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The Powerline cutter is designed to provide years of service with normal maintenance. The unit should be serviced once every sixty days.

PAPER DUST

Because of the electronics, the unit needs to be cleaned of dust and other debris at least once every 60 days. The areas of concern are the home flag sensor and encoder system. It is not intended that these spots need to physically be cleaned, although it is a good idea to use a can of compressed air to blow them out. **It is important that the position of the machines encoder sensor board and home flag sensor not be disturbed. Their positioning is precise, and crucial to the machines function. The smallest of movement of these items could be outside the boundaries of what is needed to operate. Moving these, or getting lubricant inside the sensor during lubrication is the most common mistake made in the field.**

Make sure that power to the unit is locked out before removing the front cover. The front deck is removed using a Phillips-head screw driver and set of standard Allen wrenches. Use a shop vacuum to clean electronic components (relays, transformer, etc.) See the reference diagram on the next page. **NOTE: Be careful to not hit the components with the end of the vacuum hose.**

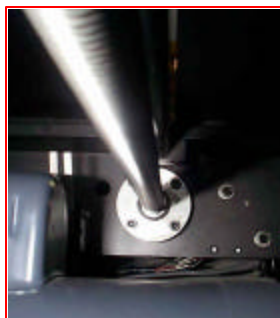


Powerline electrical system, front deck removed

LUBRICATION

Lubrication is of essential importance in realizing the life of the cutter. Systems that need maintained on a regular basis:

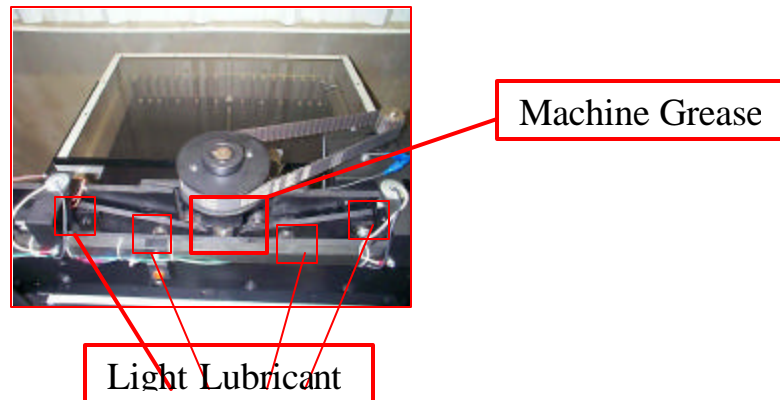
1. The **Back-gauge worm screw** should be lubricated every 60 days with a non-residue lubricant. Remember, the more lubricant residue that builds up on the worm screw, the greater the possibility that lubricant will get into the home flag sensor at the back of the cutting deck. This would result in an error “11-19” by the machine thinking that it is in “HOME” position constantly. (Permanent return signal of ‘1’ to the main logic board, test 4.)



2. The **clamp worm screw** is underneath the top shroud. This is removed by taking out (4) thumb knobs and then lifting the cover of the blade/clamp assembly. This is best done by two people. NOTE: When reinstalling the top cover, **be careful the display and**

keyboard cables don't get damaged. They protrude slightly on the top right corner of the upper frame. If damaged (pinched/broken) they could cause anything from a garbled/frozen display to an inability to take the machine into diagnostics or get any type of keyboard control.

Lubricate the clamp screw with machine grease for smooth operation. Also, apply light oil to all bushings in the clamp assembly (clamp levers, bushings, eccentric bushing on right clamp assembly and clamp link arms). The belt and drive pulley used at the top of the assembly should provide years of trouble free maintenance, A light lubricant under the pulley is all that is required.



Once every 60 days, grease the **blade carriage gibs** with a heavy machine grease. These are the plates that guide up and down motion of the blade.

ADDITIONAL BACKGUAGE COMPONENTS

From time to time (every 90 days) perform a mechanical check of the back-guage. Verify that the retaining ring and bearing are still side by side, and that there has been no movement. Also, on the rear frame, check the condition of the rubber shock grommet that provides impact absorption for the worm screw. It should be intact in the back side of the unit and there should be no more than 1/32" gap between the upper rim of the grommet and the rim of the metal cutout it is in. If the part compresses with age, it

could cause the backgauge worm screw to come out of parallel with its upper support shaft. This strain on the worm screw could cause the stepper motor to stall.

ELECTRICAL

Once every six months check the power cord to the machine for frays and pinches. Also, check the wall outlet for proper voltage (220-240 VAC). The breaker(s) for the machine should be at total rating of 20 Amperes.

BLADE CHANGE

A blade change should be performed on the unit once for every 8 hours of cutting time. Follow the directions below to remove and reinstall.

Needed for blade removal/installation: Allen wrench, two-blade change handles (both included in unit's accessory pack).

REMOVAL

1. Power machine up. Lower blade to the down position. Power down unit.
2. Completely remove the Allen screw on the far right (1/4").



NOTE: If screw is only loosened and blade is returned to upper position, it will get jammed in blade/clamp assembly. This could cause extensive damage to the trunnion.



3. Power unit back up and return blade to the upper position.
4. Remove Allen screws installed in slotted holes. Once these are removed, install the two blade change handles into the empty screw holes. Firmly tighten.

NOTE: Do not try to change out the blade without changing handles. Once each handle is securely installed, remove the two remaining Allens.

5. Slowly turn the handles until the blade begins to release. Once the blade is completely released from the housing it can be removed and set to an area free from traffic. The blade can chip very easily, so be careful to not hit the machine.
6. To install a fresh blade, reverse the above steps *. You should rotate the cutting stick of the unit after you install the new blade. Failure to rotate the stick can cause cutting difficulties. ***Make sure when reinstalling the blade that you get it completely and squarely into the carriage.**
7. Squareness of blade is controlled by making sure that it is completely and fully installed into the carriage. After installing a fresh blade, it may be necessary to make a depth adjustment in the Allen slot on the right side of the unit. Some experimentation may be necessary. The blade should go into the surface of the cutting stick 1/32”.

***Once blade change is complete, test the unit for accuracy.**