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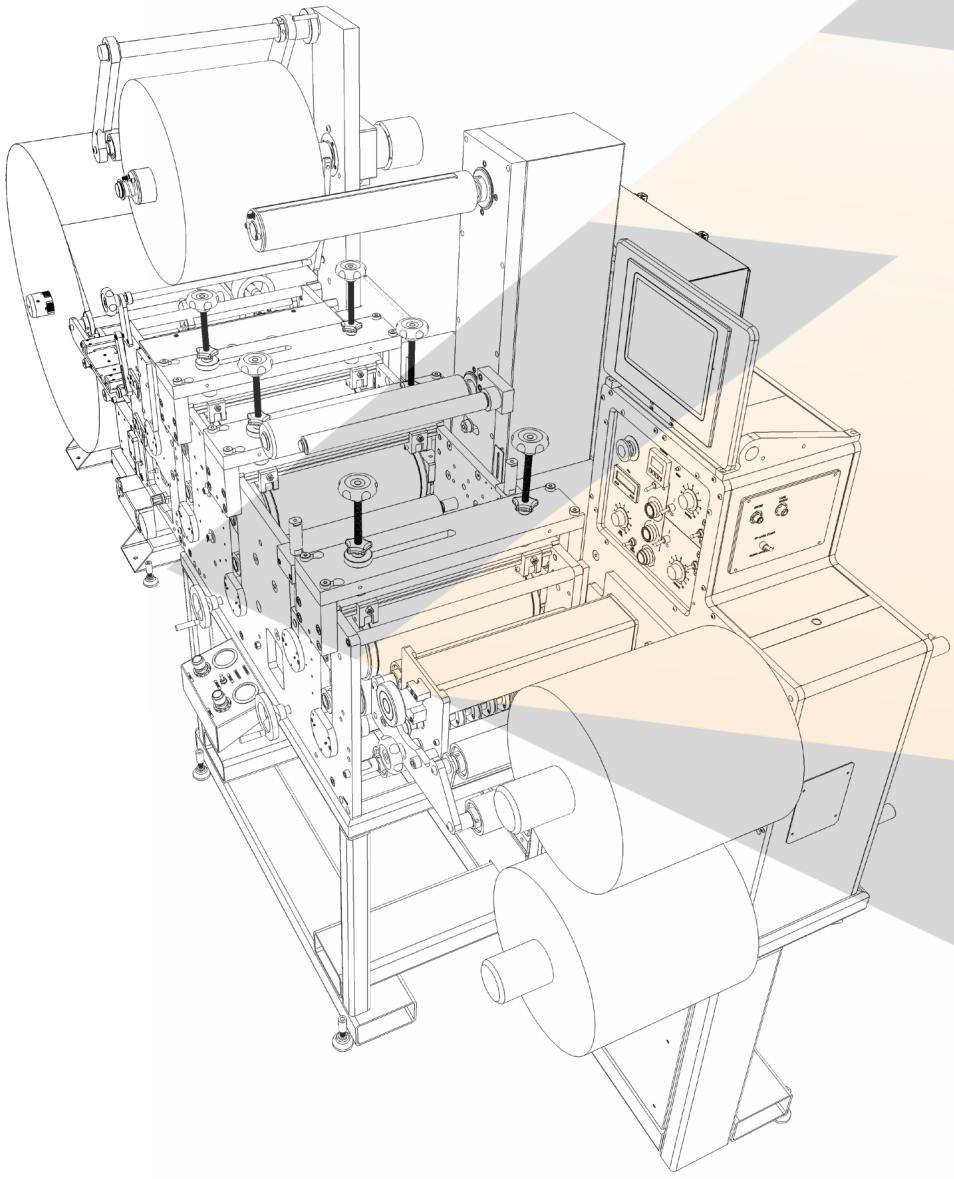
DIE MASTER
User Manual
DMRR-40XX



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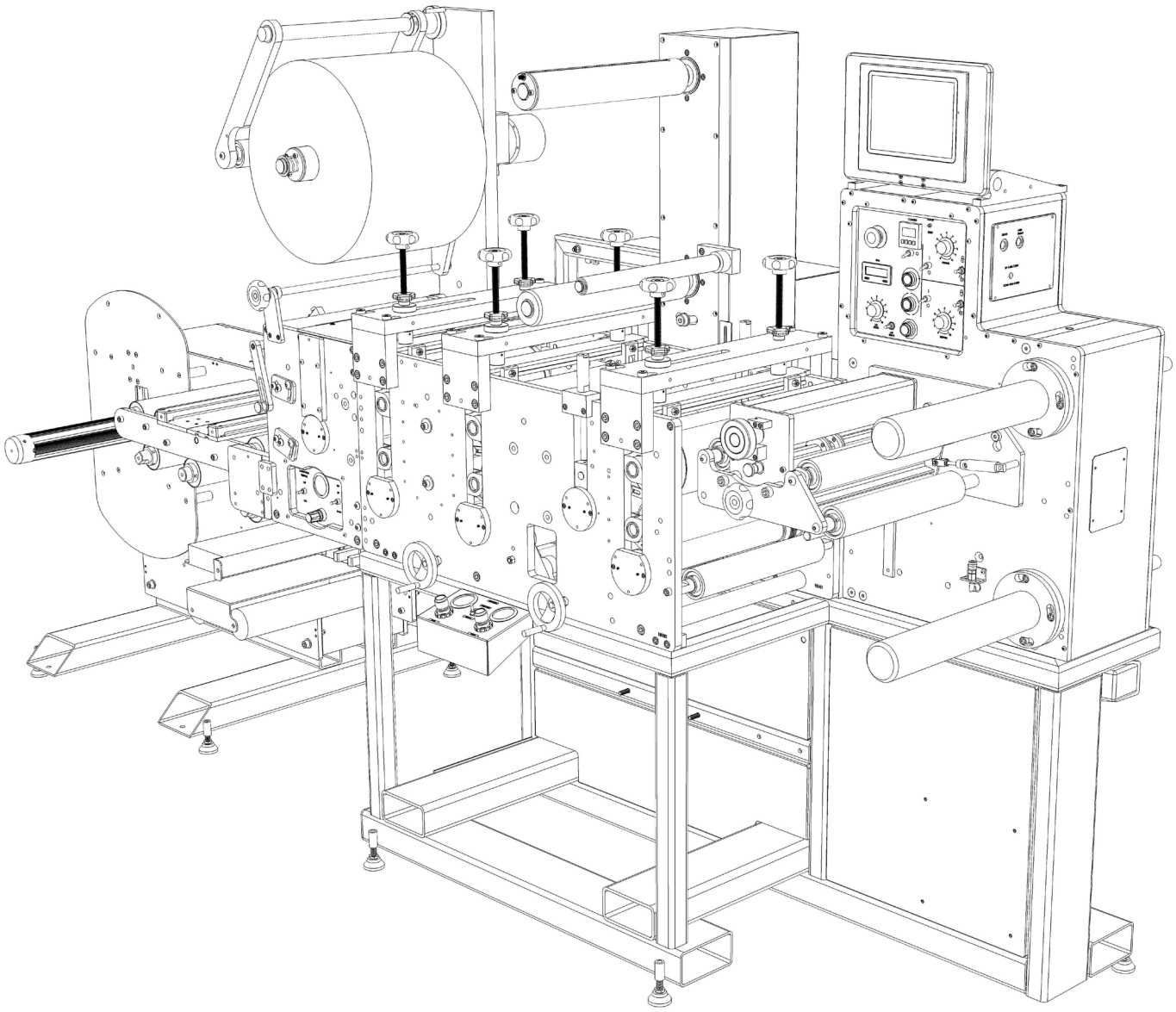
Section 1: General Information

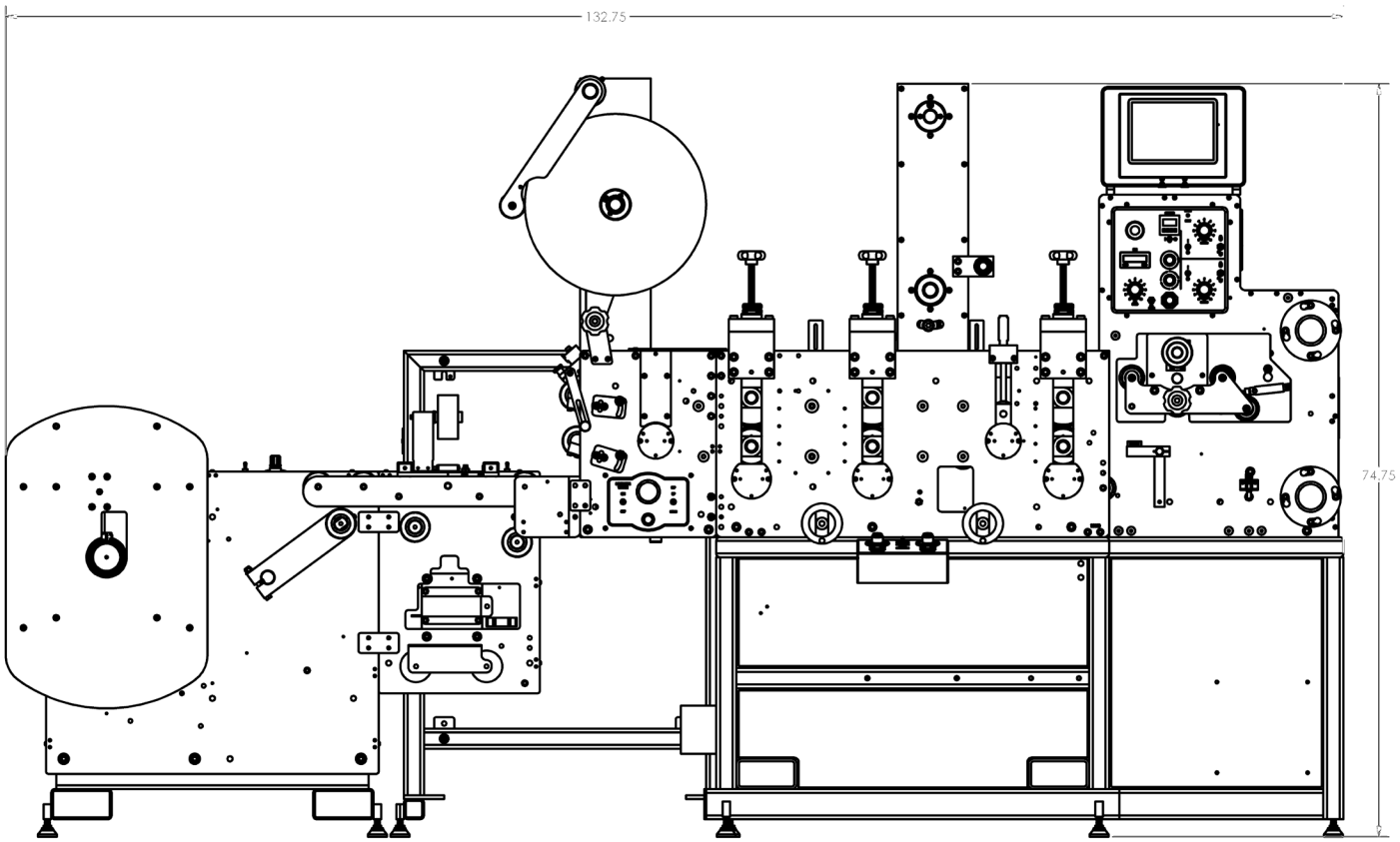
1-1: Introduction

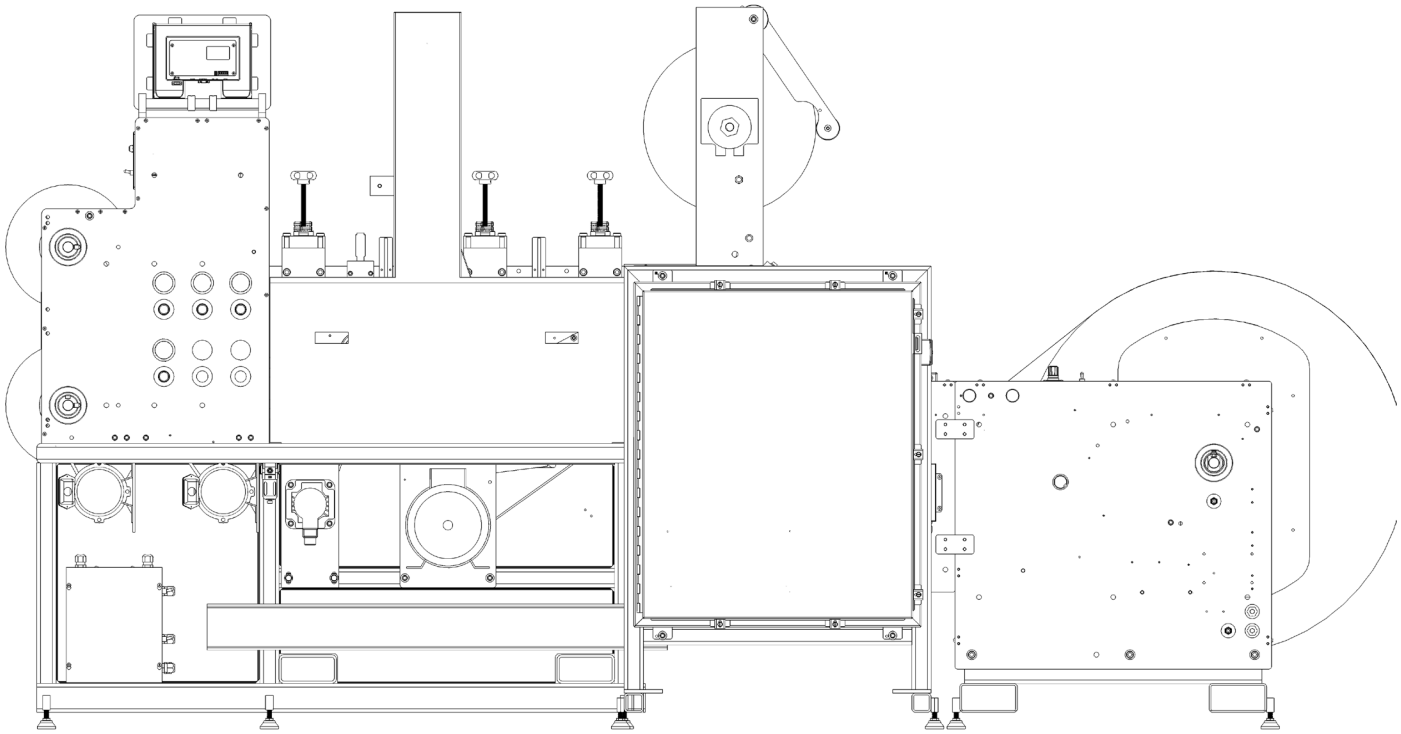
The AZTECH DieMaster Rotary Die Cutting Machine is available in 13 inch (33.02 cm), and 18 inch (45.72 cm) widths, with dual-spindle rewinds, and web speeds up to 500 feet/minute. The DieMaster is designed to be highly productive, versatile, and simple to operate and maintain. Before operating your new 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

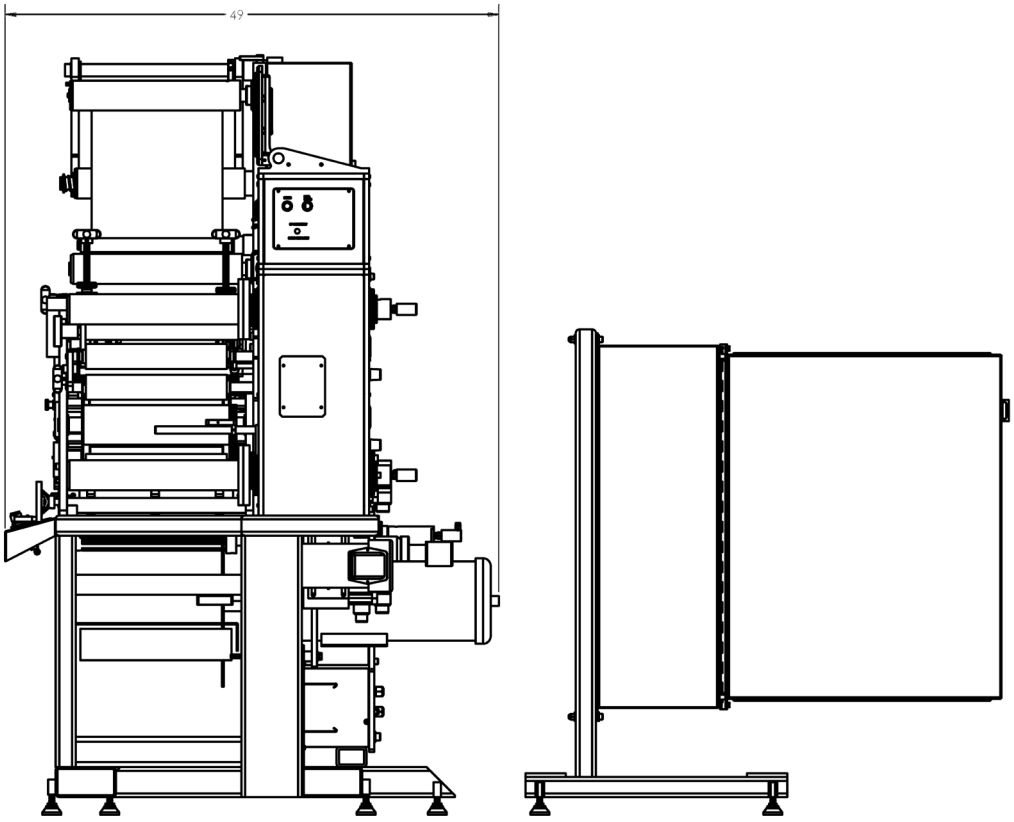


FRONT LAYOUT





SIDE LAYOUT



Web Width: 13.0in (33cm)

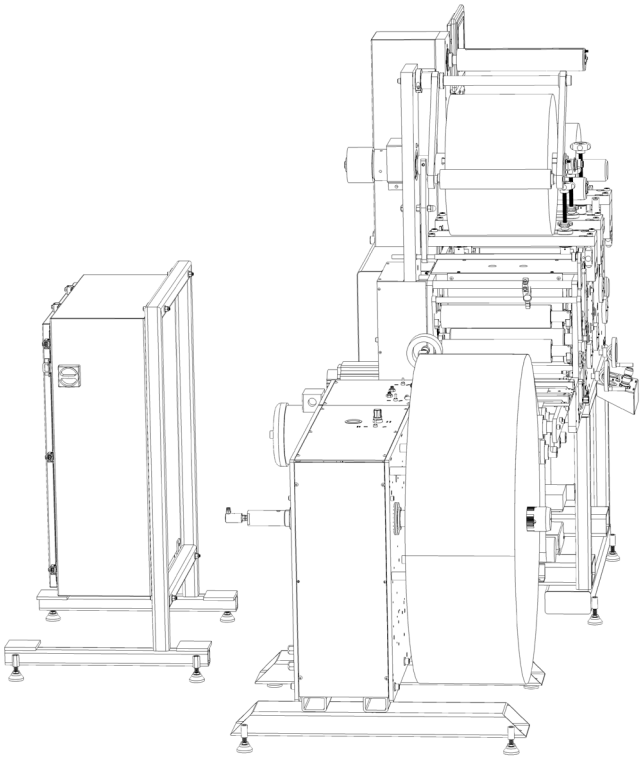
Unwind Capacity: 40in (101.6cm)

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

Web Speed: 500FPM (Job Dependant)

Main Drive: 3 HP DC
Rewind Drive: 1 HP DC
Die Nip: Yaskawa 1.3kW Servo

Power Requirements: 50A 220VAC 60Hz
90PSI @ 0.9CFM



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.

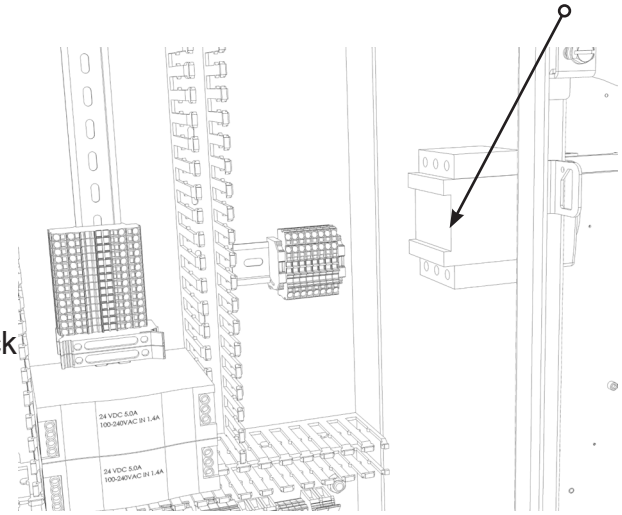
2-3: Removal and Positioning

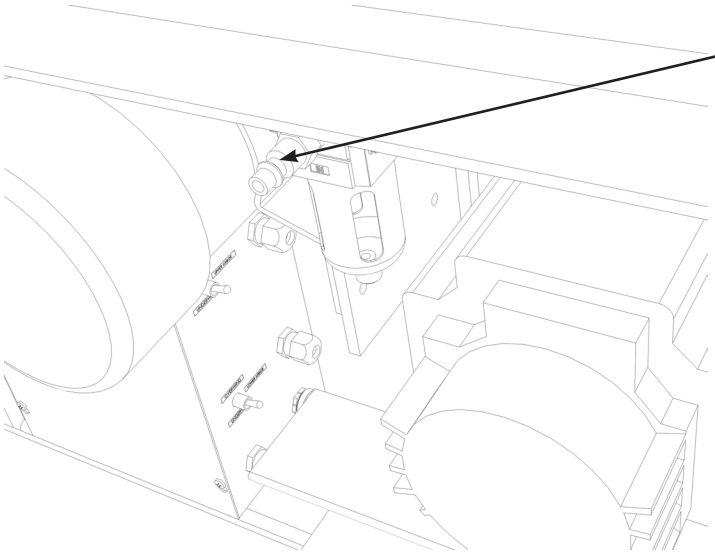
It is critical that the DieMaster be removed from the crate using a fork lift, making sure that the forks fit directly inside the 2 slots at base of the machine. Lift and remove from crate, and if equipped with adjustable feet, thread all 4 feet into threaded holes at machine's base, and lower into desired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





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

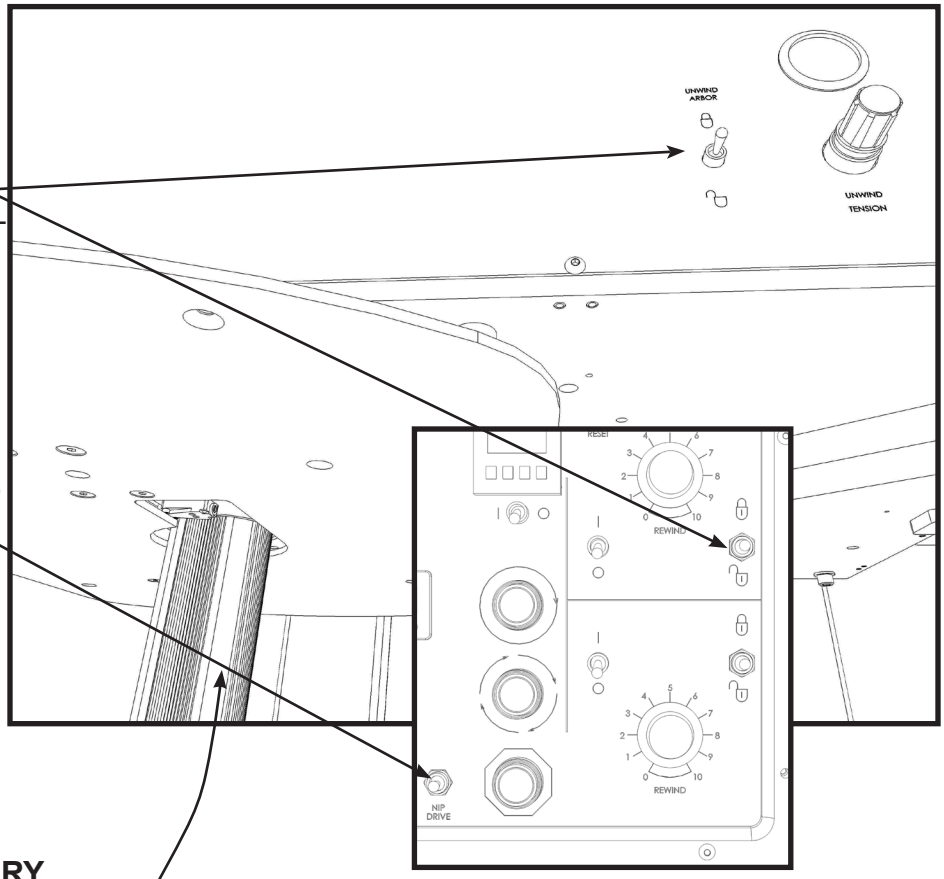
Make sure the area around your machine is clear of any objects which may impair the machine. Also inspect and make sure all belts, pulleys, rollers, and spindles are free and clear of any objects which may impede operation, and risk machine damage. Before threading your machine, accelerate and decelerate 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

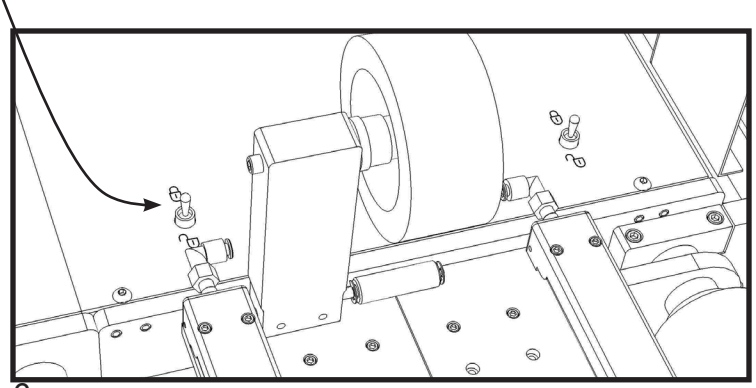
3-1: Webbing the Machine

Proper webbing of your 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:

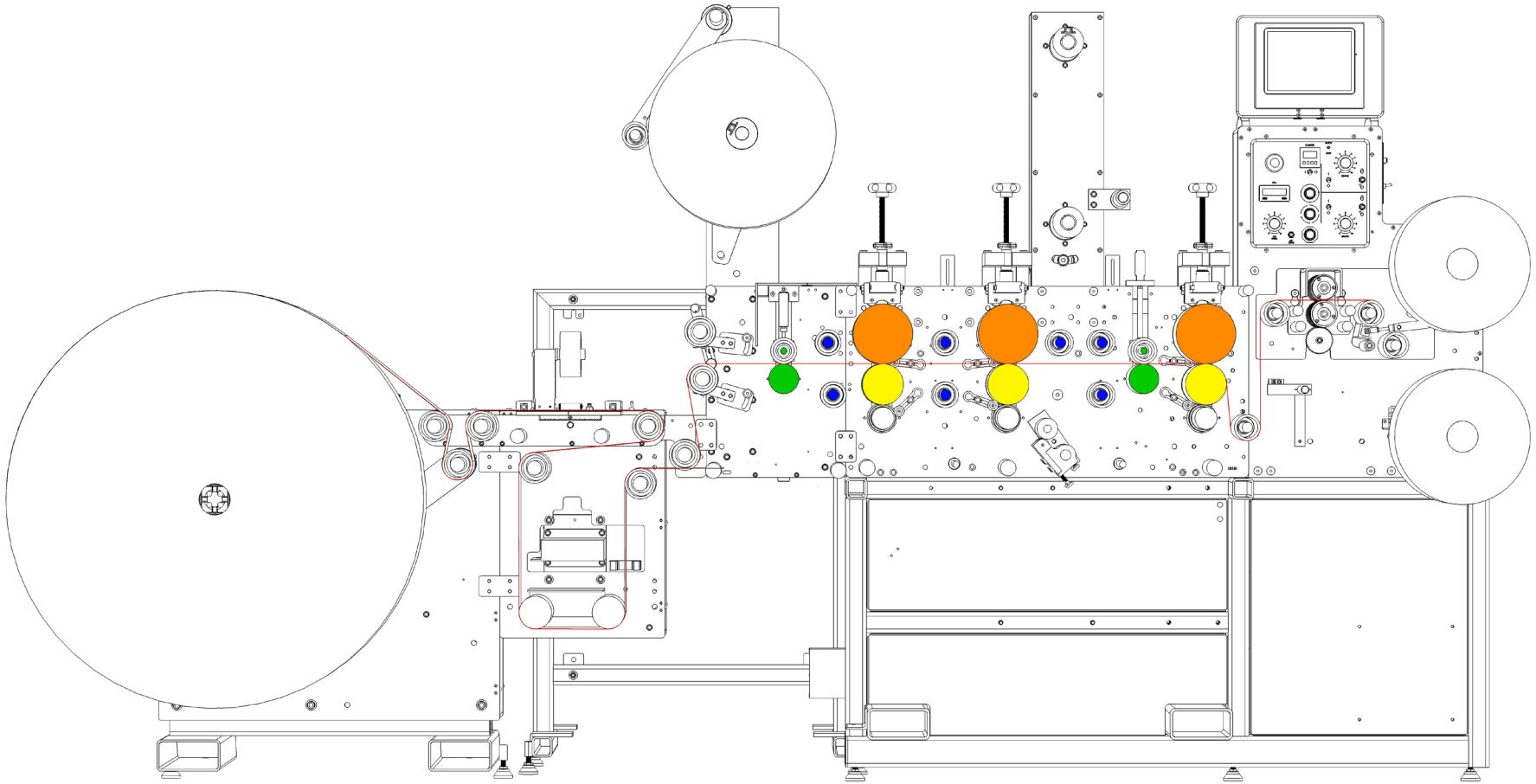


1. Turn unwind arbor switch to “DEFLATE” position.
2. Assure that the rewind and unwind switches on main panel are in the “OFF” position
3. Assure that both splice-table clamps are released into the up position.
4. Assure that the pneumatic nip roll is disengaged in the up position.
5. Assure that the 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.



DMRR 4013 w/ UDB Web Path

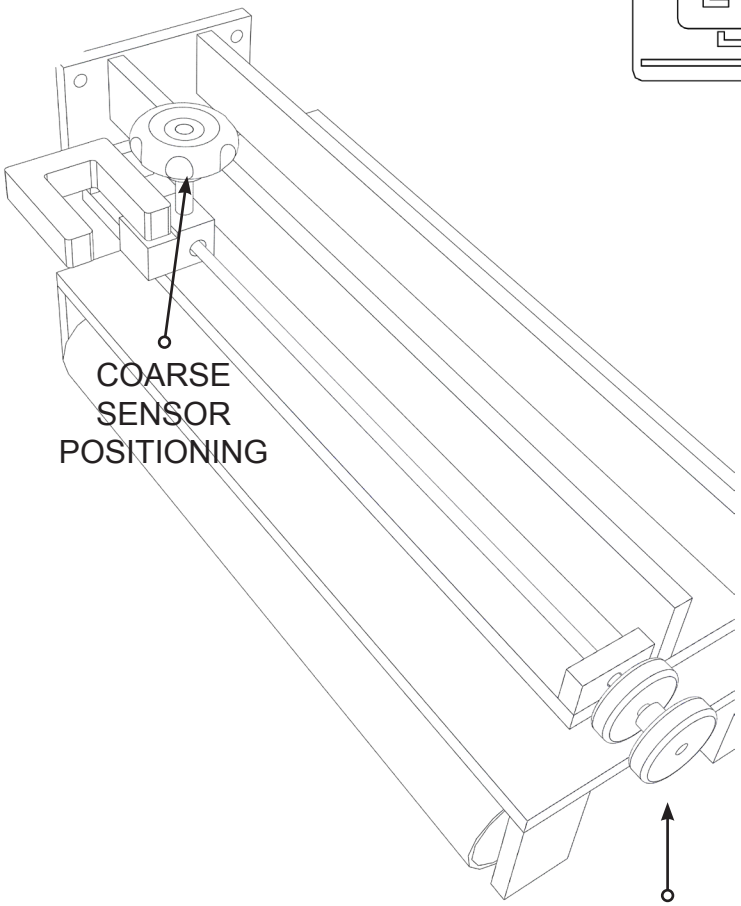
- SERVO NIP ROLLS
- MAGNETIC DIE ROLLS
- IMPRESSION ROLLS
- OPTIONAL IDLE R ROLLERS
- MINUMUM WEB PATH

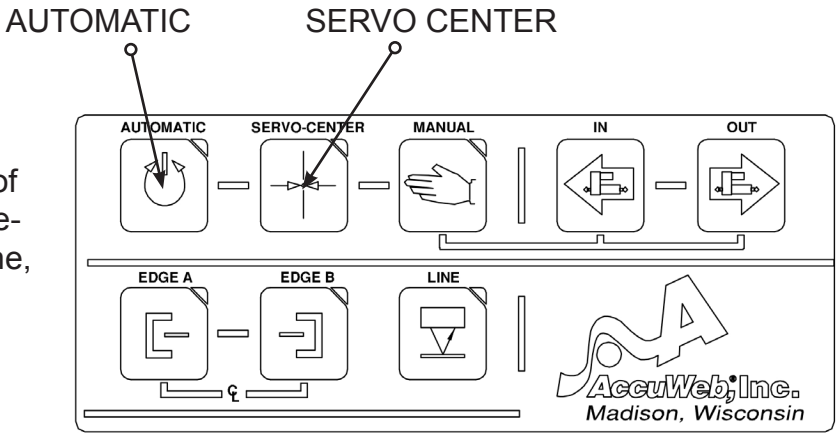


Proper webbing of your DieMaster is vital to optimal machine performance. The proper ways to thread your machine for various substrates are shown. Any improper webbing of the machine may cause tension problems that will impede operation.

3-2: Web Guide Setup

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



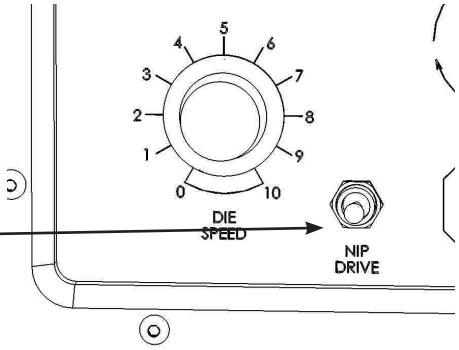


Setting the Web Guide:

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 Ac-cu-Web manual included with this manual.

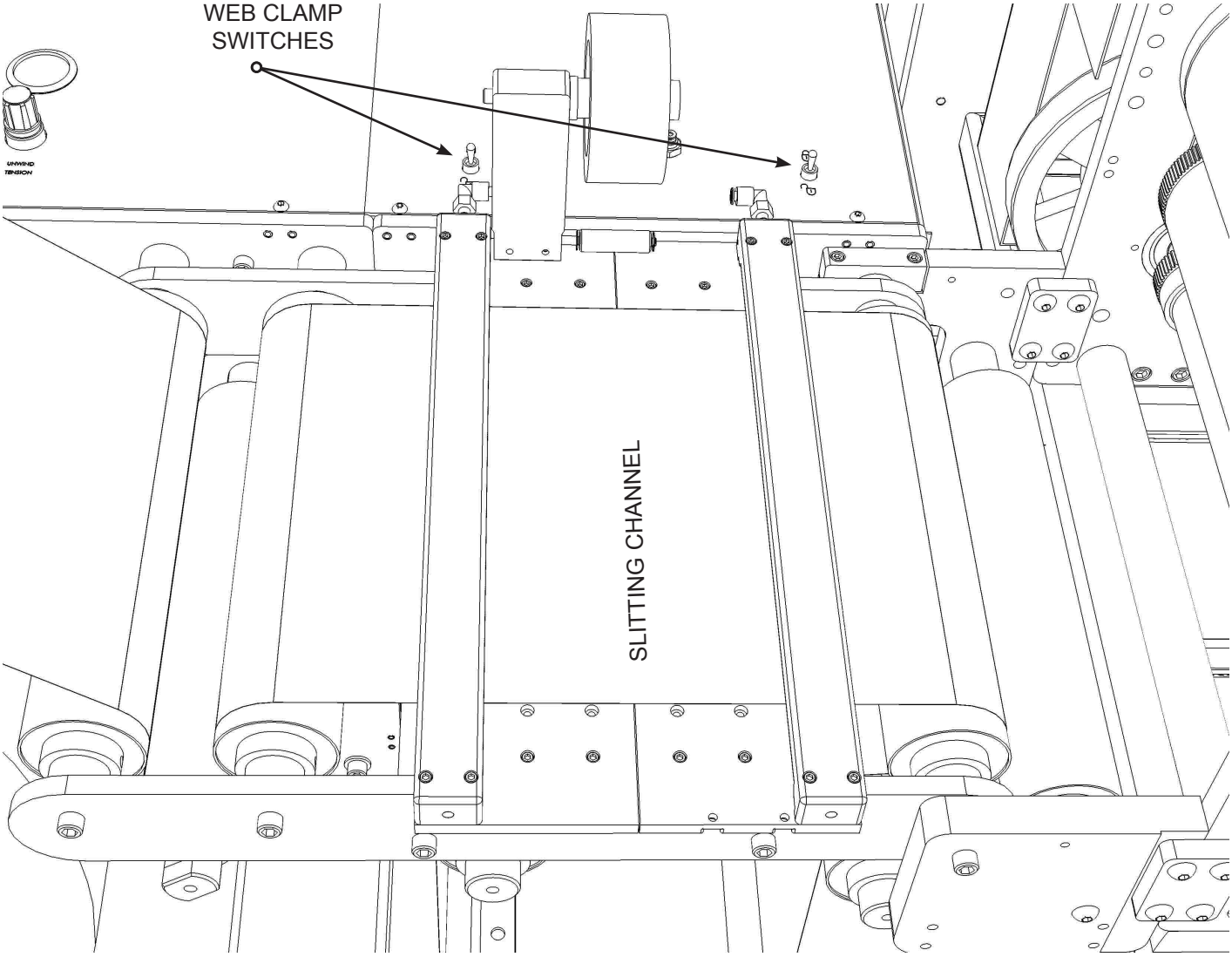
3-3: Nip Roll Operation

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



3-4: Splice Table Operation

The splice table on your 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:



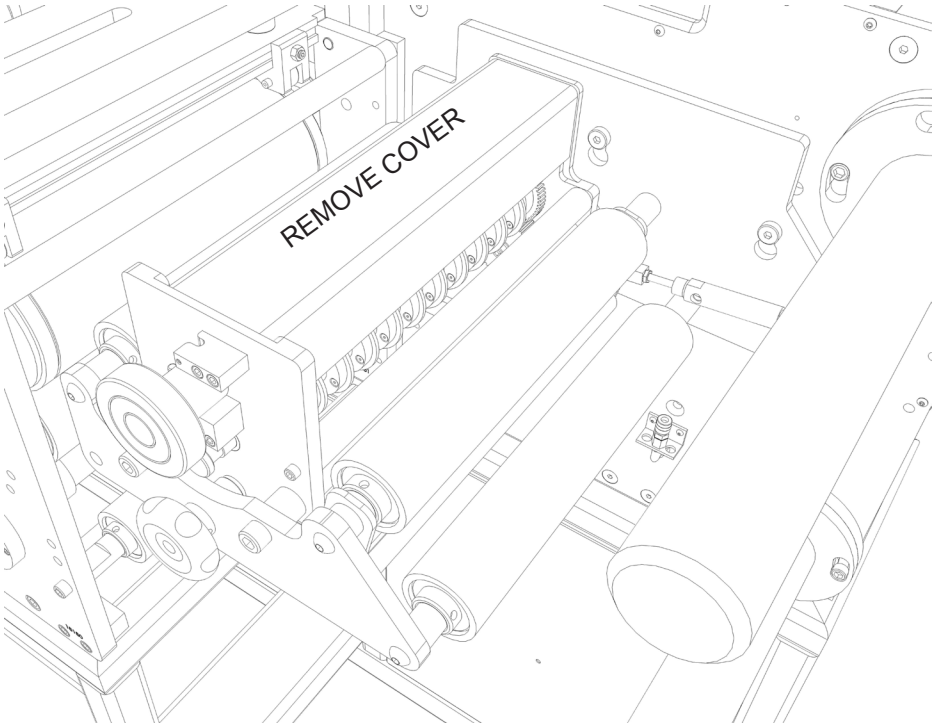
1. Turn off machine and engage both web clamp switches.
2. Using a razor blade, carefully cut the web along the slicing channel. Disengage the clamp nearest the unwind station. Be sure to leave the other clamp engaged.
3. After waste has been removed, pull through new web, carefully align with web, and 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.

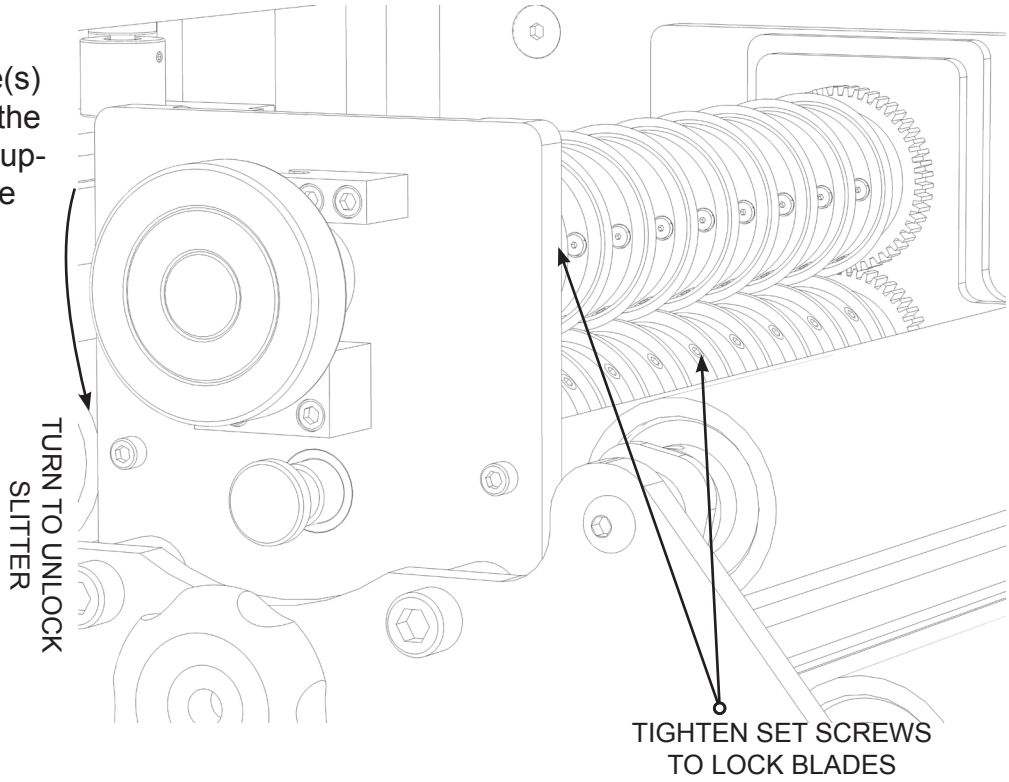
3-5: ROTARY SHEAR SET-UP

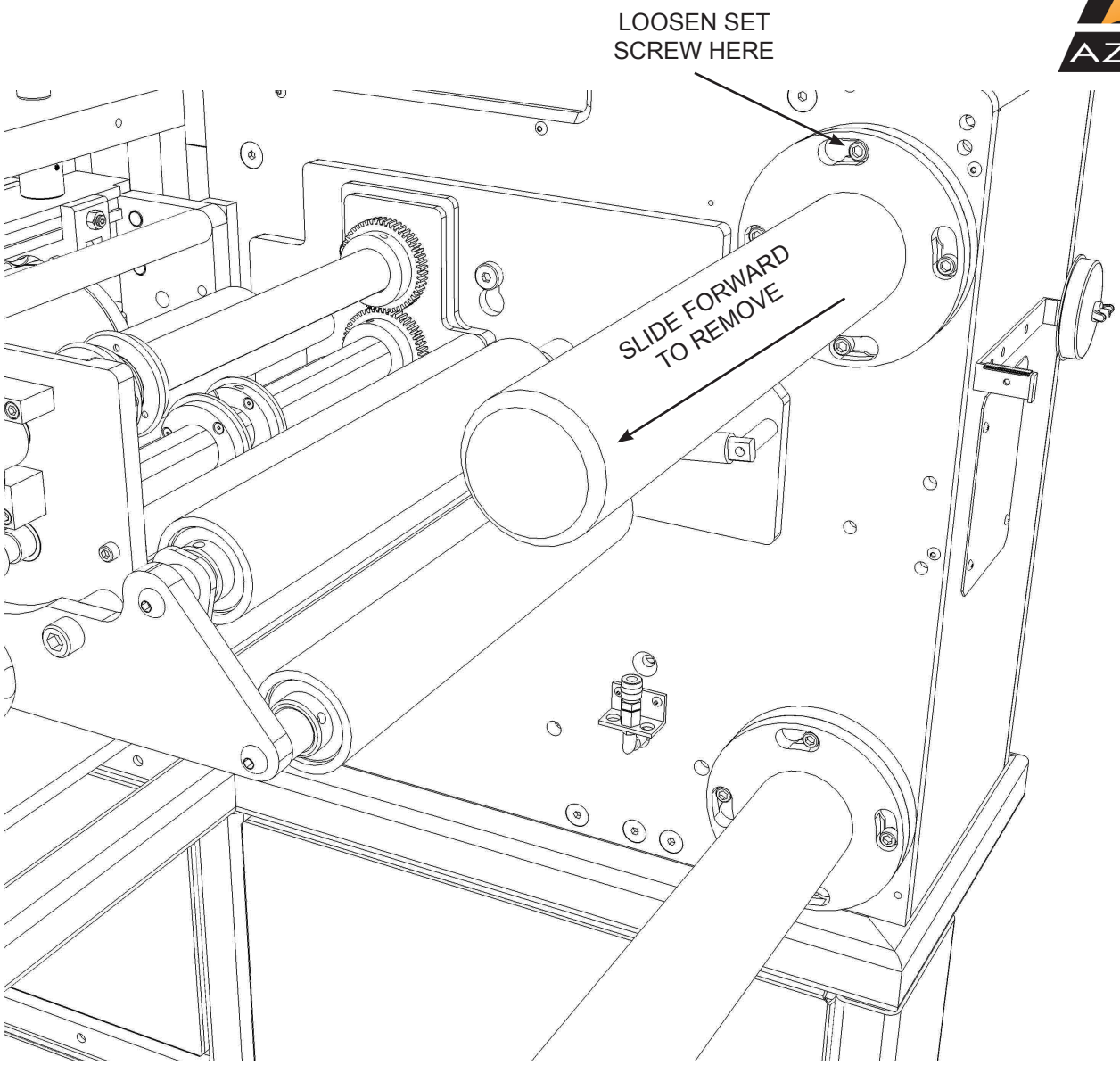
Step 1 Set lower blades for desired Slit-widths and tighten set-screws, making sure upper blades are up and not in lock position.

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.







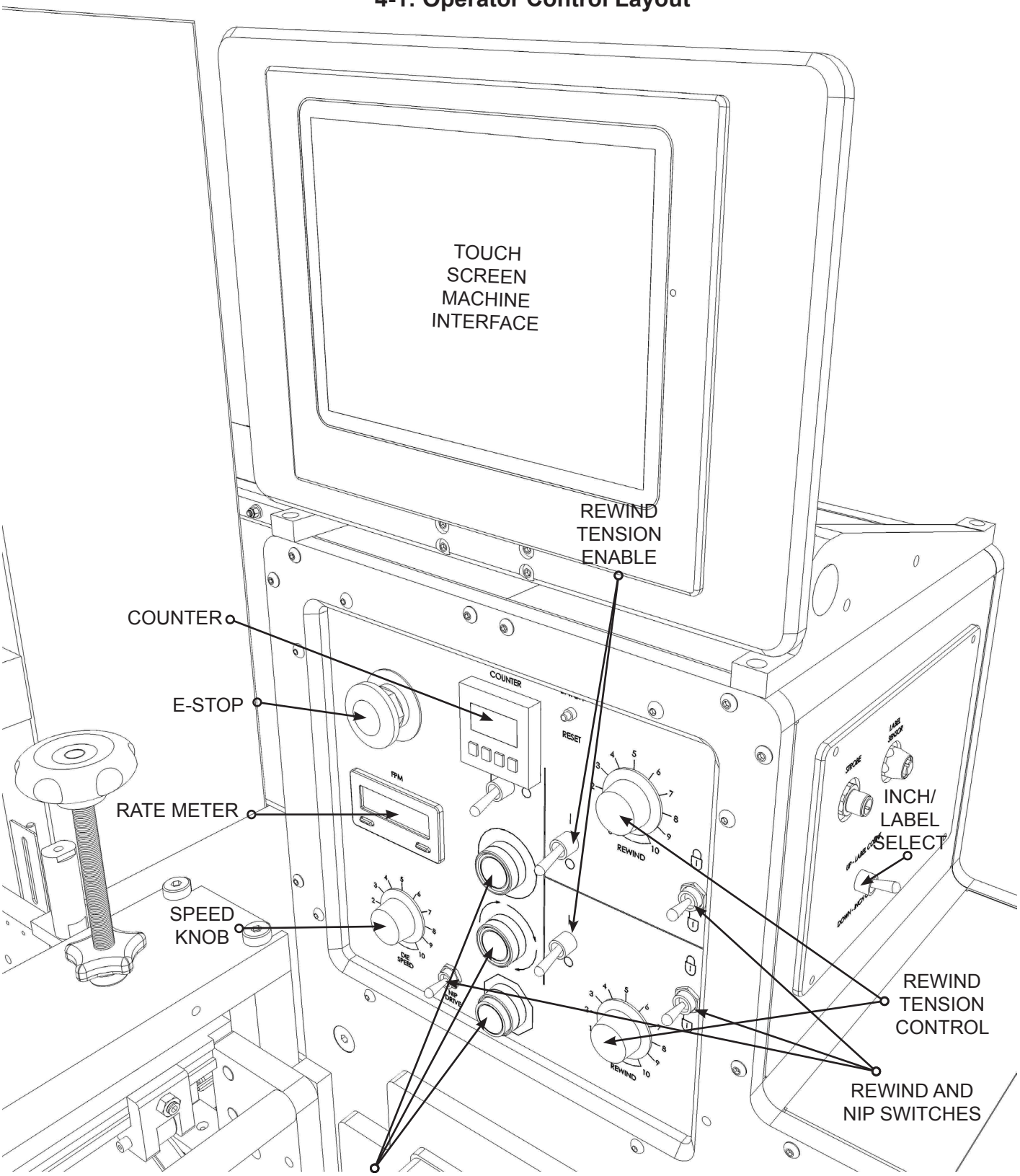
3-6: Changing Rewind Spindle

Your BSR Slitter/Rewind Inspector is equipped with Convertech 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.

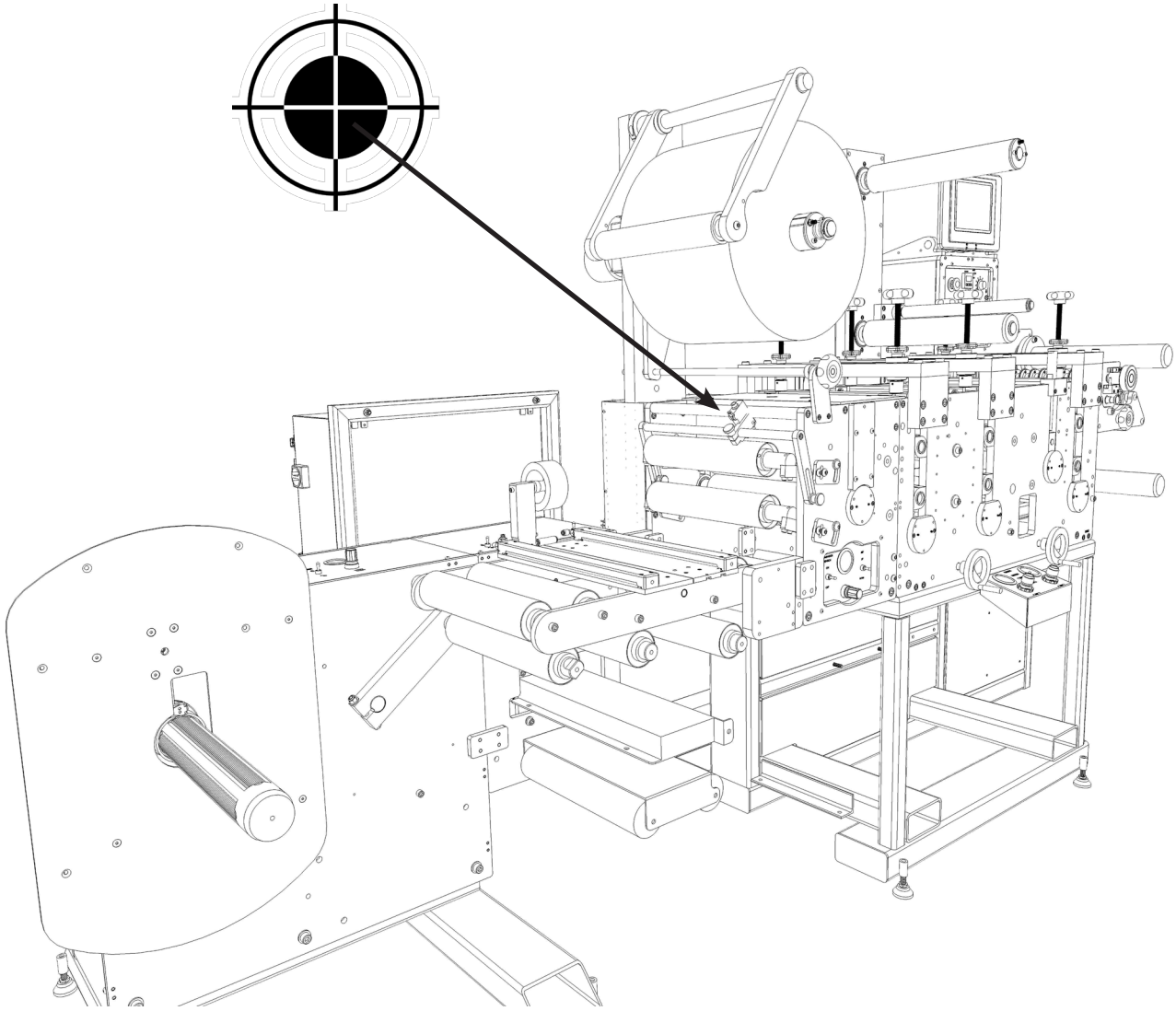
CAUTION: Utilizing Rewind Spindles less than 1.5” in diameter require the use of Outboard Support Apparatus which is NOT included in the standard equipment. Operating the machine without the support apparatus and with spindles less than 1.5” may result in serious injury.

Section 4: Machine Operation

4-1: Operator Control Layout



4-2: Registration Overview



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

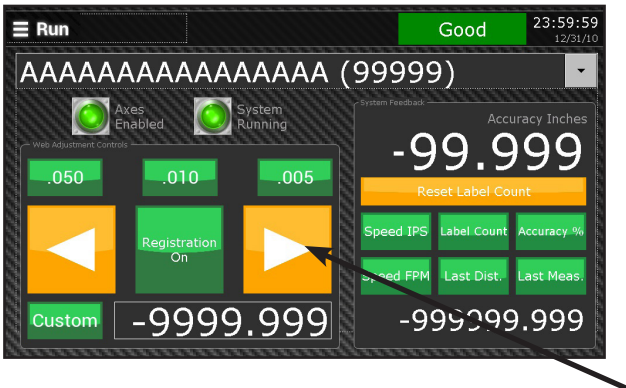
The registration system is controlled by an industrial-PC running an HMI program and controlling mulitple servo-motor controllers within the electrical control cabinet seperate from the main machine.

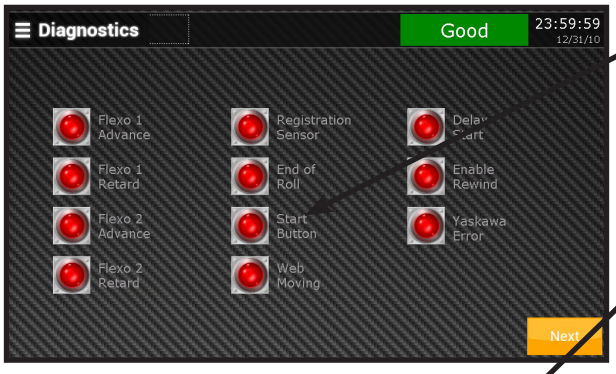
On power-up the PC boots and displays the AZTECH logo. Once it is finished loading, the MAIN MENU screen will be displayed.

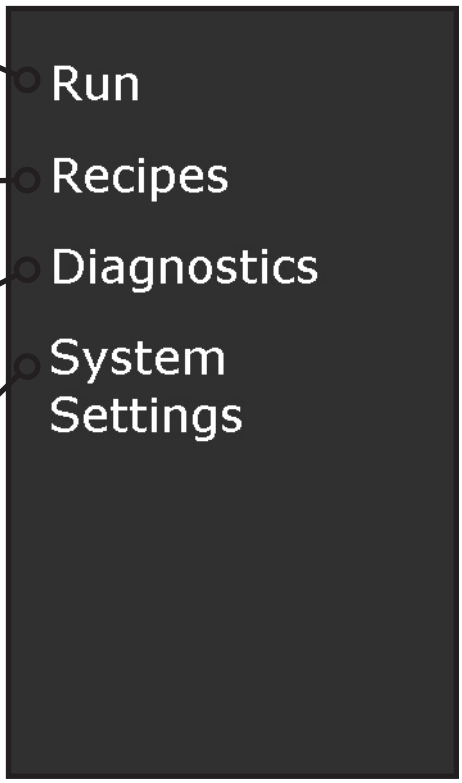
Run Screen

Setting up a job:

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

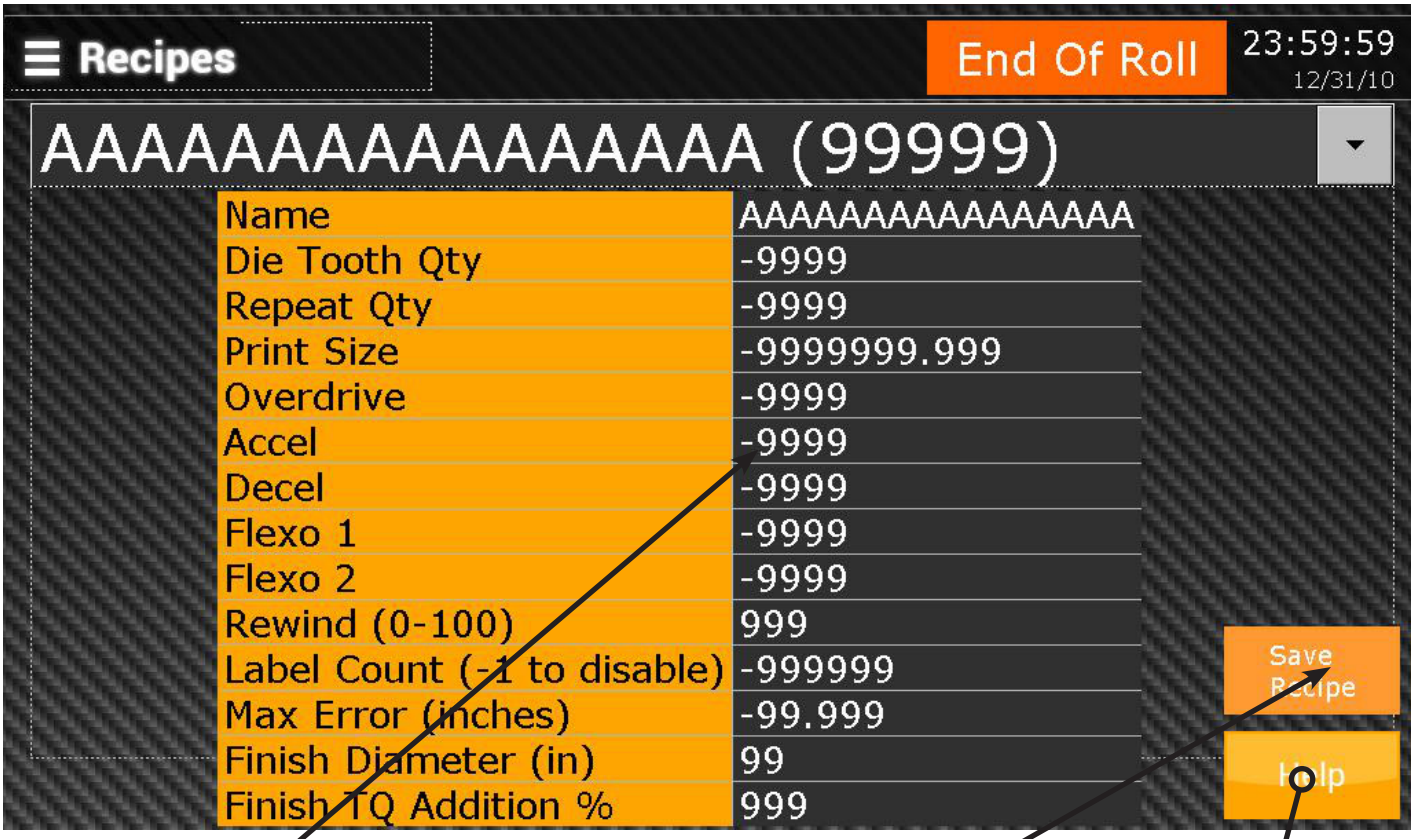






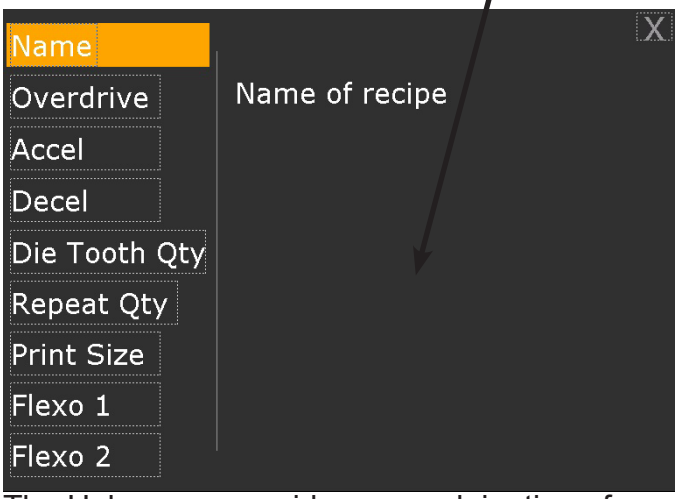
The various HMI menu selection prompts will direct you to the different sub-sections of the HMI.

Recipie Editor



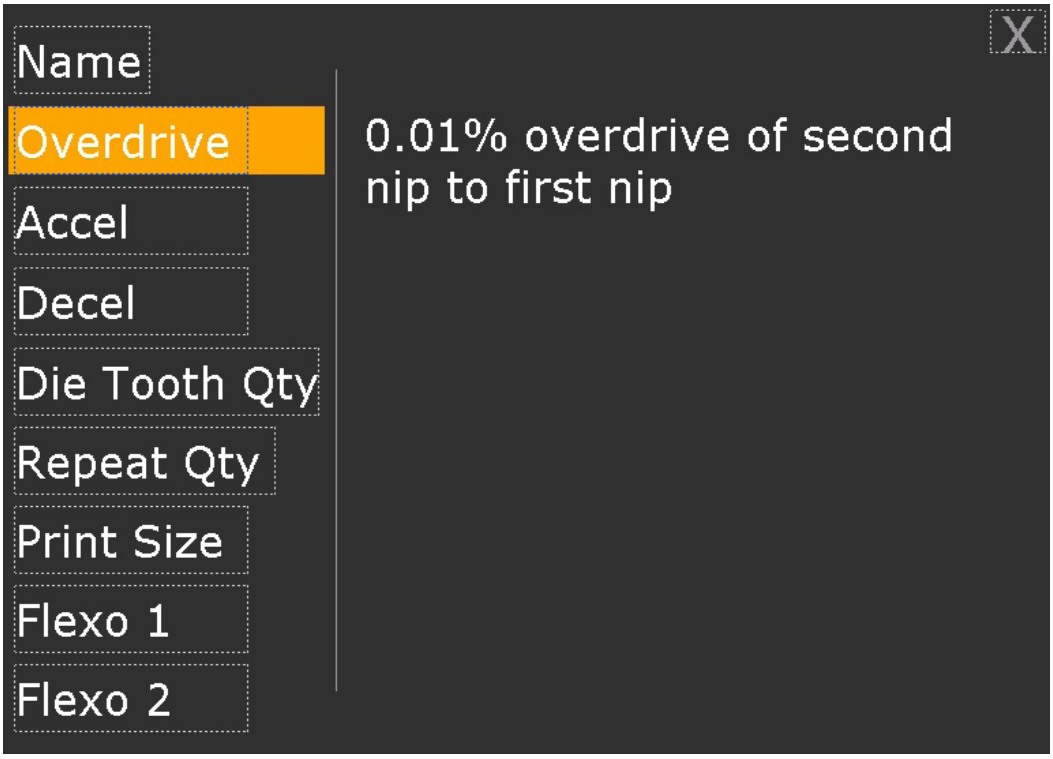
Press value to edit values

Press to save changes.



The Help menu provides an explaination of each recipe value.

Help Menu



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

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

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

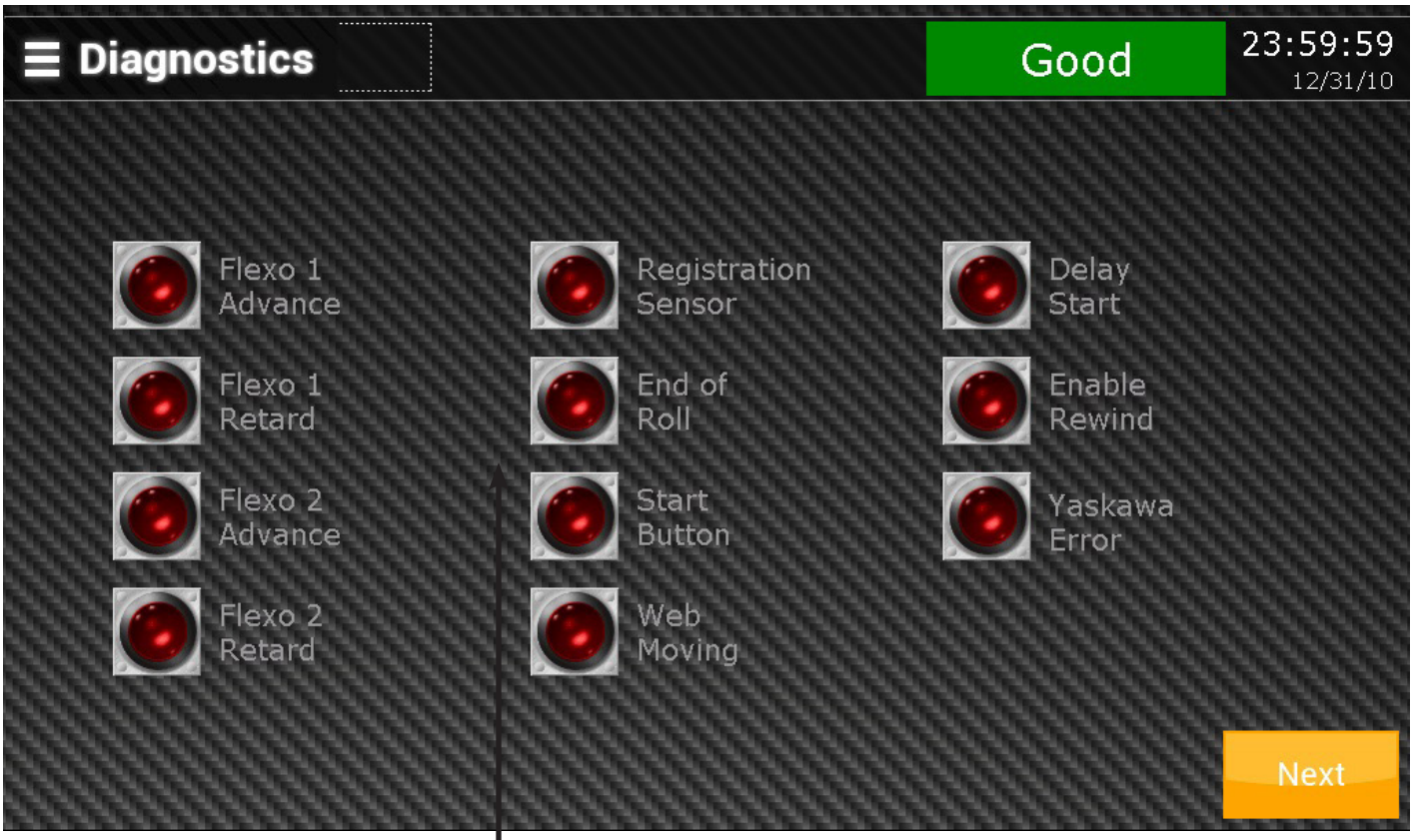
Repeat Qty: The number of repeats in the die

Print Size: The distance from mark to mark in inches

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

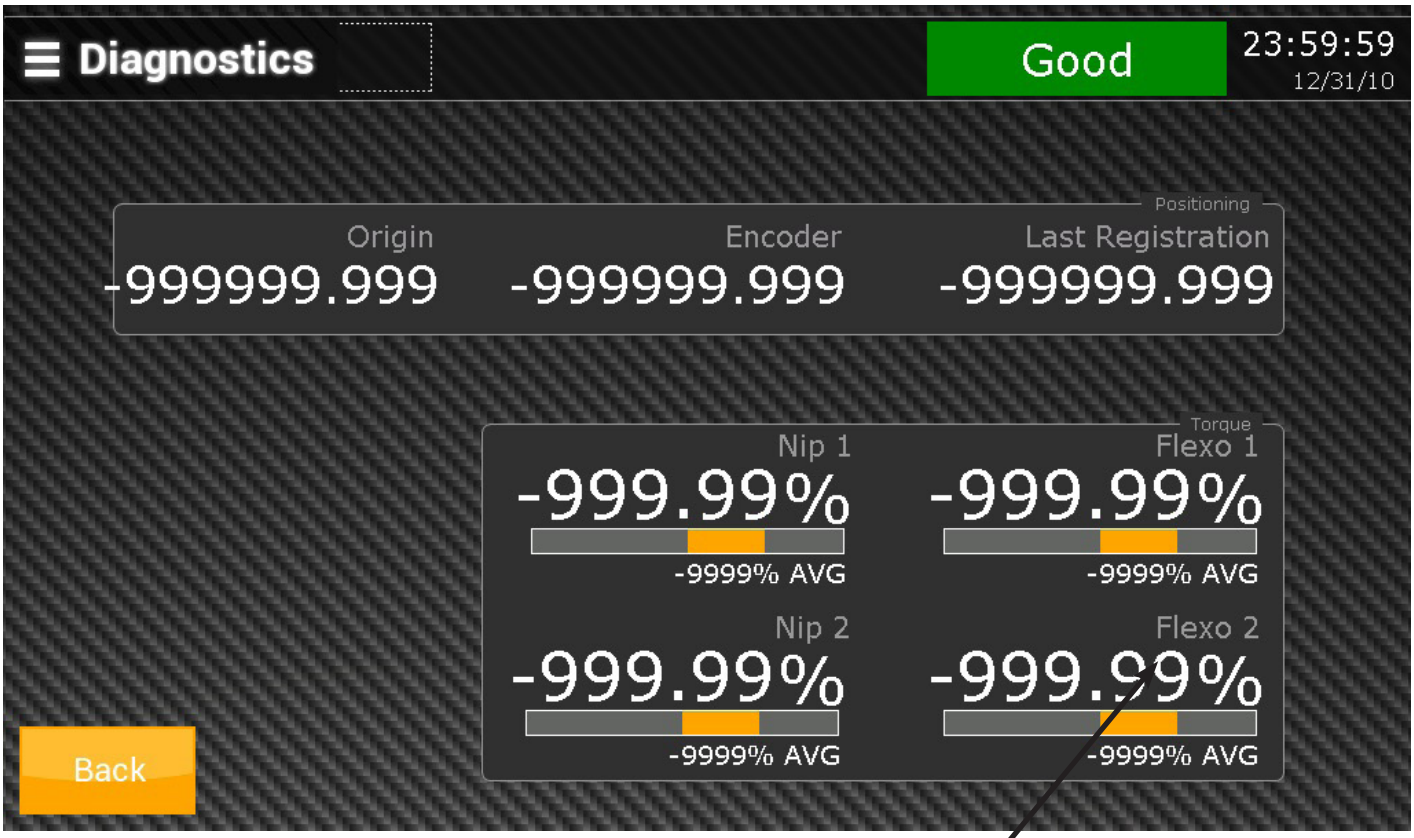
Flexo 2: The percent of overdrive on Flexo 2, 0.01%

Diagnostics, 1



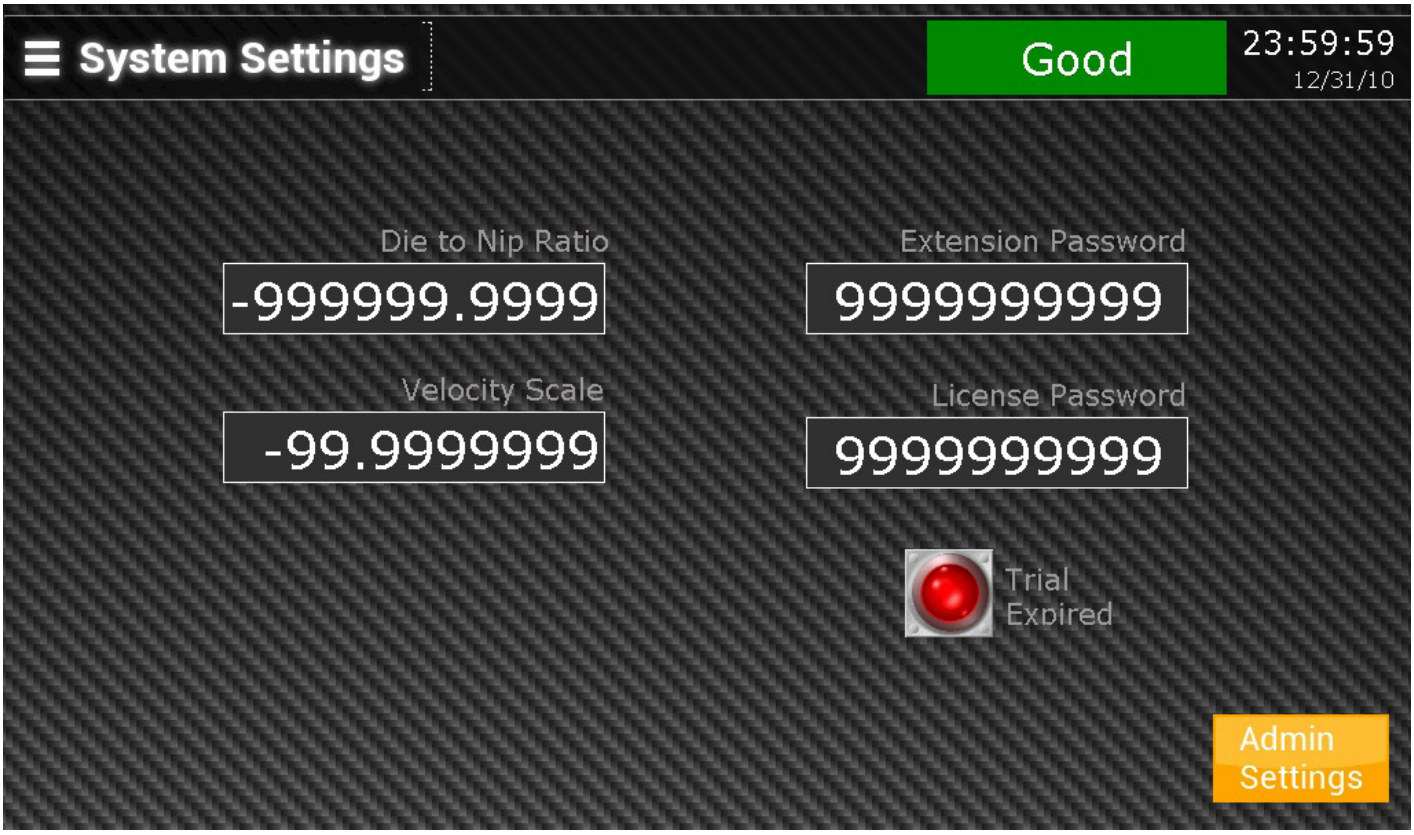
If an error is generated, the explaination is given here.

Diagnostics, 2



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

System Settings

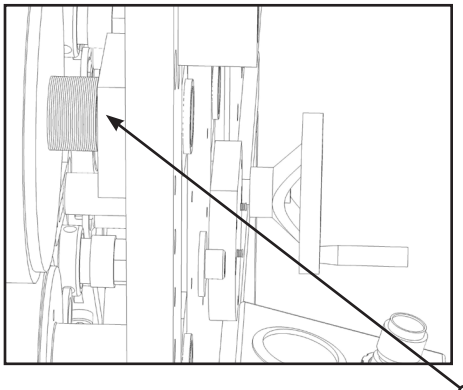


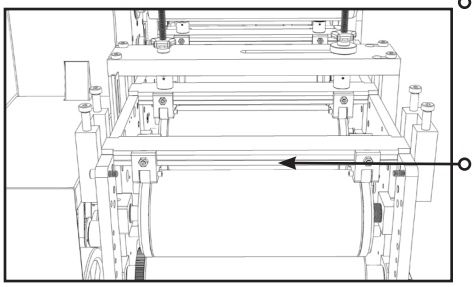
Per terms of delivery, a password is given to liscense the machine. It is entered here.

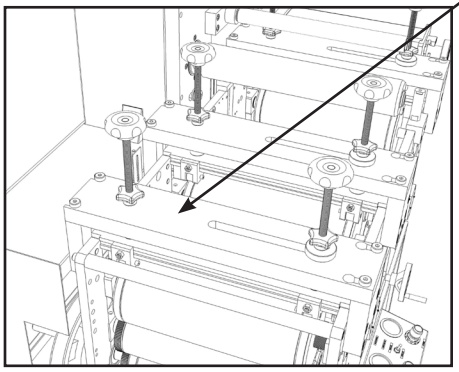
4-3: Mounting Rotary Die(s) in Die Station

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

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







To correctly mount a rotary die:

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

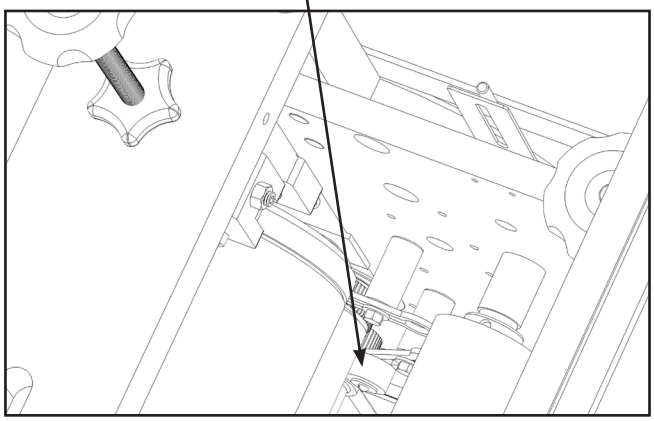
2) Slide square bearing block onto gear side journal and slide die into place. If gears are not aligned properly, remove die, and add or remove washers until aligned.

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

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

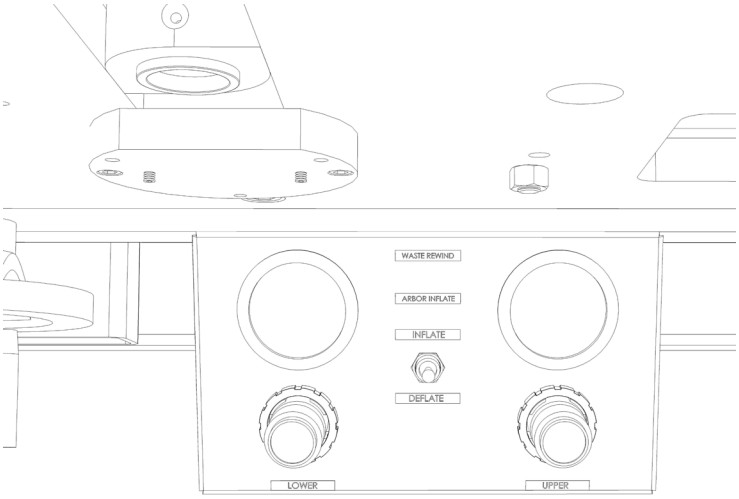
5) Slide die bridge into place, tighten all 4 hex screws, and turn both assist knobs clockwise until snug. Secure die by turning the lock knobs clockwise until tight.

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



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 than 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.

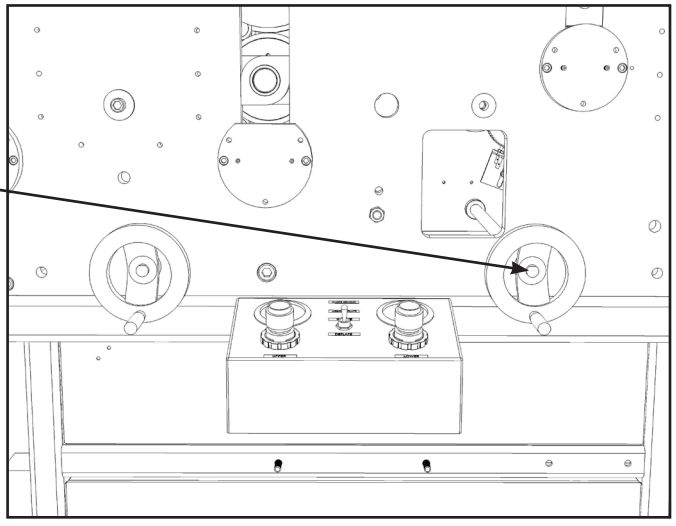
3) Thread the waste by wrapping around the capstan roll, then around the knurled idler roll, before securing to the waste windup spindle.

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

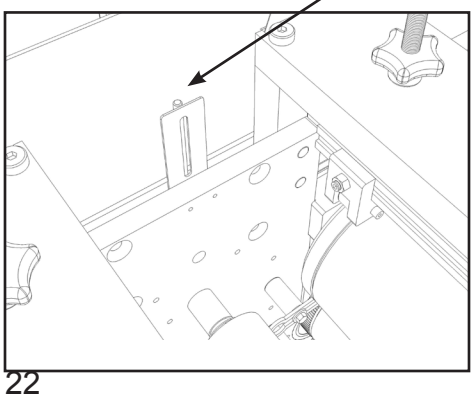
CAUTION: ALWAYS KEEP HANDS OR LOOSE CLOTHING AWAY FROM THE DIE WHEN THE MACHINE IS IN MOTION TO AVOID THE POTENTIAL FOR SERIOUS PERSONAL INJURY.

4-5: Using the Waste-Windup

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.

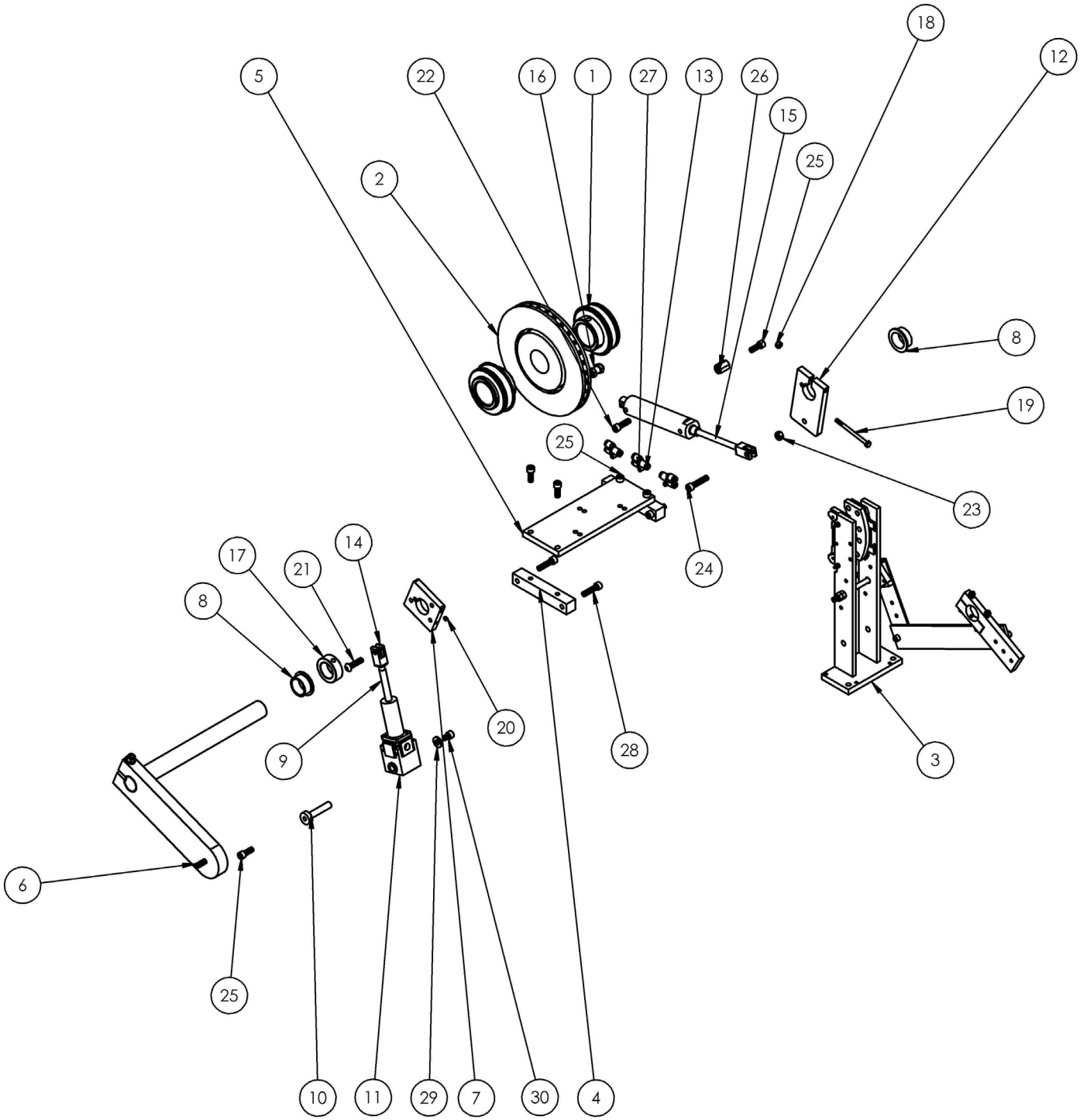
• Clean the web guide sensor to assure that it is free of dust and debris.

• 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.

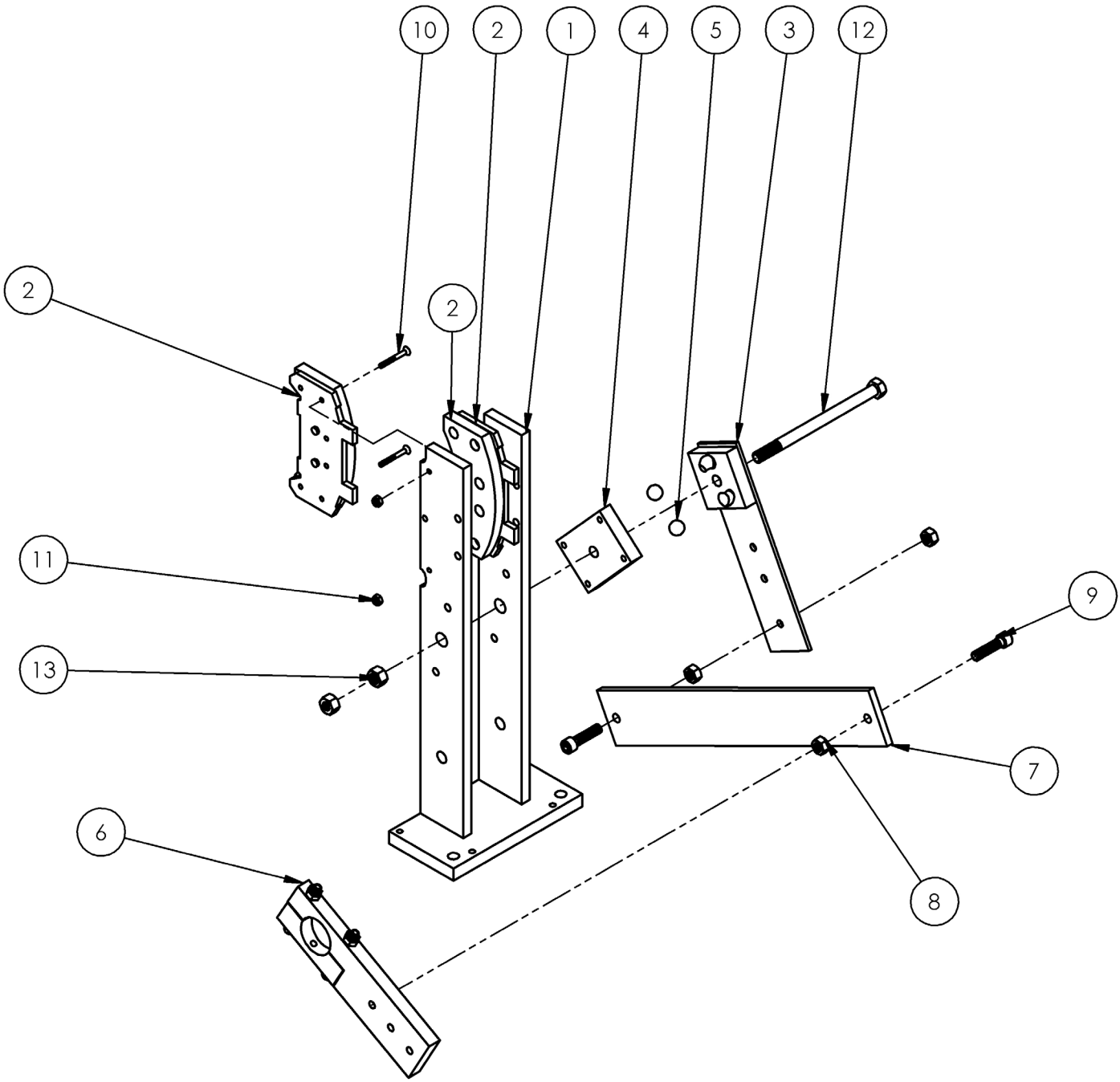
Chapter 6: Station Detail

UDB Assembly



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

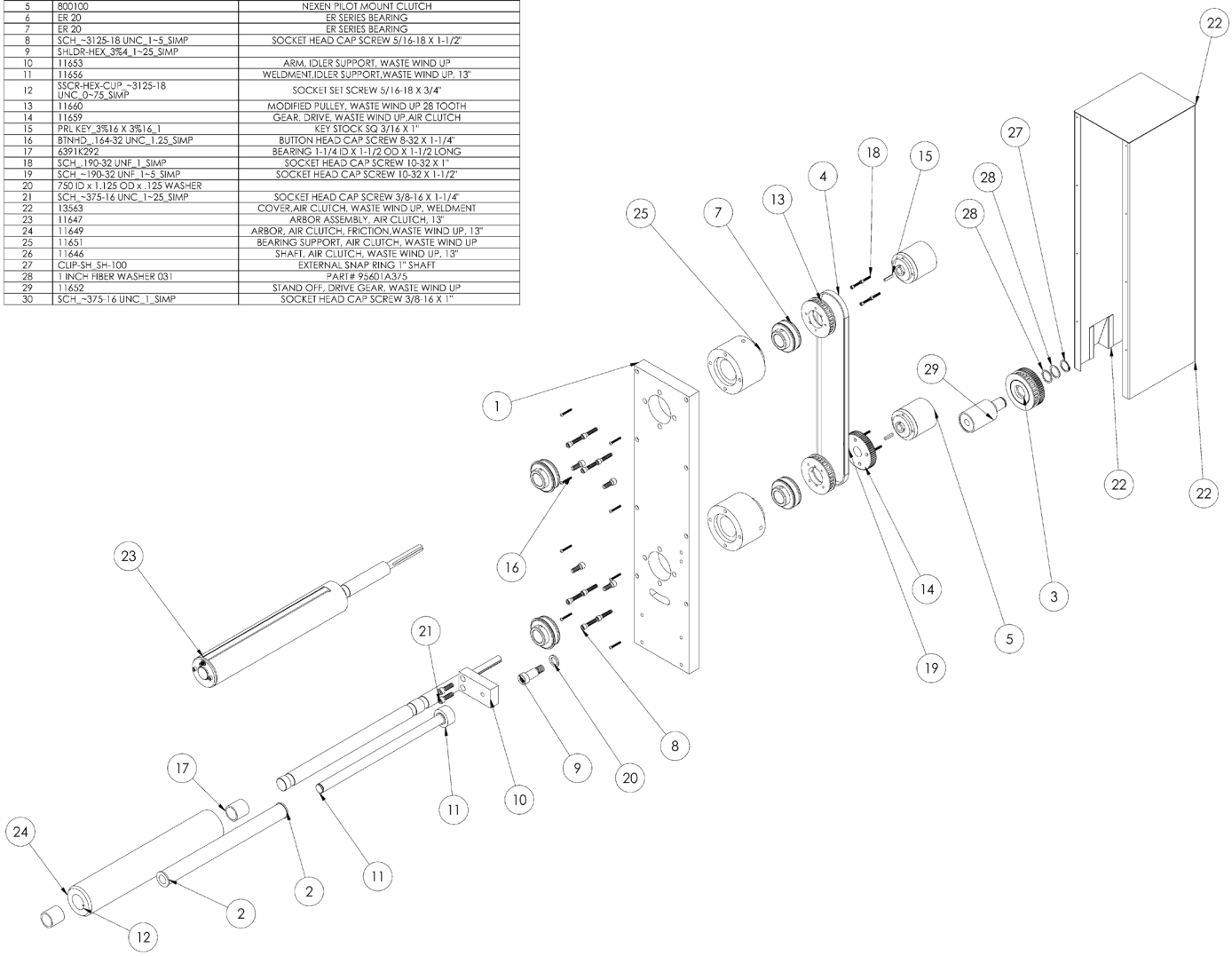
UDB Brake Detail



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

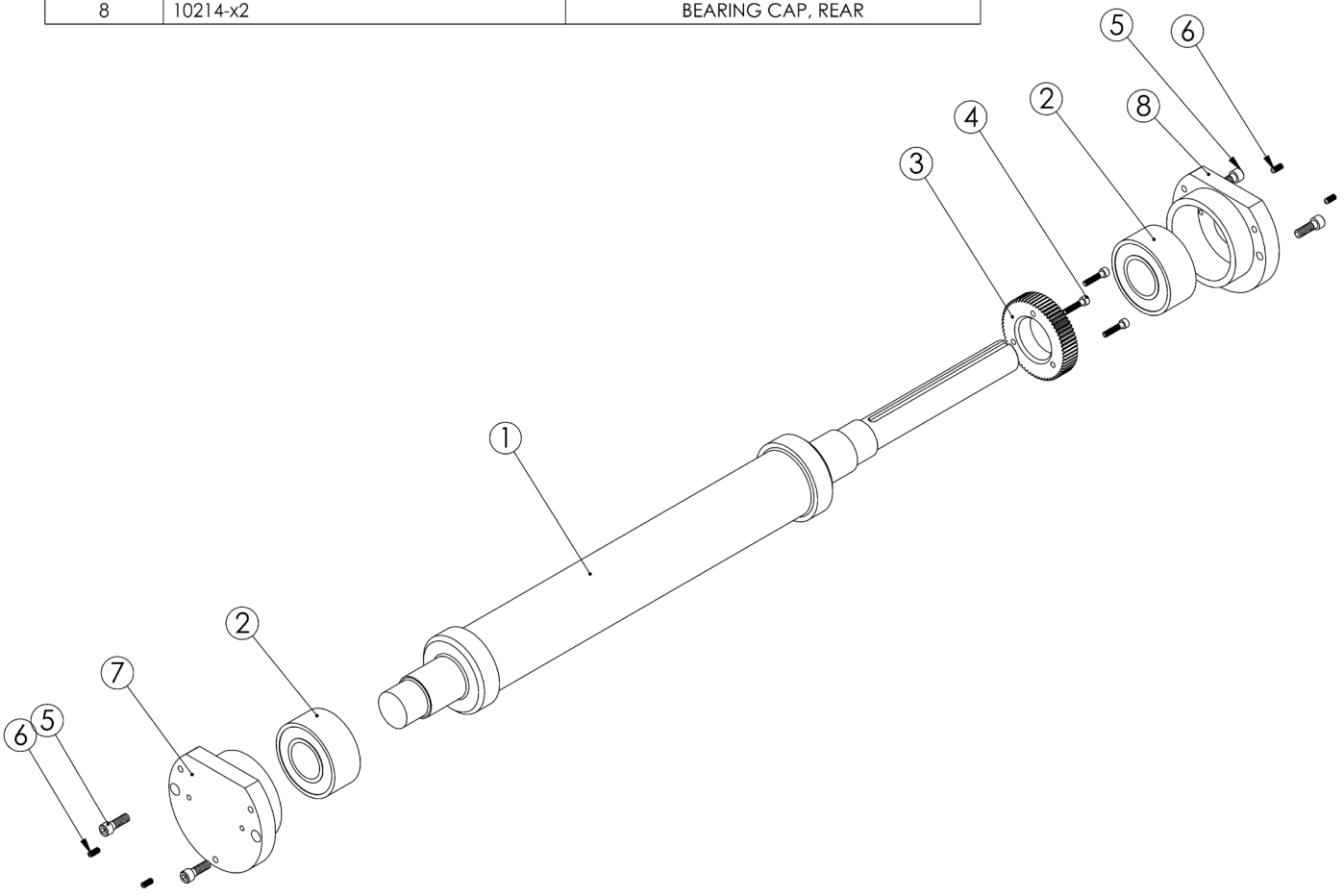
Waste Windup Assembly

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	2L592	BELT, 45", 3/8 PITCH, 1/2" WIDE
5	800100	NEXEN PILOT MOUNT CLUTCH
6	ER 20	ER SERIES BEARING
7	ER 20	ER SERIES BEARING
8	SCH_~3125-18 UNC_1~5_SIMP	SOCKET HEAD CAP SCREW 5/16-18 X 1-1/2"
9	SHLDR-HEX_3%4_1~25_SIMP	
10	11653	ARM, IDLER SUPPORT, WASTE WIND UP
11	11656	WELDMENT,IDLER SUPPORT,WASTE WIND UP, 13"
12	SSCR-HEX-CUP_~3125-18 UNC_0~75_SIMP	SOCKET SET SCREW 5/16-18 X 3/4"
13	11660	MODIFIED PULLEY, WASTE WIND UP 28 TOOTH
14	11659	GEAR, DRIVE, WASTE WIND UP,AIR CLUTCH
15	PRL KEY_3%16 X 3%16_1	KEY STOCK SQ 3/16 X 1"
16	BTNHD_164-32 UNC_1.25_SIMP	BUTTON HEAD CAP SCREW 8-32 X 1-1/4"
17	6391K292	BEARING 1-1/4 ID X 1-1/2 OD X 1-1/2 LONG
18	SCH_~190-32 UNF_1_SIMP	SOCKET HEAD CAP SCREW 10-32 X 1"
19	SCH_~190-32 UNF_1~5_SIMP	SOCKET HEAD CAP SCREW 10-32 X 1-1/2"
20	750 ID x 1.125 OD x .125 WASHER	
21	SCH_~375-16 UNC_1~25_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1-1/4"
22	13563	COVER,AIR CLUTCH, WASTE WIND UP, WELDMENT
23	11647	ARBOR ASSEMBLY, AIR CLUTCH, 13"
24	11649	ARBOR, AIR CLUTCH, FRICTION,WASTE WIND UP, 13"
25	11651	BEARING SUPPORT, AIR CLUTCH, WASTE WIND UP
26	11646	SHAFT, AIR CLUTCH, WASTE WIND UP, 13"
27	CLIP-SH_SH-100	EXTERNAL SNAP RING 1" SHAFT
28	1 INCH FIBER WASHER 031	PART# 95601A375
29	11652	STAND OFF, DRIVE GEAR, WASTE WIND UP
30	SCH_~375-16 UNC_1_SIMP	SOCKET HEAD CAP SCREW 3/8-16 X 1"



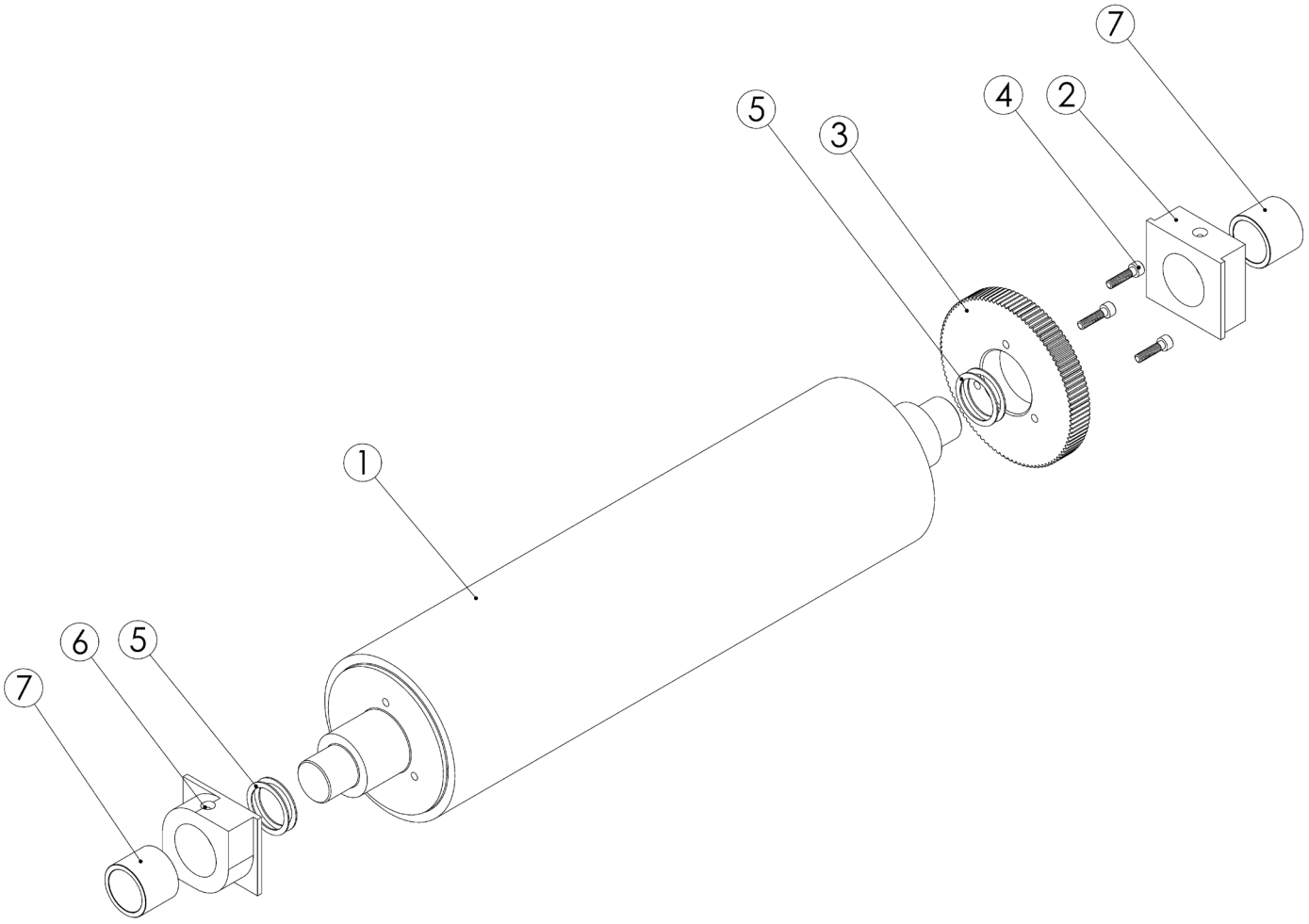
Rotary Die Station: Support Roll Assembly

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



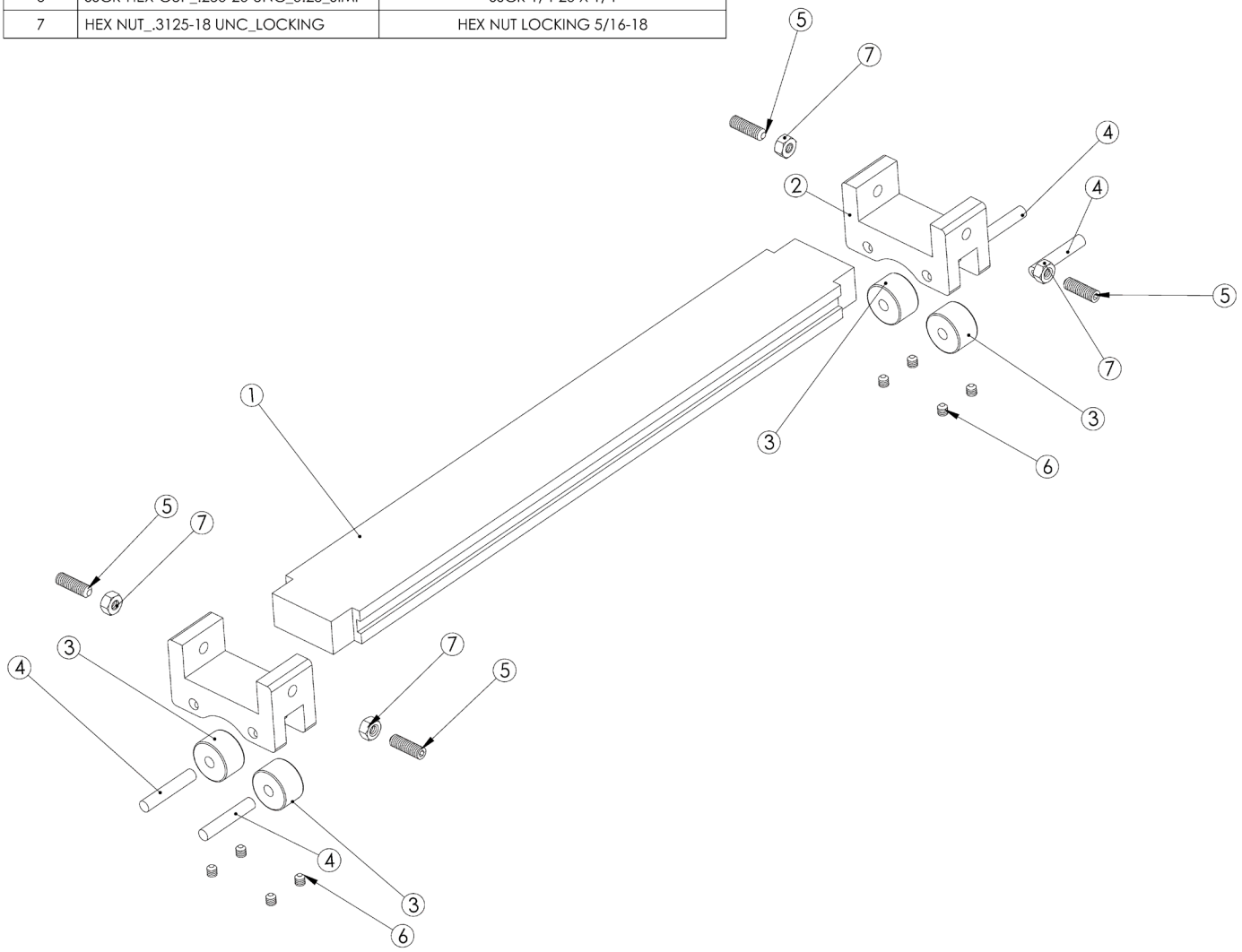
Rotary Die Station: Anvil Roll Assembly

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



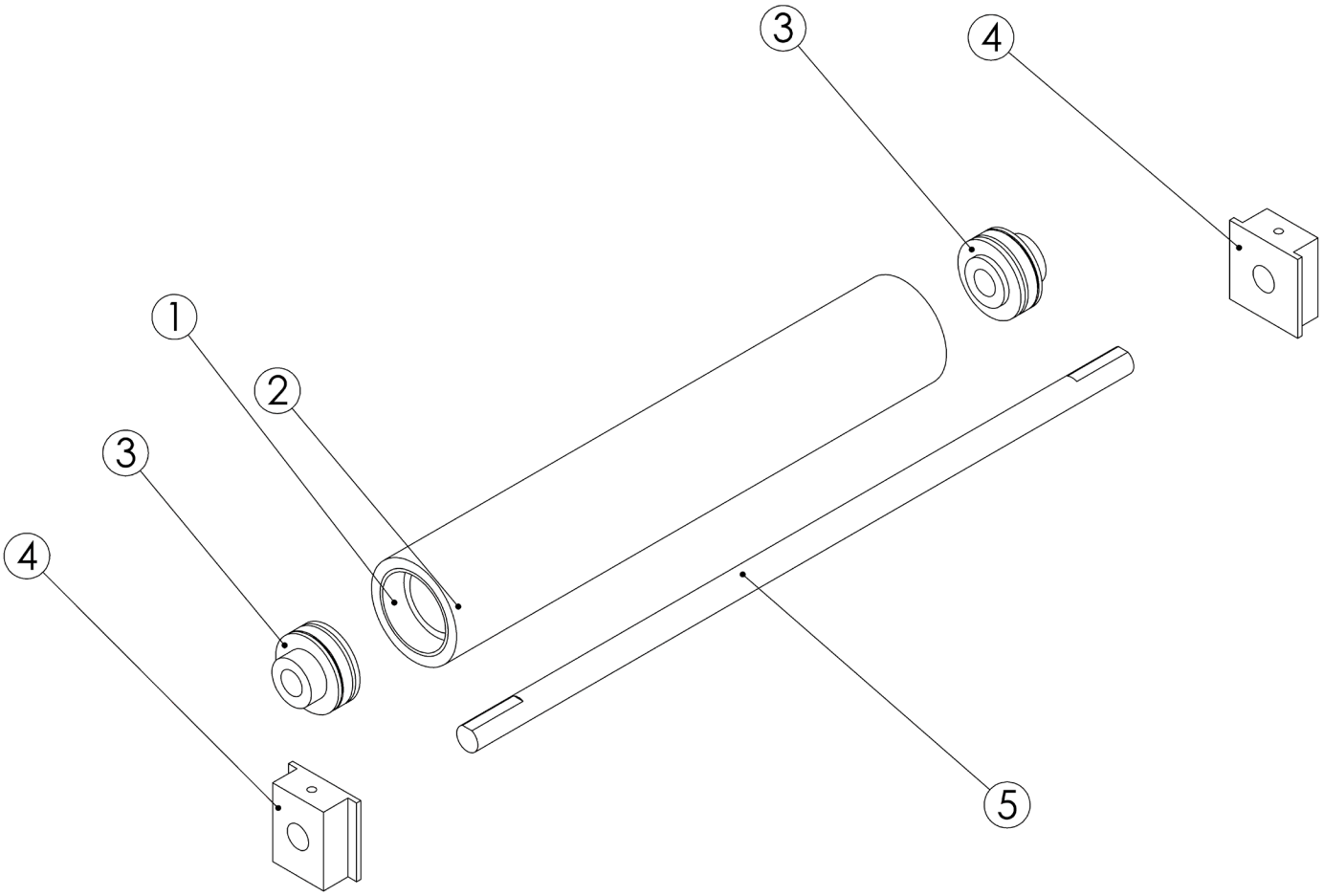
Rotary Die Station: Die Truck Assembly

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



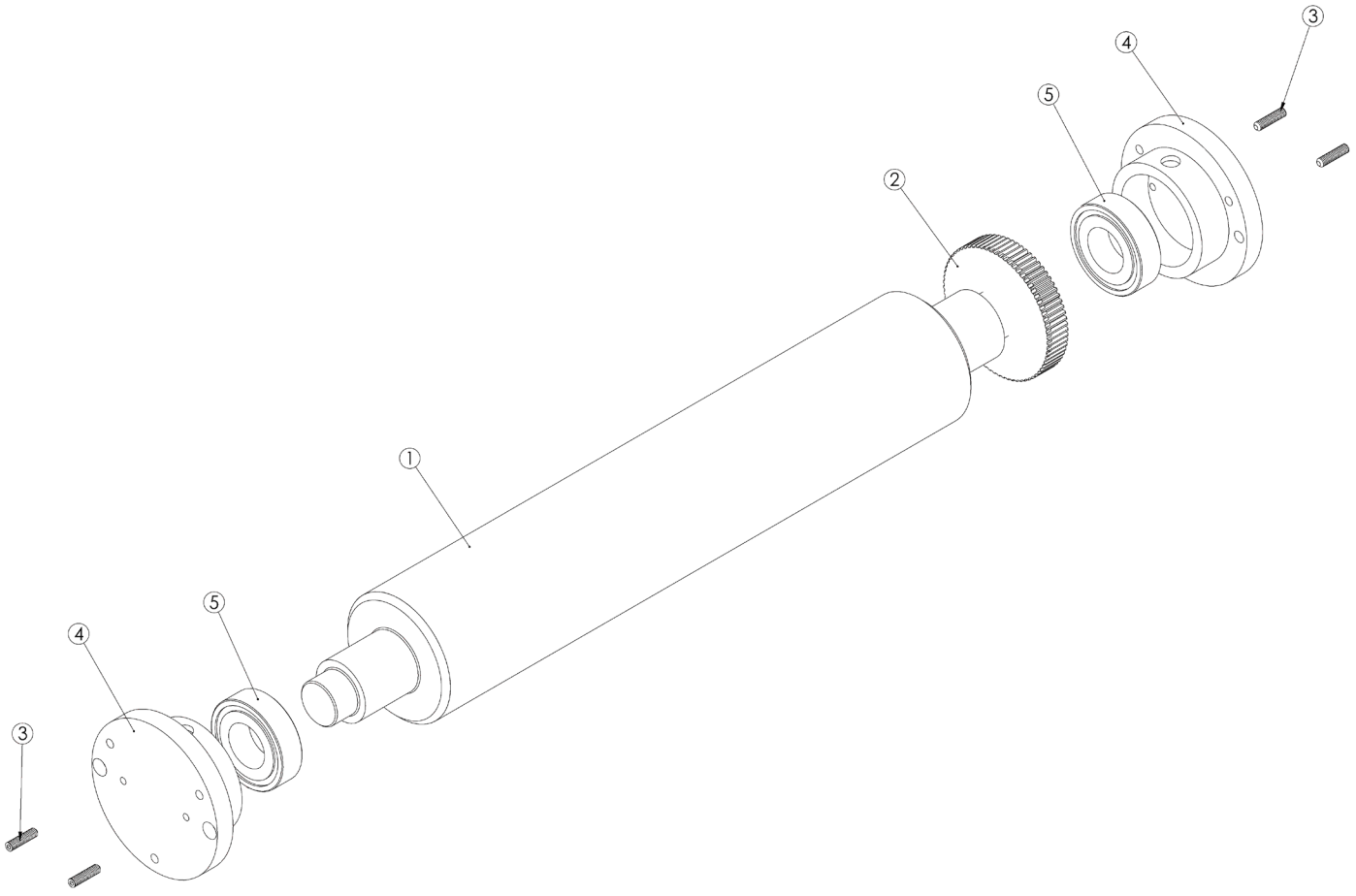
Main Drive: Nip Roll Assembly

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



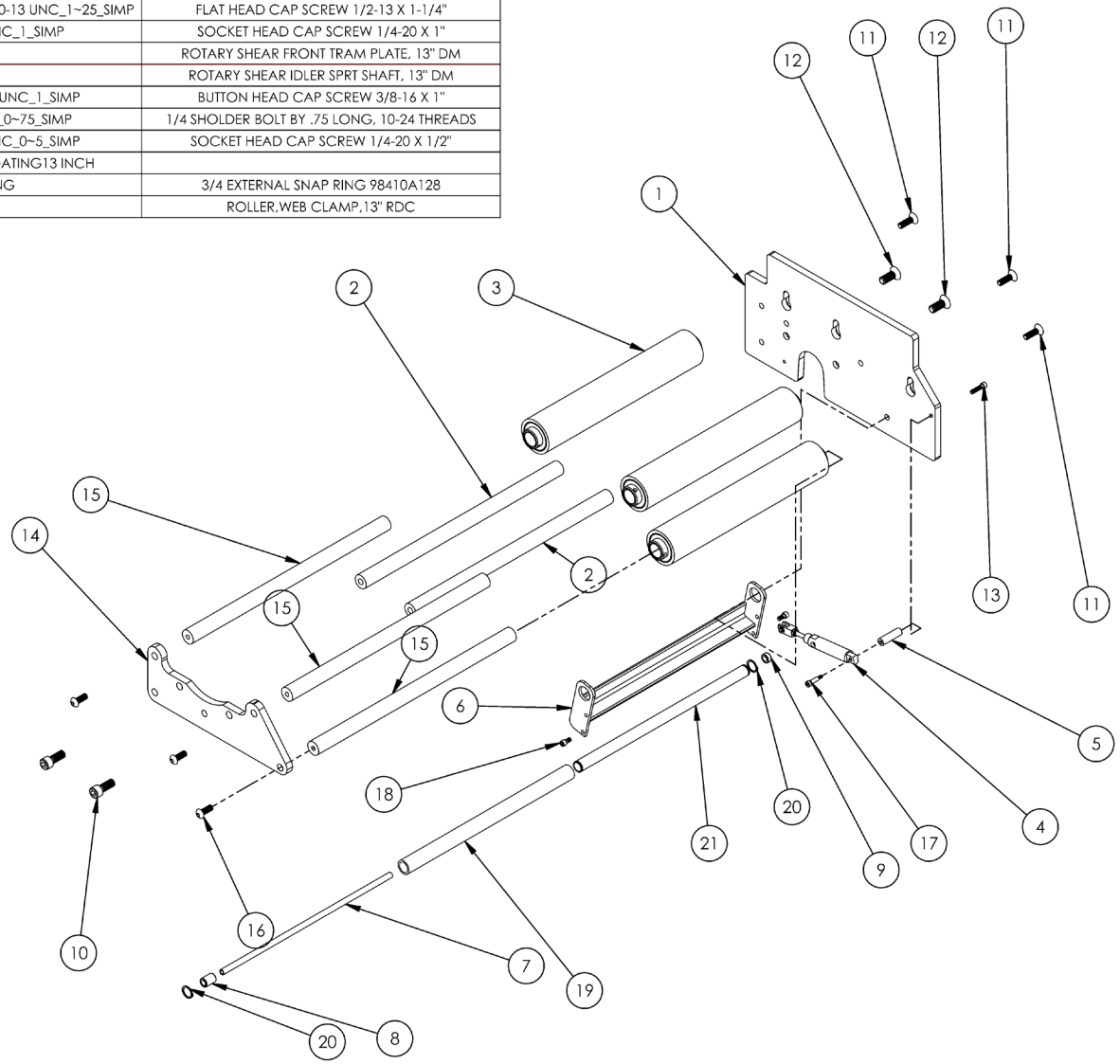
Main Drive: Pace Roll Assembly

ITEM NO.	PART NUMBER	DESCRIPTION
1	10217	PACE ROLLER, 13" WEB
2	10155	GEAR, 72 TOOTH, 1/8" PITCH
3	SSCR-HEX-CUP_.190-32 UNF_0.75_SIMP	SOCKET SET SCREW 10-32 X 3/4"
4	11046	BEARING CAP, PACE ROLLER, REREGISTRATION
5	1641	1" ID X 2" OD X .563 WIDE BEARING



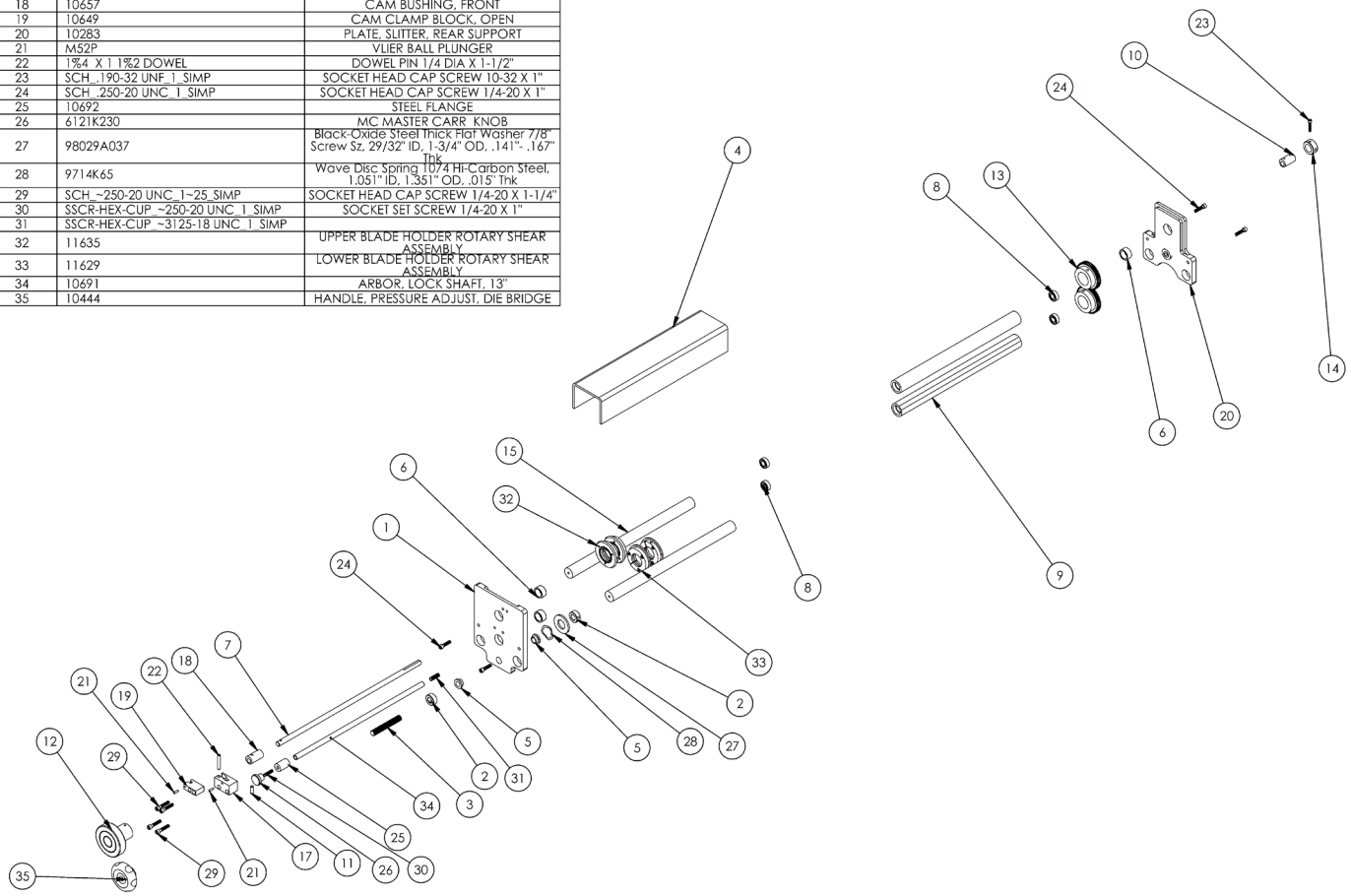
Slitting Station: Main Assembly

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



Slitting Station: Rotary Shear Assembly

ITEM NO.	PART NUMBER	DESCRIPTION
1	10285	PLATE, SLITTER, FRONT MOUNT
2	1HALF COLLAR	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	VLIER 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" Thk
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	
32	11635	UPPER BLADE HOLDER ROTARY SHEAR ASSEMBLY
33	11629	LOWER BLADE HOLDER ROTARY SHEAR ASSEMBLY
34	10691	ARBOR, LOCK SHAFT, 13"
35	10444	HANDLE, PRESSURE ADJUST, DIE BRIDGE



Section 7: Troubleshooting

7-1: Why doesn't the machine turn on?
First check to make sure that the main power switch on the back electrical panel is turned on. Then make sure that the emergency stop button on control panel is disengaged.

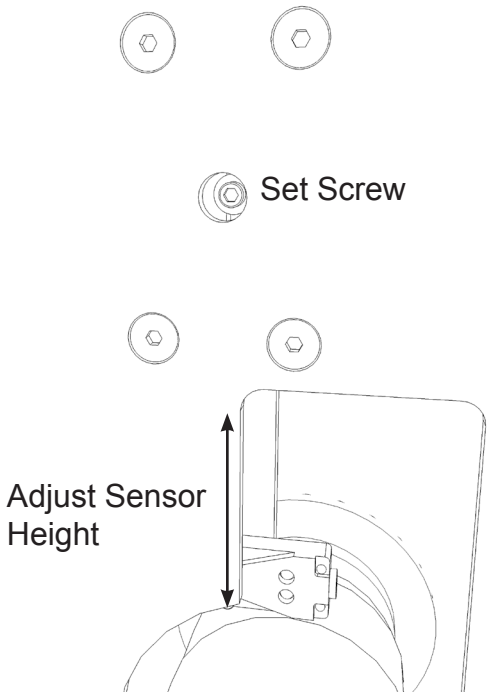
7-2: The counter is not counting accurately.
Inspect and clean both counter sensors located in the machine on the gear underneath the pace roller.

7-3: Why is the counter not counting inches?
Make sure that the counter sensor below the web guide is flashing red which assures that it is properly connected to the machine. Be sure that the setting on the PLC is "Distance".

7-4: Why is the counter not counting labels?
If your machine is equipped with the optional label counter and is not doing so, after assuring that the counter sensor below the web guide is flashing red which assures that it is properly connected, assure that the PLC is set to "LABELS".

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



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**