"XY" MATIC TRIM

1650

Revision

REVISION	DATE	NOTES	VERSION
01	18/02/2008	First edition	NLT-GB.Q895-01-03/2008
02	06/06/2008	Second edition	NLT-GB.Q895-02-06/2008
03	01/11/2010	Third Edition	NLT-GB.Q895-03-11/2010
04	22/06/2011	Fourth Edition	NLT-GB.Q895-04-26/2011
05	17/03/2015	Fifth Edition	NLT-GB.Q895-05-03/2015

The original instructions are the ones in Italian.

USER'S MANUAL

ENGLISH

1.1 DATA OF THE MANUAL 5
1.2 USERS 5
1.3 PROPERTY OF THE INFORMATION 5
1.4 CONVENTIONS USED 6
1.4.1 Conventional terms used 6
1.4.2 Conventional symbols used 6
1.5 IDENTIFICATION DATA OF THE MANUFACTURER 7
1.6 IDENTIFICATION DATA OF THE MACHINE 7
1.7 EC CONFORMITY CERTIFICATION 8
1.8 WARRANTY 8
1.9 ASSISTANCE 8
1.10 USE OF THE MANUAL 9
1.11 DESCRIPTION OF THE MACHINE 9
1.11.1 Correct use of the machine 9
1.11.2 Incorrect use of the machine 10
1.11.3 Structure of the machine 11

2.1 SAFETY CRITERIA 13
2.2 QUALIFICATIONS OF THE PERSONNEL 14
2.3 RESPONSIBILITY 14
2.3.1 Protection 14
2.3.2 Active safety devices 15
2.4 DANGEROUS AREAS AND RESIDUAL RISKS 16
2.5 NOISE 19
2.5.1 Information on noise hazard 19

3.1 TECHNICAL SPECIFICATIONS 20
3.2 POWER SUPPLY DATA 21
3.3 MACHINE PERFORMANCES 21

4.1 QUALIFICATIONS OF THE OPERATOR 22
4.2 TRANSPORTATION 22
4.2.1 Transportation conditions 22
4.2.2 Assessment of damages during transportation 23
4.3 ASSEMBLY 24
4.4 STORAGE 26
4.4.1 Characteristics 26
4.5 PLACING OF THE MACHINE 27
4.5.1 Characteristics of the area the machine is placed in 27
4.5.2 Electric wiring 28
4.5.3 Testing 28

5.1 OPERATOR INTERFACE 29
5.2 EMERGENCY STOP 34

6.1 QUALIFICATIONS OF THE OPERATOR 35
6.1.1 Place of work 35
6.1.2 Characteristics of the media to cut 35
6.1.3 Switching the machine on 36
6.1.4 Feeling media to cut ("Auto Semiauto-Manual modality) 37
6.1.5 Automatic cut mode 38
6.1.6 Semi-automatic cutting mode 42
6.1.7 Manual cutting mode 46
6.1.8 Automatic cycle in "Marks" or "InLine" modality 51
6.1.9 Feeding media to cut ("Marks" modality) 51
6.1.10 Positioning and adjustment of the marker sensor (Marks modality) 53
6.1.11 Preparation for the automatic cut in Marks modality 56
6.1.12 Adjusting the horizontal cut 64
6.1.13 How to configure the memories 66

7.1 ALARMS AND/OR INDICATIONS 68

8.1 ROUTINE MAINTENANCE 70
8.1.1 Qualifications of the operator 70
8.1.2 Procedures 70
8.2 EXTRAORDINARY MAINTENANCE 71

9.1 QUALIFICATIONS OF THE OPERATOR 72
9.2 DEACTIVATION OF THE MACHINE 72
9.2.1 Procedure 72

10.1 LIST OF ATTACHMENTS 73

A.1 EC CONFORMITY CERTIFICATION 74

B.1 REPLACING THE VERTICAL CUTTING BLADES 75
B.2 OPTIONAL VERTICAL CUTTING BLADES 77

C.1 INSTALLATION KIT ON-LINE 80
C.2 USE 83

1.1 Data of the manual

Instruction manual.
Code of manual: **NLT.Q895-05-03/2015-GB**

1.2 Users

Instruction manual.

- Transporter.
- Installer.
- User.
- Maintenance personnel.
- Demolition squad.

✓ For further details on the users of this manual, see 2.2 *Qualifications of the personnel*.

1.3 Property of the information

The information contained in this manual is reserved property. All rights are reserved.
This manual cannot be reproduced or copied, as a whole or in parts, without prior written authorization of **NEOLT FACTORY** These documents are provided only for the use of the customer whom the manual has been supplied to with the machine, and can be used only for the installation, use and maintenance of the machine the manual refers to.
NEOLT FACTORY states that the information of this manual complies with the technical and safety requirements of the machine the manual refers to. The manufacturer cannot be held responsible for any direct or indirect damages to people, objects or animals due to the use of these documents or of the machine in conditions other than those authorized.
NEOLT FACTORY reserves the right to change or improve, without notice, the paper or digital documentation and the machines. The above modifications without notice can also be applied to other marketed machines of the same model as the one this manual refers to but with a different serial number.

1.4 Conventions used

1.4.1 Conventional terms used

Machine: indicates the machine specified in *1.6. Identification data of the machine.*

Frame: bearing structure of the machine.

Qualified personnel: people, who thanks to their knowledge and preparation and experience, in addition to the knowledge of the relevant rules, safety requirements and service standards, are able to recognize and avoid any possible danger for the people, the material and the machine.

The descriptions of **direction**, **sense and position** (on the right of the machine, on the left of the machine) refer to the position of the operator in front of the machine.

1.4.2 Conventional symbols used

Text in italics: indicates the title of a chapter, a section, a sub-section, a paragraph, a table or an illustration of this manual, or another reference manual.

1 (generic number as an example): symbolic representation of a command device or signal.

A (generic letter as an example): symbolic representation of a part of the machine.

✓ Notes contain important information, and are pointed out after the text they refer to.

The danger symbols indicate those procedures which, if not respected, could cause physical damages to the operator. The manufacturer cannot be held responsible for any damages to people due to non-compliance with these regulations.

The warning symbols indicate those procedures which, if not respected, could damage the machines or the devices connected to it. The manufacturer cannot be held responsible for any damages to objects due to the noncompliance with these regulations.

1.5 Identification data of the manufacturer

Contact distributor for any maintenance intervention. Any unauthorized maintenance interventions make the warranty void.

NEOLTFACTORY

Via ITALIA, 6
24030 Valbrembo (BG) - ITALY

Tel. 035/468811
Fax 035/468886

1.6 Identification data of the machine

Type	ELECTRIC TRIMMER
Model	**XY MATIC TRIM 165**
Serial Number	
Year of Construction	
Weight	See Chap. 3 *Technical specifications*

The machine has an identification plate on the back of the machine, under the connection structure, with CE label on the side. Sample. Do not remove the label and it is absolutely forbidden to place other labels on the machine without the prior written notice of the manufacturer.

1.7 EC conformity certification

Annex *A CE conformity certification* includes a copy of the CE conformity certification of the machine.

1.8 Warranty

NEOLT FACTORY offers a one-year warranty on the machine.
The parts subject to normal wear out are not included in the warranty. The warranty is limited to the substitution or repair of the parts that should result damaged or defected.
The assessment of the defects and causes is carried out by **NEOLT FACTORY.**
The warranty is cancelled if the machine is used incorrectly, or in an improper or excessive way, if any non-original spare parts are used and for non-compliance with the standards of this manual.
In no case can the purchaser demand the resolution of the contract, claim for damages or the extension of the warranty.

The term "Original purchaser" refers to the person who first bought the product covered by this warranty for purposes other than reselling. The warranty is applicable and valid only for the original purchaser and only for the period (during the warranty period) in which the equipment is held by the original purchaser.

✓ **NEOLT FACTORY** cannot be held responsible for any negative advertising or missed profits, due to malfunctioning, technical or mechanical, of the product being used or on display.

✓ The correct and safe operation of the machine is assured only if the machine is used in accordance with what is indicated in the manual and in the relevant documentation. **NEOLT FACTORY** cannot be held responsible for any damages to people or things due to an incorrect use of the machine or modifications not authorized by the manufacturer.

1.9 Assistance

NEOLT FACTORY provides, upon request, assistance for the installation and the maintenance of the machine.

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Fax 035/468886

1.10 Use of the manual

Carefully read the chapters *General information, Safety information, Characteristics of the machine*.

✓ Please consult the relevant chapter for any transportation, installation, use, maintenance and demolition operation.
This manual and the enclosed documentation must be kept for the entire technical life of the machine in order to consult it quickly when necessary.
If the machine is sold as second-hand, this manual and the enclosed documentation must be supplied along with the product.

1.11 Description of the machine

1.11.1 Correct use of the machine

The machine is used to cut flexible media with a max. thicknesses of **1 mm.** for the horizontal cut and **0.5mm.** for the vertical cut.
The machine is made of physically independent and autonomous groups, therefore the proper use of the machine also refers to the correct functioning of only one part of it.

Use of the machine

The installation and the extraordinary maintenance of the machine must be carried out by qualified personnel only.

The machine was designed to be used in an area with the features indicated in the section *PLACING THE MACHCINE 5.5.1* and in the section *POWER SUPLPY DATA 3.2*.

1.11.2 Incorrect use of the machine

Any use other than that indicated in part *1.11.1 Correct use of the machine* is to be considered incorrect, especially:

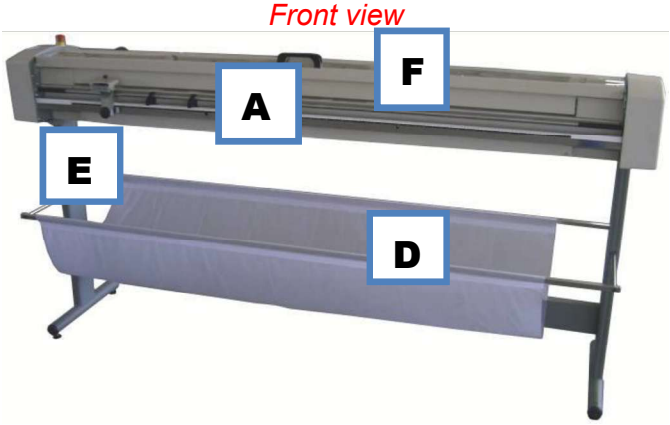
- Using the machine in ways which differ from those which it has been designed for, represents an anomalous condition and could therefore damage the structure of the machine or the operators.
- Using the machine without its protections and without the safety equipment it is provided with: particularly without the fixed protections that block access to the internal equipment.
- Not observing the procedures of this manual and especially maintenance and repair operations.
- Using the machine in an area at risk of fire or explosions if the machine itself does not have the proper fire equipment.
- Using the machine in areas containing explosive materials.
- Using the machine in an inflammable area.

1.11.3 Structure of the machine

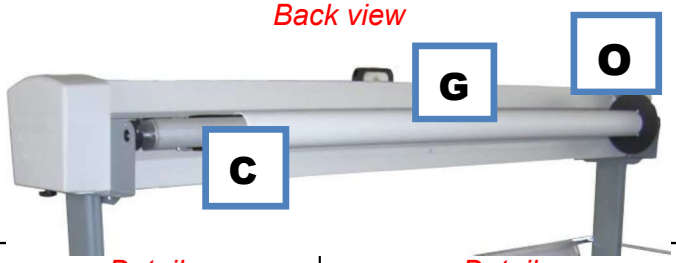
The machine includes the following parts:

- **A** front output roller.
- **B** safety switch.
- **C** Roll holder for media to cut.
- **D** Trimmed media collection basket.
- **E** Table.
- **F** Upper protection guard.
- **G** Handle with upper protection guard opening mechanism.
- **H** Power.
- **I** Keyboard.
- **L** **Horizontal** cutting head.
- **M** **Vertical** cutting head.
- **N** Pressure adjustment vertical blade.
- **O** Brackets.
- **P** Horizontal position adjustment of cross sensor.
- **Q** Vertical position adjustment of cross sensor.

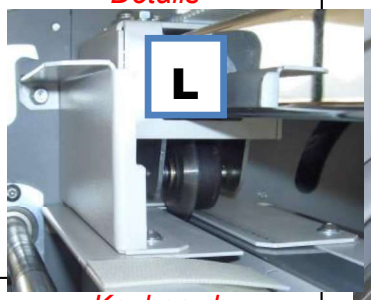
Front view



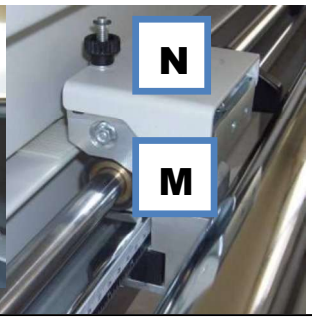
Back view



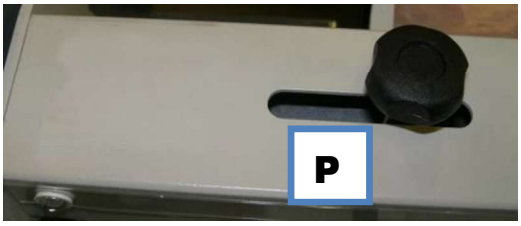
Details



Details



Details



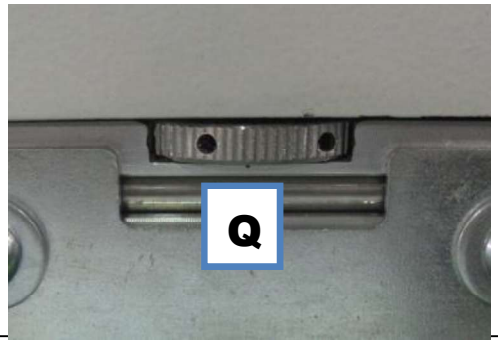
Keyboard



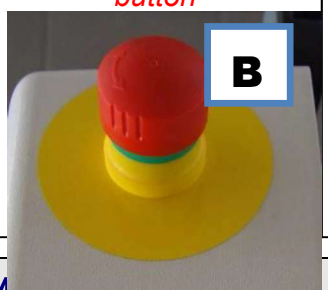
Power



Details



Stop/Emergency button



ON-LINE Kit and INCLINED TABLE (Optional)

The Kit includes the following parts:

1 Printed media feeding rollers.

2 Tensioning roller.

3 Media inlet roller in cutting area.

4 ON-LINE Kit stand.

5 Adjustment rack, media loading roller.

6 Inclined table for collection of trimmed media (optional)

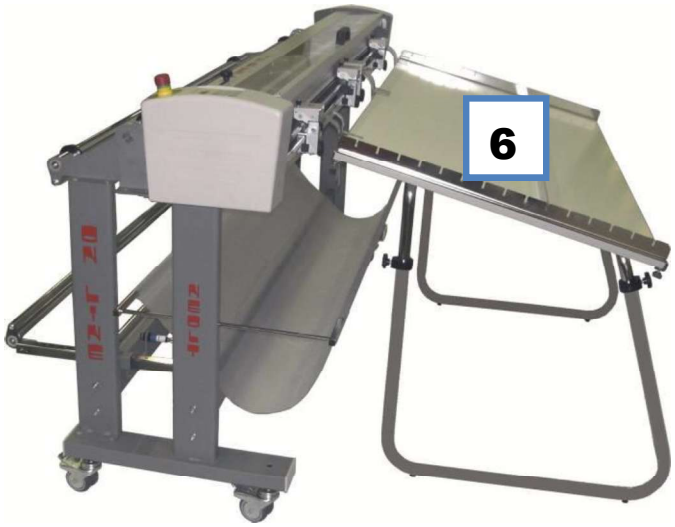
7 Printed media and cutting control sensor.

8 End-of-travel minimum limit.

Front view



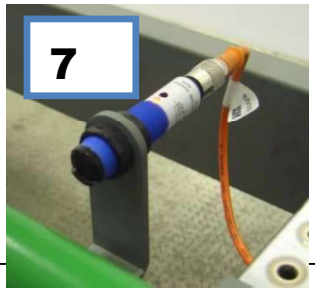
Back view



Details



Details



2.1 Safety criteria

The machine has been designed and made in compliance with the essential safety criteria and standards set forth by the standards indicated below, and following amendments and integration to the national acknowledging laws and regulations:

Thanks to the accurate risk analysis carried out by the manufacturer, most of the risks depending on the conditions of use of the machine, both foreseeable and reasonably foreseeable, have been eliminated.
The complete documentation including all the safety measures adopted are in the technical booklet of the machine, which is deposited at the manufacturer's premises.
The manufacturer recommends strictly complying with the instructions, procedures and recommendations of this manual and with the laws in force on the safety in the work place. This also refers to the use of the protection equipment foreseen, both those integrated in the machine and personal.

✓ **NEOLT FACTORY** cannot be held responsible for any damages to people, animals or objects due to noncompliance with the safety standards and recommendations of these documents.

2.2 Qualifications of the personnel

Technical life of the machine	Qualification of the operator in charge
Transportation	Qualified transportation
Installation	Qualified personnel
Use	Qualified personnel
Ordinary maintenance	Qualified personnel
Extraordinary maintenance	Technicians appointed by **NEOLT FACTORY**
Demolition	Qualified personnel

2.3 Responsibility

✓ **NEOLT FACTORY** cannot be held responsible for any damages to people, animals or objects due to noncompliance with the safety standards and recommendations of these documents.

⚠ Tampering with the protections and the safety devices is dangerous for the people using the machine and for those exposed to.

✓ **NEOLT FACTORY** cannot be held responsible for any damages to people, animals or objects due to tampering with the protections.

2.3.1 Protection

The machine is provided with the following protections.

Inter-locked moving safety guards:
- Right guard
- Left guard
- Upper transparent door.

2.3.2 Active safety devices

- The machine is fitted with a Stop/Emergency button above the left guard. ***(fig. 2.1)***.
- Fixed guards such as the left and right guard to protect the moving mechanical devices such as gears and motors.
- Earth connections for all electric, electronic and metallic parts of the machine.
- Safety microswitch for opening of the upper protection door. ***(fig. 2.2)***.
- Optical sensor for setting to zero the travel of the carriage. ***(fig. 2.3)***. the sensor sets the steps of the carriage travel to zero after each travel up and down.
- End-of travel sensor and machine block when the section of the printed media is not enough to assure the correct operation of the trimmer (only for machine with ON- LINE Kit) ***(fig. 2.4)***.

Fig. 2.1



Fig. 2.2



Fig. 2.3



Fig. 2.4



2.4 Dangerous areas and residual risks

All the areas around the machine in which people are at risk of injuries or health problems are considered dangerous.

Pay close attention to hands during the cutting operations.

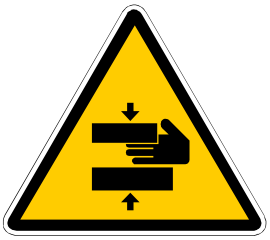
Fig. 2. 4



During certain intervention procedures on the machine, which are pointed out each time in this manual, residual risks for the operator may arise. Residual risks can be avoided by carefully complying with the procedures of this manual and using the personal protection devices indicated, such as:

- Position the power cable so it is not stepped on and ruined.
- Do not put the power cable where it can be damaged.
- Maintenance and service operations must be performed only by the technical service authorized by the producer.
- Pay attention to the danger signs on the trimmer. The sensitive parts are:
  - The feeding area for the material to trim ***(fig. 2.4)***.
  - The area where the vertical cutting blades are positioned.
  - The area where the light of the horizontal cutting line is positioned

✓ **NEOLT FACTORY** cannot be held responsible for any damages to people, animals or objects due to noncompliance with the relevant standards or incorrect use of the personal protection equipment (PPE).





Rotating parts and cutting blade:
The trimmer is fitted with an electronic device that prevents contact with the horizontal cutting blade, during the normal cutting movement. Cutting risks may arise during certain operations, for example when changing the blades or during the feeding of the media for the cutting phases; particularly during the feeding operations it is necessary to pay close attention to the vertical cutting blades that during this operation are easy to access.
The areas of potential danger are indicated on site by the following symbols (see illustrations) "Caution: hand crushing" and by the symbol "shearing danger". The operators must not wear loose clothing that could get caught in the moving elements of the machine, correct clothing includes tight-fitting clothing, particularly as regards the upper limbs. Do not wear rings, watches or other objects that could generate risk of trapping or dragging if they come into contact with moving elements of the machine.

The danger labels, described above, are placed in the points indicated in the photo.

Back inlet of media to trim	Vertical cutting blade
	



Electric parts – danger due to the presence of electricity.
Do not remove the protection panels of the machine to avoid injuries due to electricity. Remove the protection panels only for maintenance purposes. In this case make sure the machine is disconnected from the mains and that the operator can see the cable well.

The danger labels, described above, are placed in the points indicated in the photo.

Power



2.5 Noise

Information on noise produced by a machine identical to the one indicated in this manual, measured according to the indications of the "Machine Directive.

Level of equivalent continuous pondered acoustic pressure A, produced by the machine is lower than 63,46dB (A)
The measurements were done in front of the machine (standard position of the operator), at a distance of one meter from the machine, with the machine idling.
The calculation of aerial noise was performed according to the ISO 11202:1995 standard.

Average level of continuous pondered equivalent acoustic pressure, around the machine at one meter's distance:

- While the machine is operating: lower than 56,76 db.

2.5.1 Information on noise hazard

The levels of acoustic emission indicated are not necessarily safe for the workers. The levels of exposure of the worker are obviously linked to the emission levels of the machine, however other factors affect the levels of exposure of the workers: duration of the exposure, characteristics of the area and the presence of other machines. The levels of emission of the machine, however, allow the users to assess the danger related to acoustic emissions.



A continuous use of the machine and of other machinery present in the area of installation could lead to a high level of personal daily exposure to noise.
When daily personal exposure is equal to or higher than 85 dB (A) the use of PPE is recommended (protective caps, protective ear plugs, ...).
When daily personal exposure is equal to or higher than 90 dB (A) the use of PPE is obligatory (protective caps, protective ear plugs, ...).
For information on other safety measures in Italy refer to Legislative Decree no. 195, of 10.04.2006 <<Acknowledgement of directive 2003/10/CE relating the exposure of workers to the risks resulting from physical agents (noise))>>.

3.1 Technical specifications

Model		1650
Max. length of cut		1650mm. / 65"
Max horizontal cutting thickness		1 mm. / 0,04"
Max vertical cutting thickness		0,5 mm. / 0,02"
Max. speed for horizontal cut.		40 m/min. / 131,24 ft/min.
Max. speed for vertical cut.		12,5 m/min. / 41,01250 ft/min.
Horizontal cutting tolerance		±1mm. per mt.
Vertical cutting tolerance		According to the precision of the operator in positioning the vertical cutting blade
Including		TABLE ROLL HOLDER STANDS 2" AND 3" TWO UNITS OF VERTICAL CUTTING
Dimensions	Width	2160 mm. / 85"
	Depth	800 mm / 31.5" Including paper collection basket
	Height with stand	1110mm. / 43.7"
	Height of working table	970 mm. / 38.2"
Net weight		95 Kg. / 209.5 lbs.
Reel	Max. diameter of roll	Ø 200 mm. / Ø 7.8"
	Max. width of roll	1650 mm. / 65"
	Max. weight of roll	40 Kg. / 90 Lbs.
Model		**1650 MATIC ON-LINE**
Dimensions	Media width	1650mm. / 65"
	Width	2160 mm. / 85"
	Depth	1150mm. / 46"
Weight of machine + ON-LINE Kit		160 Kg. / 352 lbs.

3.2 Power supply data

- Voltage and single-phase frequency: 230V/50Hz – 240V/50Hz – (110V/60Hz).
- Absorption: max 0,5A – (max 1A).
- Power fuse T2A.

Responsibility

✓ **NEOLT FACTORY** cannot be held responsible for problems or defects that should arise due to noncompliance with the power supply values supplied.

3.3 Machine performances

- Max horizontal cutting thickness **1 mm.** .
- Max vertical cutting thickness **0.5 mm.** .

4.1 Qualifications of the operator

The transportation, installation and connecting operations of the machine must be carried out by qualified personnel only, transporters and electricians.

4.2 Transportation

4.2.1 Transportation conditions

The trimmer is shipped with a packaging including polystyrene sheets **2** to protect the components, and carton boxes **1** which covers everything. *Fig. 4.1 Transportation conditions*.

The size of the packaging and its total weight (packaging and trimmer) are as follows

Model	165
Dimension (LxPxH - cm/Inch)	235 / 92,5"x60 / 23,62"x63 / 24,80"
Weight (gross)	128 Kg. / 282 lbs

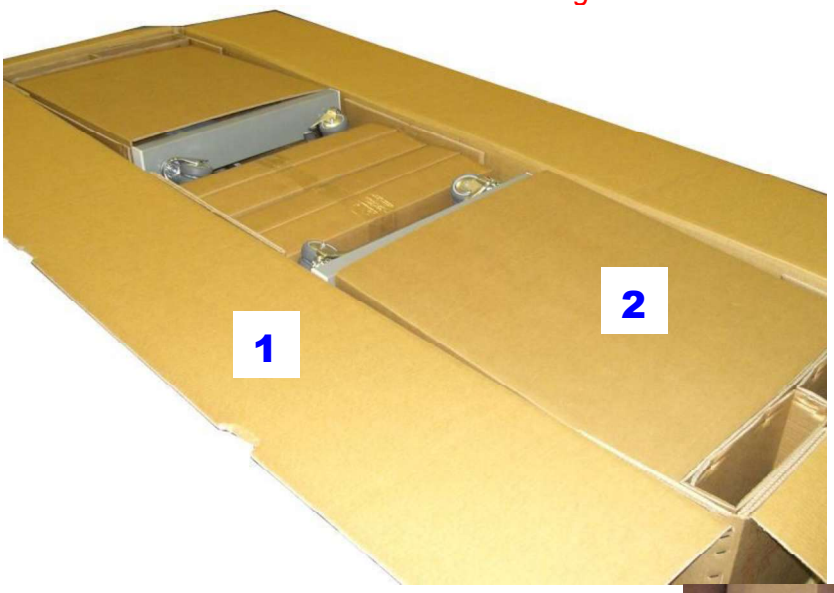
The hoisting, transportation and handling operations of the machine or its parts must be carried out only by specialized and qualified personnel.

It is absolutely forbidden to pass or stop under hanging loads.

The devices used for hoisting, transportation and handling the machine must be suitable for the weight of the machine and the shape of the elements to life, carry and handle and must comply with the regulations in force in the place of installation and use of the machine.

Please take the necessary precautions to avoid any crashes and overturning. Protect the machine from external atmospherics see paragraph *Characteristics of the area of installation 4.5.1*.

Fig. 4.1





4.2.2 Assessment of damages during transportation

Check the conditions of the machine by visually inspecting it, after having removed it from the shipping box. Any defects on the visible parts of the machine indicate crashes during transportation, which could also affect the normal operation of the machine.

Especially assess the conditions of these parts:

- Right and left guards
- Plexiglas of carriage safety guard.
- Rollers of the optional ON-LINE kit

4.3 Assembly

- Open the packaging box **1** which contains all parts ***(Fig. 4.1))***.
- Remove the carton shells **2** ***(Fig. 4.1)***.

This operation must be carried out by at least two people.

- To install the stand, screw on the lower cross bar ***(fig. 4.3)*** , first one shoulder and then the other using the four screws (TCCE 6x50) and the bushes supplied ***(fig. 4.2)***.

Attention the side of the shoulder has different sized holes. The side with the bigger holes should face outwards to insert the bushes.

Fig. 4.2

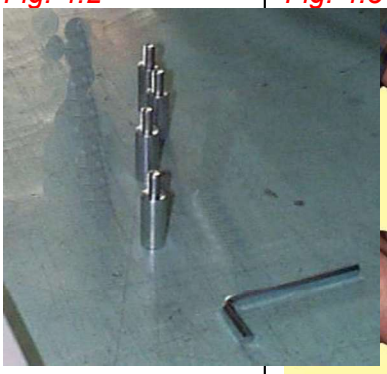


Fig. 4.3





- Slide the basket stems in the specific housing on the front of the shoulder ***(fig. 4.4)***.
- Slide the basket supporting stems of paper collection basket in the holes so that it projects evenly on both sides ***(fig. 4.5 – 4.6)*** .

Fig. 4.4

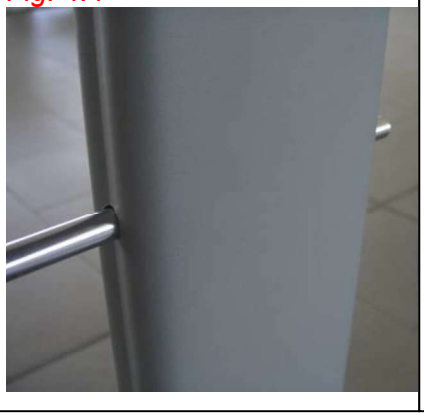
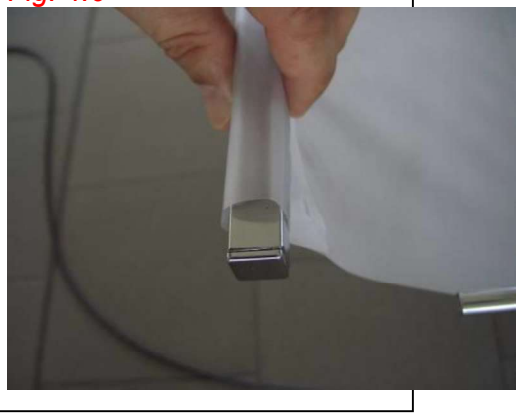


Fig. 4.5



Fig. 4.6



Attention there are different sized holes also for the basket supporting stems. The side with the bigger holes must face outwards to insert the head of the screw that fixes the stem to the rod iron inserted in the shoulder.

Attention the paper collection basket must pass over the cross beam that was fixed earlier.

- Screw on the two basket supporting stems to the rod iron inserted in the shoulder. One on one side and the other on the opposite side, sliding the screw in the bigger hole of the square stem, so that the head of the screw remains fixed to the stem itself, then tighten the screws ***(fig. 4.7)***.

Fig. 4.7



Considering the heavy weight of the machine, these operations should be carried out by two operators. It is necessary to wear protection gloves to optimize the grip on the machine.

- Position the trimmer on the stand assembled previously and fix it to the stand using the supplied screws (2 per side) ***(fig. 4.8)***.

Fig. 4.8



✓ No other adjustments are necessary because the machine is factory tested.

4.4 Storage

The indications contained in this section must be followed during the periods of temporary storage of the machine which could take place in the following situations:

- When the machine is not installed immediately after it is delivered.
- When the machine is disconnected and stored while waiting for it to be relocated.

For as much as possible the machine must be stored so that unauthorized personnel cannot access it. It must be protected against possible damages due to dust, humidity, heat, cold, sun rays or other substances that could corrode or attack it.
The storage area must not be near dangerous areas.

4.4.1 Characteristics

- Temperature range: from -5°C to +55°C.
- Humidity range: from 30% to 95% without condensate . ideal humidity ~55%, with max. temperature 40°C.
- The user must assure that the lighting in the place of work is good enough to allow for good visibility during operation and visibility of all the elements of the machine; the lighting level complies with standard UNI EN 12464-1:2004; particularly shadow areas should be avoided, as well as direct glares and stroboscopic effects.
- Proper protection from atmospherics.
- Adequate space to carry out the hoisting and transportation operations in a safe and easy way.
- Horizontal surface with a capacity higher than the mass of the machine.
- Adequate space to carry out ordinary maintenance and technical operations.

4.5 Placing of the machine

4.5.1 Characteristics of the area the machine is placed in

Power supply
The area where the machine is installed must be equipped with the power supply connections described in *3.2 Power supply data*.

Space requirements
For the normal use of the machine and the loading and unloading operations, it is important to have an area directly proportional to the size of the media to cut.

Protection from atmospherics
The machine must be placed in a suitably protected room, away from atmospherics.

Floor requirements
Prepare the stable horizontal surface of the machine keeping in mind the mass of the machine itself. Also take into account all extra accessories.

Optimal stability and use conditions can be obtained with a maximum planarity error of ± … mm/m. Furthermore the machine must be balanced off by using back wheels. The maximum inclination of the floor must not exceed 10° inclination.

Illumination
The user must assure that the lighting in the place of work is good enough to allow for good visibility during operation and visibility of all the elements of the machine; the lighting level complies with standard UNI EN 12464-1:2004; particularly shadow areas should be avoided, as well as direct glares and stroboscopic effects (approx. 200 - 600 lux).

Atmospheric characteristics of the area
- Temperature range: from 18°C to 35°C.
- Humidity range: from 30 % to 95% without condensate. Ideal humidity ~55%, with maximum temperature 40°C.

General characteristics of use
- The machine must not be used near explosive atmospheres
- The machine must not be used with acids, corrosive agents, salt, etc.
- The machine must not be used with ionizing and non-ionizing radiations (X-rays, microwaves, ultraviolet rays).

4.5.2 Electric wiring

✓ The machine is powered through a 2.5 meter cable (98") and a plug compliant with what is indicated on the identification plate.

⚠ Verify that the electric distribution line is adequate for the power of the machine.

- Position the power cable so it is not stepped on and ruined.
- Do not put the power cable where it can be damaged.
- Maintenance and service operations must be performed only by the technical service authorized by the producer.

⚠ Electric hazards. Connect machine to a ground outlet before carrying out any other connection to the mains.

- Disconnect the electric line that powers the machine.
- Connect the power cable to a power outlet with adequate features and positioned near the machine.
- Power the line that powers the machines.

The electric power system of the machine must include:

- Protection against over-currents, through devices with intervention current, sized taking into account the maximum absorption of the machine.
- An intervention device for isolation defects (differential) with label data sized properly for the type of the machine.
- An external equipotential protection circuit (ground connections) adequate and complaint with the laws in force in the country of installation of the machine.

4.5.3 Testing

Before using the machine continuously check the general operation of the machine by doing some trial cuttings.

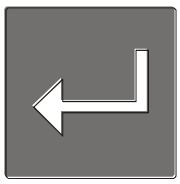
📖 If there are vibrations or unusual noises, immediately switch off the machine and contact the **NEOLT FACTORY** technical assistance see *Identification data of manufacturer 1.5.*.

5.1 Operator interface

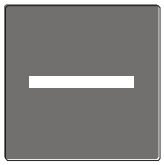
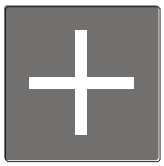
The keyboard ***(fig.5.1)*** is made up of easy-to-use control and programming keys. Below is a list of the functions of each key.

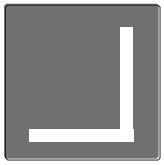
Fig. 5.1



Key	Description
	***STOP key*** The STOP key stops the trimmer during any phase of operation active **In manual mode** It disables this modality, switches off the exclamation mark at the end of the line and sets the displayed values to zero
	***START key*** After having configured the various parameters press the START key to start the set cutting sequence. **In manual mode** It enables this mode displaying the exclamation mark at the end of the line on the display.
	***ENTER key*** After modifying the parameters in the various sections where it is possible, press the ENTER key to confirm the set value, or the STOP key to delete the operation.
	***MEMORY CONTROL key*** Use this key to retrieve one of the 8 functions saved according to the cuts with constant and repetitive size and media in time. Also save the new settings configured according to the new needs. Press STOP to exit the modality without saving the settings.

Key	Description
	***MOTOR SPEED CONTROL key*** Show the display area with the motor configurations. Press once to change the cutting speed value **SC** (variable value from 1 to "n" according to the value set as parameter). Confirm value pressing ENTER. Press twice in sequence to change the value of the media feeding speed **SM** (variable value from 1 to "n" according to the value set as parameter). Confirm value pressing ENTER. Press three times in sequence to change the value that enables to adjust the cutting precision for the movement of the media **AM** (values expressed in tenths of a millimeter per meter). Confirm value pressing ENTER. Press STOP to exit any of the modalities without saving the modification.
	***FUNCTION CONTROL key*** Press once to set the operating modality (press "**+**" or "**-**" while the function flashes, to switch from AUTO, SEMI-AUTOMATIC, MANUAL, MARK, INLINE). Confirm value pressing ENTER. Press twice in a row to position the media to trim (press "**+**" or "**-**" to adjust the trimming edge of the printed media, with the edge of the cutting line). Press "**+**" o "**-**" and the key "motors speed management" at the same time for a quick feed movement. Press STOP to end operation. Press three times in sequence for the roll measurement function (press START to begin the roll measurement procedure). Press STOP to end measuring, the value of the display is in mm. If the START button is pressed again, the value increases, continuing the measurement. Press STOP with machine not operating to exit the function and set the counter to zero. Press four times in a row for the copy measurement function (press START to start the copy measurement procedure at standard speed, for a more precise adjustment use "**+**" or "**-**"). Press the key DIMENSION so that the measured value is automatically set as the feeding length of the support value "**L**" of the display. Press STOP to exit the function without saving anything.

Key	Description
	***DECREASE key*** Use this key to decrease the set value of a specific function containing a variable that can be changed. It also enables to alternate the display with information on the dimension of the format to cut, speed information and edge adjustment values, cut and margin configurations in "Mark" and "InLine" modality.
	***INCREASE key*** Use this key to decrease the set value of a specific function containing a variable that can be changed. It also enables to alternate the display with information on the dimension of the format to cut, speed information and edge adjustment values, cut and margin configurations in "Mark" and "InLine" modality.
	***CUT key*** When this key is pressed, a horizontal cutting operation starts. In the AUTO function there is also the relating eject movement of the trimmed media.

Key	Description
	***Space CUT key*** Key used to select, in cycle (automatic, semi-automatic, manual) the feeding value the trimmer must cover to eliminate the space between the two subsequent prints. Max. allowed value: 50 mm. use this key to automatically select the cut in "Mark" and "InLine" modality.
	***DIMENSION key*** Key used to select the value of the width and length of the movement. The value can also be selected in cycle (automatic),. The unit of measure can be expressed in inches or centimeters. Use this key to manually set the size of the cut in "Mark" and "InLine" modality.
	***Key NUMBER OF COPIES*** When the key is pressed the symbol "*I*" starts flashing on the display, use keys "**+**" and "**-**" to set the number of copies or cuts to perform or that are present on the roll of printed media. Active only for the automatic modality. This key is also used to copy the current settings used on the machine in the selected memory.

5.2 Emergency stop

The machine can be stopped by the operator at any time, if he notices something unusual during operation or for safety reasons. To immediately stop the machine, press the emergency button above the left side guard.

To restore the standard operating mode of the machine, after solving the cause of the emergency stop, rotate the button oppressed earlier clockwise or counter-clockwise.

6.1 Qualifications of the operator

Only qualified personnel can use the machine.
It is necessary and useful to carefully read this user's manual before using the machine.

6.1.1 Place of work

Position of the operator: during machine start-up and cutting operations the operator stands in front of the machine with the control panel on his left above the left guard. During maintenance operations the position depends on the specific operation that needs to be carried out.

6.1.2 Characteristics of the media to cut

This trimmer was designed to cut media of the sizes indicated in this manual.

Caution: do not cut media with characteristics different from those indicated. It could seriously damage the machine.

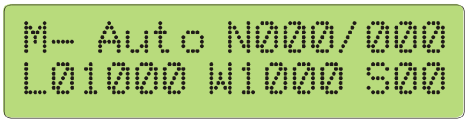


6.1.3 Switching the machine on

The power supply group, with general power cable and switch, is behind the left safety guard. After the general switch is pressed to ON "**I**" the display of the trimmer will show the version (or release) of the control software for a few seconds.

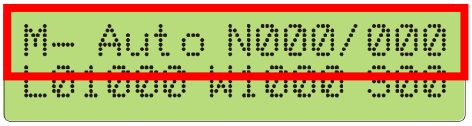


Afterwards the display will show the configuration information saved during the previous use.

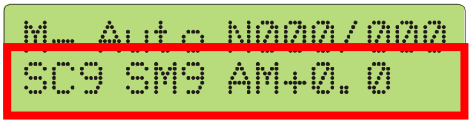


The display controls several screens, needed to supply all the information relating the use and the configuration of the trimmer. The information is cyclical and can be displayed by pressing + or − .

The display will cyclically indicate the most important information for the operation of the trimmer.

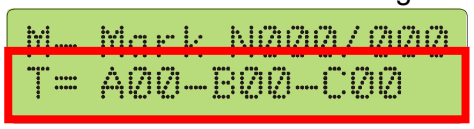


"**Auto**" operating modality / "**N**" progressive number of cuts. / Number of cuts to perform .

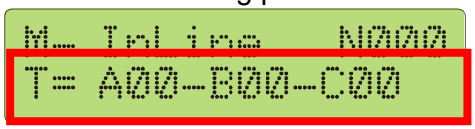


"**SC**" speed of cut / "**SM**" Speed of media / "**AM**" Correction value for the feeding of the media to trim.

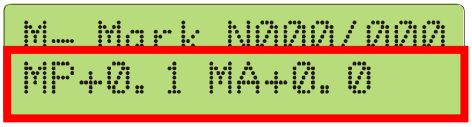
In the "**Marks**" and "**InLine**" modality two more screens are displayed, with other information useful for the configuration of the machine cutting procedures.



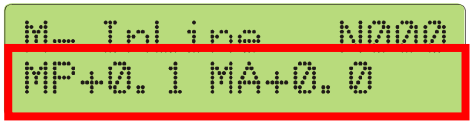
or



"**T**" indicates the type of mark "**+**" cross, "**-**" line, "**=**" double line (suggested mark). / "**A**-**B**-**C**" indicates the size of the markers.



or



"**MP**" back cutting margin from cross / "**MA**" front cutting margin from cross.

6.1.4 Feeling media to cut ("Auto Semiauto-Manual modality)

The trimmer can be used to cut media in a roll or sheets. To cut rolls it is necessary to use the brackets supplied with the machine. The roll to cut must be wrapped around a reel, made of carton or plastic, and possibly well-balanced to avoid oscillating and cuts that are not perpendicular during the feeding and cutting process of the media. If the media is in rolls, use the roll-holder inserting the media up to the flange ***(fig. 6.1)***, then place the roll holder in the appropriate seats ***(fig. 6.2)***. Attention: on the left of the roll holder there is a fractioning mechanism. It prevents the movement from unwinding the media for no reason.

Fig. 6.1



Fig. 6.2



Follow this procedure to load the media on a roll or feed it separately into the machine:

- Open the upper protection guard by using the opening mechanism under the central handle ***(fig. 6.3)***. After lifting the guard, place the media on the conveyor rolls and line it up with the cutting line ***(fig. 6.4)***. Close the protection guard, making sure that the side clamps click into their seats.

Fig. 6.3



Fig. 6.4



Make a cut to verify that the cutting line is in line with the edge of the printed media. To perform this trial cut press CUT  .

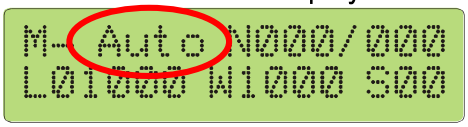
6.1.5 Automatic cut mode

This mode enables to use all the potentialities of the machine.
To operate in the best way possible, consider that the media to trim was printed with constant dimensions and sizes for its entire length, and that this information was given to the operator to set up the machine.

Example:
Roll with 10 images, 50cm long, printed on a roll of media 70cm wide, with a space of 4cm between one and the other.

Set up the trimmer in the following way:

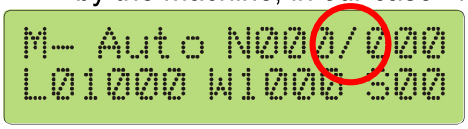
- Verify that the display shows "**Auto**", otherwise press D. / M., pressing + or — until the display shows "**Auto**"



- Confirm by pressing (ENTER) ↵.

Insert the number of copies to trim:

- Press (COPIES) . The symbol "/" starts flashing, press "**+**" or "**-**" to set the number of images to trim. The display shows the number of cuts that will be made by the machine, in our case "10"

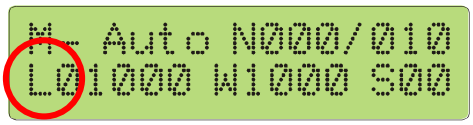


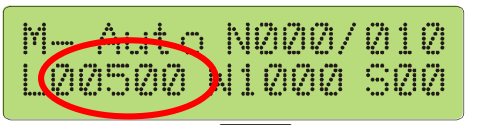


- Confirm the set parameter by pressing (ENTER) ↵.

Enter the sizes of the image format and of the reel:

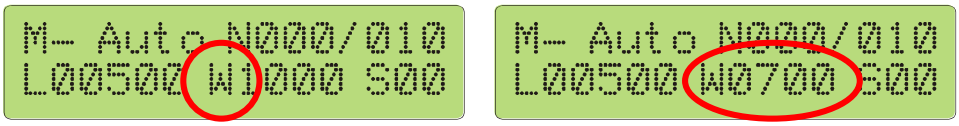
- Press (DIMENSION) once and the letter "**L**" starts flashing on the display, press "**+**" or "**-**" to set the length of the image to trim. The display will show the size values in mm. or inches. So according to our example, the display should be set to "500"





- Confirm the set parameter by pressing (ENTER) ↵.

- Press (DIMENSION)  twice in a row, the letter "**W**" starts flashing on the display, press "**+**" or "**-**" to set the width of the reel with the media to trim. The display will show the size values in mm. or inches. So according to our example, our display should be set to "700"

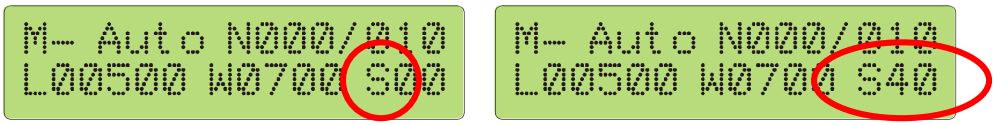


- Confirm the set parameter by pressing (ENTER) .

<u>Enter the distance between one image and the other:</u>

- If there is an area to trim between one image and the other. Press (Space CUT) 

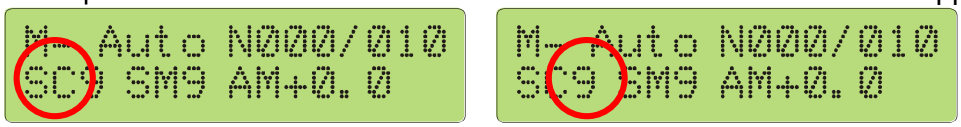
the letter "**S**" , starts flashing on the display, press "**+**" o "**-**" to set the distance between the end of the first image and the beginning of the following. The display will show the size values in mm. or inches. So according to our example, the display should be set to "40"



- Confirm the set parameter by pressing (ENTER) .

<u>Horizontal cutting speed:</u>

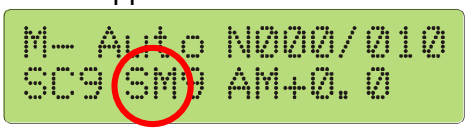
- The horizontal cutting speed can be adjusted according to the media to trim. To change this parameter move to the second window on the display using the keys  or . Press (MOTOR SPEED COTNROL)  once, the letters "**SC**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 40m/min.

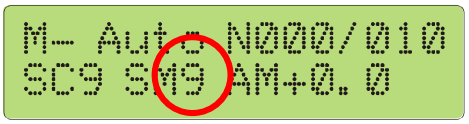


- Confirm the set parameter by pressing (ENTER) .

<u>Feeding speed for vertical cut:</u>

- The feeding speed for the vertical cut can be adjusted according to the material to trim. If the display shows something different from the image below use  or  to change the display. Press (MOTOR SPEED COTNROL)  twice in a row and the letters "**SM**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 12.5m/min.

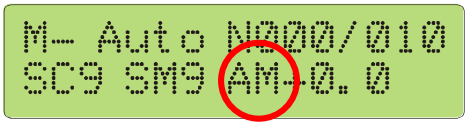


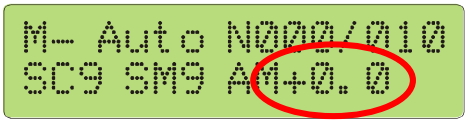


- Confirm the set parameter by pressing (ENTER) .

<u>Adjusting the media feeding speed:</u>

- The feeding speed for the vertical cut can vary according to the media to trim and the motor sensors can in the long run generate delayed or early parameters that can be corrected easily in the following way:
- If the display shows something different from the image below use  or  to change the display. Press the key (MOTOR SPEED CONTROL)  three times in sequence. The letters "**AM**" flash on the display. Press "**+**" or "**-**" to set the correction according to the delay or advance time, the value is expressed in tenths of a millimeter or tenths of $^{1}/_{32}$ of an inch, and ranges from -9.9 to +9.9. The value is the correction assigned to 1 linear meter. By changing the media it might be necessary to cut 1 linear meter of product, measure it and enter the difference in "**+**" or "**-**" as correction.



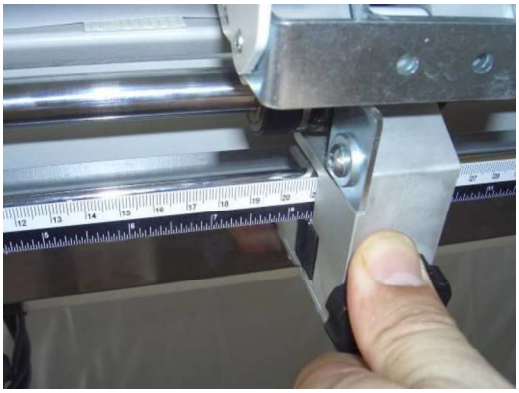


- Confirm the set parameter by pressing (ENTER) .

After setting all the parameters that the trimmer can use in automatic mode, it is necessary to position the two blades for the vertical cut. Loosen the knobs that block ***(fig. 6.5)*** the cutting heads and slide them along the sliding bar. Use the millimeter scale to position it correctly, or, if there are already printed edges, to position it so that the image is trimmed also along these edges, so that the final result is a trimmed image on all four sides.

Fig. 6.5

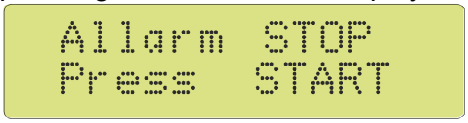




Press start  to perform the sequence of cuts for all ten images.



Press stop  to stop the selected action, in the case an error was recognized in the planning, the display visualizes the following message



, press the key start  for reset the system.

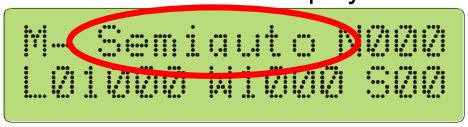
6.1.6 Semi-automatic cutting mode

This modality enables to use all those potentialities of the auto mode except for the cut repeat function for more than copy.
To operate in the best way possible, consider that the media to trim was printed with constant dimensions and sizes for its entire length, and that this information was given to the operator to set up the machine.

Example
Roll with 4 images, 70cm long, printed on a roll of media 110cm wide, with a space of 0cm between one and the other.

Set up the trimmer in the following way:

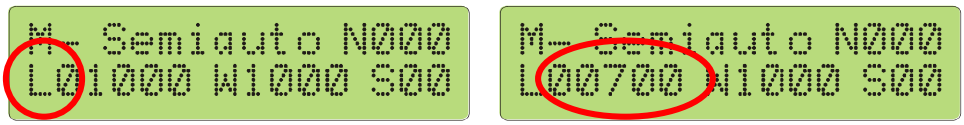
- Verify that the display shows "**Semiauto**" otherwise press D. / M., pressing + or − until the display shows "**Semiauto**"



- Confirm by pressing (ENTER) ↵.

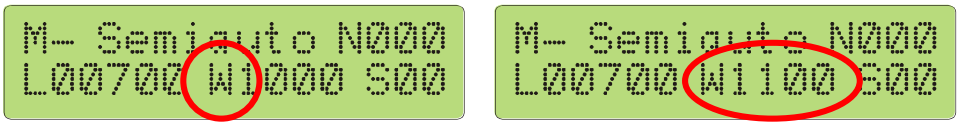
Enter the sizes of the image format and of the reel:

- Press (DIMENSION) ⌟ once and the letter "**L**" starts flashing on the display, press "**+**" or "**-**" to set the length of the image to trim. The display will show the size values in mm. or inches. So according to our example, the display should be set to "700"



- Confirm the set parameter by pressing (ENTER) ↵.

- Press (DIMENSION)  twice in a row, the letter "**W**" starts flashing on the display, press "**+**" or "**-**"to set the width of the reel with the media to trim. The display will show the size values in mm. or inches. So according to our example, the display should be set to "1100".

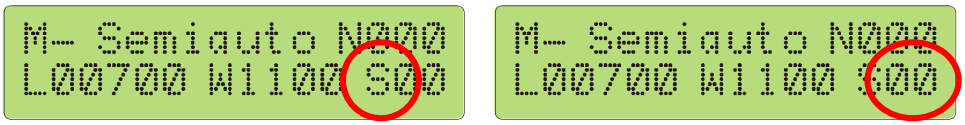


- Confirm the set parameter by pressing (ENTER) .

<u>Enter the distance between one image and the other:</u>

- If there is an area to trim between one image and the other. Press (Space CUT) 

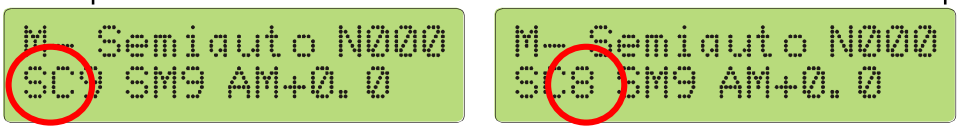
the letter "**S**" , starts flashing on the display, press "**+**" o "**-**" to set the distance between the end of the first image and the beginning of the following. The display will show the size values in mm. or inches. So according to our example, our display should be set to "0"



- Confirm the set parameter by pressing (ENTER) .

<u>Horizontal cutting speed:</u>

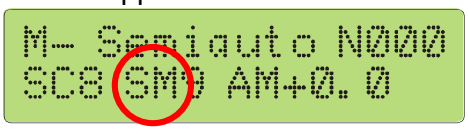
- The horizontal cutting speed can be adjusted according to the media to trim. To change this parameter move to the second window on the display using the keys  or . Press (MOTOR SPEED COTNROL)  once, the letters "**SC**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 40m/min.

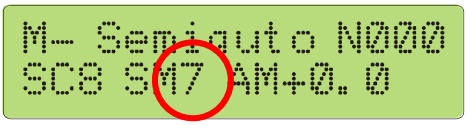


- Confirm the set parameter by pressing (ENTER) .

Feeding speed for vertical cut:

- The feeding speed for the vertical cut can be adjusted according to the material to trim. If the display shows something different from the image below use  or  to change the display. Press (MOTOR SPEED COTNROL)  twice in a row and the letters "**SM**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 12.5m/min.

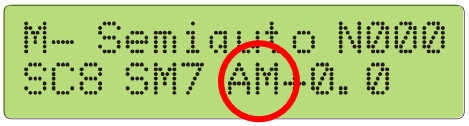


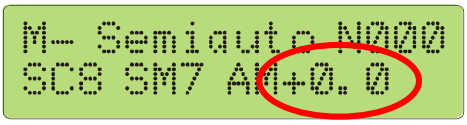


- Confirm the set parameter by pressing (ENTER) .

Adjusting the media feeding speed:

- The feeding speed for the vertical cut can vary according to the media to trim and the motor sensors can in the long run generate delayed or early parameters that can be corrected easily in the following way:
- If the display shows something different from the image below use  or  to change the display. Press the key (MOTOR SPEED CONTROL)  three times in sequence. The letters "**AM**" flash on the display. Press "**+**" or "**-**" to set the correction according to the delay or advance time, the value is expressed in tenths of a millimeter or tenths of $^{1}/_{32}$ of an inch, and ranges from -9.9 to +9.9. The value is the correction assigned to 1 linear meter. By changing the media it might be necessary to cut 1 linear meter of product, measure it and enter the difference in "**+**" or "**-**" as correction.



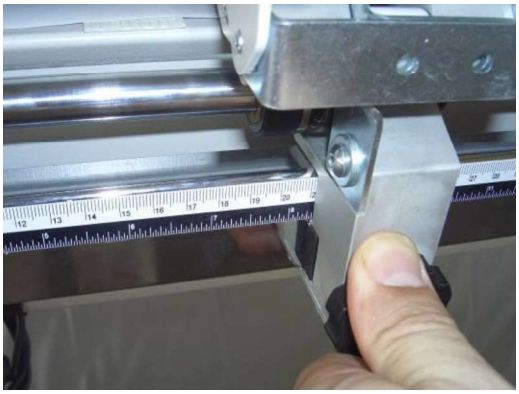


- Confirm the set parameter by pressing (ENTER) .

After setting all the parameters that the trimmer can use in automatic mode, it is necessary to position the two blades for the vertical cut. Loosen the knobs that block ***(fig. 6.6)*** the cutting heads and slide them along the sliding bar. Use the millimeter scale to position it correctly, or, if there are already printed edges, to position it so that the image is trimmed also along these edges, so that the final result is a trimmed image on all four sides.

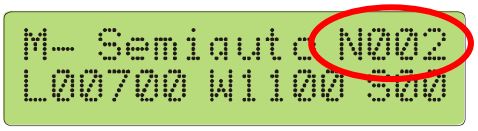
Fig. 6.6



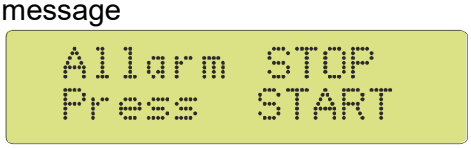


Press start  to run the programmed sequence, since it is semi-automatic mode the key must always be pressed again at the end of every sequence for all the images of our reel.

Every time the key is pressed the copy counter shows the number of cuts made.



Press stop  to stop the selected action, in the case an error was recognized in the planning, the display visualizes the following message



, press the key start  for reset the system.



6.1.7 Manual cutting mode

This modality enables the use the trimmer with horizontal cuts and media movements controlled individually and with the intervention of the operator for every operation.
To operate in the best way possible, consider that the media to trim was printed with constant dimensions and sizes for its entire length, and that this information was given to the operator to set up the machine.

In "**Manual**" mode the 

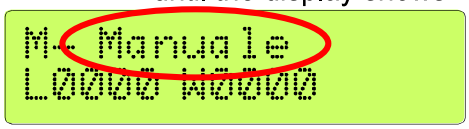
Space Cut function is disabled and the size key  can set only the cutting width. The other parameters such as speed of horizontal carriage, transportation speed of media and adjusting of the media feed must be set before enabling the manual mode.

Example:
Roll of 4 images printed on a coil media with a width of 160cm.

Set up the trimmer in the following way:

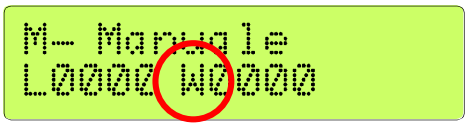
- Verify that the display shows "**Manual**" otherwise press 

, pressing  or  until the display shows "**Manual**"



- Confirm by pressing (ENTER) .

- Press the  key (SIZE) once the letter "**W**" starts flashing on the display, press "**+**" or "**-**" to set the width of the coil with the media to trim. The display shows the values of the size in mm or inches, so with reference to our example the display must be set to "1600"





- Confirm the parameter entered by pressing  (ENTER).

Horizontal cutting speed:

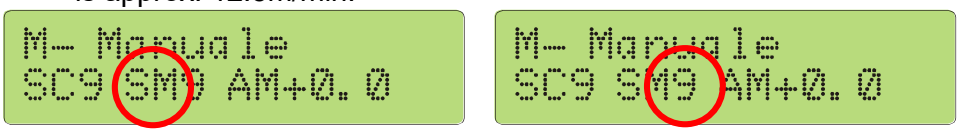
- The horizontal cutting speed can be adjusted according to the media to trim. To change this parameter move to the second window on the display using the keys — or +. Press (MOTOR SPEED COTNROL) n/min once, the letters "**SC**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 40m/min.



- Confirm the set parameter by pressing (ENTER) ↵.

Feeding speed for vertical cut:

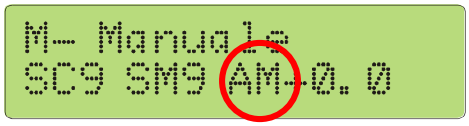
- The feeding speed for the vertical cut can be adjusted according to the material to trim. If the display shows something different from the image below use — or + to change the display. Press (MOTOR SPEED COTNROL) n/min twice in a row and the letters "**SM**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 12.5m/min.

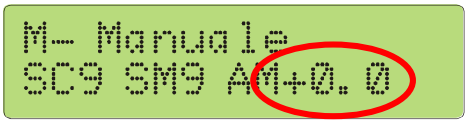


- Confirm the set parameter by pressing (ENTER) ↵.

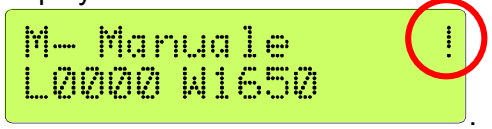
Adjusting the media feeding speed:

- The feeding speed for the vertical cut can vary according to the media to trim and the motor sensors can in the long run generate delayed or early parameters that can be corrected easily in the following way:
- If the display shows something different from the image below use  or  to change the display. Press the key (MOTOR SPEED CONTROL)  three times in sequence. The letters "**AM**" flash on the display. Press "**+**" or "**-**" to set the correction according to the delay or advance time, the value is expressed in tenths of a millimeter or tenths of $^{1}/_{32}$ of an inch, and ranges from -9.9 to +9.9. The value is the correction assigned to 1 linear meter. By changing the media it might be necessary to cut 1 linear meter of product, measure it and enter the difference in "**+**" or "**-**" as correction.



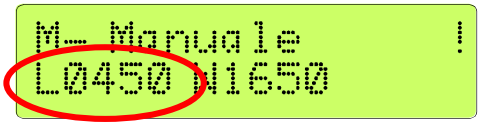


- Confirm the set parameter by pressing (ENTER) .
- Press  start to enable the "**Manual**" mode and enable the cut functions, the display shows an exclamation mark at the end of the first line.



.

- Press  or  to roll out or rewind the media, the display shows the "**L**" current feed value in mm.



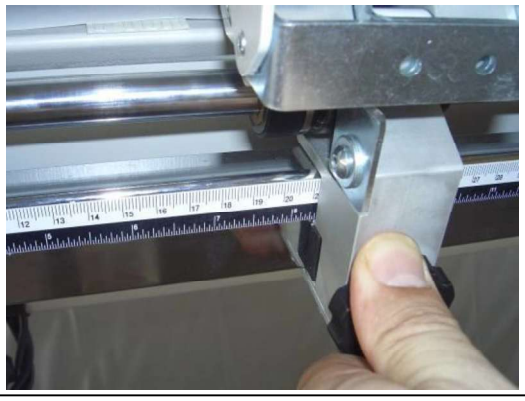
.

- To rewind the media with double speed in relation to the normal speed press  and  simultaneously.

After setting all the parameters that the trimmer can use in automatic mode, it is necessary to position the two blades for the vertical cut. Loosen the knobs that block ***(fig. 6.7)*** the cutting heads and slide them along the sliding bar. Use the millimeter scale to position it correctly, or, if there are already printed edges, to position it so that the image is trimmed also along these edges, so that the final result is a trimmed image on all four sides.

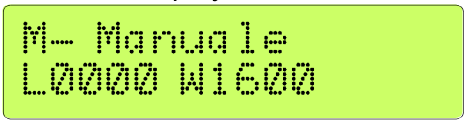
Fig. 6.7





Press the cut key  to perform operations, from the horizontal to the vertical cut and ejection; after every cut and when setting the following feeding of the media it sets the value of the size to zero.



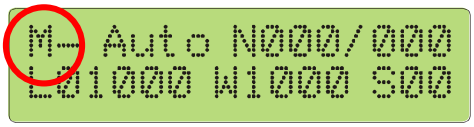
- Press  to disable the "**Manual**" mode, the display does not show the exclamation mark at the end of the first line 

.

All the settings or configurations that have been examined in the examples above can be memorized. For example for repetitive operations with the same media or with standard size images, in order to facilitate the setting of sizes between one image and the length of the rolls.

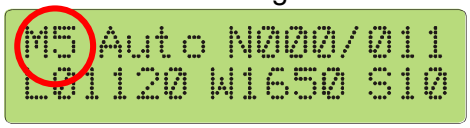
To configure and save a setting, follow this procedure:

After configuring the various parameters, press . The "**M**" on the display starts to flash.



Press 

to change the number of the memory.



Press  to save the current settings in the displayed memory.

Press  to load the settings, save them in the selected memory.

Press  to exit the function without saving or loading anything.

It is absolutely prohibited to lean against or put any object on the feeding table or the covering panel.

6.1.8 Automatic cycle in "Marks" or "InLine" modality

These operating modalities can fully exploit the potentialities of the trimmer. The prints must be marked by markers that are then read by the sensors of the machine and enable a precise and automatic lining up of the media.
To function correctly the trimmer must know which type of marker is being used, the dimensional quality of the markers and the type of material.
The markers considered are three types:
CROSS, LINE and DOUBLE LINE.
The **cross** is the type of marker placed on the side of the print in the white field at the head and end line of the print .
The **line** is a marker placed on the sides in the white field at the beginning/end of the prints.
The **double line** is the marker that is always placed in a white space between two adjacent prints.
This information can be given to the trimmer in two ways, either through self-learning making the sensor directly read the marker or by manually entering the values of the marker. All types of marks must be intense black and with minimum width of 0.5mm.

6.1.9 Feeding media to cut ("Marks" modality)

In "marks" modality the trimmer is used to cut pre-printed media with markers and rolled up in a roll. To cut rolls it is necessary to use the brackets supplied with the machine. The roll to trim must be wrapped around a core, that can be either plastic or carton, and possible even at the ends to avoid oscillations and cuts that are not perpendicular due to dragging imperfections. Use the roll holder and slide the media up to the reference flange ***(fig. 6.8)***, slide in the opposite flange to block the printed roll ***(fig. 6.9)***.

Fig. 6.8



Fig. 6.9

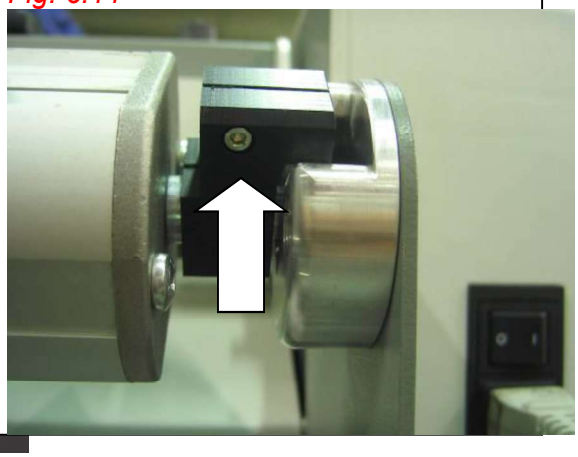


Then place the roll holder in the housing ***(fig. 6.10)***. Caution: on the right of the roll holder there is a friction mechanism to prevent the inertia of the movement to unroll the media for nothing. To increase or decrease the resistance to unwrapping, work on the socket head screw, tightening or loosening it ***(fig. 6.11)***.

Fig. 6.10



Fig. 6.11



To lead the media on the machine follow this procedure :

- Open the upper protection panel using the opening mechanism under the central handle ***(fig. 6.12)***. After lifting the panel, place the media on the feeding rollers ***(fig. 6.13)*** and line up with the cutting line, close the panel and verify that the lateral hooks click into position.

Fig. 6.12

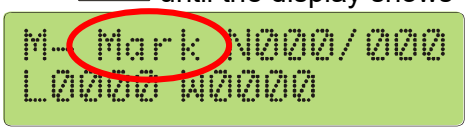


Fig. 6.13



Set up the trimmer in the following way:

- Verify that the display shows "**Mark**" otherwise press D. / M., pressing + or − until the display shows "**Mark**".



- Confirm by pressing (ENTER) ↵.

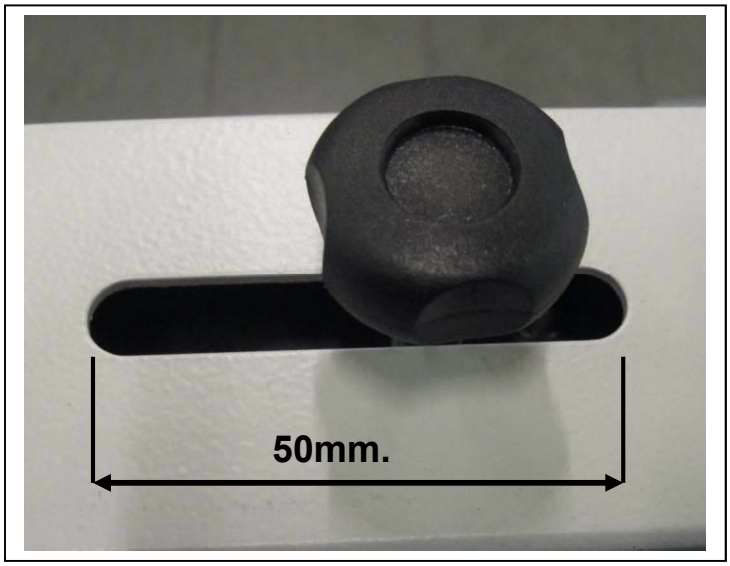
6.1.10 Positioning and adjustment of the marker sensor (Marks modality)

The marker sensor has three main adjustments

- Horizontal adjustment.
- Vertical adjustment or optical focus.

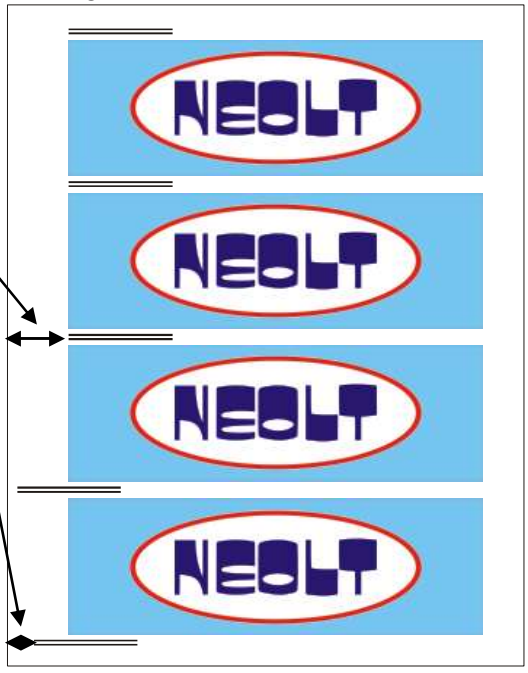
Horizontal adjustment

All media is printed in a different way with margins that can vary from roll to roll. It is possible to adjust the sensor from 0 to maximum 50mm. by using the horizontal adjustment knob.

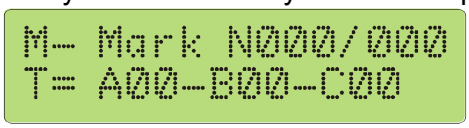


Naturally even the media are printed according to certain rules, such as:

To optimize the reading of the crosses, the distance between the edge and the series of crosses must not exceed 40mm-

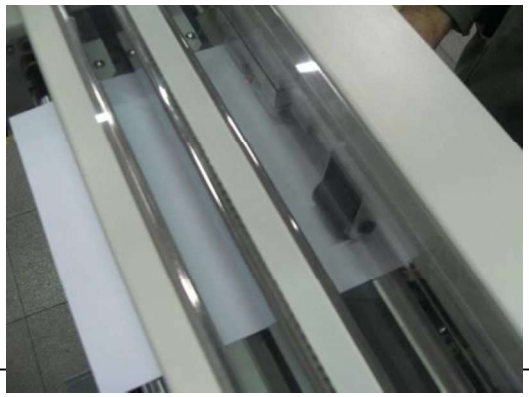


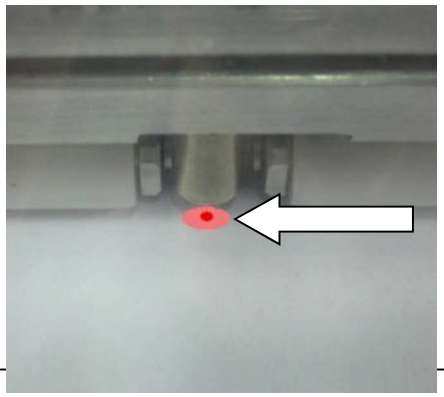
Adjust the sensitivity of the optical sensor in the following way to optimize the reading of the markers, and have a more precise cut, this operation is recommended before any change of material.

- Insert a white sheet of paper under the sensor. Verify that it is tightly pulled between the front and back rollers ***(fig. 6.14)***.
- Press the key  or the key  to display the following information on the display 

.
- Verify that the light beam of the sensor is right above the white background of the media ***(fig. 6.14)***.

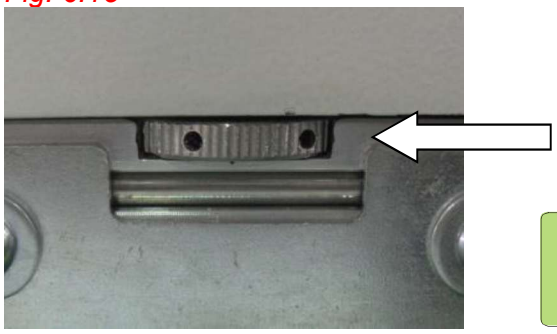
Fig. 6.14

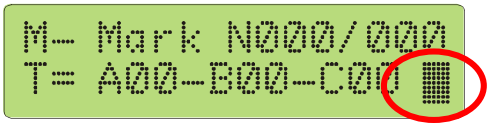




- Turn to the right the adjusting little wheel until when you see a black rectangle, that means the sensor has reached the limit of its adjusting range in that direction. At this point, we turn the little wheel to the left counting the number of rotations we had carried out before having seen the black rectangle itself that identifies the limit of the adjusting range in this direction.

Fig. 6.15



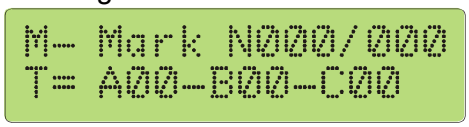


- The number of rotations identifies the adjusting range inside which the sensor can work on the material to be cut. In other words we move the sensor up and down so that it could be always able to read the material properly. Therefore, having found a limit, if we carry out a certain number of rotations in reverse way like the half of rotations necessary to reach the opposite limit, we are sure the sensor is the farthermost from the right and left limits and from its adjusting range, and so the material reading will turn out to be precise. Thus, if we have turned the little wheel of N rotations to reach the left limit, we need to turn of N/2 rotations the little wheel itself to the right to get the best sensor regulation.

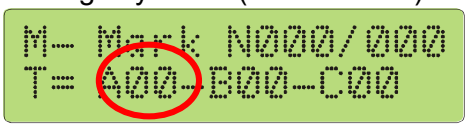
6.1.11 Preparation for the automatic cut in Marks modality

After adjusting the position of the sensor, by adapting it to the fed media, enter the data to allow the machine to recognize the cutting markers.
The information on the marker can be entered in two ways, manually or it can be detected automatically, after selecting the type of marker (cross, line, double line).

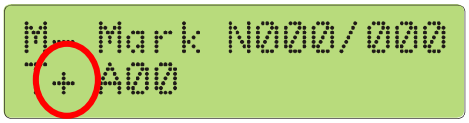
- Pressing  or  show the following information on the display

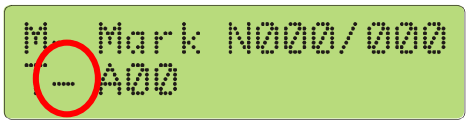


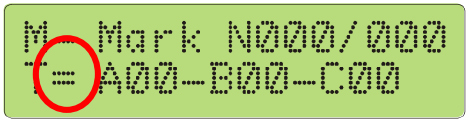
.

- To select the marker. Press the following key once (DIMENSION)  the letter "**T**" starts flashing on the display 

, press  or  to change the symbol on the side

- "**+**" cross 

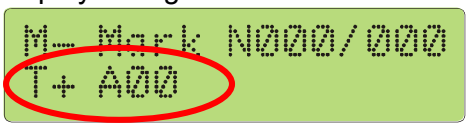
- "**-**" line 

- "**=**" double line 

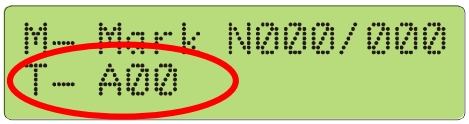
- After selecting the best marker press (ENTER)  to confirm or press (STOP)  to exit function without saving.

According to type of marker the display changes:

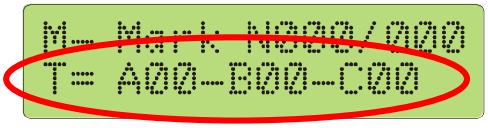
- Cross



- Line

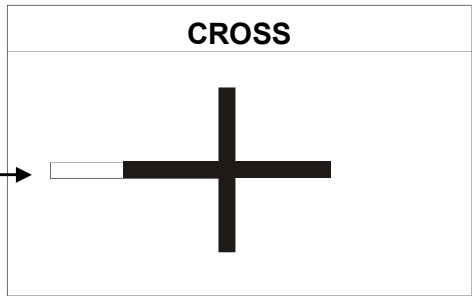


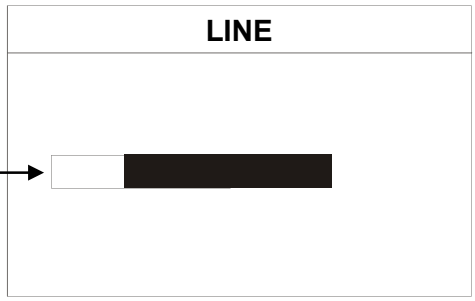
- Double Line

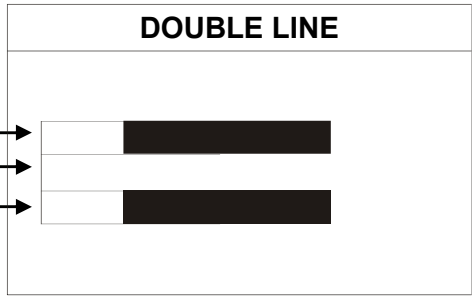


Where "**A**-**B**-**C**" indicate the thickness and distance values from the marker lines.

Value "**A**" identifies the thickness of the line for all types of markers.







Value "**C**" identifies the thickness value of the second, valid only for the double line

Value "**B**" identifies the distance value between the two lines, valid only for the double line.

Value "**A**" identifies the thickness of the line for all types of markers

As said previously, the values of the marker lines can be entered in two different ways, manually if you know the values or having the machine detect them automatically (suggested).

To have the machine detect them automatically follow this procedure:

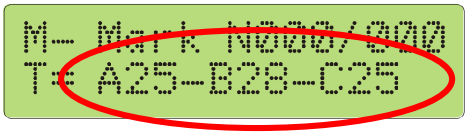
- Position the marker before the sensor (3/4cm).
- Press (Space CUT) 

letter "**A**" (Cross and Line modality) or "**A-B-C**" (Double Line modality) start flashing on the display.
- The media moves passing under the sensor which detects the marker values automatically. If the cross is not read by the sensor, adjust the height or the focus. After reading, the media is automatically brought into start position. When the key (Space CUT) 

is pressed a second time the reading operation is repeated. If it confirms the previous data, the media is brought back to start position, if the values are different, the reading error is displayed. When the key (Space CUT) 

is pressed a third time, the reading operation is repeated, but this time, after the data is confirmed, it moves to the cut line, without performing the cut. When the key (Space CUT) 

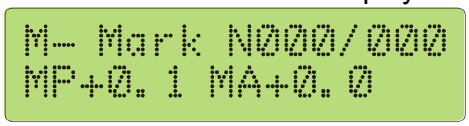
, is pressed a fourth time and for the following times, it looks for the following markers, it reads the values, and then positions them on the cut line.
- To confirm the displayed values press (ENTER) .
- The values are expressed in tenths of millimeters.



If the markers are entered by the user during the creation of the file, we suggest keeping a line thickness between 1 and 2 mm.

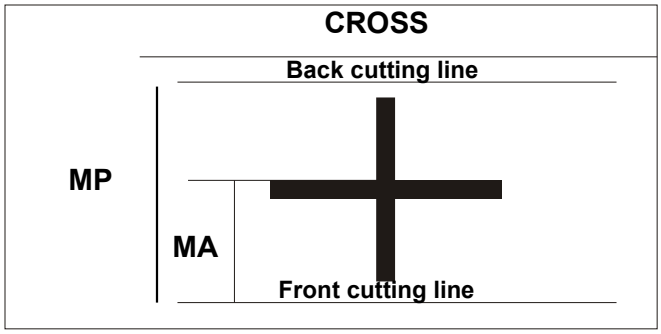
Now enter the data to identify the cutting line in relation to the marker. These are values to enter manually, identifying them on the media in the following way:

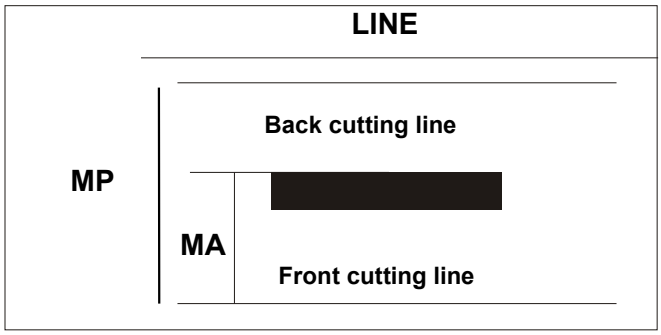
- Press  or  to display the following information

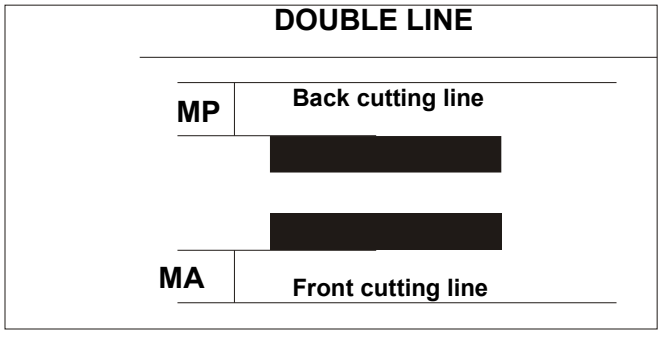


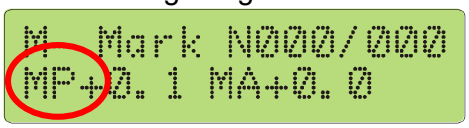
"**MP**" is the distance or margin between the upper edge of the marker and the back cutting line. Whereas "**MA**" is the distance or margin between the upper edge of the marker and the front cutting line.

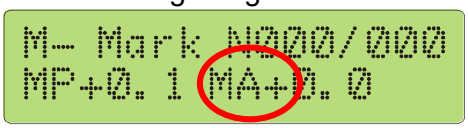
Selecting a line (-) or a cross-mark (+) and setting the value of **MP=0**, the cutter carries out one cut only and does not cancel the cross-mark





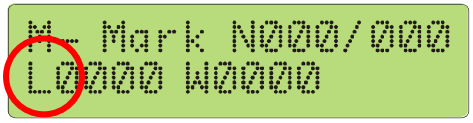
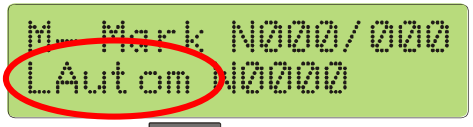


- To enter the cutting margins. Press this key once (DIMENSION)  the letters "**MP**"  start flashing on the display, press  or  to set the measure in tenths of a millimeter.
- The range of values goes from 0 to 9,9mm.
- Confirm the set parameter by pressing (ENTER) .

- To enter the cutting margins. Press this key twice (DIMENSION)  the letters "**MA**"  start flashing on the display, press  or  to set the measure in tenths of a millimeter.
- The range of values goes from 0 to 9,9mm.
- Confirm the set parameter by pressing (ENTER) .

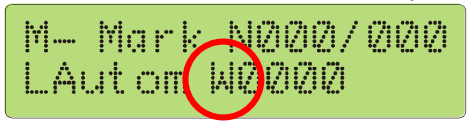
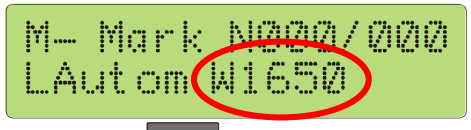
<u>Enter the sizes of the image format and of the reel:</u>

- Press this key once (DIMENSION)  the letter "**L**" starts flashing on the display, press "**+**" or "**-**" to set the values of "L" on "Automatic"

- Confirm the set parameter by pressing (ENTER) .

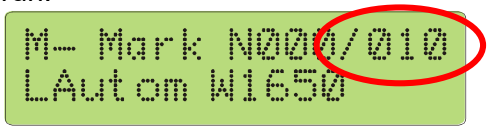
- Press the key (DIMENSION)  once. The program by default sets the size "**L**" on "**Autom**" and enables only the modification of the parameters referred to the width of the media inserted with the flashing of the letter "**W**". Press "**+**" or "**-**" to set the width of the reel. The display shows the values in mm. or inches.

- Confirm the set parameter by pressing (ENTER) .

Insert the number of copies to trim:

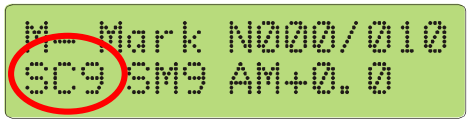
- Press (COPIES) . The symbol "/" starts flashing, press "**+**" or "**-**" to set the number of images to trim. The display shows the number of cuts the machine will run.



- Confirm the set parameter by pressing (ENTER) .

Horizontal cutting speed:

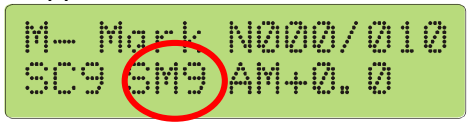
- The horizontal cutting speed can be adjusted according to the media to trim. To change this parameter move to the second window on the display using the keys  or . Press (MOTOR SPEED COTNROL)  once, the letters "**SC**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 40m/min.



- Confirm the set parameter by pressing (ENTER) .

Feeding speed for vertical cut:

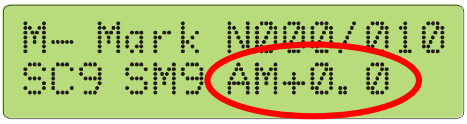
- The feeding speed for the vertical cut can be adjusted according to the material to trim. If the display shows something different from the image below use  or  to change the display. Press (MOTOR SPEED COTNROL)  twice in a row and the letters "**SM**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 12.5m/min.



- Confirm the set parameter by pressing (ENTER) .

Adjusting the media feeding speed:

- The feeding speed for the vertical cut can vary according to the media to trim and the motor sensors can in the long run generate delayed or early parameters that can be corrected easily in the following way:
- If the display shows something different from the image below use  or  to change the display. Press the key (MOTOR SPEED CONTROL)  three times in sequence. The letters "**AM**" flash on the display. Press "**+**" or "**-**" to set the correction according to the delay or advance time, the value is expressed in tenths of a millimeter or tenths of $^{1}/_{32}$ of an inch, and ranges from -9.9 to +9.9. The value is the correction assigned to 1 linear meter. By changing the media it might be necessary to cut 1 linear meter of product, measure it and enter the difference in "**+**" or "**-**" as correction.

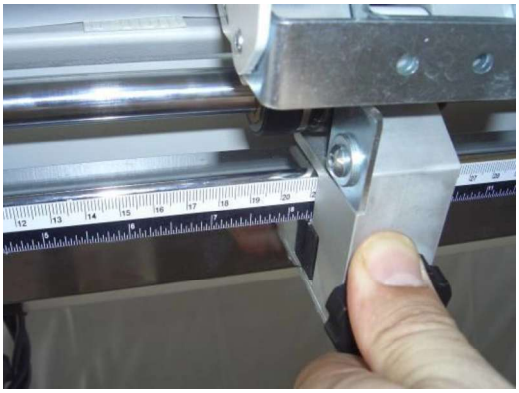


- Confirm the set parameter by pressing (ENTER) .

After setting all the parameters that the trimmer can use in automatic mode, it is necessary to position the two blades for the vertical cut. Loosen the knobs that block ***(fig. 6.16)*** the cutting heads and slide them along the sliding bar. Use the millimeter scale to position it correctly, or, if there are already printed edges, to position it so that the image is trimmed also along these edges, so that the final result is a trimmed image on all four sides.

Fig. 6.16



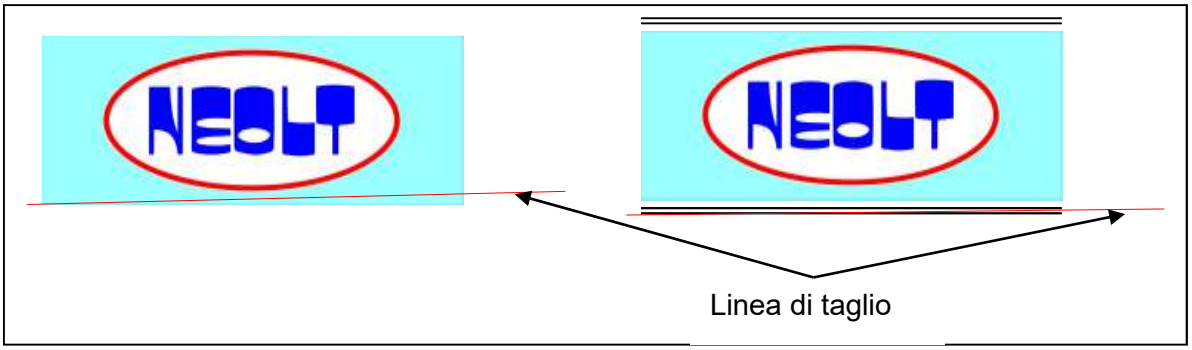


Press start  to run the cutting sequence for all the set images.



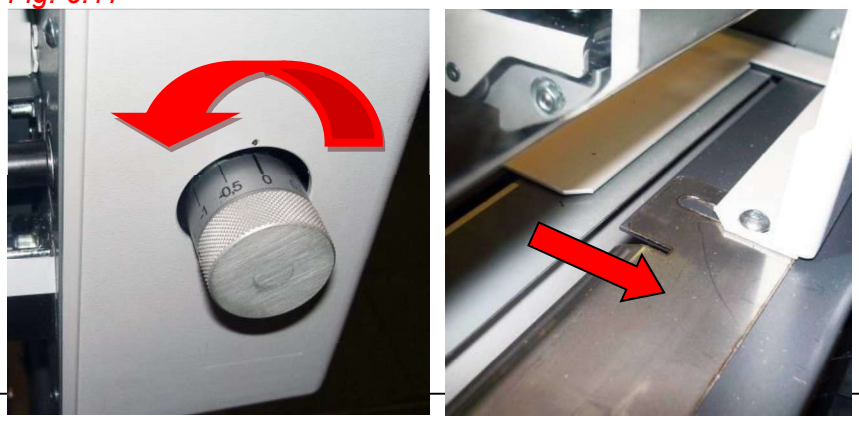
6.1.12 Adjusting the horizontal cut

In line printed media, or printed and coils rewound media, could present horizontal cut images or marks that are not perfectly in line with the horizontal cut blade of the machine.



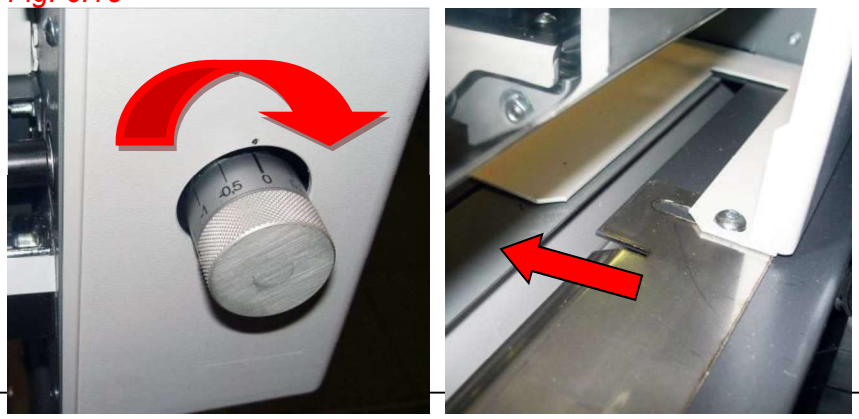
Although it is not possible to align the media, it is possible to adjust the direction of the horizontal cut blade within certain limits.
The knob placed on the panel of the machine is used to modify the direction of the counter-blade against which the rotating blade moves, aligning the cut to the needs of the operator.
To move the cut line forward rotate the knob counter-clockwise ***(fig. 6.17)***.

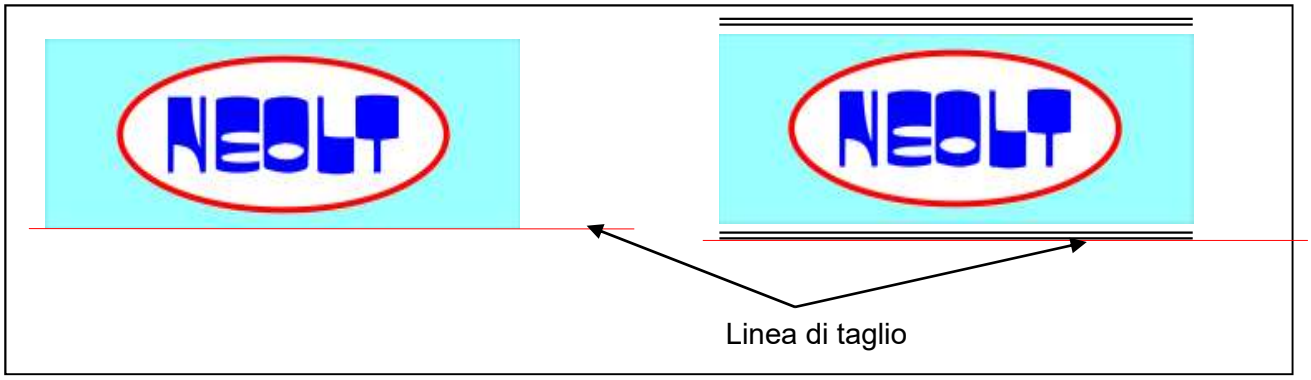
Fig. 6.17



To move back the cut line rotate the knob clockwise ***(fig. 6.18)***.

Fig. 6.18

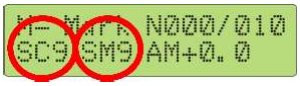


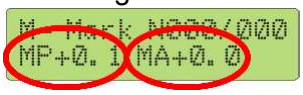


Verify the cut line until the correct alignment is reached.

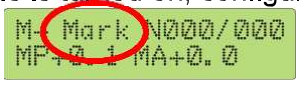
Caution avoid adjusting while the machine is in the cutting phase.

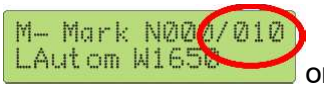
6.1.13 How to configure the memories

Note: the speed carriage and the speed media 

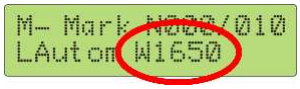
must be set according to the media that you are using even the rear and front margin 

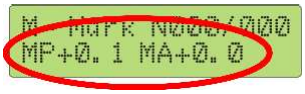
if the machine is set to Mark or "on line" mode.

- Once the machine is turned on, configure the parameters needed:
  - Modality: 

Manual, Semiauto, Auto, Marks or In line.
  - Number of copy to cut 

only if you are working with the automatic,
  - Mark and In line mode
  - **L** 

as the length for each copy to be cut, not for Mark and In line mode, this size is automatically detected by the optical sensor of the machine.
  - **W** 

as width of reel or sheet to be cut.
  - **S** as the space between the copies to be cut with Manual, Semiauto and Auto mode, <u>with Mark and In line mode, it is determined by the front and rear margin</u> 

<u>previously set.</u>
- After setting the various parameters, press the key  the M on the machine display starts blinking.
- Press the key 

to select the number of the memory to set, in totally 8 available memories
- Press the key  to save the current setting into the displayed memory.
- Machine ready to work.

How to recall a saved memory

- Once the machine is turned on:
  - Press the key  the M on the display starts blinking.
  - Press the key  to select the number of the memory that you want to recall.
  - Press the key  to confirm your selection.

How to re-write a saved memory

- Once the machine is turned on:
  - Press the key  the M on the display starts blinking.
  - Press the key  to select the number of the memory you want to rewrite (eg. M1).
  - Press the key  to confirm your selection.
  - Start to modify the parameters as the procedure used to configure the memories.
  - Press the key  to confirm.
  - Press the key  again the M on the display starts blinking.
  - Press again the key  to select the re-write memory M1.
  - Press the key  again to save the new rewritten setting into the displayed memory.

The trimmer provides the operator with information on operation faults or wrong configuration parameters. The information is shown on the display.

7.1 Alarms and/or indications

CODE	CAUSE	ACTION
PERDITA DATI ATTESA	Problems in loading the data in the memory	Wait for the memory to be set to zero. If it happens again request intervention of technician.
AZZERAMENTO MEM. ATTESA	Memory set to zero caused by a FW updating or loss of data.	Wait for the reset of the parameters and memory.
FUORI F.C. Premere START	Machine or cutting operation start up with carriage out of position zero.	Press START, the carriage moves to position zero, if another error appears, act accordingly.
ERRORE MEMORIA	Memory error or temporarily out of control.	Start-up the machine again. If it happens again request intervention of technician.
ERRORE MOTORE	Motor or motor start-up error or temporarily out of control.	Start-up the machine again. If it happens again request intervention of technician.
PROTEZ. ATTIVATA	Cover guard devices End of travel bar enabled (Mod. "InLine").	Close cover, lower the bar and restart (Mod. "InLine").

CODE	CAUSE	ACTION
ERRORE F. C.	Sensor, cutting motor or ON/OFF switch faulty or out of control.	Start-up the machine again. If it happens again request intervention of technician.
ERRORE GENERICO COD: XXX	Generic error.	Start-up the machine again. If it happens again request intervention of technician.
NON VALIDO ST M–	Problems in saving data in selected memory.	Start-up the machine again. If it happens again request intervention of technician.
NON VALIDO LD M–	Problems in loading the data in the selected memory.	Start-up the machine again. If it happens again request intervention of technician.
ERRORE LETTURA Premere STOP	The automatic reading of the cut-mark does not match with the previous one.	Control height of sensor or media not compatible.
MAX DIMENSIONE Premere STOP	Dimension between one cross and the other exceeds the max. one	Press STOP and if necessary start up again with START.
ERRORE A, B, C=0 Premere STOP	Cut-marks not configured.	Press STOP and configure manually or automatically.

8.1 Routine maintenance

Before carrying out any maintenance or cleaning operation on the machine disconnect it from the mains by disconnecting the power cable to avoid any unexpected machine start-ups.

Routine maintenance includes all those periodical and preventive operations that allow the machine to be used safely.

8.1.1 Qualifications of the operator

Routine maintenance of the machine must be carried out by qualified personnel only.

8.1.2 Procedures

Please carry out the periodic operations listed in the table below.

Operation to be carried out	Frequency of execution	Procedure	Precautions
General dusting.	At user's discretion.	• Clean the entire machine with a damp cloth.	Do not use aggressive products.
Cleaning the scrap material.	If there is a lot of scrap material.	• Open the upper guard. • Eliminate the scrap material with an aspirator and/or compressed air.	Wear a pair of protection gloves.

Operation to be carried out	Frequency of execution	Procedure	Precautions
Replace fuse of general wiring.	If the fuse is burned.	• Open the fuse-holder connector • Remove the burned fuse. • Replace with a new one T2A. 	Isolate the machine from power supply sources by unplugging the power cable.

8.2 Extraordinary maintenance

Directly contact **NEOLT FACTORY** for any extraordinary maintenance operation non contained in this manual.

9.1 Qualifications of the operator

The machine can be demolished by qualified personnel only.

9.2 Deactivation of the machine

Once the machine has reached the end of its technical and operating life, it must be deactivated. The machine must be deactivated and put in the condition of not being used for the purposes which it had originally been designed for. However, it must allow the reuse of the raw materials which it was built with.

✓ **NEOLT FACTORY** cannot be held responsible for damages to people or animals due to the reutilization of single parts of the machine for purposes or in situations different from those which it has been designed for.

9.2.1 Procedure

Disconnect the power cable.
In case the machine has to be moved, refer to *4.2 Transportation*.

The machine is made of non biodegradable materials. It must therefore be brought to an authorized center for its disposal.

If for any reason the machine has to be put out of order, please comply with the following rules for the protection of the environment.
Aluminum, Iron, Plastic, general electric material and electronic boards must be removed and disposed of separately, by qualified personnel.

According to the information received from our suppliers, we declare that the product complies with the RoHS directive. Hence it does not contain the substances prohibited by the regulations themselves beyond the maximum concentration values.
DIRECTIVE 2002/95/CE

To comply with the RAEE standards the label with crossed container applied on certain details indicates that the product must not be disposed of through the normal procedure used for household waste. To avoid any damages to the environment and human health, separate this product from other domestic waste so that it can be recycled according to the procedures in force for the protection of the environment. For more details on the available collection structures, contact the competent local office.

10.1 List of ATTACHMENTS

Attachment A	***EC conformity declaration***
Attachment B	***Optional VERTICAL cutting blades***
Attachment C	***Optional ON-LINE KIT***

A.1 EC conformity certification

Manufacturer of the machine

	NEOLT FACTORY

Name and address of the person authorized to set up the technical file:

Description of the machine:

General name	*Electric trimming machine*
Brand	*NEOLT FACTORY*
Model	*"XY" MATIC TRIM 165*
Use	*CUTTING OF MEDIA USING A DOUBLE ROTATING BLADE*
Serial number	---
Commercial name	*DISPENSER TRIM – MATIC TRIM ON-LINE*
Supplied accessories	-

The above company DECLARES under its sole responsibility that the machine this document refers to complies with the following standards:

- **Directive 2006/42/EC (Machinery Directive)**
- **Directive 2004/108/EC (EMC Directive)**
- **Directive 2006/95/EC (Low Voltage Directive)**

Place and date

Ponte San Pietro XX/XX/XXXX

Name, function and signature of person being appointed by manufacturer or agent established in the community

B.1 Replacing the vertical cutting blades

Follow this procedure to replace one or more vertical cutting blades:

- Loosen but do not remove the knob used to adjust the pressure of the media feeding rollers. Press the locking sheet and remove the knob ***(fig. B.1)***.
- Lift the locking sheet. Pay close attention to the two springs under the sheet and remove them ***(fig. B.2)***.

Fig. B.1

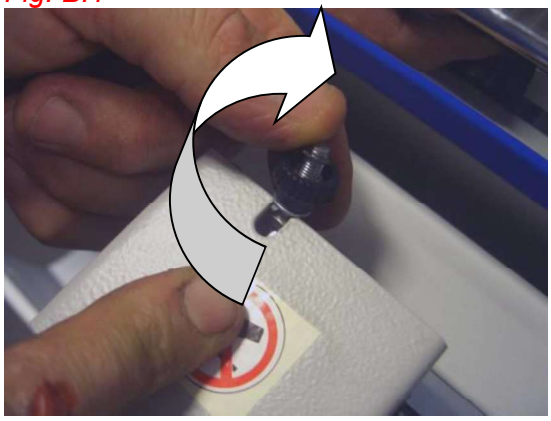
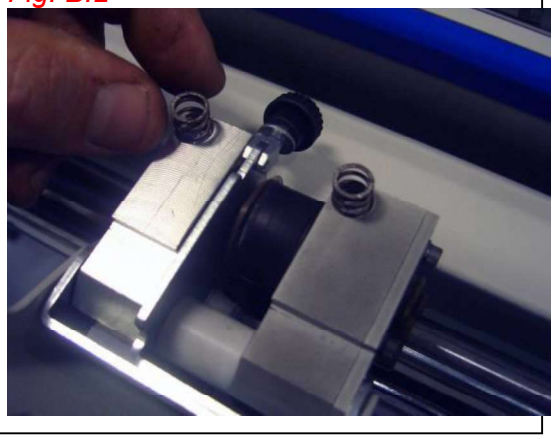


Fig. B.2



- Loosen the two screws under the "L" shaped plate, without removing them ***(fig. B.3)***.
- Remove the two locking screws of the bearing holder plate, on the right or left. Only on one side. ***(fig. B.4)***.

Fig. B.3



Fig. B.4

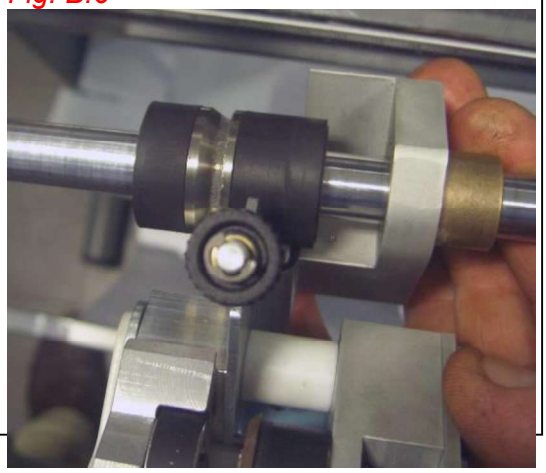


- Slide out the bearing holder plate from the blade sliding shaft ***(fig. B.5)***.
- Lift the blocks roller pressing blocks and slide out the counter-blade roller ***(fig. B.6)***.

Fig. B.5



Fig. B.6



- Slide out the blade holder block ***(fig. B.7)***.
- Replace the vertical blade holder block and put it back following the procedure in the reverse order.
- After re-positioning the blade holder block, carefully slide in the counter-blade roller, that has to be positioned with the counter-blade facing the cutting block, turn over the block with the rotating blade and fix it into the counter-blade roller. Reassemble everything following the rest of the procedure in the reverse order ***(fig. B.8)***.

Fig. B.7

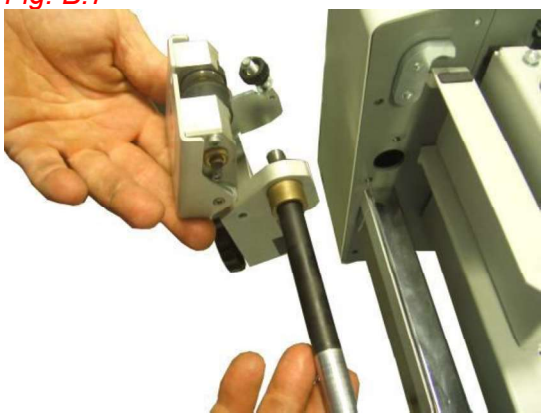
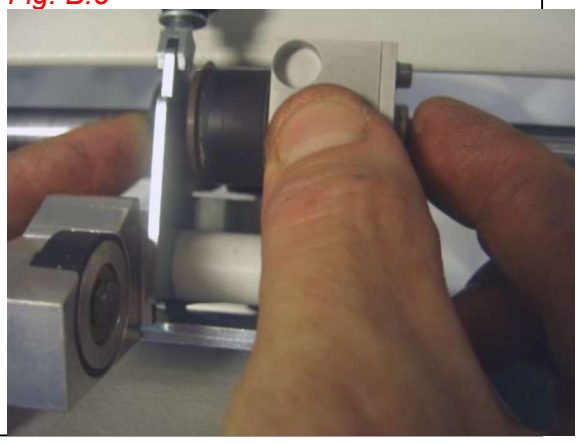


Fig. B.8



B.2 Optional vertical cutting blades

Follow this procedure to position one or more optional vertical cutting blades:

- Loosen the two screws under the "L" shaped plate, without removing them, of all vertical blade holder blocks on the machine ***(fig. B.9)***.
- Remove the two locking screws of the bearing holder plate, on the right or left. Only on one side. ***(fig. B.10)***.

Fig. B.9



Fig. B.10



- Slide out the bearing holder plate from the blade sliding shaft ***(fig. B.11)***.
- Slide in the optional blade holder block on the sliding shaft ***(fig. B.12)***.

Fig. B.11



Fig. B.12



- Slide in the counter-blade roller and lean it on the blade holder block ***(fig. B.13)***.
- Fix the rotating blade of the blade holder block in the counter blade ***(fig. B.14)***.

Fig. B.13

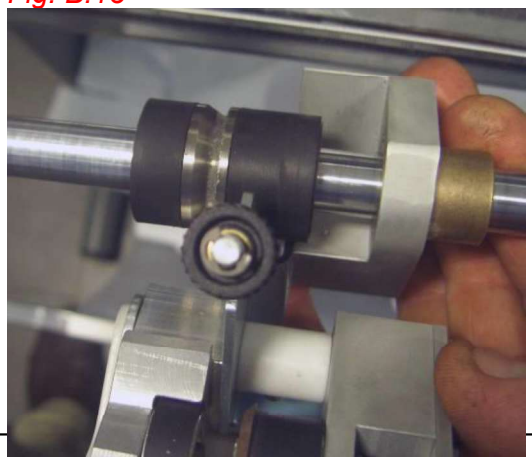
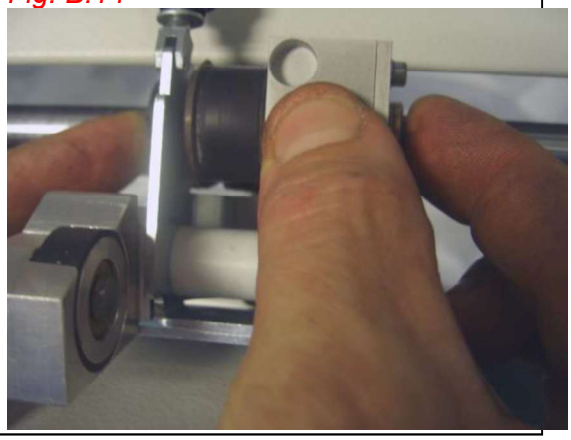


Fig. B.14



- Turn over the blocks and insert the adjustment springs ***(fig. B.15)***.
- Turn over the pressure adjustment sheet and keeping it pressed lock it with the pressure adjustment knob of the feeding roller of the media to trim ***(fig. B.16)***.

Fig. B.15



Fig. B.16



- Tighten the locking screws of the bearing holder plate, which was removed earlier ***(fig. B.17)***.
- Tighten the two screws under the "L" shaped plate, locking the blade holder to the millimeter sliding bar ***(fig. B.18)***.

Fig. B.17



Fig. B.18



With the optional cutting blade kit it is possible to cut rolls or sheets with images such as the figure below, with a minimum image kit of 20x10 cm. to a maximum of 100 x 1,650 Mt.

C.1 Installation kit on-line

- Open the packaging that holds all the pieces.

This operation must be carried out by at least two people.

- Install the shoulder on one of the legs of the MATIC TRIM ***(fig. C.1)***.
- Fix the cross beam ***(fig. C.1)*** first to one shoulder then the other using the four screws (TCCE 6x50) and bushes supplied ***(fig. C.2)***.
- Fix the other shoulder on the opposite leg and tighten all the screws.

Attention the side of the shoulder has different size holes. The side with the bigger holes should face outwards to insert the bushes.

Fig. C.1



Fig. C.2

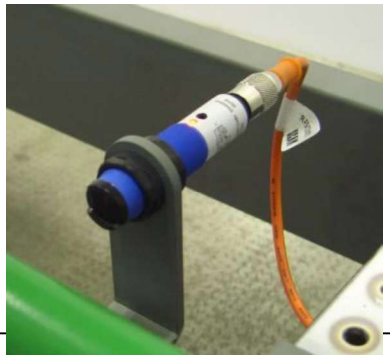


- Screw the spacing guides on the cross beam ***(fig. C.3)*** with the inlet tensioning roller of the printed media.
- Screw the reading sensor ***(fig. C.4)*** of the printed media to the cross beam on the same side of the marker reading sensor.

Fig. C.3



Fig. C.4



- Slide the banner tightened roller in the toothed guides ***(fig. C.5)***. Be very careful to linearity when inserting the roller, to assure a uniform pressure along the entire printed media.
- Always fix the machine stop mechanical micro on the side of the detection sensor. The micro stops the machine when the printed media does not assure the proper operation of the trimmer ***(fig. C.6)***,.

Fig. C.5

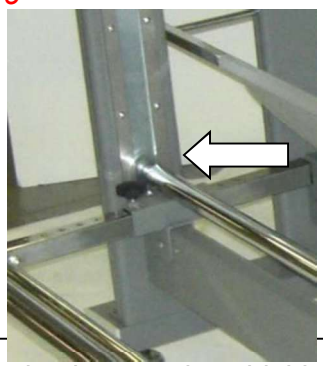


Fig. C.6



Remove the back protection shield ***(fig. C.7)***.

- Slide in the appropriate eyeholes in the back sheet ***(fig. 6.8)*** the two wires with connectors of the two sensors and connect them in the following way: the sensor **A** to the electronic board ***(fig. C.9)***, and the micro to the faston connector **B** ***(fig. C.10)***.
- Reassemble the electronics protection shield.

Fig. C.7

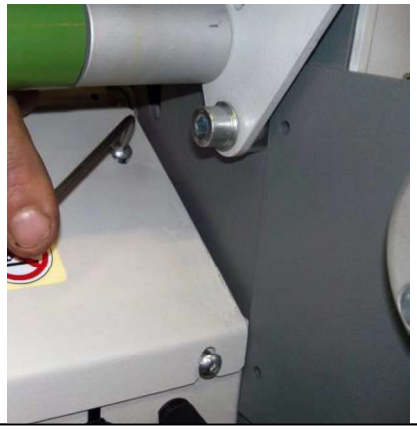


Fig. C.8

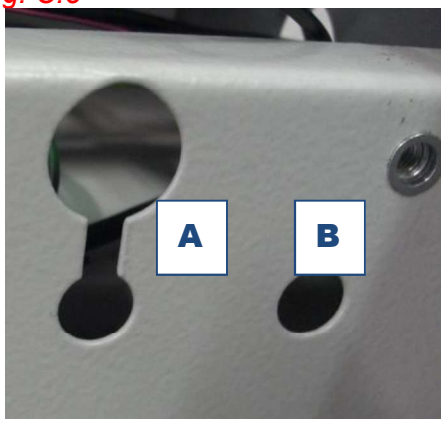


Fig. C.9

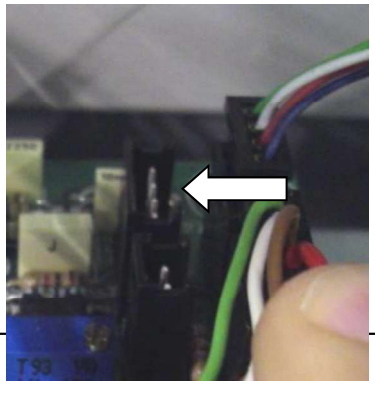
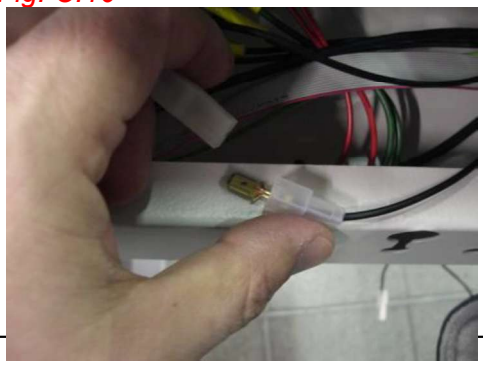


Fig. C.10



Considering the weight of the machine two operators should perform this operation. Use protection gloves to optimize grip on the machine.

- Put the return roller group on the shoulders assembled earlier, by sliding the shaped roller in the aluminum roll holder guides on the back shoulders of the trimmer ***(fig. C.11)***, screwing the shoulders of the return roller group to the shoulders ***(fig. C.12)***.

Fig. C.11

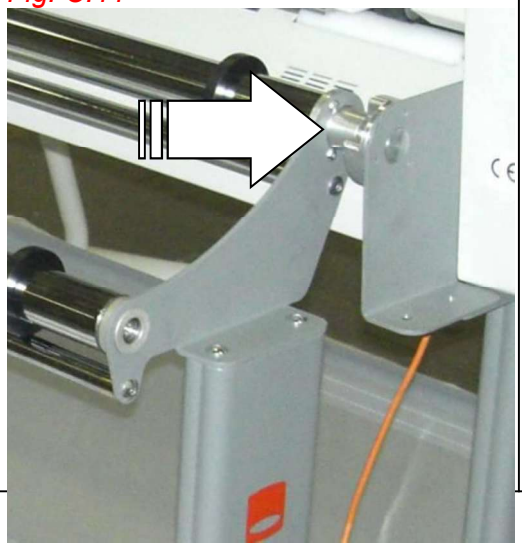
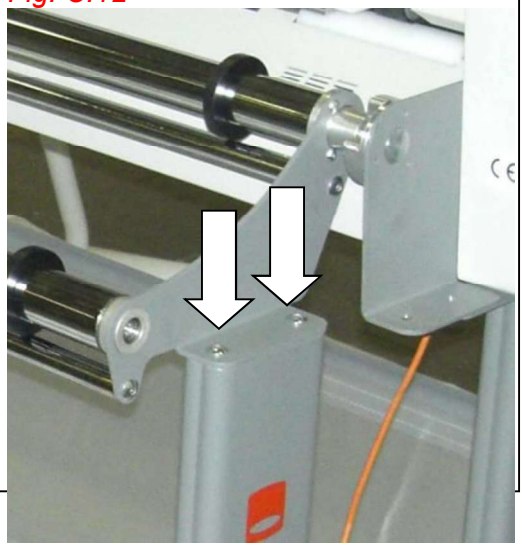


Fig. C.12



- Tighten all the screws.
- Connect the trimmer to the mains and switch it on ***(fig. C.13)***.

Fig. C.13



C.2 Use

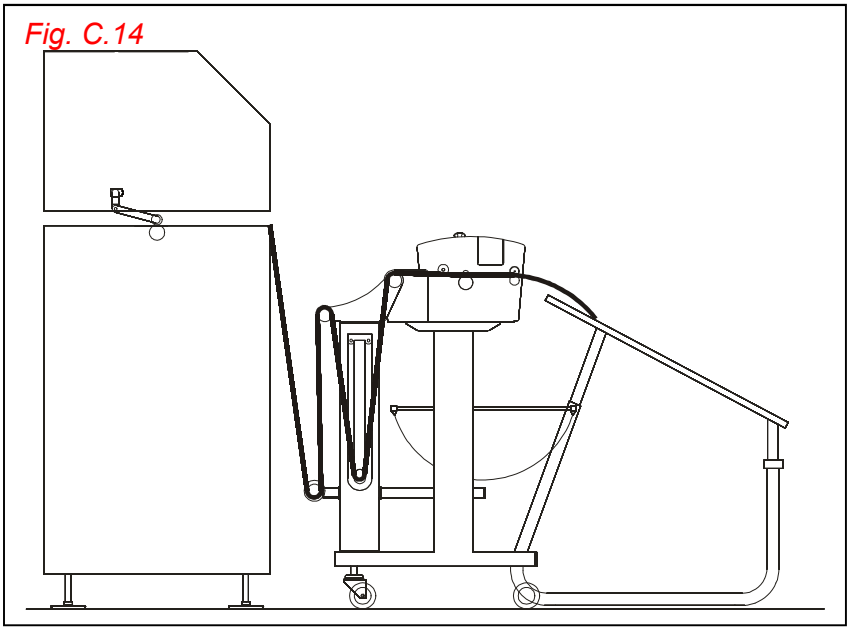
Automatic cycle in "InLine" modality

These operating modalities can fully exploit the potentialities of the trimmer. The prints must be marked by markers that are then read by the sensors of the machine and enable a precise and automatic lining up of the media.
To function correctly the trimmer must know which type of marker is being used, the dimensional quality of the markers and the type of material.
The markers considered are three types:
CROSS, LINE and DOUBLE LINE.
The **cross** is the type of marker placed on the side of the print in the white field at the head and end line of the print .
The **line** is a marker placed on the sides in the white field at the beginning/end of the prints.
The **double line** is the marker that is always placed in a white space between two adjacent prints.
This information can be given to the trimmer in two ways, either through self-learning making the sensor directly read the marker or by manually entering the values of the marker. All types of marks must be intense black and with minimum width of 0.5mm.

Feeding media to cut ("InLine" modality)

In "InLine" modality the trimmer is used to cut pre-printed media with markers and with trimmer directly in line with the printing plotter. The feeding and cutting functions are directly controlled by the software of the trimmer. The machine must be fed according to the direction shown in the illustration. ***(fig. C.14)***.

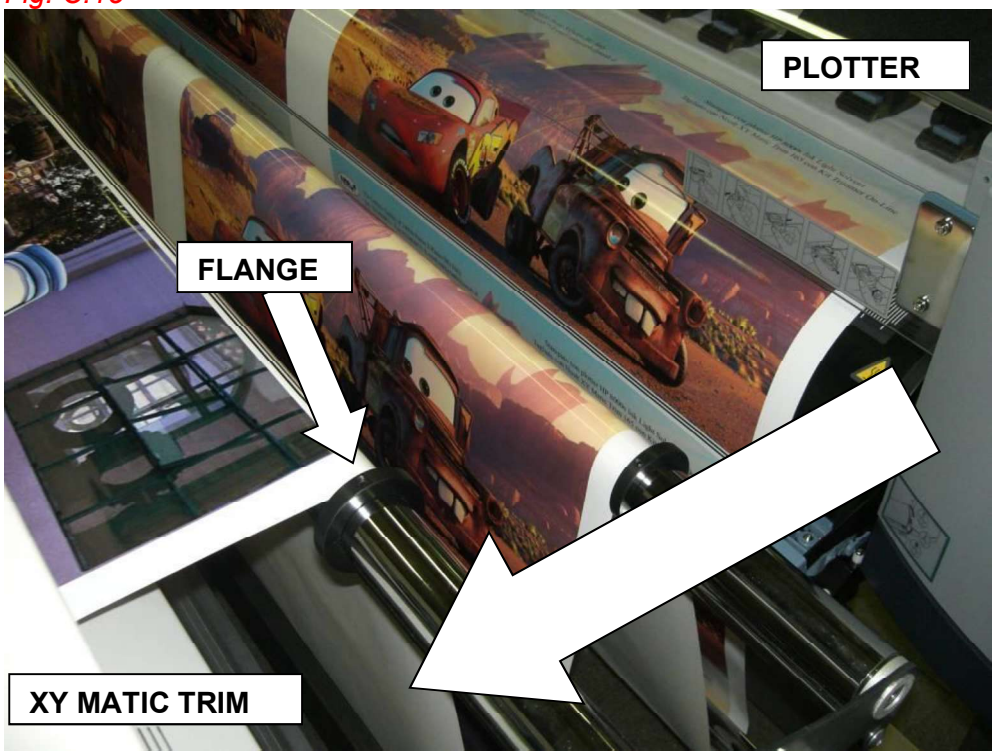
Fig. C.14



Follow this procedure to feed the media into the machine:

Make the printed media follow the path indicated in the illustration above. Make sure the printed side always passes inside the rubber rollers to avoid ruining the print. Afterwards adjust the holding flanges ***(fig. C.15)***.

Fig. C.15



- Open the upper protection panel using the using the opening mechanism under the central handle ***(fig. C.16)***. After lifting the panel, place the media on the feeding rollers ***(fig. C.17)*** and line up with the cutting line, close the panel and verify that the lateral hooks click into position.

Fig. C.16

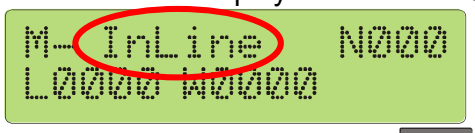


Fig. C.17



Set up the trimmer in the following way:

- Verify that the display shows "**InLine**" otherwise press D. / M., pressing + or − until the display shows "**InLine**"



- Confirm by pressing (ENTER) ↵.

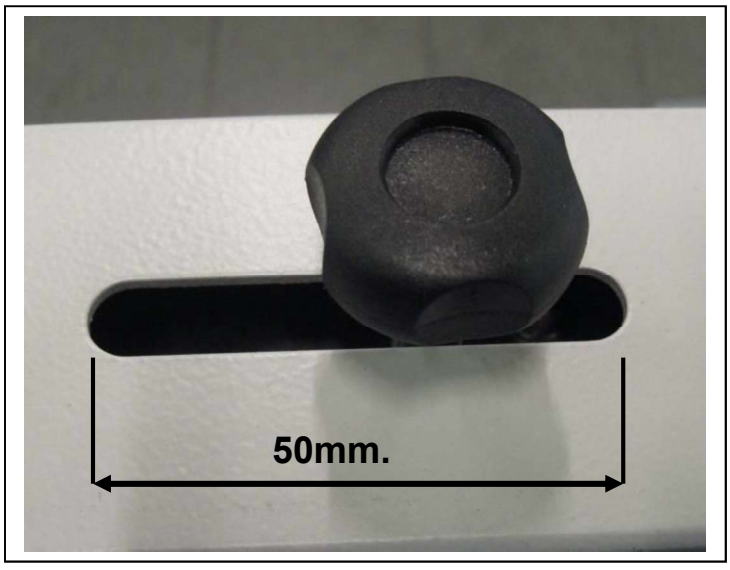
Positioning and adjustment of the marker sensors

The marker sensor has three main adjustments

- Horizontal adjustment.
- Vertical adjustment or optical focus.

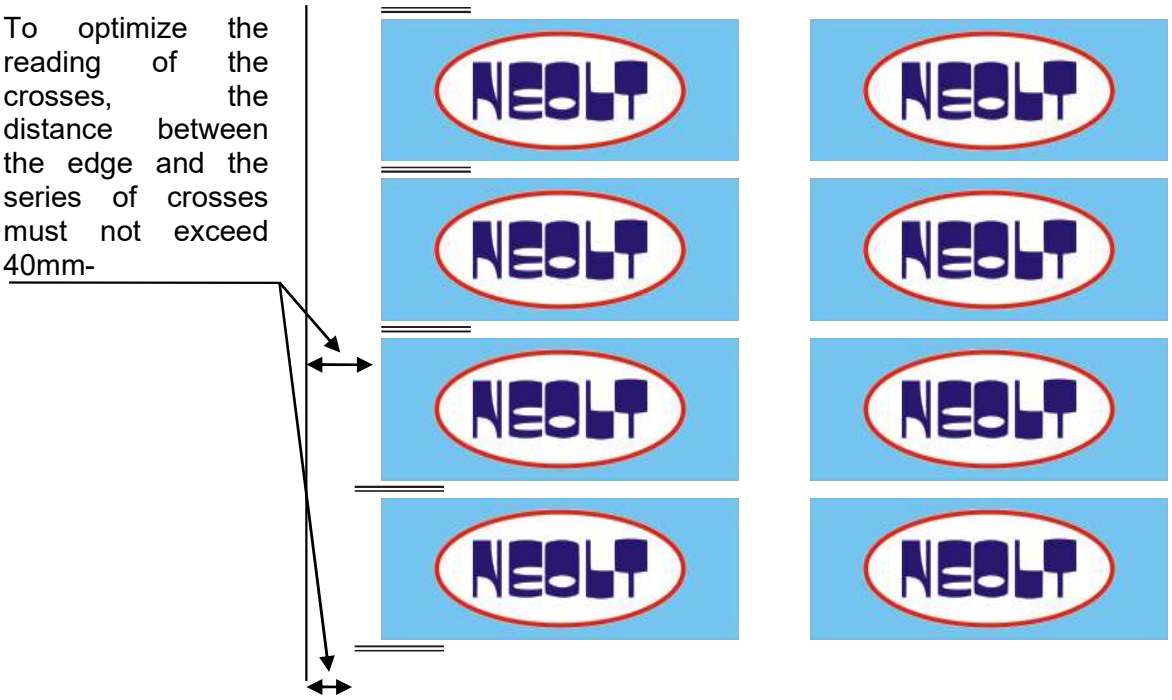
Horizontal adjustment

All media is printed in a different way with margins that can vary from roll to roll. It is possible to adjust the sensor from 0 to maximum 50mm. by using the horizontal adjustment knob.

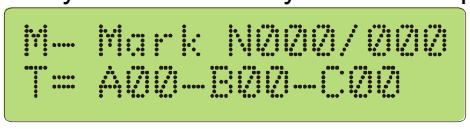


Naturally even the media are printed according to certain rules, such as:

To optimize the reading of the crosses, the distance between the edge and the series of crosses must not exceed 40mm-



Adjust the sensitivity of the optical sensor in the following way to optimize the reading of the markers, and have a more precise cut, this operation is recommended before any change of material.

- Insert a white sheet of paper under the sensor. Verify that it is tightly pulled between the front and back rollers ***(fig. 6.14)***.
- Press the key  or the key  to display the following information on the display 

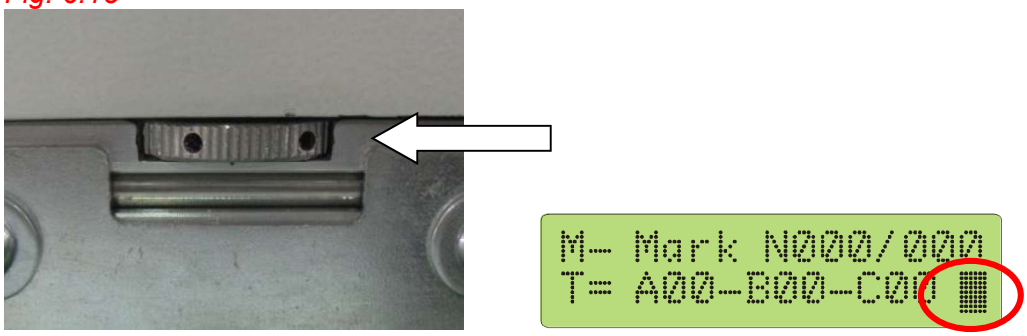
.
- Verify that the light beam of the sensor is right above the white background of the media ***(fig. 6.14)***.

Fig. 6.14



- Turn to the right the adjusting little wheel until when you see a black rectangle, that means the sensor has reached the limit of its adjusting range in that direction. At this point, we turn the little wheel to the left counting the number of rotations we had carried out before having seen the black rectangle itself that identifies the limit of the adjusting range in this direction.

Fig. 6.15



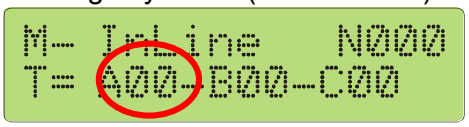
- The number of rotations identifies the adjusting range inside which the sensor can work on the material to be cut. In other words we move the sensor up and down so that it could be always able to read the material properly. Therefore, having found a limit, if we carry out a certain number of rotations in reverse way like the half of rotations necessary to reach the opposite limit, we are sure the sensor is the farthermost from the right and left limits and from its adjusting range, and so the material reading will turn out to be precise. Thus, if we have turned the little wheel of N rotations to reach the left limit, we need to turn of N/2 rotations the little wheel itself to the right to get the best sensor regulation.

Preparation for the automatic cut in In Line modality

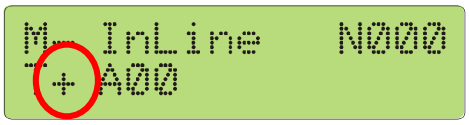
After adjusting the position of the sensor, by adapting it to the fed media, enter the data to allow the machine to recognize the cutting markers.
The information on the marker can be entered in two ways, manually or it can be detected automatically, after selecting the type of marker (cross, line, double line).

- Pressing  or  show the following information on the display



- To select the marker. Press the following key once (DIMENSION)  the letter "**T**" starts flashing on the display 

, press  or  to change the symbol on the side

- "**+**" cross 

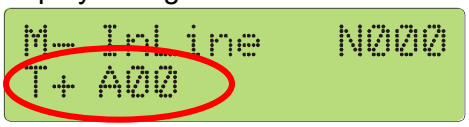
- "**-**" line 

- "**=**" double line 

- After selecting the best marker press (ENTER)  to confirm or press (STOP)  to exit function without saving.

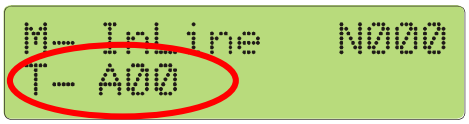
According to type of marker the display changes:

- Cross



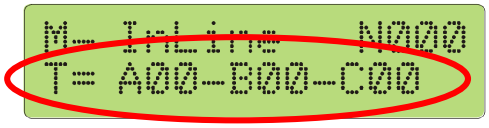
.

- Line



.

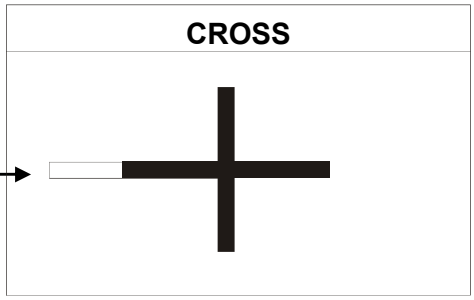
- Double Line

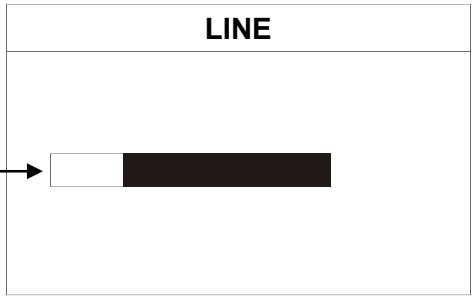


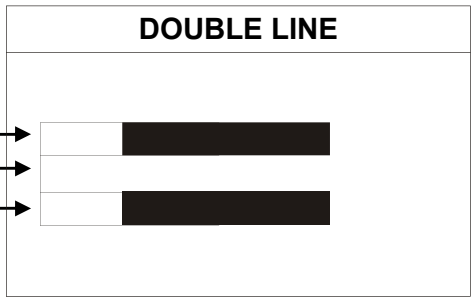
.

Where "**A**-**B**-**C**" indicate the thickness and distance values from the marker lines.

Value "**A**" identifies the thickness of the line for all types of markers.







Value "**C**" identifies the thickness value of the second, valid only for the double line

Value "**B**" identifies the distance value between the two lines, valid only for the double line

Value "**A**" identifies the thickness of the line for all types of markers

As said previously, the values of the marker lines can be entered in two different ways, manually if you know the values or having the machine detect them automatically (suggested).

To have the machine detect them automatically follow this procedure:

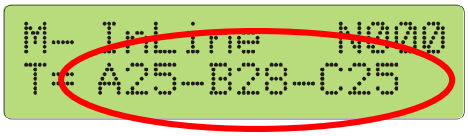
- Position the marker before the sensor (3/4cm).
- Press (Space CUT) 

letter "**A**" (Cross and Line modality) or "**A**-**B**-**C**" (Double Line modality) start flashing on the display.
- The media moves passing under the sensor which detects the marker values automatically. If the cross is not detected by the sensor adjust the height or the focus. After reading, the media is automatically brought into start position. When the key (Space CUT) 

is pressed a second time the reading operation is repeated. If it confirms the previous data, the media is brought back to start position, if the values are different, the reading error is displayed. When the key (Space CUT) 

is pressed a third time, the reading operation is repeated. If it confirms the previous data, the media is brought back to start position, and so on for the following times the key is pressed.

- To confirm the displayed values press (ENTER) .
- The values are expressed in tenths of millimeters.

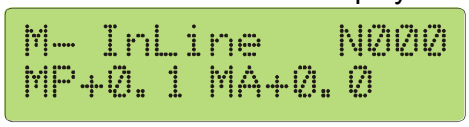




If the markers are entered by the user during the creation of the file, we suggest keeping a line thickness between 1 and 2 mm.

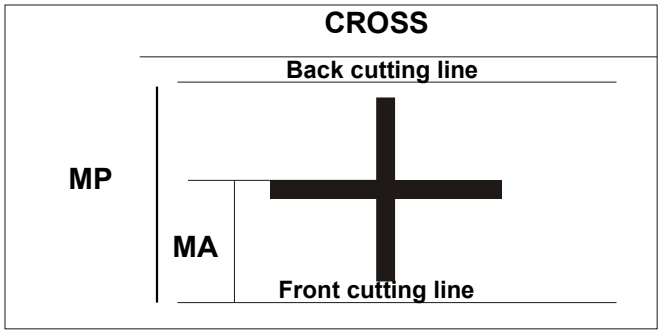
Now enter the data to identify the cutting line in relation to the marker. These are values to enter manually, identifying them on the media in the following way:

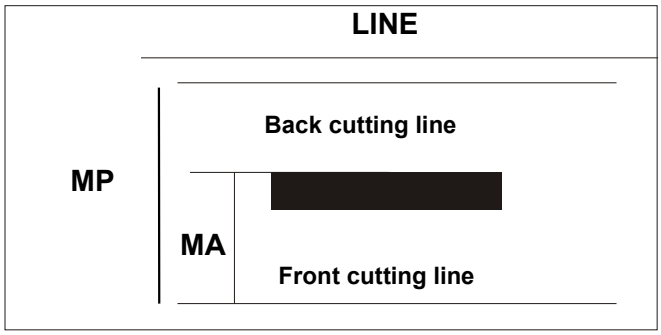
- Press  or  to display the following information

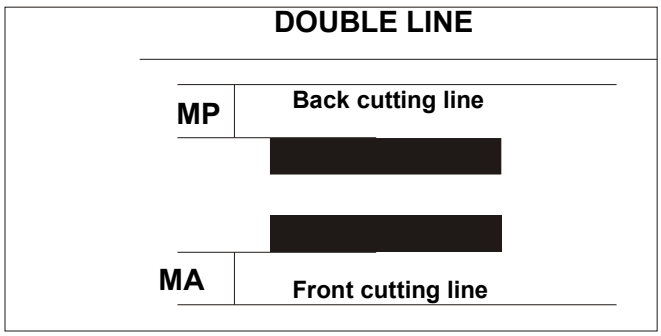


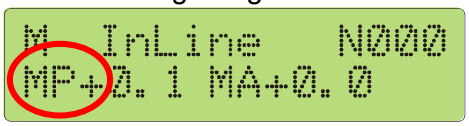
"**MP**" is the distance or margin between the upper edge of the marker and the back cutting line. Whereas "**MA**" is the distance or margin between the upper edge of the marker and the front cutting line.

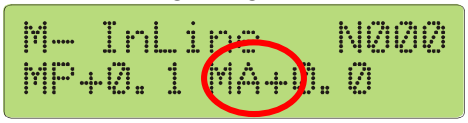
MP= Ø
Execute only one cut and advances without deleting the cross





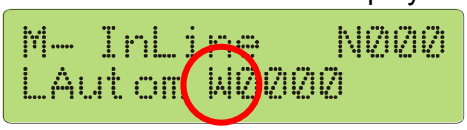


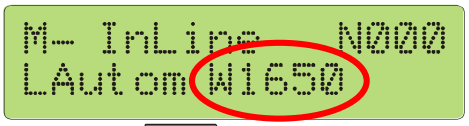
- To enter the cutting margins. Press this key once (DIMENSION)  the letters "**MP**"  start flashing on the display, press  or  to set the measure in tenths of a millimeter.
- The range of values goes from 0 to 9,9mm.
- Confirm the set parameter by pressing (ENTER) .

- To enter the cutting margins. Press this key twice (DIMENSION)  the letters "**MA**"  start flashing on the display, press  or  to set the measure in tenths of a millimeter.
- The range of values goes from 0 to 9,9mm.
- Confirm the set parameter by pressing (ENTER) .

<u>Enter the sizes of the image format and of the reel:</u>

- Press the key (DIMENSION)  once. The program by default sets the size "**L**" on "**Autom**" and enables only the modification of the parameters referred to the width of the media inserted with the flashing of the letter "**W**". Press "**+**" or "**-**" to set the width of the reel. The display shows the values in mm. or inches.

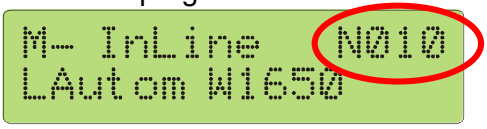




- Confirm the set parameter by pressing (ENTER) .

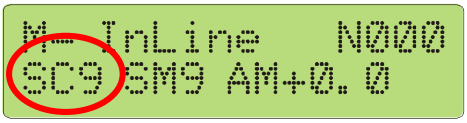
Insert the number of copies to trim:

- In this modality the key (COPIES)  is disabled so the display shows the number of progressive cuts that are done by the machine.



Horizontal cutting speed:

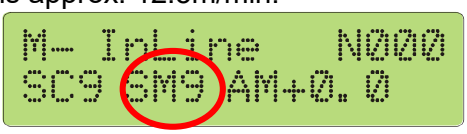
- The horizontal cutting speed can be adjusted according to the media to trim. To change this parameter move to the second window on the display using the keys  or . Press (MOTOR SPEED COTNROL)  once, the letters "**SC**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 40m/min.



- Confirm the set parameter by pressing (ENTER) .

Feeding speed for vertical cut:

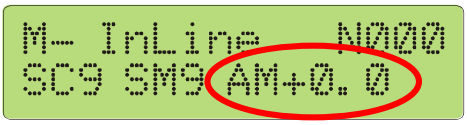
- The feeding speed for the vertical cut can be adjusted according to the material to trim. If the display shows something different from the image below use  or  to change the display. Press (MOTOR SPEED COTNROL)  twice in a row and the letters "**SM**" start flashing on the display, press "**+**" o "**-**" to set the speed of the carriage. The speed varies from a minimum of "1" to a maximum of "9" which is approx. 12.5m/min.



- Confirm the set parameter by pressing (ENTER) .

Adjusting the media feeding speed:

- The feeding speed for the vertical cut can vary according to the media to trim and the motor sensors can in the long run generate delayed or early parameters that can be corrected easily in the following way:
- If the display shows something different from the image below use  or  to change the display. Press the key (MOTOR SPEED CONTROL)  three times in sequence. The letters "**AM**" flash on the display. Press "**+**" or "**-**" to set the correction according to the delay or advance time, the value is expressed in tenths of a millimeter or tenths of $^{1}/_{32}$ of an inch, and ranges from -9.9 to +9.9. The value is the correction assigned to 1 linear meter. By changing the media it might be necessary to cut 1 linear meter of product, measure it and enter the difference in "**+**" or "**-**" as correction.

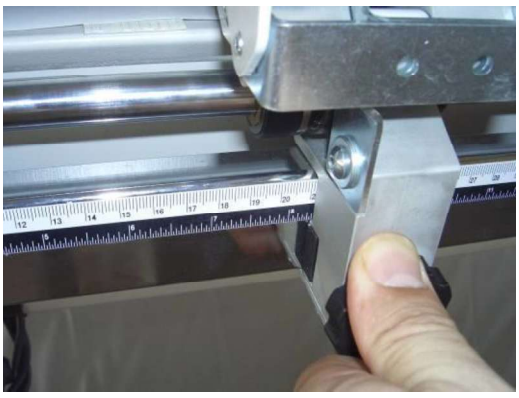


- Confirm the set parameter by pressing (ENTER) .

After setting all the parameters that the trimmer can use in automatic mode, it is necessary to position the two blades for the vertical cut. Loosen the knobs that block ***(fig. C.20)*** the cutting heads and making them slide along the sliding bar, using the millimeter scale position them correctly, or if there are already printed edges, in order for the image to be trimmed along these edges, so that the final result is an image trimmed on all four sides.

Fig. C.20





Press start  to run the cut in sequence. The operation stops when the sensor does not detect any more markers. Everything depends on the printing speed of the plotter used for the operation.



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