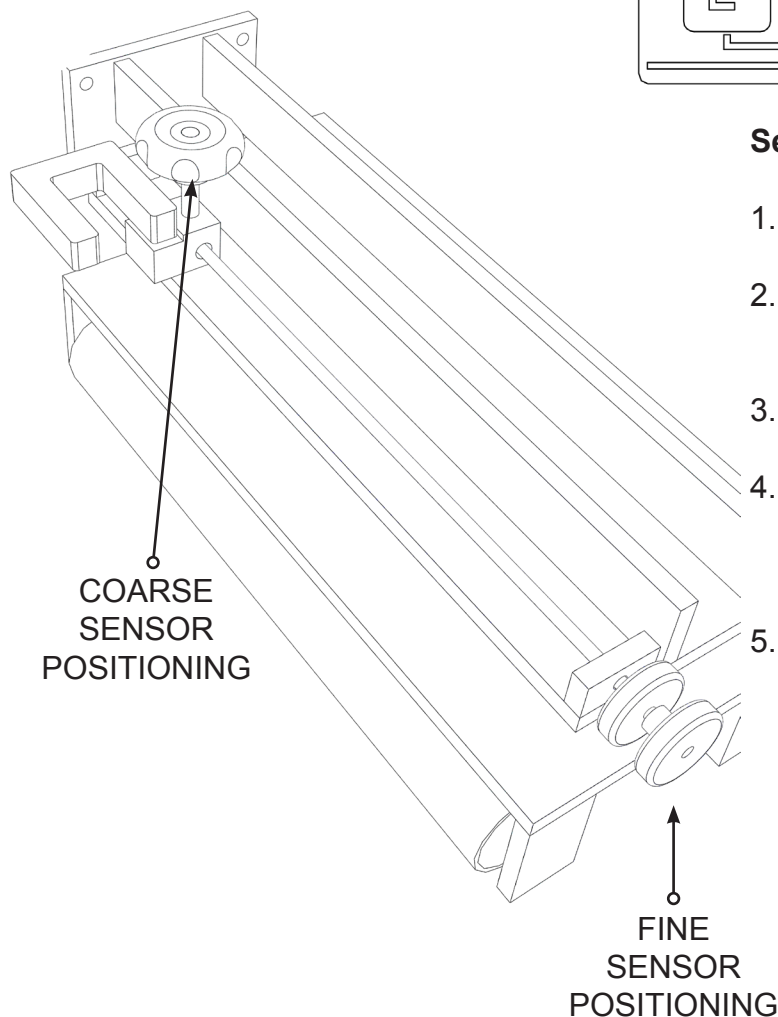


# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### 3-2: Web Guide Setup

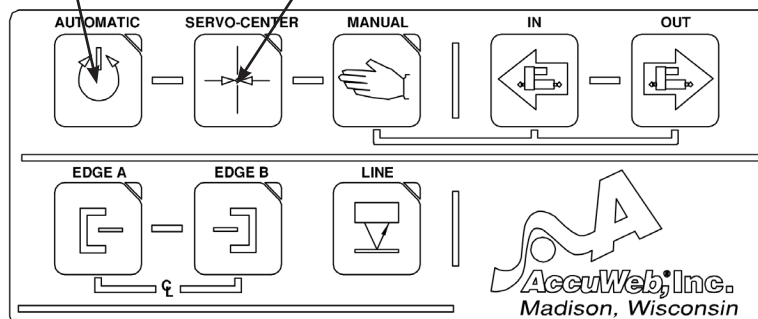
The web guide is located in the center of the machine between the unwind and rewind stations. After webbing the machine, set the web by doing the following:



### 3-3: Nip Roll Operation

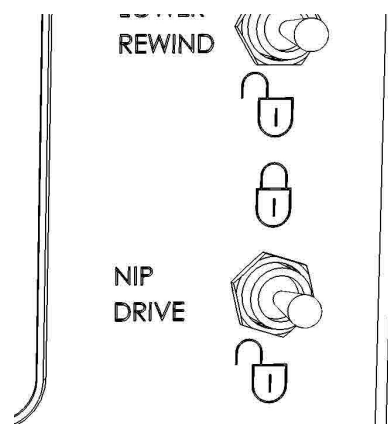
The Nip Roll is pneumatically controlled using control switch and must be in the up position while machine is running, and in the down position when threading machine.

#### AUTOMATIC SERVO CENTER



#### Setting the Web Guide:

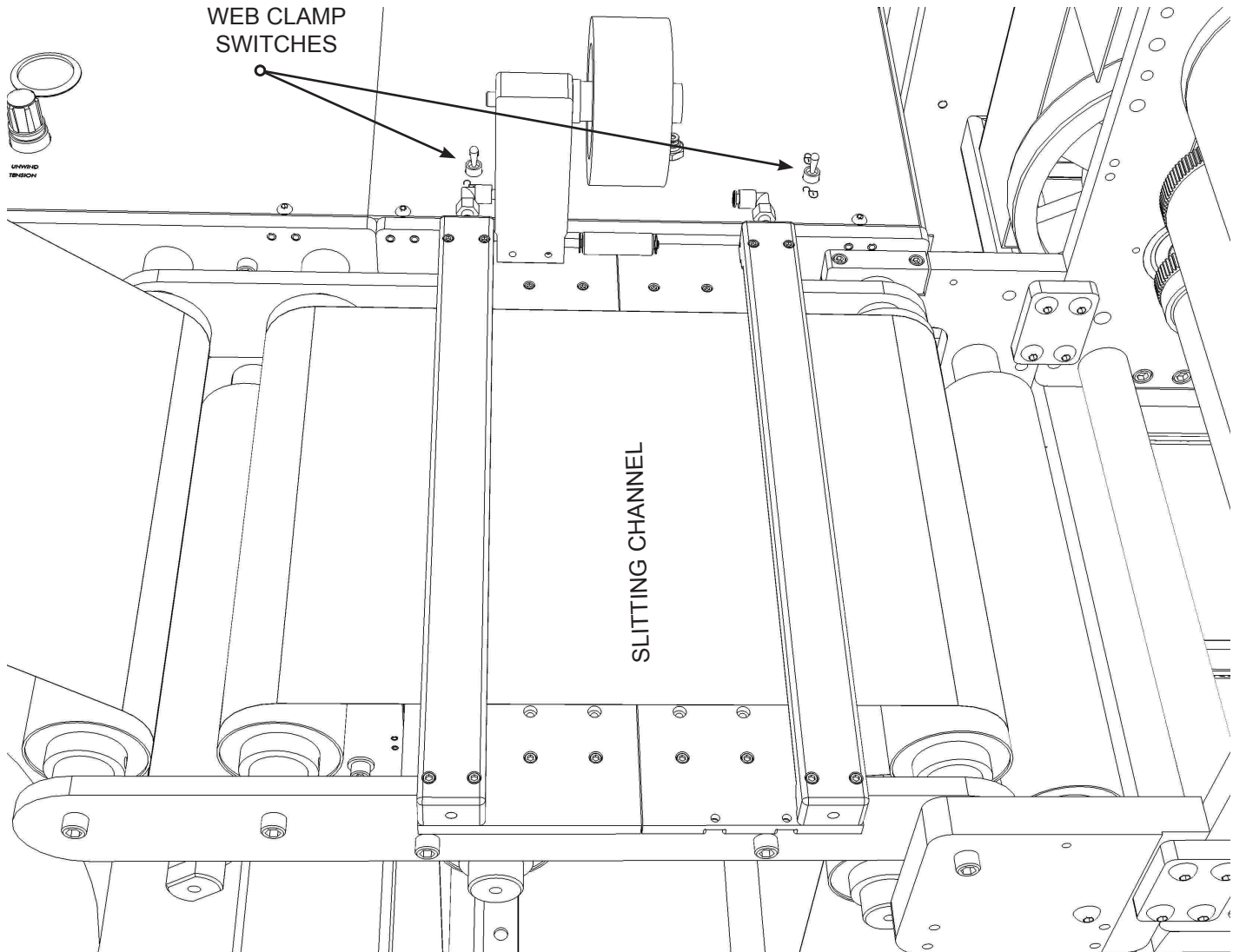
1. Press the "SERVO-CENTER" button on the front of the web guide.
2. Align the sensor with the inside edge of the web. For fine alignment adjustment, turn knob on outside of web guide.
3. Jog the machine briefly to assure that the web is moving smoothly.
4. Press the "AUTOMATIC" button which will engage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





### 3-4: Splice Table Operation

The splice table on your Sidewinder BSR 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.



# AZTECH CONVERTING SYSTEMS

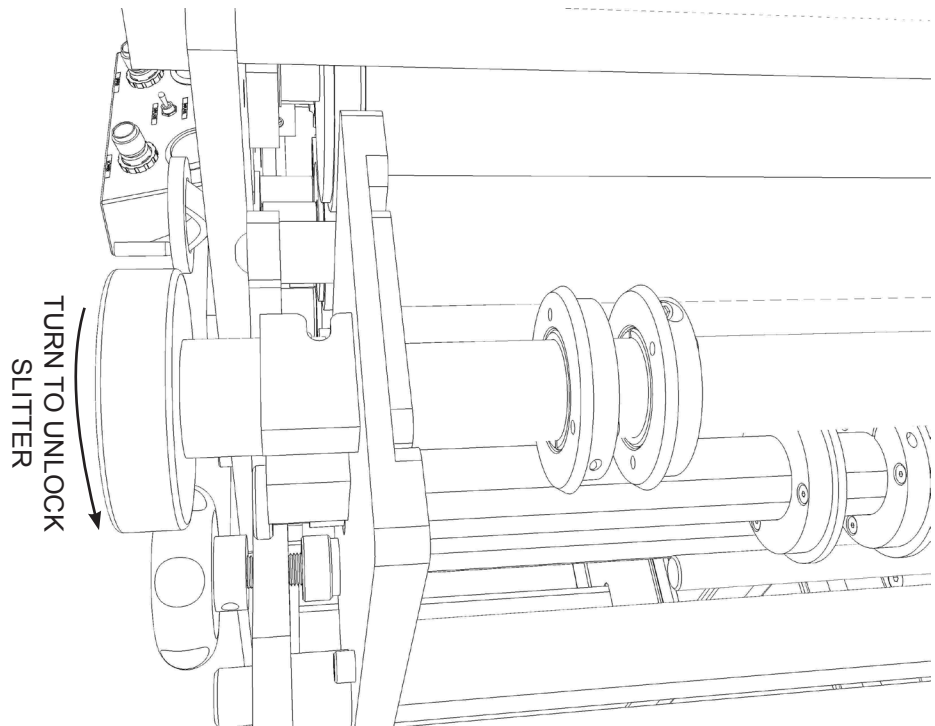
## DM-40XX USER MANUAL

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

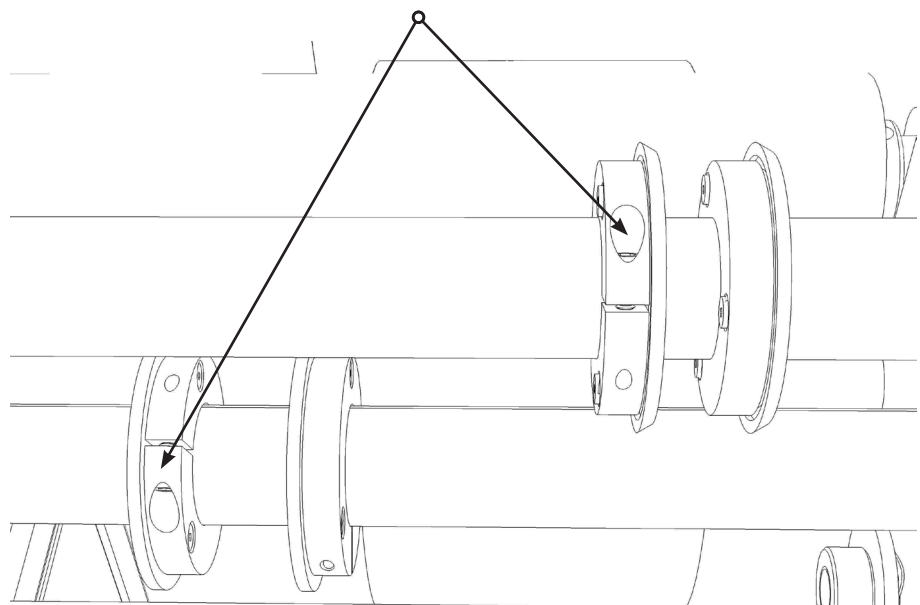
**Step 1** Set lower blades for desired slit-widths and tighten set-screws, making sure upper blades are up and not in lock position.

**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.

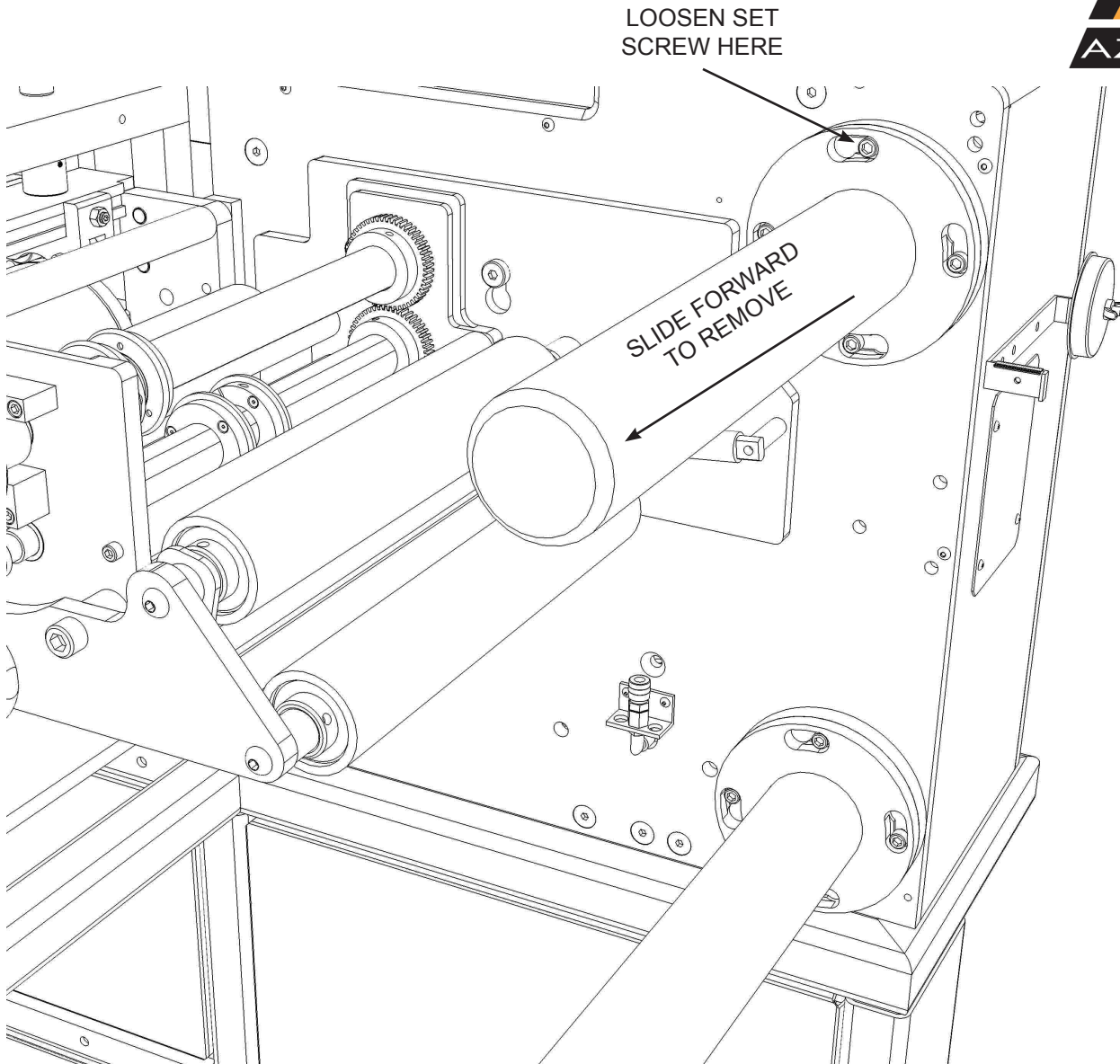
**Step 3** Gently slide upper blade(s) into cutting position flush against the lower blade(s) by pushing on both sides of the blade to avoid wobble. Hold upper blade against lower blade and tighten set-screw.



TIGHTEN SET SCREWS  
TO LOCK BLADES







### 3-6: Changing Rewind Spindle

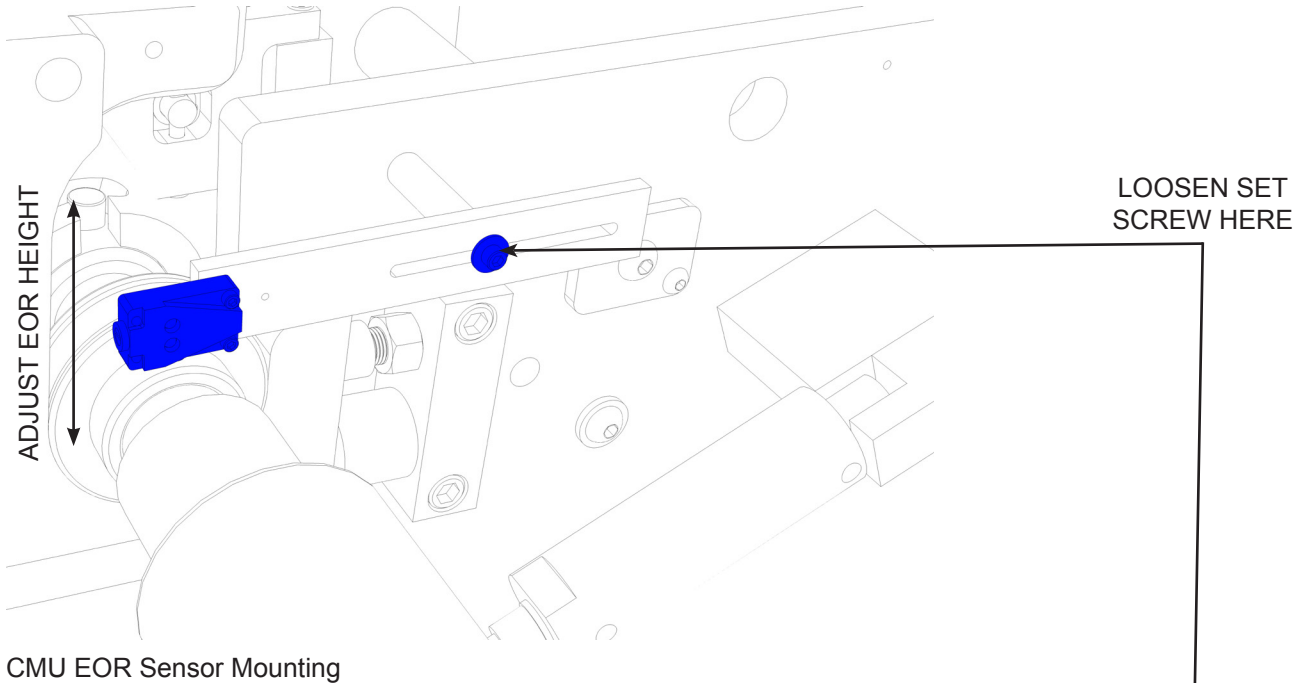
Your Die Master may be equipped with Converttech pneumatically inflatable modular rewind spindles. These spindles are easily removed by loosening the hex-screw at the machine side and pulling away from machine. To insert new spindle, simply insert spindle into rewind station and tighten hex-screw firmly.

**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.



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

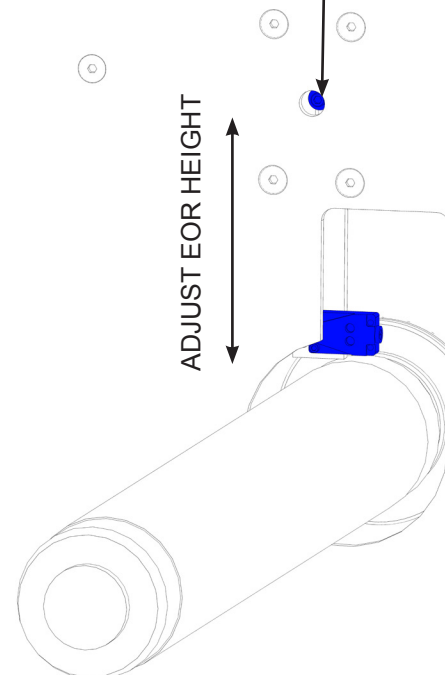


CMU EOR Sensor Mounting

### 3-7: End-of-Roll (EOR) Sensor Adjustment

The unwind unit will come equipped with an end-of-roll sensor. When this sensor is switched on, the machine will not RUN if there is insufficient material on the unwind roll. To adjust the sensor:

- 1: Loosen the screw retaining the EOR sensor mount.
- 2: Move the sensor into a position where it is just "OFF" with an empty core.
- 3: Tighten the retaining screw.



UDB EOR Sensor Mounting



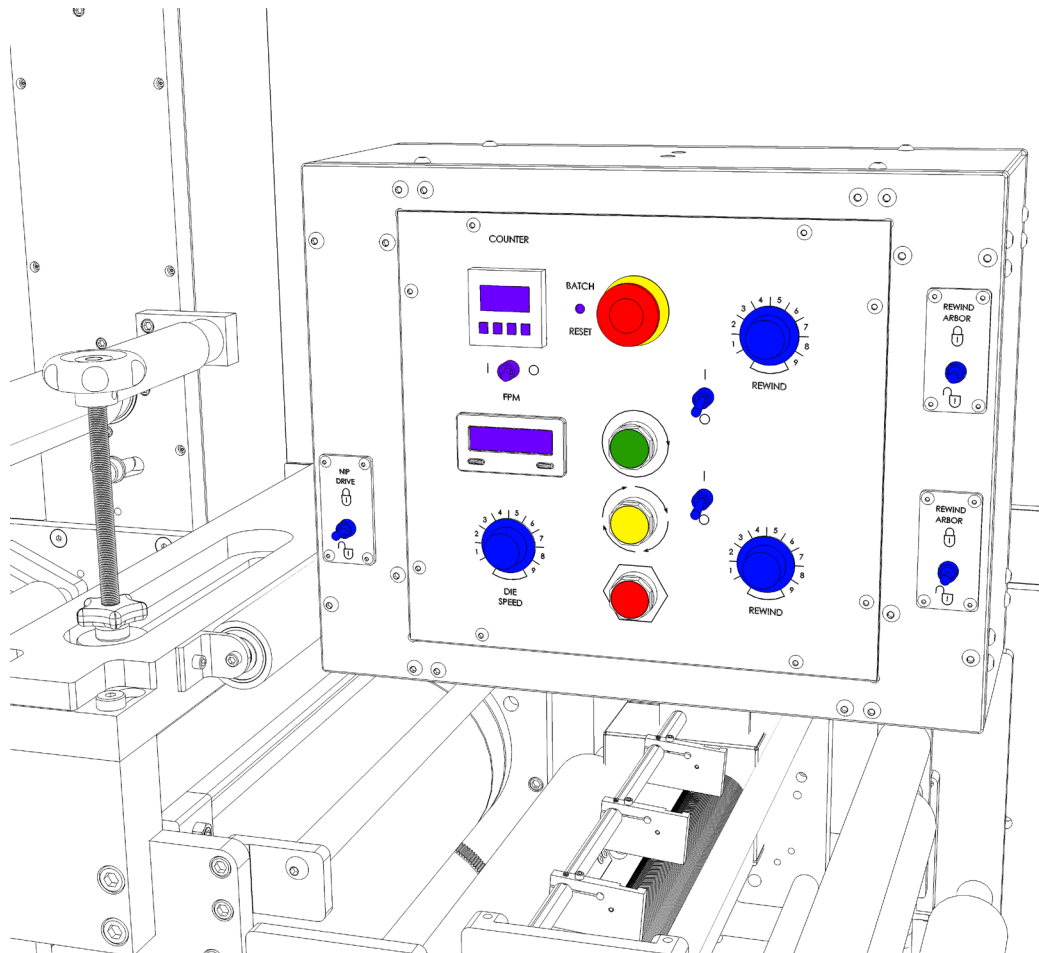
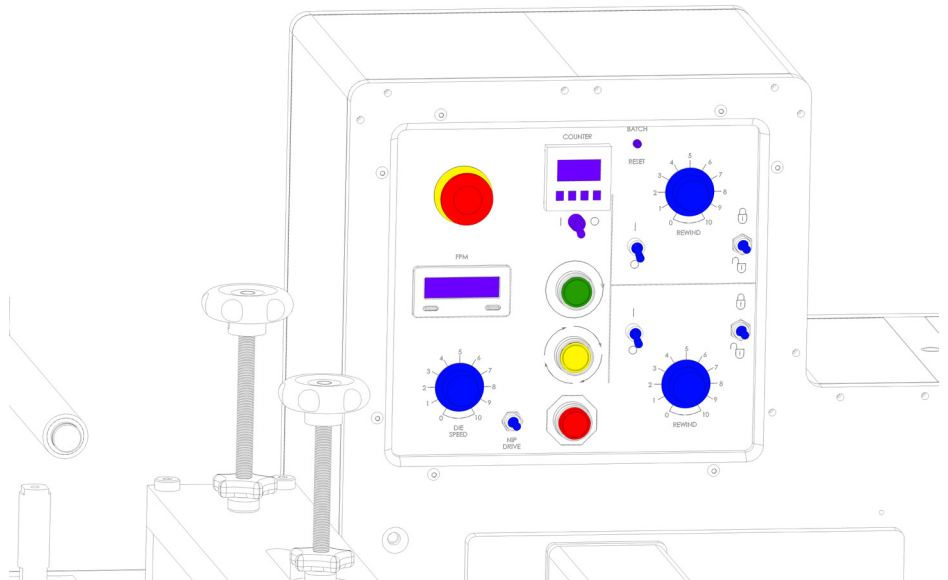


### Section 4: Machine Operation

#### 4-1: Operator Control Layout

13"- 18" Standard model Die-Master

- START PB
- JOG PB
- STOP PB
- SPEED KNOB
- REWIND CONTROLS
- COUNTER CONTROL
- E-STOP



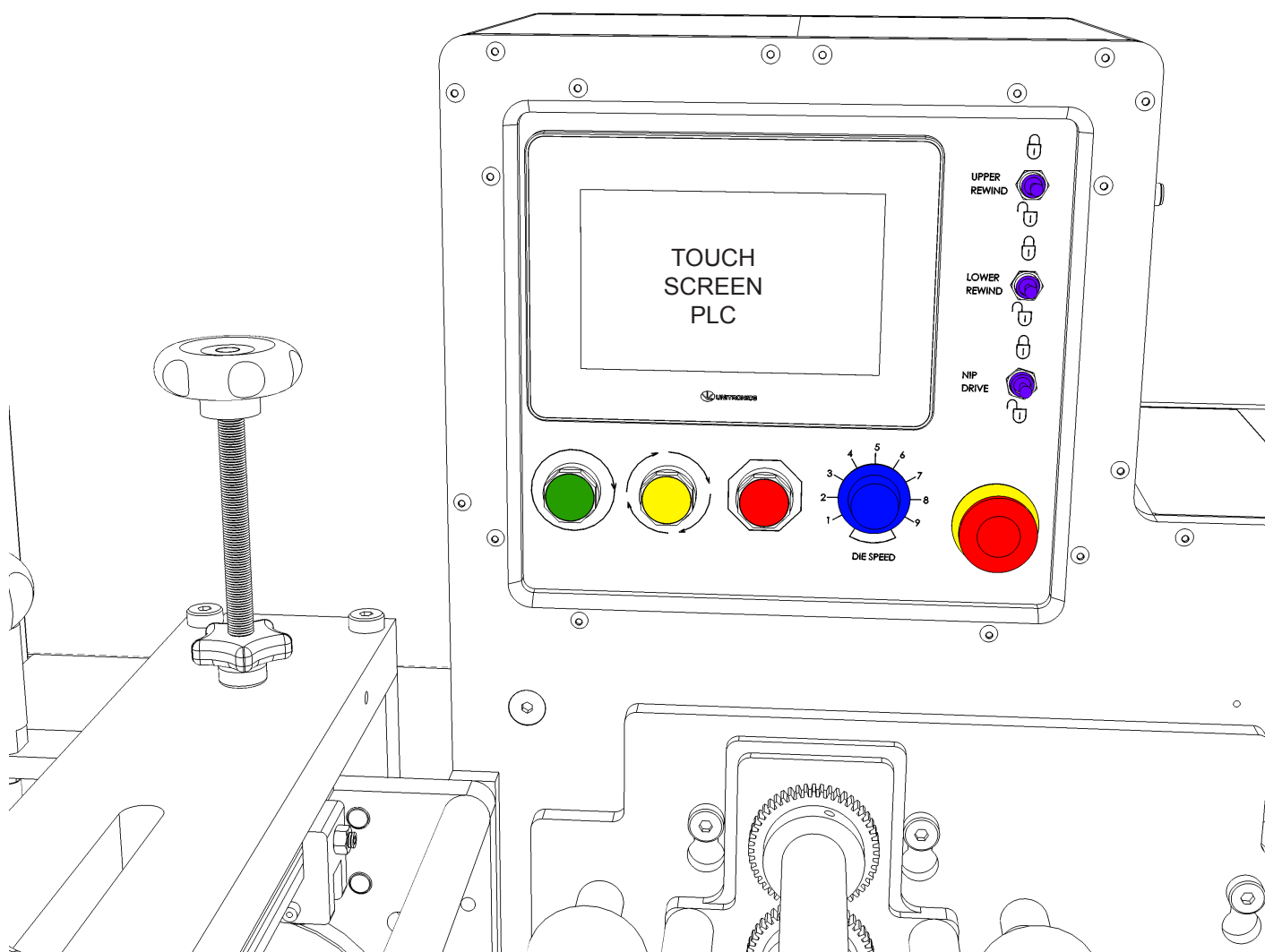
20" Standard model Die-Master



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### 4-1: Operator Control Layout



- START PB
- JOG PB
- STOP PB
- SPEED KNOB
- REWIND CONTROLS
- AIR CONTROLS
- E-STOP

The Die-Master is also available with a PLC machine control with a touch-screen interface. The operation of the HMI interface is described in the next section.



## 4-2: PLC OPERATION



### 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 a minute or two.

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.

The menu jumps displayed in white may be accessed by the user, the yellow MACHINE DIAGNOSTICS jump is password protected.

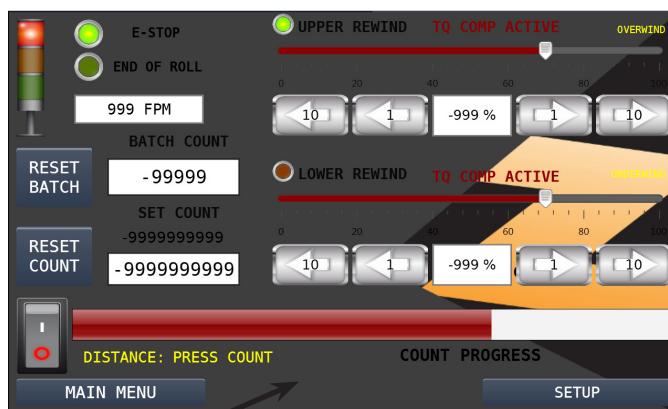
The PLC may be setup to have controls labeled in Spanish or German. Pressing the flags at the bottom changes between these languages.



## MAIN MENU

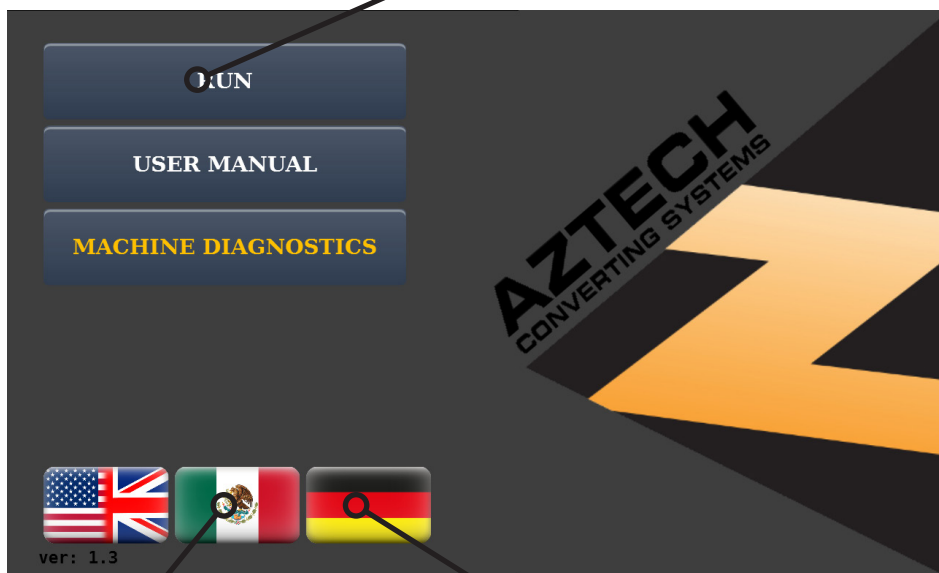
# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



RUN SCREEN

Buttons to access primary machine functions are displayed on the MAIN MENU.



Menú principal en Español



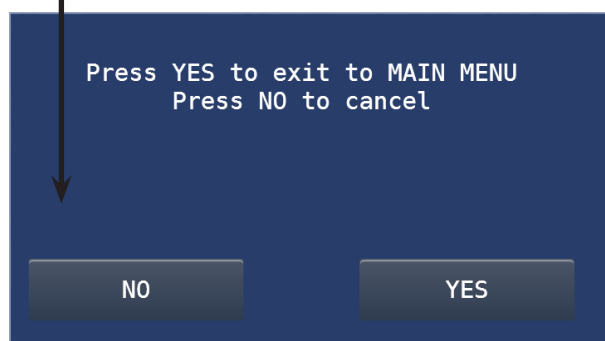
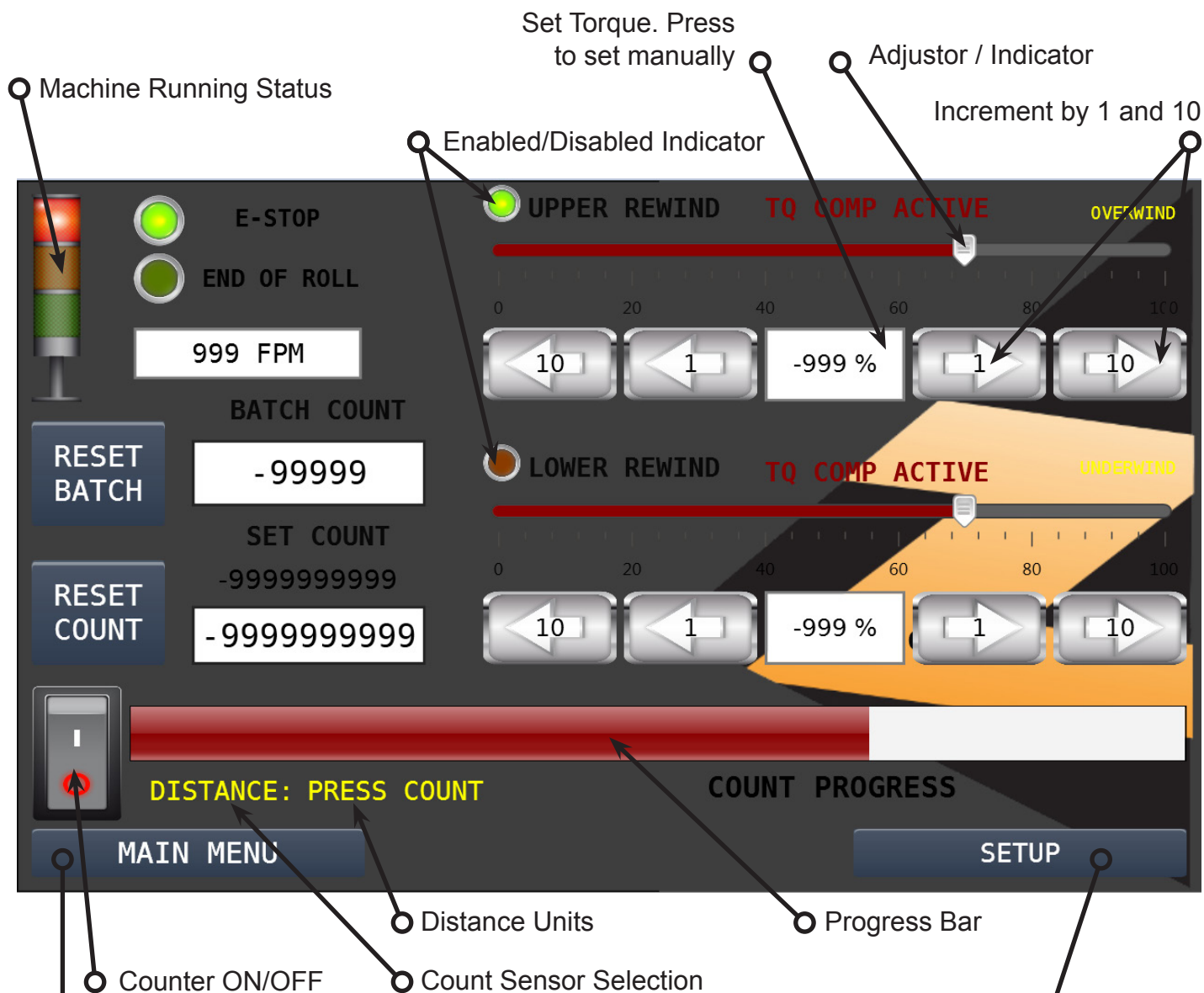
Hauptmenu auf Deutsch

# AZTECH CONVERTING SYSTEMS

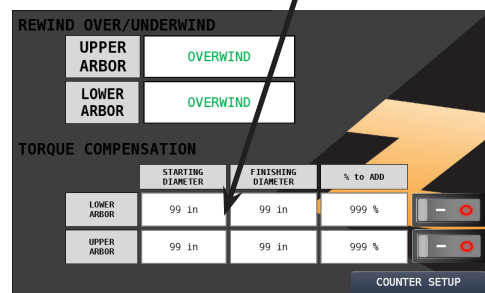
DM-40XX  
USER MANUAL



## RUN MENU



Exit to Main Menu Prompt



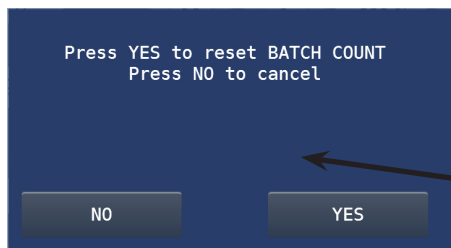
Rewind Setup



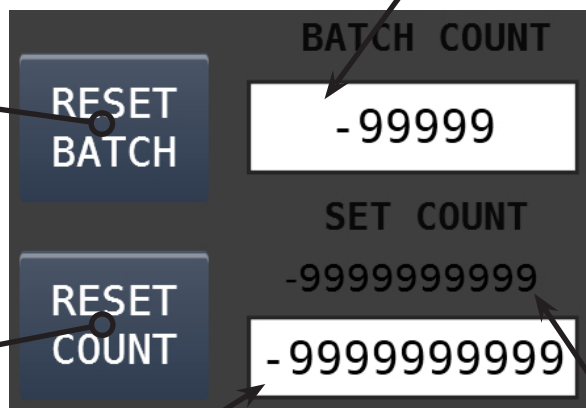
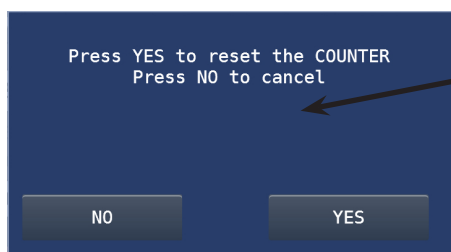
# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### COUNTER STATUS DISPLAY



The user is prompted to confirm reset. The prompt clears in 5 seconds.



The Batch Count increments every time the set count is reached and the counter is on.

The current count is displayed

The Set count is displayed

The count progress is visually represented as a percentage scale.



Press here to turn the counter on and off.

The count sensor selection is shown. If in distance, the units are displayed.

# AZTECH CONVERTING SYSTEMS

DM-40XX  
USER MANUAL



Press the box to change between Over and Underwind.

**DO NOT SWITCH WHILE RUNNING**

**REWIND OVER/UNDERWIND**

UPPER ARBOR	OVERWIND
LOWER ARBOR	OVERWIND

**TORQUE COMPENSATION**

	STARTING DIAMETER	FINISHING DIAMETER	% to ADD
LOWER ARBOR	99 in	99 in	999 %
UPPER ARBOR	99 in	99 in	999 %

COUNTER SETUP

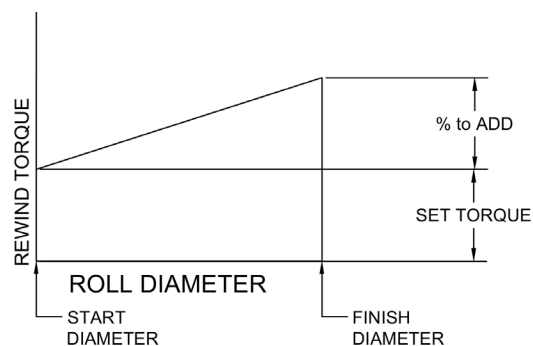
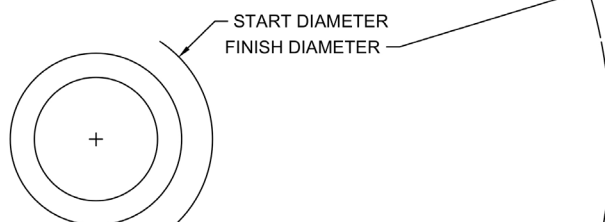
E-STOP  
END OF ROLL  
999 FPM  
BATCH COUNT  
RESET BATCH -99999  
SET COUNT -999999999  
RESET COUNT -999999999  
DISTANCE: PRESS COUNT  
COUNT PROGRESS  
MAIN MENU  
SETUP

COUNTER

999999999	SET COUNT	COUNT UNITS
999999999	SLOWDOWN POINT	Inches
		Press Count
		Feet
		Yards
		Meters

DISTANCE COUNT  
END OF ROLL SENSOR  
RUN MANUAL  
REWIND SETUP

## TORQUE COMPENSATION



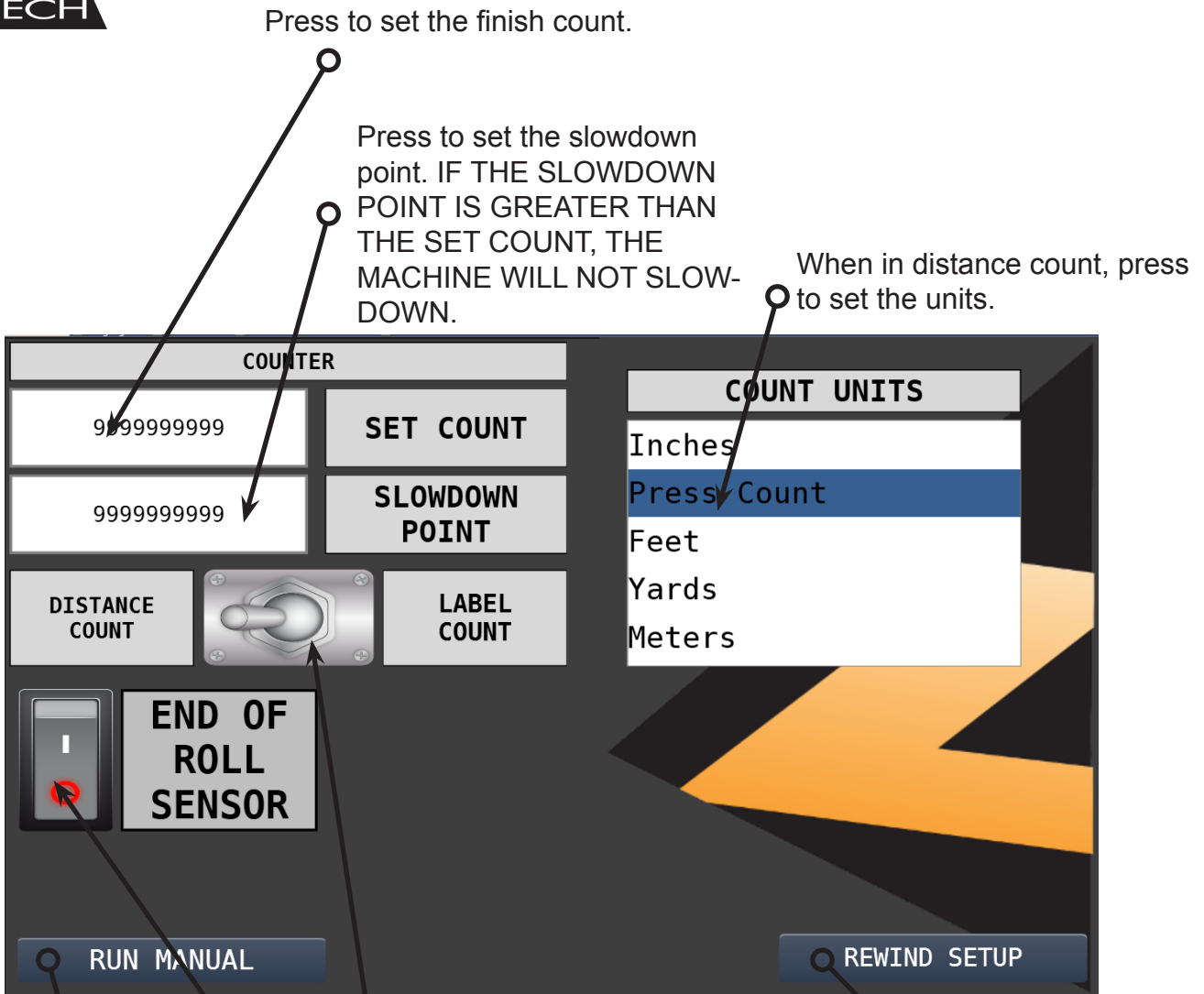
The Torque Compensation feature mimics the act of slowly increasing rewind torque by gradually turning up the knob while the roll grows. To set up the feature, enter the core diameter as the Starting Diameter. Enter the finished roll size as the Finishing Diameter. Subtract the torque setting used to start the roll from the setting used to finish the roll and enter this as the % to ADD. When the TQ COMP is on, a text will be displayed above the rewind torque bar.





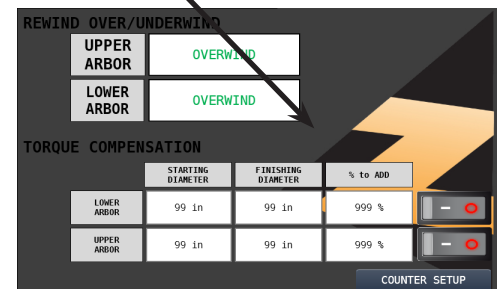
# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



Press to toggle between count sensors.

Press to turn the EOR on and off.



When the End of Roll sensor is on, an indicator showing its status will show on the Run Menu.

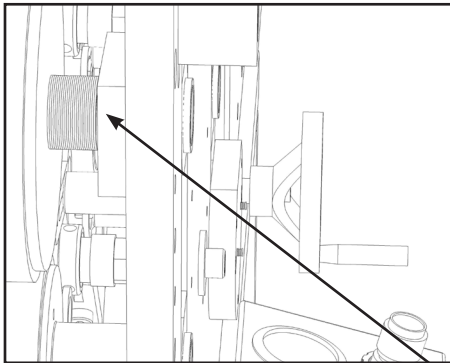




### 4-3: Mounting Rotary Die(s) in Die Station

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

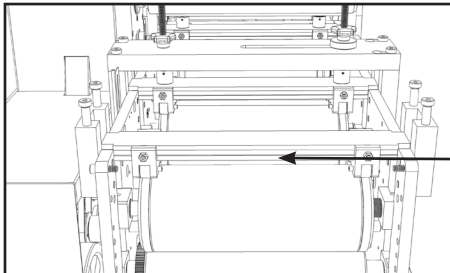
**ALWAYS USE CAUTION WHEN HANDLING ROTARY TOOLING AS DAMAGE MAY OCCUR IF MISHANDLED. WHEN LAYING A ROTARY DIE DOWN, ALWAYS MAKE SURE TO SET ON SOFT SURFACE TO HELP AVOID DAMAGE.**



To correctly mount a rotary die:

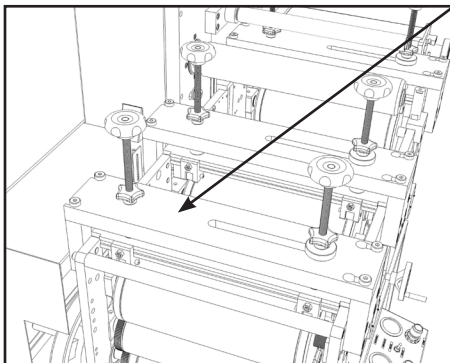
1) Use spacer washer(s) on journal on gear side to assure that the die gear is properly aligned to the anvil roll gear.

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



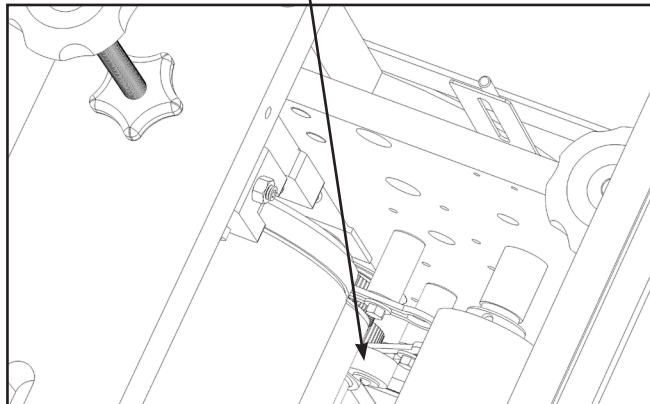
3) Use spacer washer(s) on outboard side, and slide quarter-turn bearing block onto shaft and turn counter-clockwise, making certain that the die is snug and does not slide around.

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



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

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



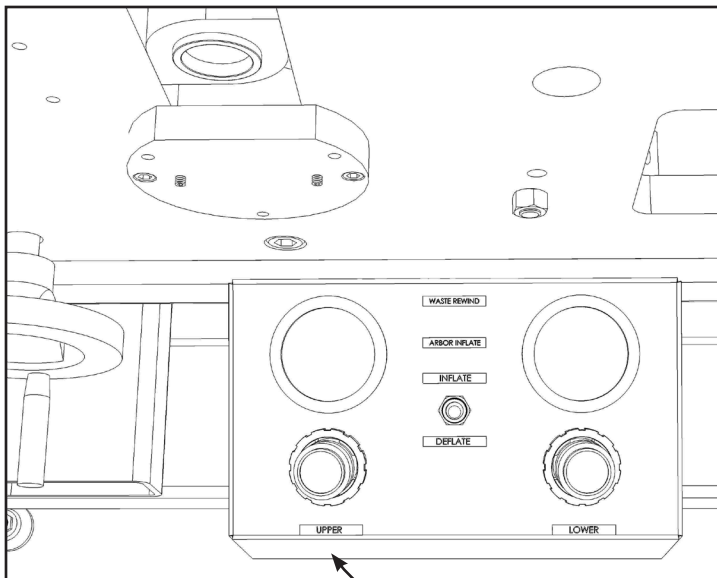


# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### 4-4: Using the Waste-Windup

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



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

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

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

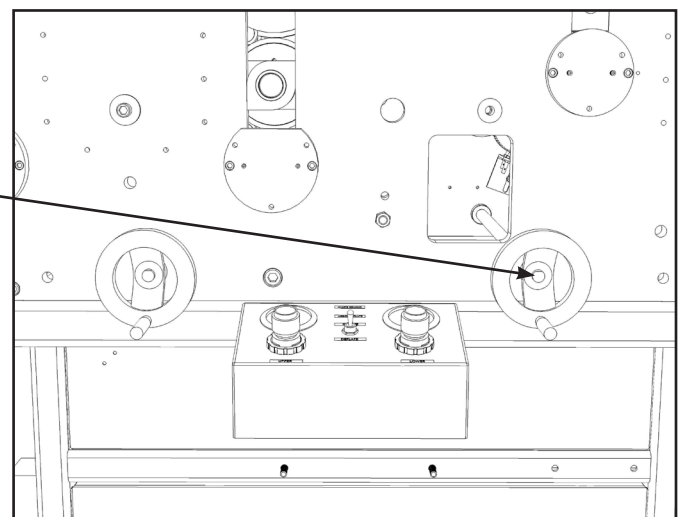
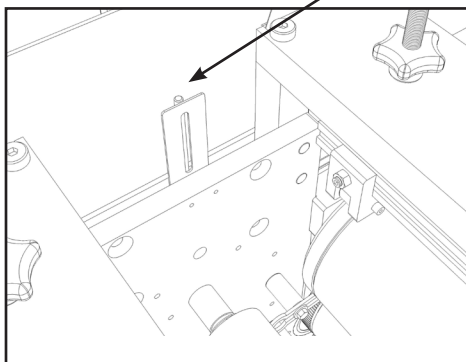
4) Adjust both lower capstan and waste-wind-up spindle tensions using the pneumatic dials.

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

### 4-5: Adjusting Die Timing

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

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





## Chapter 5: Maintenance

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

### REGULAR MAINTENANCE:

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

### PERIODIC MAINTENANCE:

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

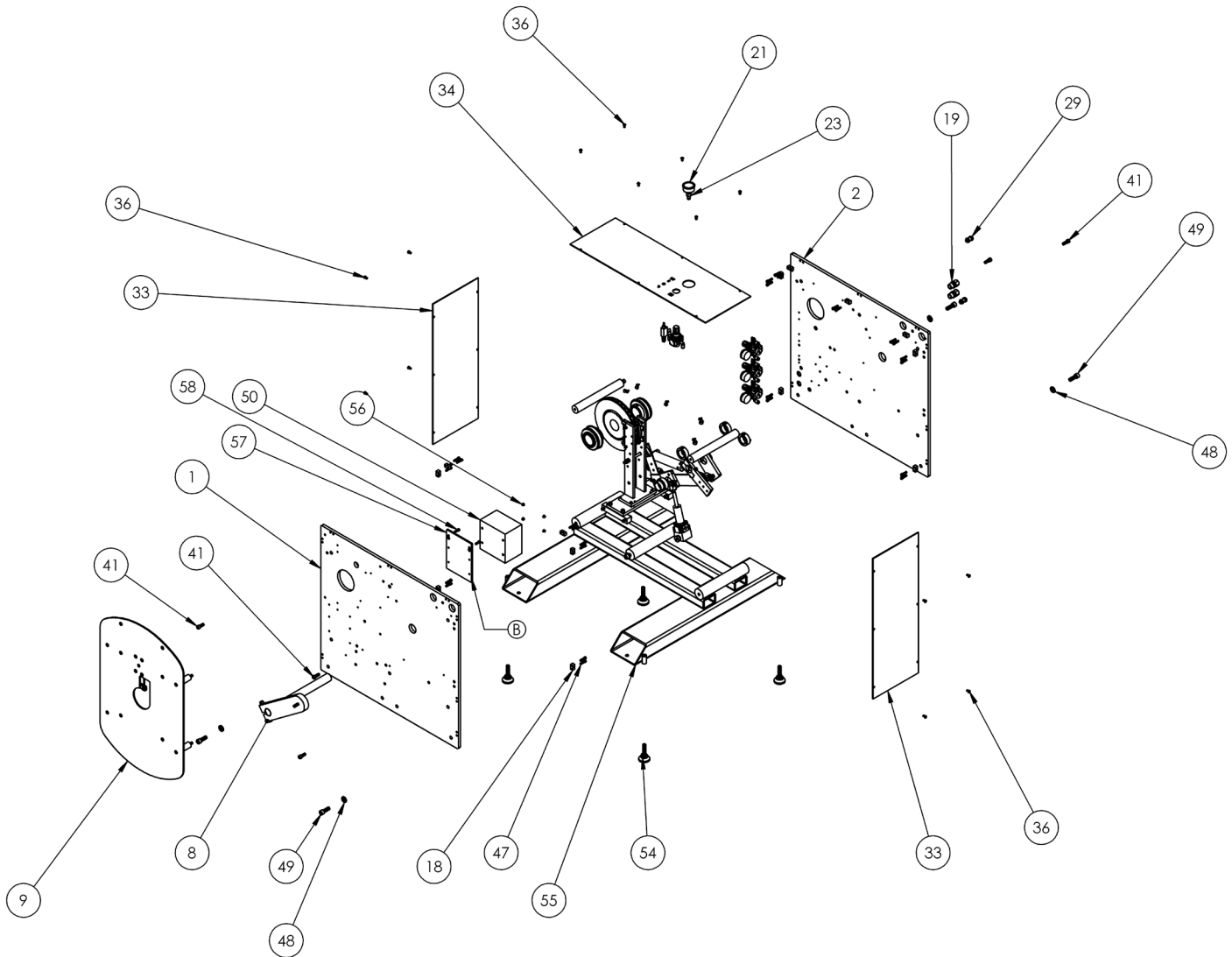


# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### Chapter 6: Station Detail

#### UDB Main Assembly



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



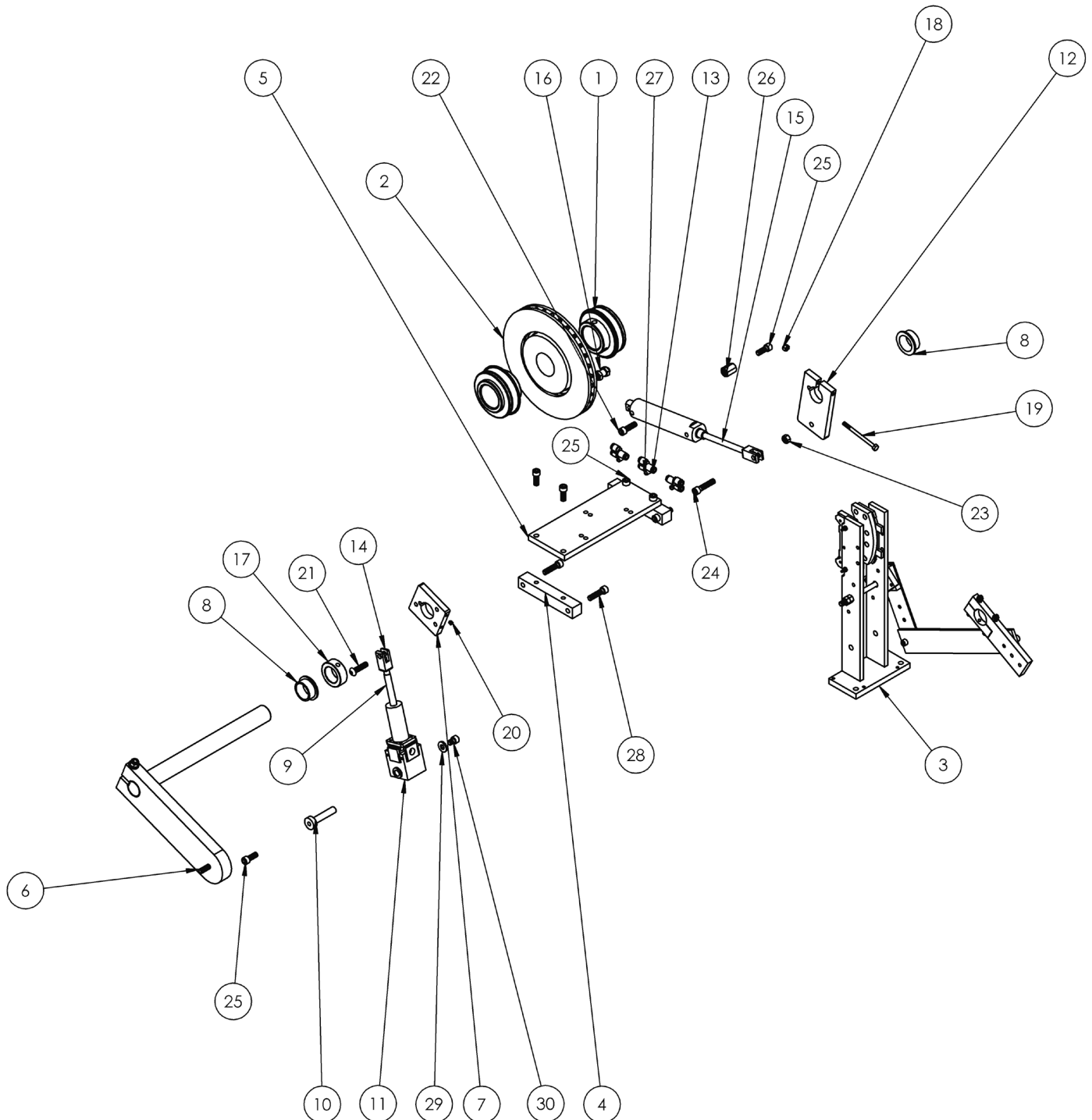
ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	17429	UDB2 FRONT MAIN PLATE	1
2	17430	UDB2 REAR MAIN PLATE	1
3	2.0000er32	ER-32 BEARING	2
4	11418	BRAKE ROTOR ASSEMBLY	1
5	15928	UDB2, BRAKE ASSEMBLY	1
6	16017	UDB BRAKE SPRT BRACKET FOR BOTTOM PLATE	2
7	16016	UDB BRAKE SPRT BOTTOM PLATE	1
8	10515-C	DANCER ASSEMBLY, ROLL MASTER	1
9	15718	REWIND DIE CUTTER UNWIND BACK PLATTER ASSEMBLY	1
10	15884	REWIND DIE CUTTER DANCER PIVOT AIR LOCK ARM	1
11	1-38 flanged oilite	KAMFF1618	2
12	15389	AR25-N02H-Z PRESSURE ROD	1
13	15885	REWIND DIE CUTTER BRAKE REGULATOR PIVOT SPRT	1
14	15386	BSR BRAKE REGULATOR ASSEMBLY AR25	1
15	15889	INSPECTION REWINDER, DANCER PIVOT ARM	1
16	11568	1-3/8 SET COLLARS	1
17	10523	STANDOFF, FRAME, TOP, BASE UNIT	2
18	15894	MOUNT BLOCK 1/2 X 1/2 X 1 1/4-20 THREAD, TWO .257 HOLES THRU 1/2" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	14
19	1_2 STRAIN RELIEF ASSEMBLY		2
20	AR20K-N01-Z		1
21	T8D-U	AIR GUAGE	1
22	SMC KQ2L07-34S	1/4 COMP TO 1/8 MPT	2
23	KQ2F07-35	1/4 ONE TOUCH TO 1/4 FEMALE PIPE THREAD	1
24	MJTV-3 ASSEMBLY	3 WAY 1/8 PORT TOGGLE VALVE	1
25	KQ2U07-00	NAME	3
26	EXP3417	AIR REGULATOR WITH GUAGE AND FITTINGS	3
27	NY-125	ROD CLEVIS 3/8" CROSS HOLE 7/16-20 END THREAD	1
28	NCMC150-0400	AIR CYLINDER	1
29	BULK HEAD FITTING 1-4 TO 1-4 ONE TOUCH ASSEMBLY	1/4 TO 1/4 ONE TOUCH BLK HD FITTING	2
30	1_4 CORD CLAMP WITH BOLT	1/4 cord clamp with 8-32 x 1/2 button head cap screw	3
31	1_2 CORD CLAMP WITH BTHHD 8-32 X 1_2	1/2" CORD CLAMP WITH 8-32 X 1/2" BTHHD CAP SCREW	3
32	1-3EIGHTS COLLAR	1-3/8 SET COLLARS	3
33	17432	UDB2 SIDE COVER 2011	2
34	17431	UDB2 TOP COVER 2011	1
35	SCH_~190-32 UNF_1_SIMP	SOCKET HEAD CAP SCREW 10-32 X 1"	1
36	BTNHD_~250-20 UNC_0~5_SIMP	BUTTON HEAD CAP SCREW 1/4-20 X 1/2"	14
37	BTNHD_~375-16 UNC_1~5_SIMP	BUTTON HEAD CAP SCREW 3/8-16 X 1-1/2"	1
38	SCH_~375-16 UNC_1~25_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1-1/4"	1
39	HEX NUT_~375-16 UNC_0_SIMP	HEX NUT 3/8-16	1
40	SCH_~375-16 UNC_1~75_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1-3/4"	1
41	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"	10
42	91034A110	11/16 HEX DIA X 1" LONG, 3/8-16 THREADED THRU	1
43	BTNHD_~164-32 UNC_1_SIMP	BUTTON HEAD CAP SCREW GRADE 5 8-32 X 1"	3
44	SCH_~375-16 UNC_1~5_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1-1/2"	4
45	WSHR A_~375 HARD	3/8" HARD WASHER	1
46	SCH_~375-16 UNC_0~5_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1/2"	1
47	SCH_~250-20 UNC_1_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 1"	28
48	WSHR A_~500 HARD	HARD FLAT WASHER 1/2"	6
49	SCH_~500-13 UNC_1~5_SIMP	SOCKET HEAD CAP SCREW 1/2-13 X 1-1/2"	6
50	6 X 6 X 4 SC BOX		1
51	HEX NUT_~250-20 UNC_0_LOCK	HEX NUT NYLOCK 1/4-20	1
52	HEX BOLT_~250-20 UNC_3~5_SIMP	HEX BOLT 1/4-20 X 3-1/2"	1
53	SSCR-HEX-CUP_~250-20 UNC_0.25_SIMP	SSCR 1/4-20 X 1/4	1
54	6111K22	LEVELING PAD, 1/2-13	4
55	15999	UDB2 BASE WELDMENT 40 SERIES	1
56	BTNHD_~250-20 UNC_0~25_SIMP	BUTTON HEAD CAP SCREW 1/4-20 X 1/4"	4
57	19121	6 X 6 SC BOX SPRT PLATE	1
58	SCH_~250-20 UNC_0~75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 3/4"	2



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### UBD: Brake Assembly



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



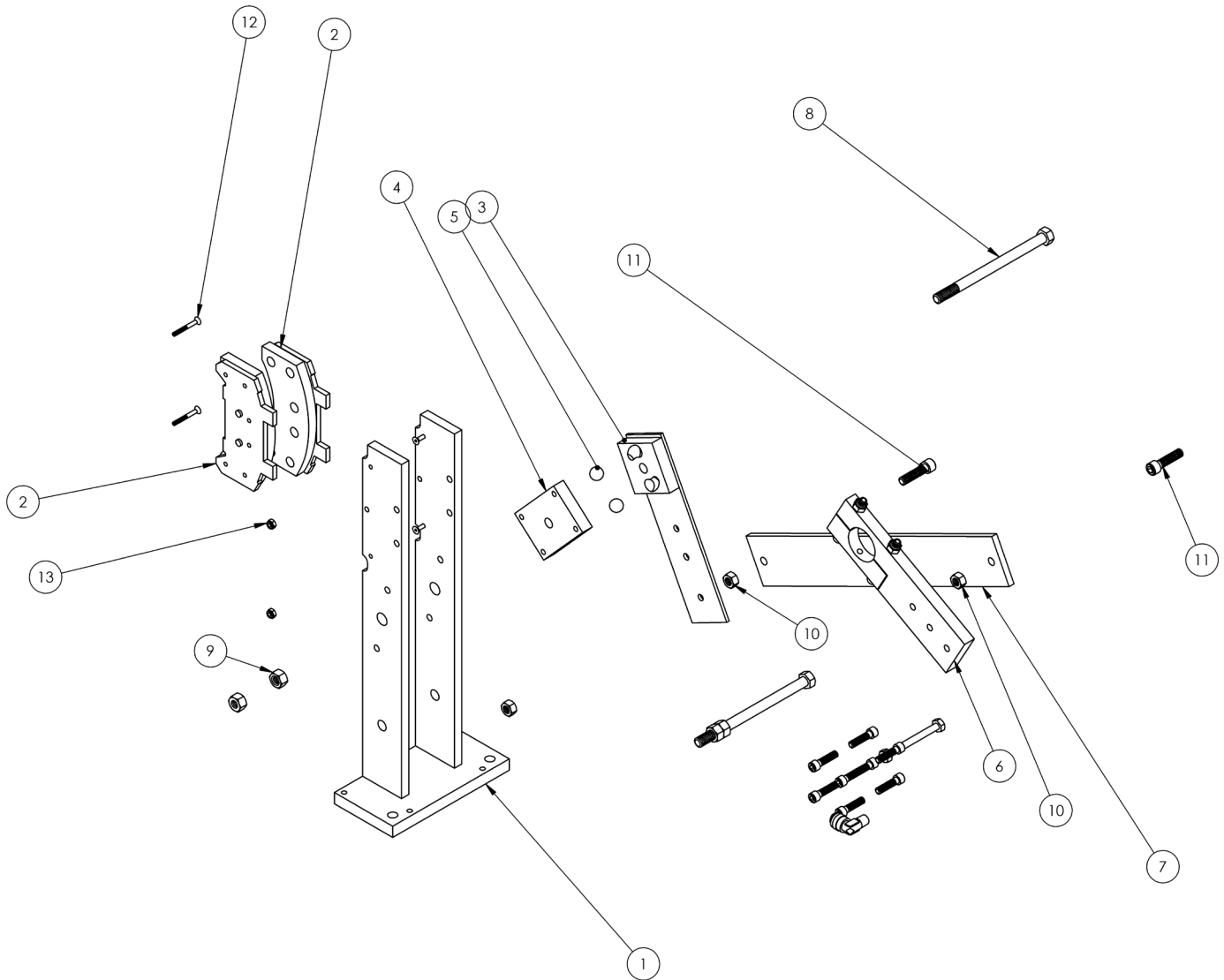
ITEM NO.	PART NUMBER	DESCRIPTION	INTERNAL VIEW/QTY.
1	2.0000er32	ER-32 BEARING	2
2	11418	BRAKE ROTOR ASSEMBLY	1
3	15928	UDB2, BRAKE ASSEMBLY	1
4	16017	UDB BRAKE SPRT BRACKET FOR BOTTOM PLATE	2
5	16016	UDB BRAKE SPRT BOTTOM PLATE	1
6	10515-C	DANCER ASSEMBLY,ROLL MASTER	1
7	15884	REWIND DIE CUTTER DANCER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



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### UDB: Brake Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	FLOAT/QTY.
1	12043	BRAKE ASSEMBLY PLATE MOUNT	1
2	brake pad MOVABLE	DISC BRAKE PAD	2
3	11823	BRAKE PIVOT ARM ASSEMBLY,BSR,SR,DM	1
4	11818	BRAKE RAMP PLATE, FIXED,BSR, SR, RM	1
5	1_2 BALL	MCMASTER-CARR# 96455K56	2
6	11813	CAM BRAKE MASTER ARM PIVOT	1
7	15929	UDB2, BRAKE TRANSFER LINK	1
8	HEX BOLT ~375-16 UNC 5-5 SIMP	HEX BOLT GRADE 5, 3/8-16 X 5.5"	1
9	HEX NUT ~375-16 UNC 0 SIMP	HEX NUT 3/8-16	2
10	HEX NUT ~3125-18 UNC SIMP	HEX NUT 5-16-18	3
11	SCH ~3125-18 UNC 1-25 SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4"	2
12	FLH-SCH-82 ~138-32 UNC 1-25 SIMP	FLAT HEAD CAP SCREW 6-32 X 1-1/4"	4
13	HEX NUT 6-32 LOCK	HEX NUT 6-32 NYLOCK	4
14	Assem1^15928	NAME	1



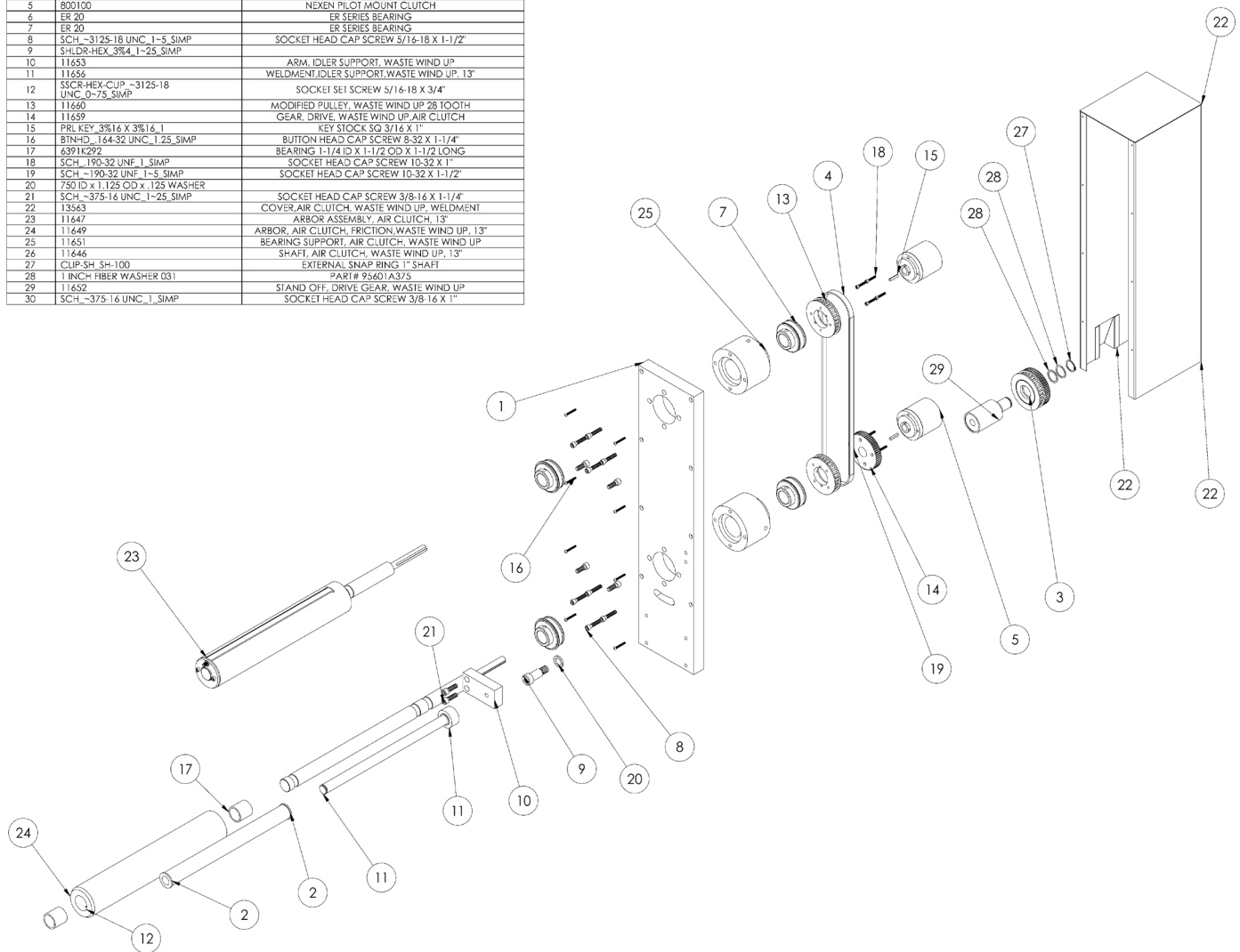
# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



### Waste Windup Assembly

ITEM NO.	PART NUMBER	DESCRIPTION
1	11645	MOUNTING PLATE, WASTE WIND UP, 13", AIR CLUTCH
2	10309	WASTE SMALL IDLER ASSEMBLY, 13"
3	11758	WASTE IDLE GEAR ASSEMBLY, AIR CLUTCH
4	21592	BELT 45", 3/8" PITCH, 1/2" WIDE
5	800100	NEXEN PILOT MOUNT CLUTCH
6	ER 20	ER SERIES BEARING
7	ER 20	ER SERIES BEARING
8	SCH -3125-16 UNC, 1-5, SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/2"
9	SHLDR-HEX_3%4_1-25_SIMP	SOCKET SET SCREW 5/16-18 X 3/4"
10	11653	ARM, IDLER SUPPORT, WASTE WIND UP
11	11656	WELDMENT, IDLER SUPPORT, WASTE WIND UP, 13"
12	SSCR-HEX-CUP_-3125-16 UNC, 0-75, SIMP	MODIFIED PULLEY, WASTE WIND UP 28 TOOTH
13	11660	GEAR, DRIVE, WASTE WIND UP, AIR CLUTCH
14	11659	KEY STOCK SQ 3/16 X 1"
15	PRL KEY_3%16 X 3%16_1	BUTTON HEAD CAP SCREW 8-32 X 1-1/4"
16	BTNHD_-164-32 UNC, 1_25, SIMP	BEARING 1-1/4 ID X 1-1/2 OD X 1-1/2 LONG
17	6391K292	SOCKET HEAD CAP SCREW 10-32 X 1"
18	SCH_-190-32 UNF, 1 SIMP	SOCKET HEAD CAP SCREW 10-32 X 1-1/2"
19	SCH_-190-32 UNF, 1-5, SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1-1/4"
20	750 ID X 1.125 OD X .125 WASHER	COVER AIR CLUTCH, WASTE WIND UP, WELDMENT
21	SCH_-375-16 UNC, 1-25, SIMP	ARBOR ASSEMBLY, AIR CLUTCH, 13"
22	11563	ARBOR, AIR CLUTCH, FRICTION, WASTE WIND UP, 13"
23	11647	BEARING SUPPORT, AIR CLUTCH, WASTE WIND UP
24	11649	SHAFT, AIR CLUTCH, WASTE WIND UP, 13"
25	11651	EXTERNAL SNAP RING 1" SHAFT
26	11646	PART# 95601A375
27	CLIP-SH SH-100	STAND OFF, DRIVE GEAR, WASTE WIND UP
28	1 INCH FIBER WASHER 031	SOCKET HEAD CAP SCREW 3/8-16 X 1"
29	11652	
30	SCH_-375-16 UNC, 1 SIMP	



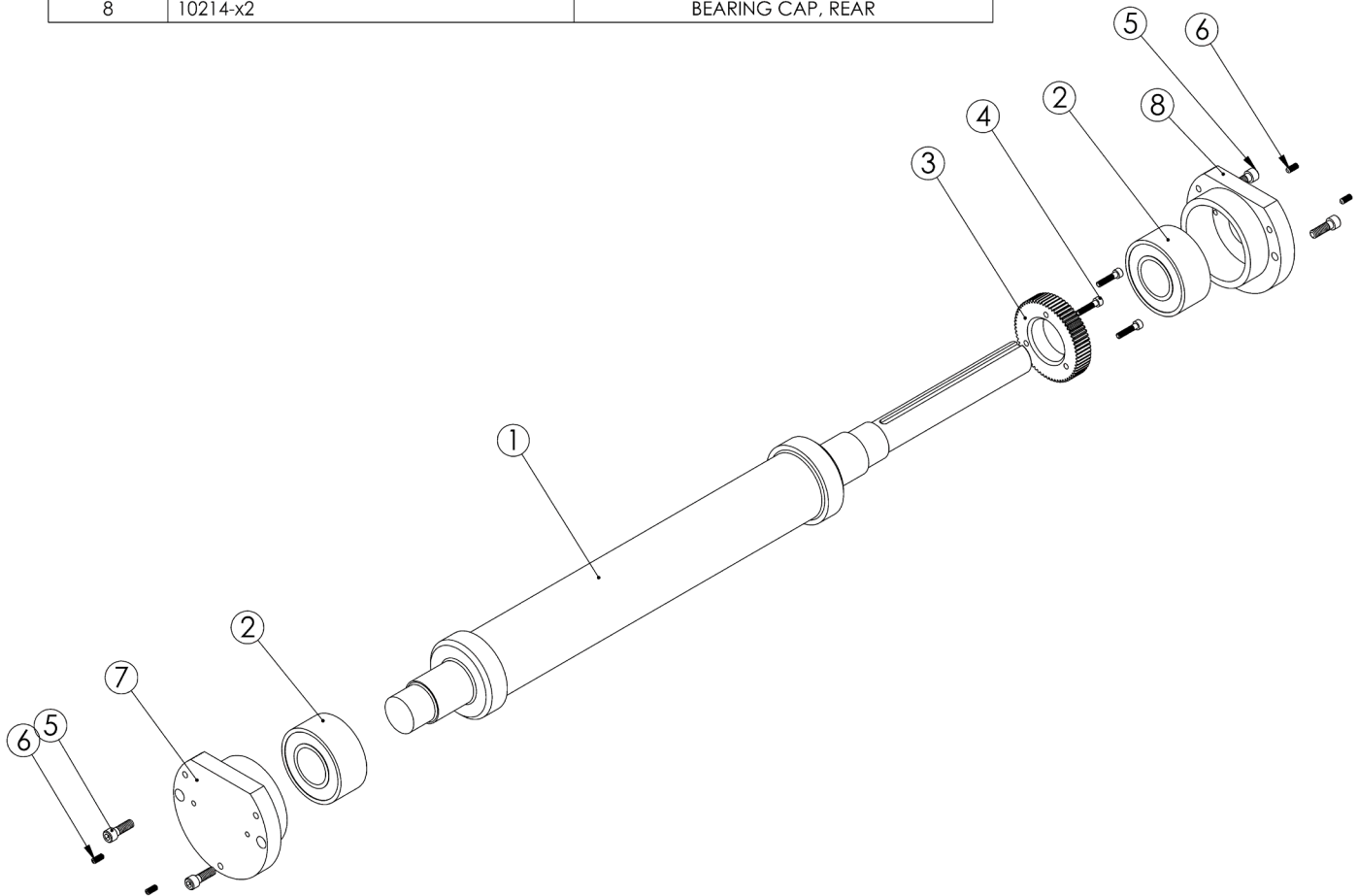


# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### Rotary Die Station: Support Roll Assembly

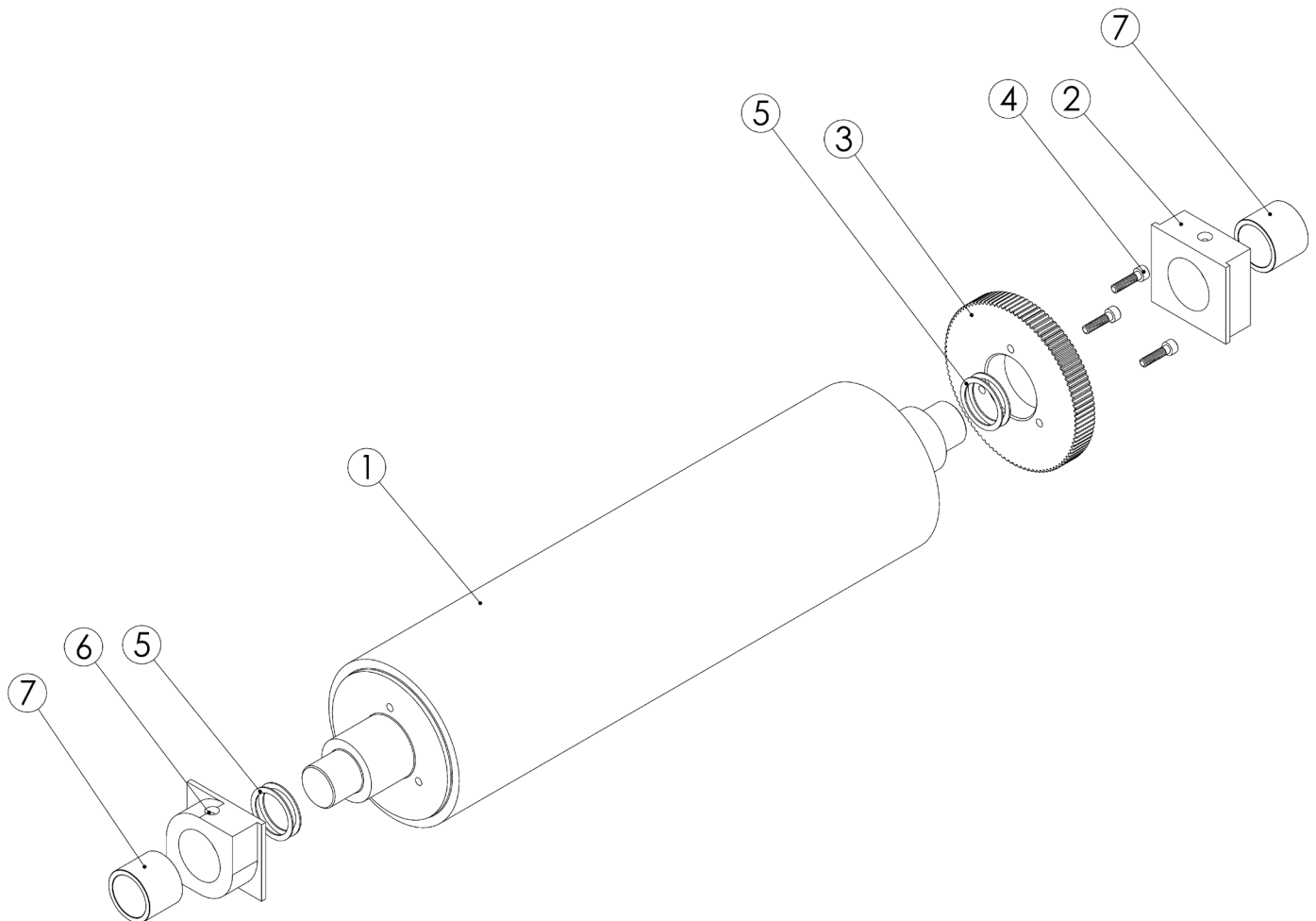
ITEM NO.	PART NUMBER	DESCRIPTION
1	10203-x3	LOWER SUPPORT ROLL, 13"
2	5206A2RS1	BEARING
3	10054-x3	GEAR, 64 TOOTH, 1/8" PITCH
4	SCH_.164-32 UNC_0.75_SIMP	SOCKET HEAD CAP SCREW 8-32 X 3/4"
5	SCH_.250-20 UNC_0.75_SIMP	SOCKET HEAD CAP SCREW 1/4-20 X 3/4"
6	SSCR-HEX-CUP_.164-32 UNC_0.375_SIMP	SOCKET SET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





### Rotary Die Station: Anvil Roll Assembly

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



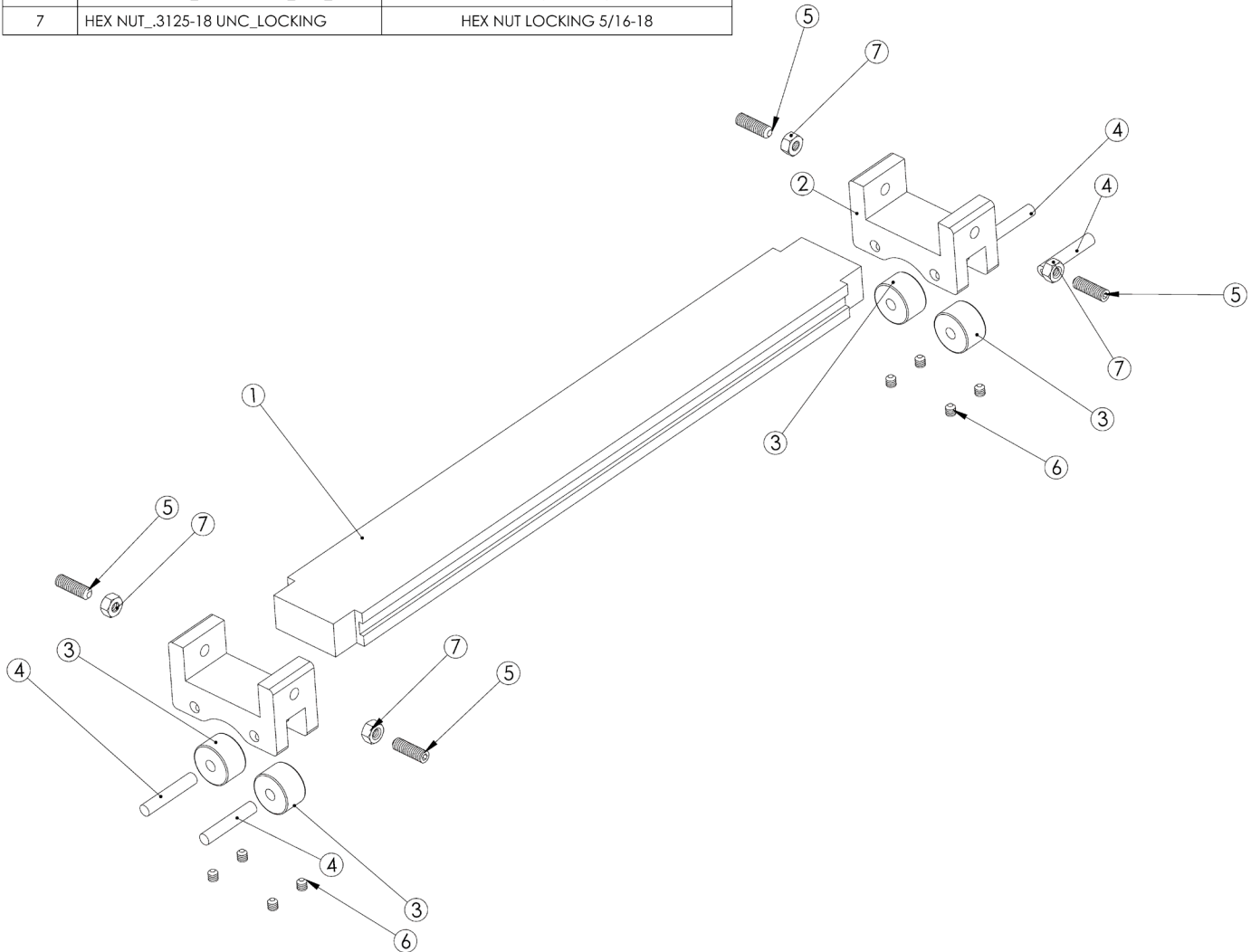


# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### Rotary Die Station: Die Truck Assembly

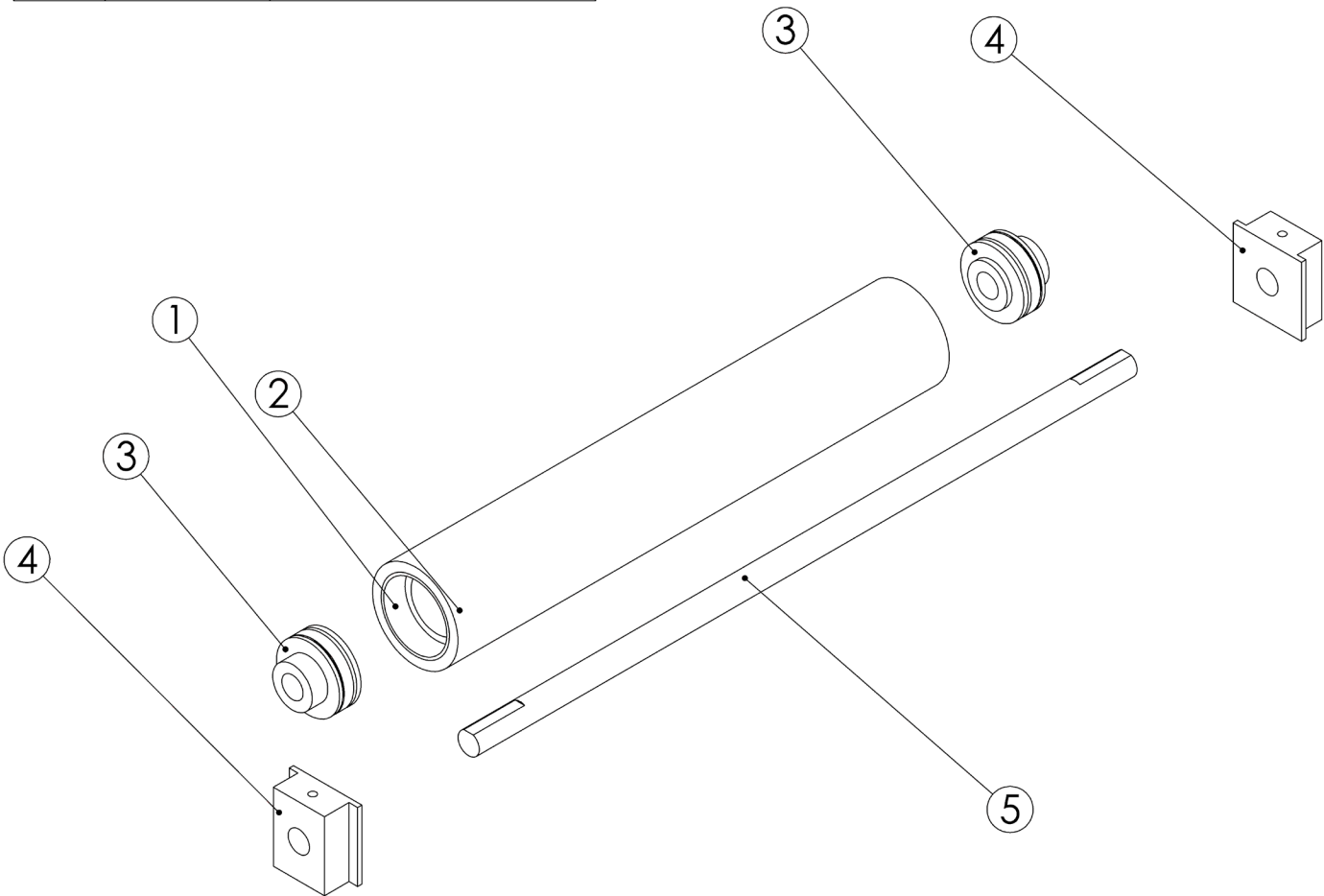
ITEM NO.	PART NUMBER	DESCRIPTION
1	10272	CAM FOLLOWER MAIN BRIDGE, 13"
2	10028	CAM FOLLOWER SUPPORT BRIDGE
3	Y-36-S	BEARING
4	10735	PIN,TRUCK, DIE CUTTER
5	SSCR-HEX-CUP_.3125-18 UNC_1_SIMP	SOCKET SET SCREW CUP POINT 5/16-18 X 1"
6	SSCR-HEX-CUP_.250-20 UNC_0.25_SIMP	SSCR 1/4-20 X 1/4
7	HEX NUT_.3125-18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





### Main Drive: Nip Roll Assembly

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





# AZTECH CONVERTING SYSTEMS

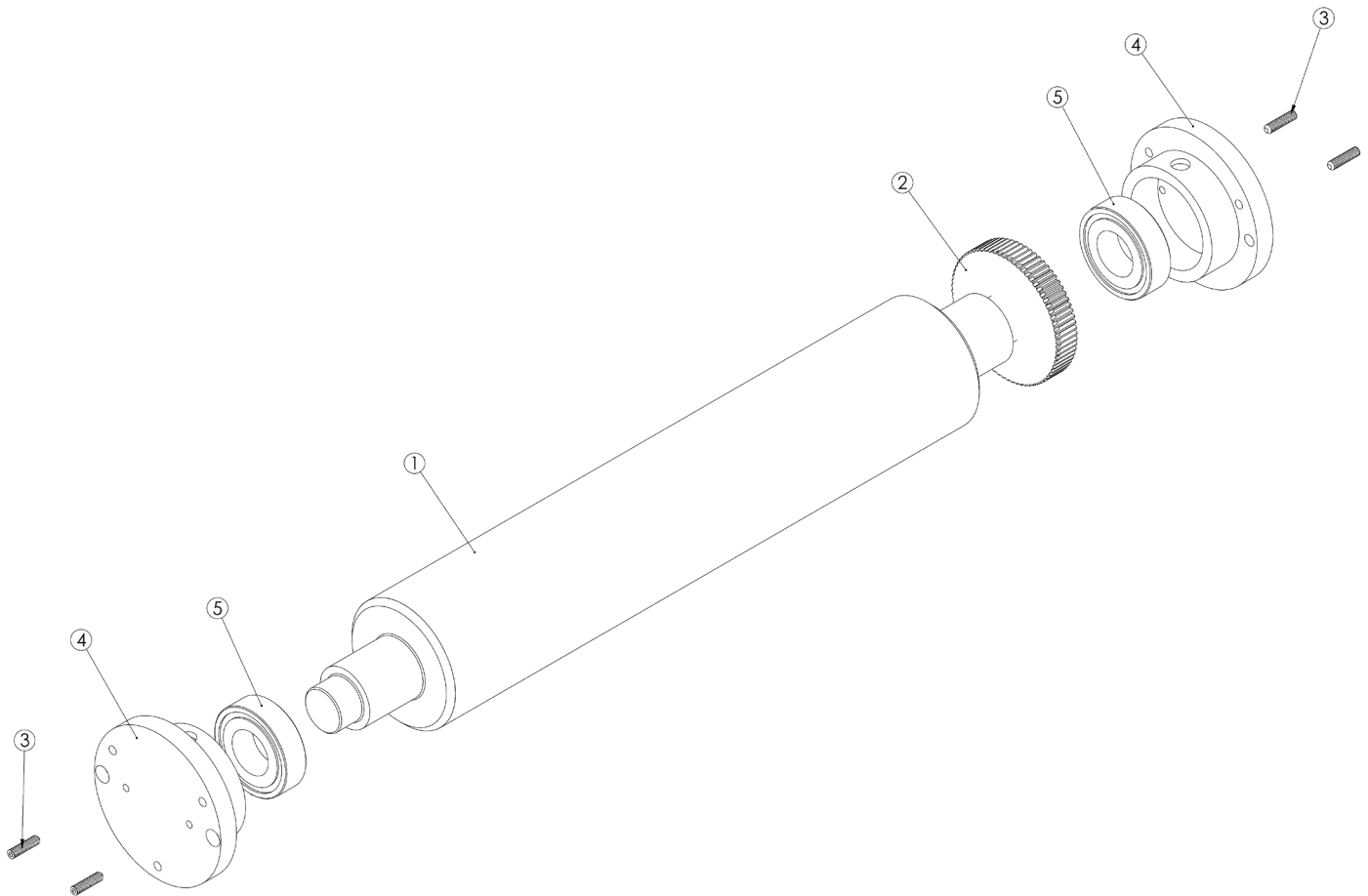
## DM-40XX

### USER MANUAL

---

#### Main Drive: Pace Roll Assembly

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



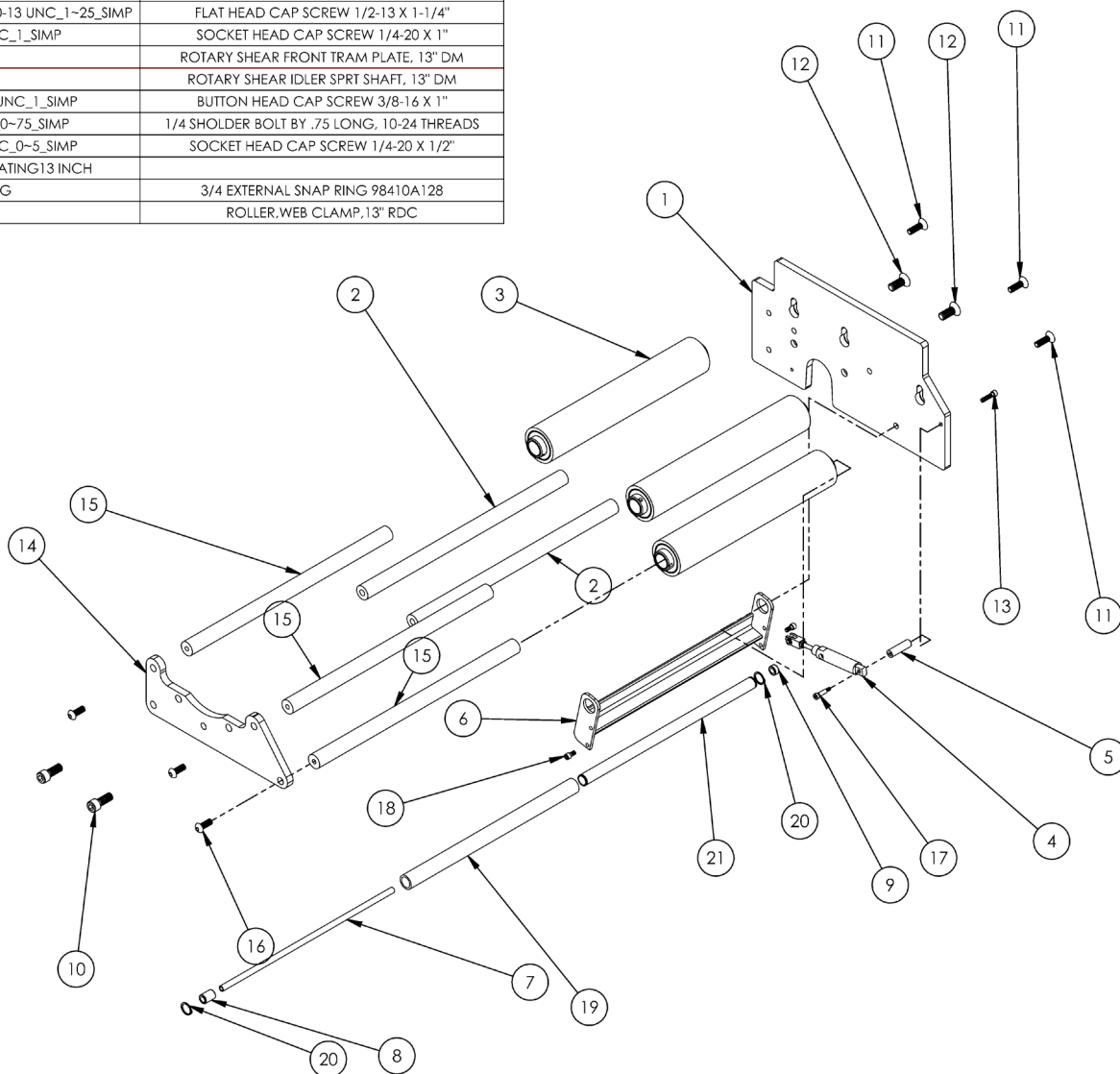
# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



### Slitting Station: Main Assembly

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







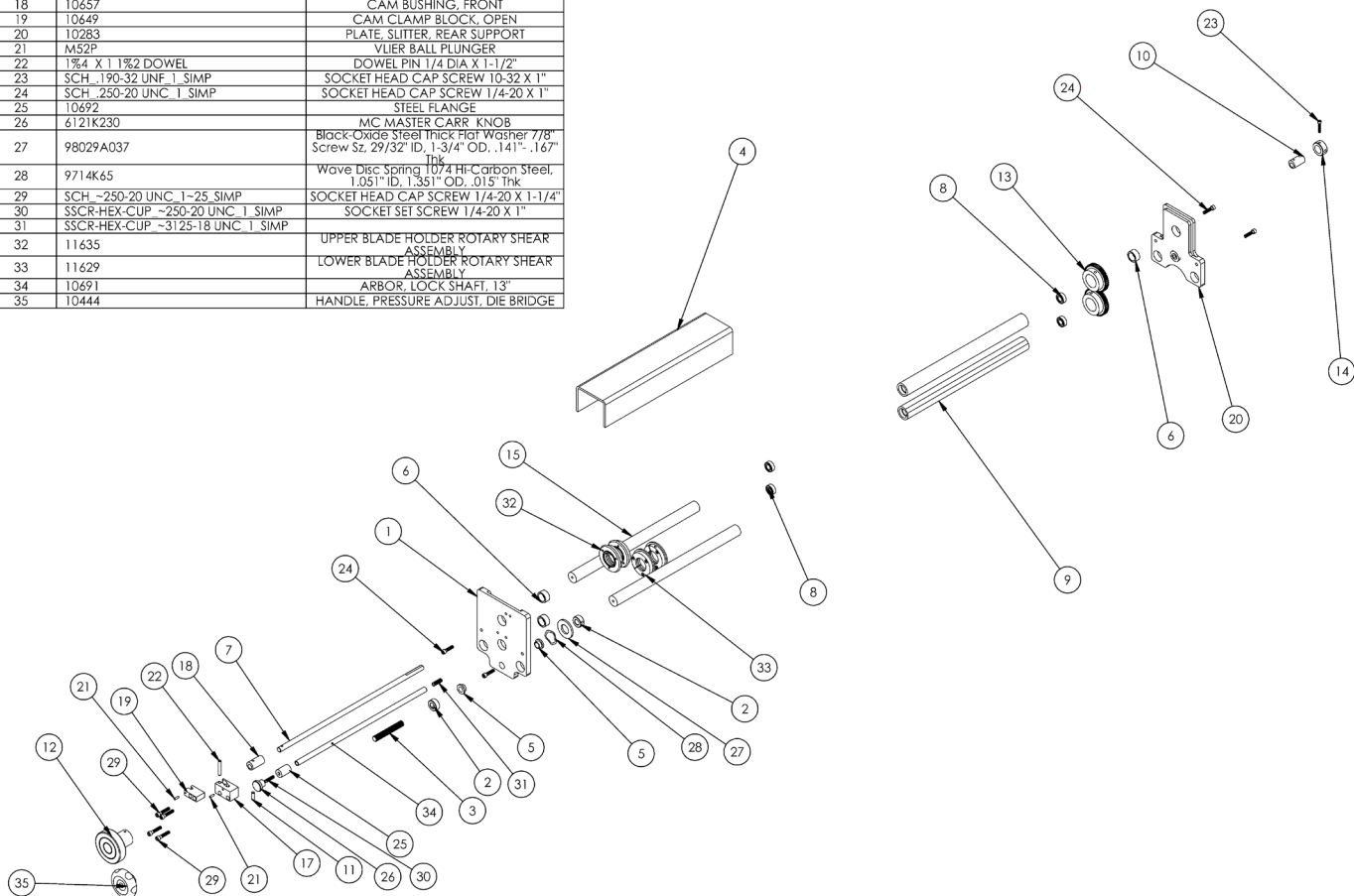
# AZTECH CONVERTING SYSTEMS

## DM-40XX

### USER MANUAL

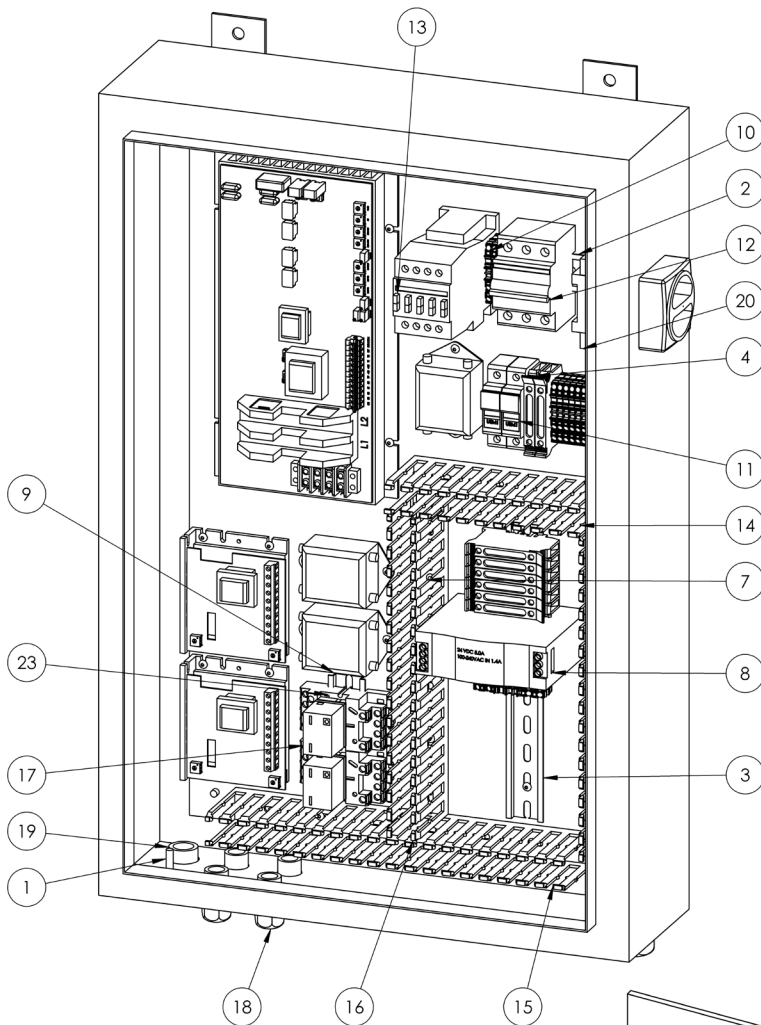
## Slitting Station: Rotary Shear Assembly

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



# AZTECH CONVERTING SYSTEMS

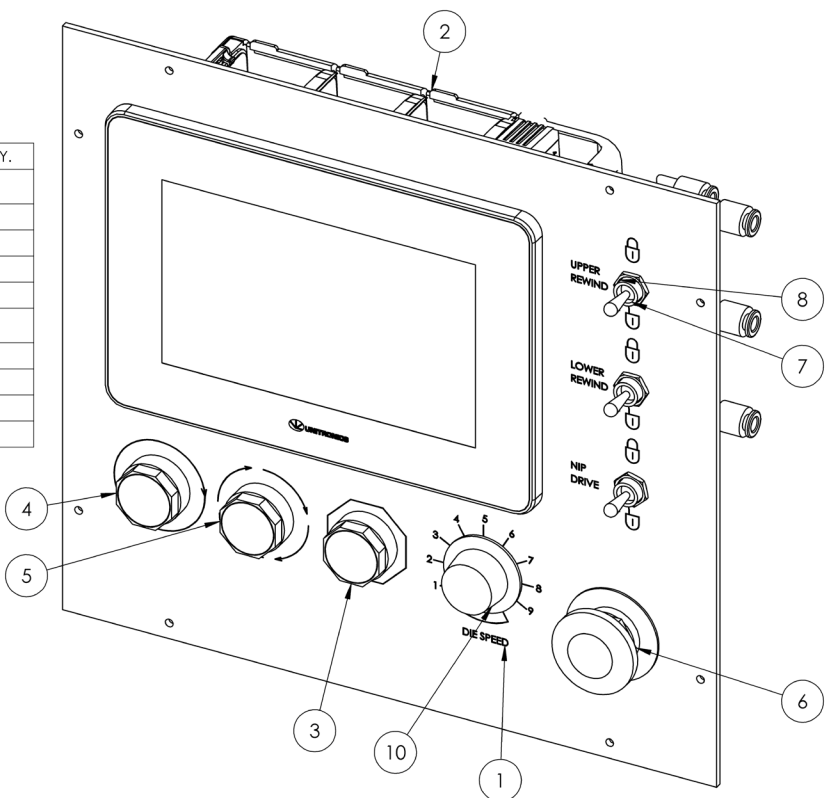
## DM-40XX USER MANUAL



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	E-302010 ASSM (6in)	20" x 30" x 6" Electrical Cabinet	1
2	Din Rail 7.5in	DIN RAIL, 7.5in	1
3	DIN RAIL 11in	DIN RAIL 11in	1
4	3004171 FUSE BLOCK	Midget Fuse Block, Press In, DIN RAIL MOUNT	9
5	BTNHD .164-32 UNC_0-5_SIMP	BUTTON HEAD CAP SCREW 8-32 X 1/2"	5
6	KBTC-225	DC Motor Drive	2
7	BTNHD .164-32 UNC_0-5_SIMP	BUTTON HEAD CAP SCREW 8-32 X 1/2"	29
8	WAGO 2002-1401	Terminal Block, 4-Conn, DIN Rail, 14-22AWG	5
9	KBRF-200A	RF Filter for DC Motor Drives	3
10	WAGO 2006-1301	TERMINAL BLOCK, 3-POLE, 12-20AWG, DIN MOUNT	11
11	USM1	Midget Fuse Block, Press In, DIN RAIL MOUNT	2
12	S203	40A Circuit Breaker, 3Pole	1
13	AL40-30-10	MCR Contactor, 60A	1
14	8.5in WIREWAY		1
15	13in WIREWAY		1
16	12in WIREWAY		2
17	784 RELAY ASSY 24VDC	784 Series Relay Assy, 24VDC	2
18	1 2 STRAIN RELIEF ASSEMBLY	1/2" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	4
19	3 4 STRAIN RELIEF ASSEMBLY	3/4" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	2
20	0172201 Disconnect	BACO 50A Disconnect	1
21	Din Rail 5in	DIN RAIL, 5in	1
22	RGF-403-25	1-5 HP Regen Reversing SCR Drive	1
23	Din Rail 4.5	DIN RAIL, 4.5in	1
24	SDR-120-24	24 VDC POWER SUPPLY	1

### Press Controls, PLC OPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	20267	DIE MASTER PLC MAIN OPERATOR PANEL	1
2	20282	Univision 7" PLC ASSEMBLY, 2I/O	1
3	E22PB3	GREEN PUSH BUTTON	1
4	E22PB2	RED PUSH BUTTON	1
5	E22PB4	YELLOW PUSH BUTTON	1
6	E22LB2N86 MAIN ASSEMBLY	E STOP 40 MM MUSHROOM HEAD	1
7	MJTV-3 ASSEMBLY	3 WAY 1/8 PORT TOGGLE VALVE	3
8	MJTV NUT	MJTV SERIES NUT	3
9	SPEED POT	10K SPEED POT	1
10	ROTARY KNOB	PART# 6094K57	1





**AC MAIN SERVICE**  
 415 V, 3 PH, 50/60 HZ, 3 WIRE  
 3 Phase, 4 Wire, 480V  
 80 Ampere (Circuit Breaker)

**DC1**  
 1 2 3 4 5 6 7 8 9 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

**DC2**  
 1 2 3 4 5 6 7 8 9 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

**DC3**  
 1 2 3 4 5 6 7 8 9 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

**24VDC SUPPLY**  
 1 2 3 4 5 6 7 8 9 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

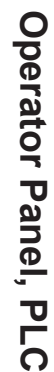
**12VDC SUPPLY**  
 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100

**24VDC MOTOR**  
 1 2 3 4 5 6 7 8 9 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

**12VDC MOTOR**  
 1 2 3 4 5 6 7 8 9 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

**Legend**  
 12VDC MOTOR  
 1750 RPM  
 100% TORQUE  
 100% SPEED  
 100% CURRENT  
 100% VOLTAGE  
 100% POWER  
 100% EFFICIENCY  
 100% FACTOR  
 100% LOSS  
 100% RATIO  
 100% GEAR  
 100% DRIVE  
 100% MOTOR

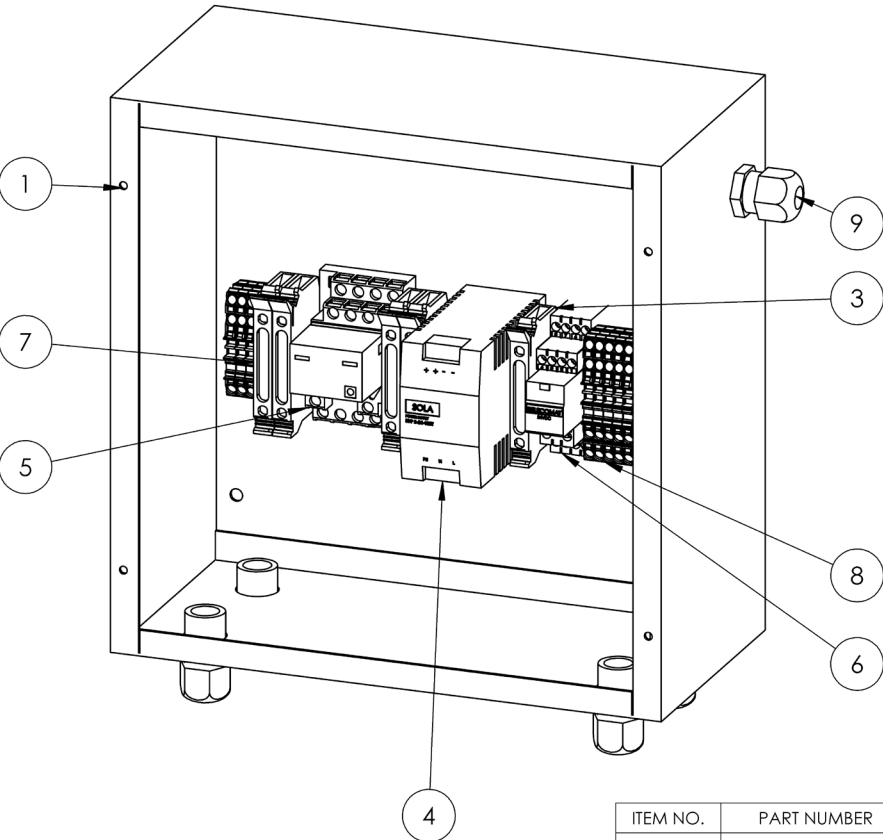






# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



ITEM NO.	PART NUMBER	DESCRIPTION	NO DOOR/QTY.
1	12 X 12 X 6 SC BOX	12 X 12 X 6 SC BOX	1
2	DIN RAIL 11in	DIN RAIL 11in	1
3	3004171 FUSE BLOCK	Midget Fuse Block, Press In, DIN RAIL MOUNT	5
4	SDP-2-100T	SPD 100W Power Supply	1
5	784 RELAY ASSY 24VDC	784 Series Relay Assy, 24VDC	1
6	RELAY ASSY, 4PDT, DIN MOUNT S9&C9	4PDT ICE CUBE RELAY ASSEMBLY	1
7	WAGO 2006-1301	TERMINAL BLOCK, 3-POLE, 12-20AWG, DIN MOUNT	4
8	WAGO 2002-1401	Terminal Block, 4-Conn, DIN Rail, 14-22AWG	10
9	1/2 STRAIN RELIEF ASSEMBLY	1/2" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	5

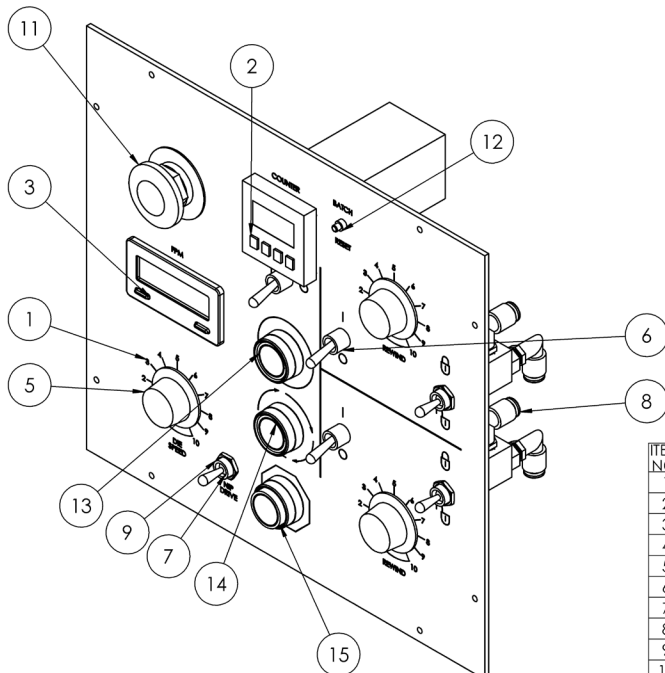
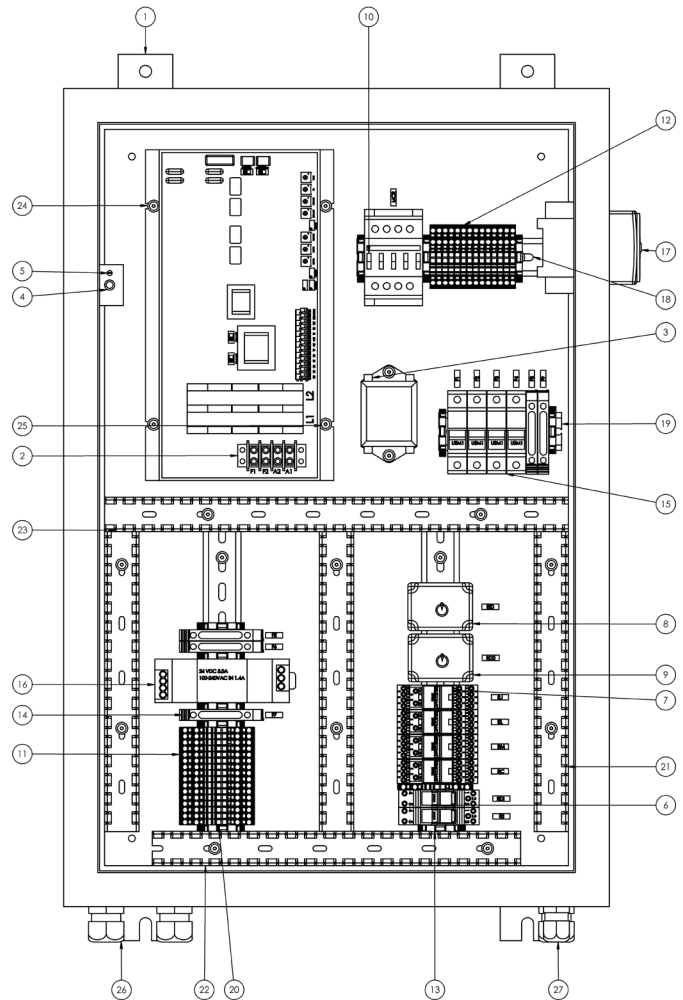


# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

### Press Controls, STANDARD

ITEM NO.	PART NUMBER	DESCRIPTION	NO DOOR/QTY.
1	E-302010 (6in)	20" x 30" x 6" Electrical Cabinet	1
2	RGF-403-25	1-5 HP Regen Reversing SCR Drive	1
3	KBRF-200A	RF Filter for DC Motor Drives	1
4	11657-B		1
5	SPEED POT	10K SPEED POT	1
6	C10 RELAY ASSY	C10 and S10 Relay / Socket Assembly	2
7	RELAY ASSY, 4PDT, DIN MOUNT, S9&C9	4PDT ICE CUBE RELAY ASSEMBLY	4
8	OFF DELAY RELAY	TR-51628 Relay & SR3P-05 Socket	1
9	ON DELAY RELAY	TR-50228-05 Relay & SR2P-05 Socket	1
10	AL40-30-10	MCR Contactor, 60A	1
11	WAGO 2002-1401	Terminal Block, 4-Conn, DIN Rail, 14-22AWG	17
12	WAGO 2006-1301	TERMINAL BLOCK, 3-POLE, 12-20AWG, DIN MOUNT	14
13	249-116	End Stop 7mm	11
14	3004171 FUSE BLOCK	Midget Fuse Block, Press In, DIN RAIL MOUNT	5
15	USM1	Midget Fuse Block, Press In, DIN RAIL MOUNT	4
16	SDR-120-24	24 VDC POWER SUPPLY	1
17	0172201 Disconnect	BACO 50A Disconnect	1
18	Din Rail 7.5in	DIN RAIL, 7.5in	1
19	Din Rail 4.5	DIN RAIL, 4.5in	1
20	DIN RAIL 11in	DIN RAIL 11in	2
21	11in WIREWAY		3
22	13in WIREWAY		1
23	17in WIREWAY		1
24	WSHR A_164	8-32 FLAT WASHER	24
25	BTNHD_164-32 UNC_0.5_SIMP	BUTTON HEAD CAP SCREW 8-32 X 1/2"	24
26	3_4 STRAIN RELIEF ASSEMBLY	3/4" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	3
27	1_2 STRAIN RELIEF ASSEMBLY	1/2" NON METALLIC LIQUID-TIGHT TYPW B CONNECTOR	1

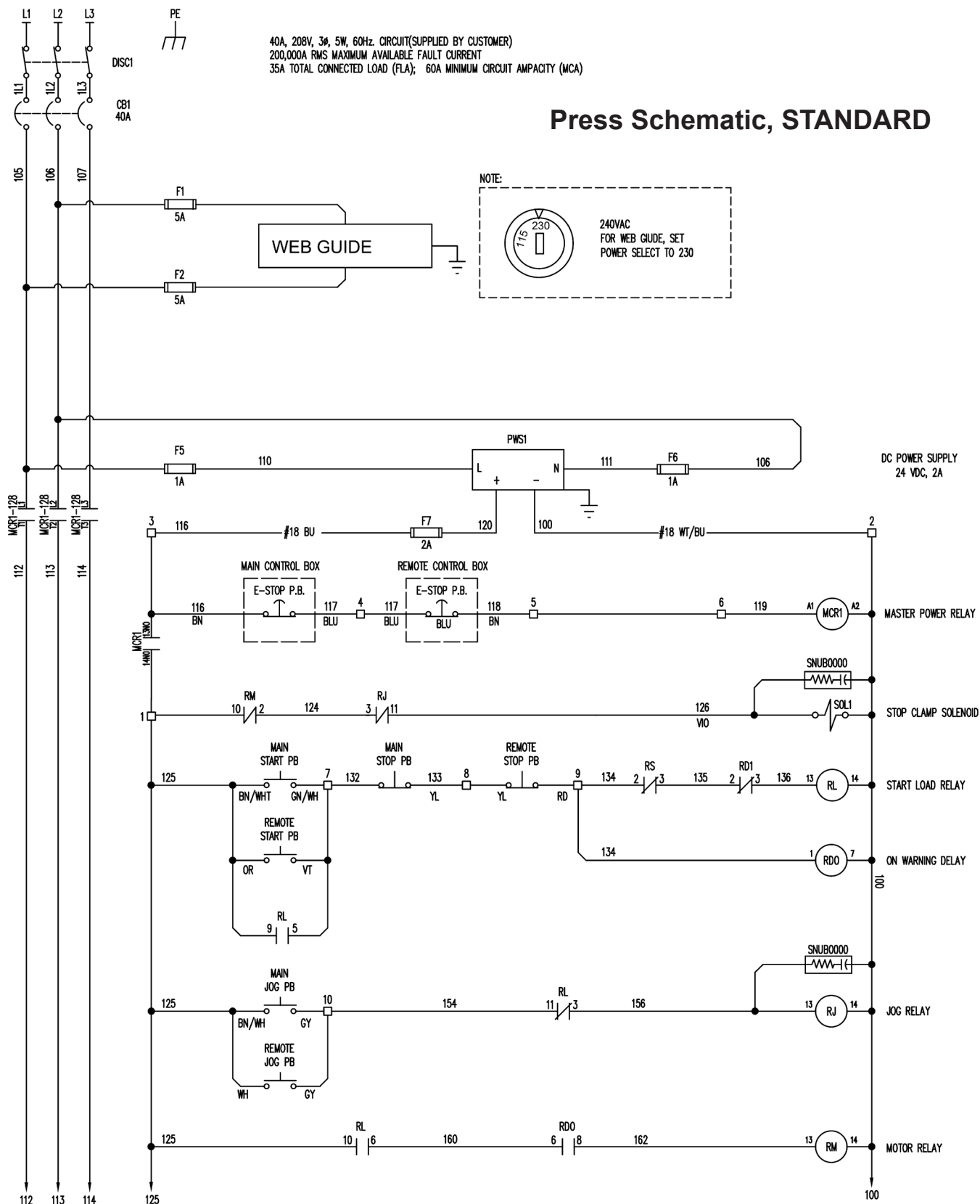


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	10747	PLATE, CONTROLS.MAIN, RDC.DUAL MOTOR	1
2	C48CD012-20115	RED LION COUNTER	1
3	DT900020 ASSEMBLY		1
4	SPEED POT	10K SPEED POT	1
5	ROTARY KNOB	PART# 6094K57	3
6	SPST ASSEMBLY	PART# 2FA54-73	3
7	MJTV-3	3 PORT AIR TOGGLE VALVE	3
8	SMC KQ2L07-34S	1/4 COMP TO 1/8 MPT	6
9	MJTV NUT	MJTV SERIES NUT	3
10	SPEED POT 5K	5K SPEED POT	2
11	E22LLB2N86 MAIN ASSEMBLY	E STOP 40 MM MUSHROOM HEAD	1
12	30-3	PUSH BUTTON SWITCH 30-3	1
13	20428	IDEC START BUTTON ASSY	1
14	20429	IDEC JOG BUTTON ASSY	1
15	20430	IDEC STOP BUTTON ASSY (NO)	1



# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL



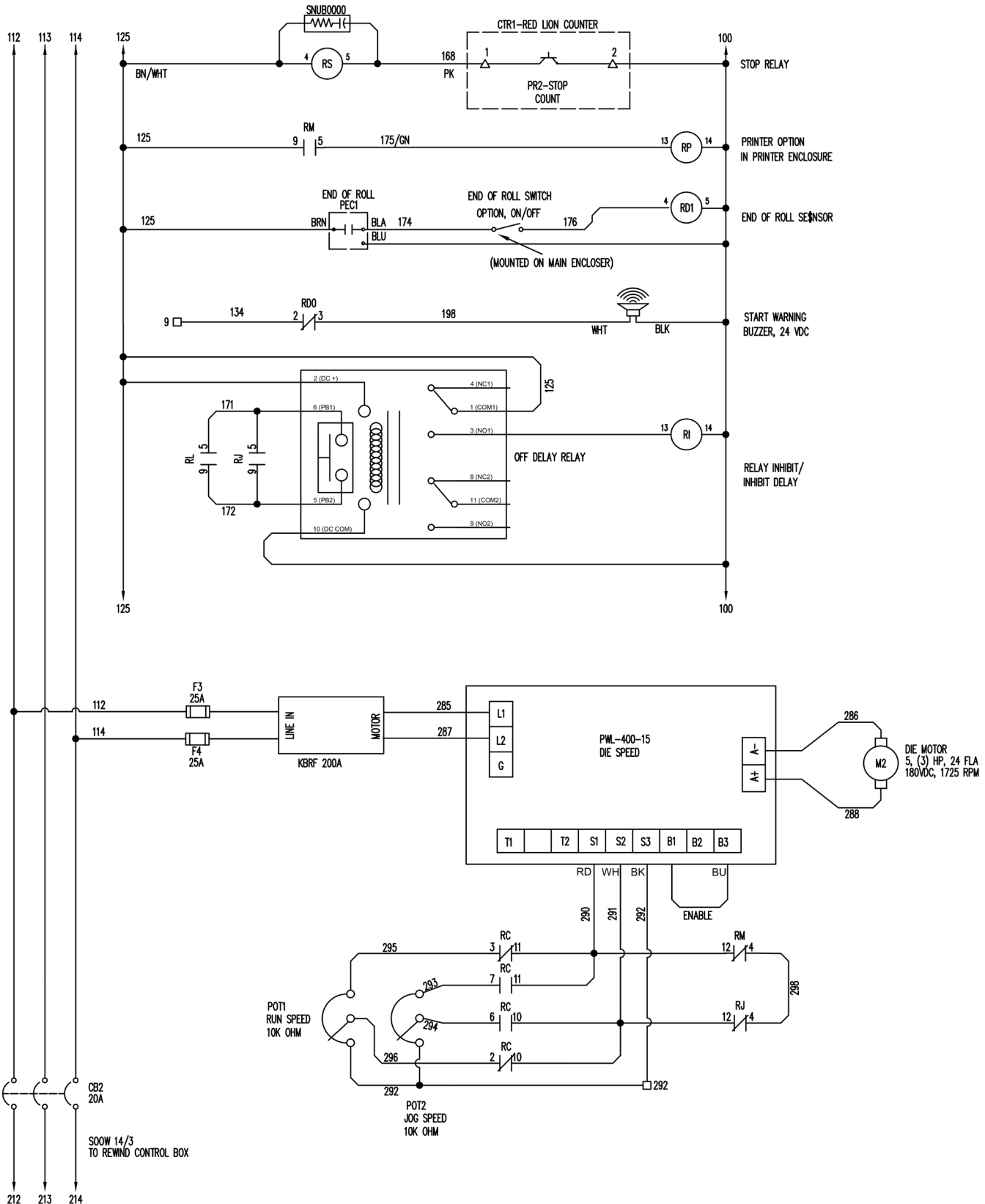


# AZTECH CONVERTING SYSTEMS

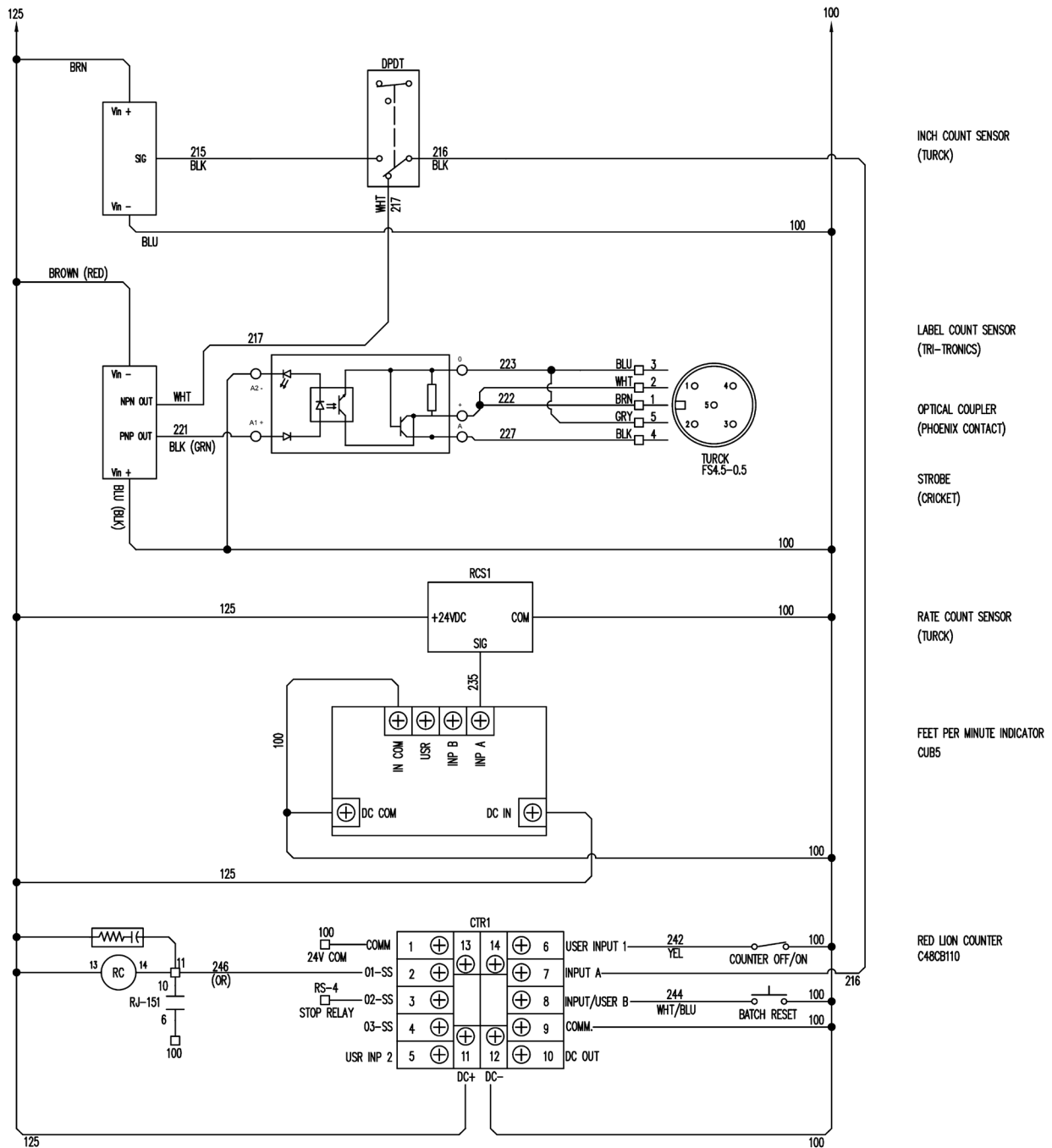
## DM-40XX

### USER MANUAL

## Press Schematic, STANDARD



# DM-40XX USER MANUAL



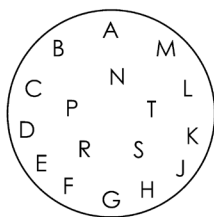
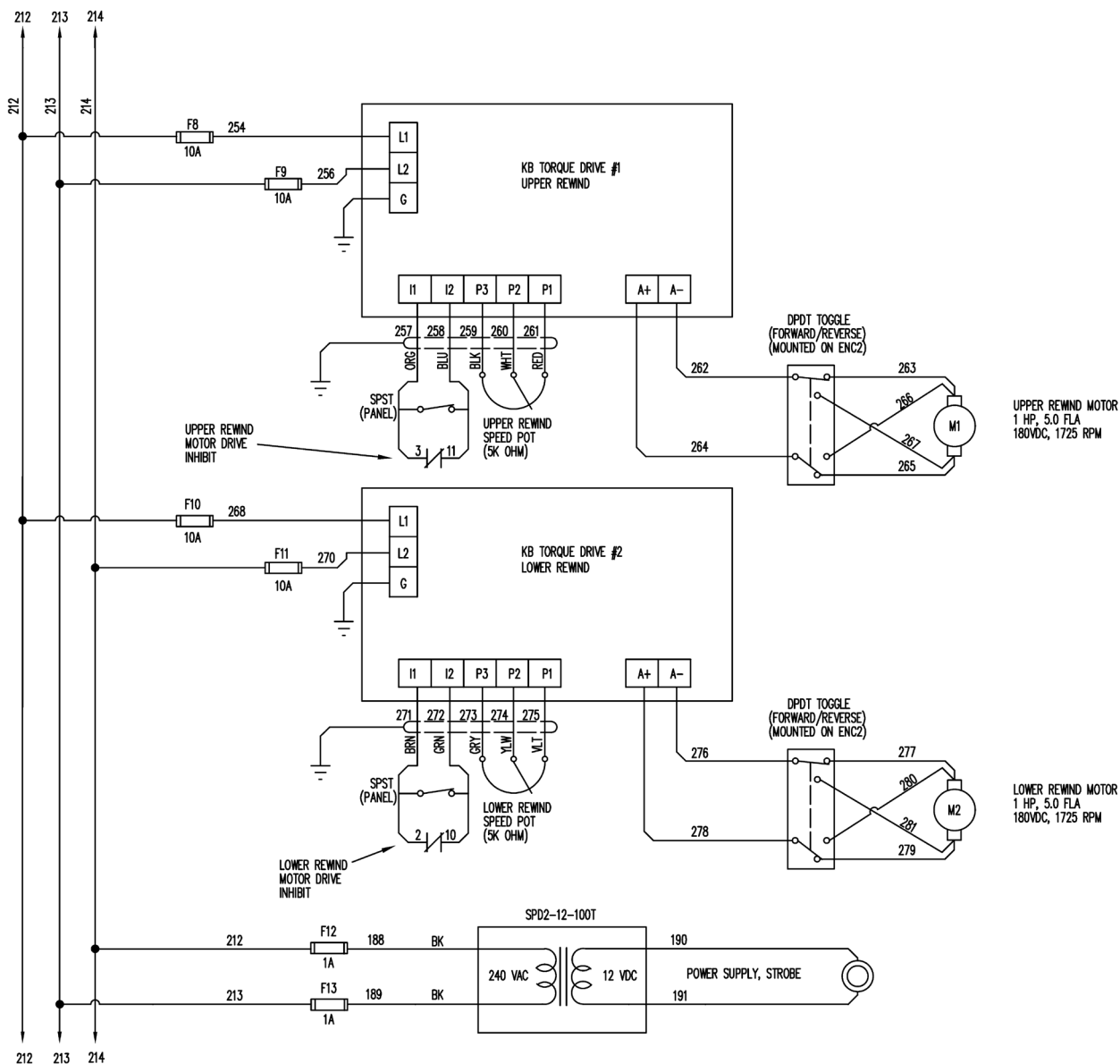


# AZTECH CONVERTING SYSTEMS

## DM-40XX

### USER MANUAL

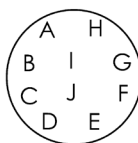
## Press Schematic, STANDARD



MAIN PANEL PINOUT															
A	B	C	D	E	F	G	H	J	K	L	M	N	P	R	S
BU	BU/WT	WH	YW	PK	BK	GN/YL	GN/WH	VT	BN/WH	NC	NC	SHL D	BN	GY	RD
T															OR

### MAIN PANEL

AMPHENOL:  
97-3012A-20-29S



REMOTE CABLE PINOUT									
A	B	C	D	E	F	G	H	I	J
BU	OR	RD	GN	GY	VT	YW	BN	WT	BK

### REMOTE

AMPHENOL:  
97-3106A-18-1P



## Section 7: Troubleshooting

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

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

### 7-2: The counter is not counting accurately.

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

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

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

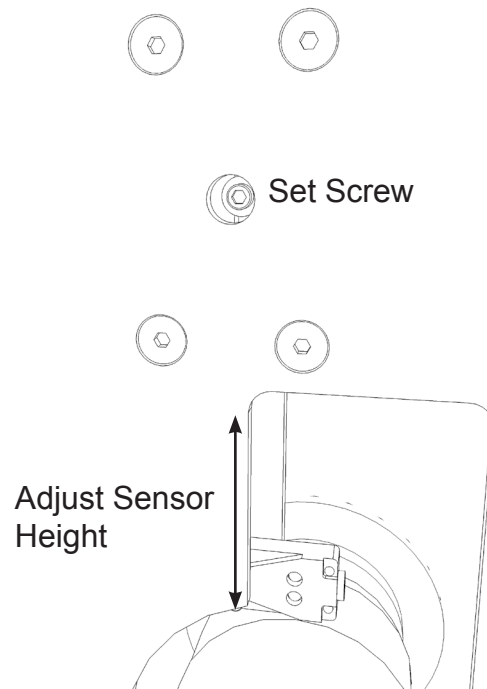
### 7-4: Why is the counter not counting labels?

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

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

If your DieMaster 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





# AZTECH CONVERTING SYSTEMS

## DM-40XX USER MANUAL

---

### Section 8: Warranties and Service

#### 8-1: Warranties & Provisions

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

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

#### EXCLUSIONS

##### THE FOLLOWING ITEMS ARE EXCLUDED FROM THIS WARRANTY:

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

#### DISCLAIMER OR WARRANTY

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

#### 8-2: Technical Service

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

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