intec
PRINTING SOLUTIONS

LCF215

OPERATIONS MANUAL

Manual Version 1.1

Thank You for Selecting an Intec Printing Solutions Product

At Intec Printing Solutions we are committed to serving you, our customer. Our goal is to provide you with competitive, quality products and services to meet your needs. Customer input is of great value to Intec; therefore, we encourage any comments or suggestions.

The instructions contained in this manual are intended to ensure the safe installation, operation and maintenance of your machine. Please read this manual carefully before performing any activity on the equipment. Please note information contained in this manual does not modify or alter, in any way, the standard terms and conditions of your Intec Printing Solutions purchase contract.

This manual should be readily accessible to operating and maintenance personnel at all times. Proper use of this manual, in addition to other Original Equipment Manufacturer's manuals and your in-house manuals, will assure safe, reliable and cost-effective performance of Intec machinery.

If you are in need of service, please contact our Technical Support staff as instructed on the following pages. In order to expedite your request please include the serial number of your machine. Each Intec Printing Solutions machine has a label identifying its serial number.

General Information

Intec Printing Solutions (Hereafter known as Intec) Operating Manuals and Addenda provide a general understanding of the operation of the contracted system, its major components and the functional elements of those components.

The Manuals and Addenda contain Safety, Description, Installation, Operation and Maintenance information. We strongly recommend thoroughly reading and understanding the information in this manual before operating this equipment. If additional information is required or clarification needed, feel free to contact Intec.

Receiving and Inspecting the Equipment

Inspect the Intec equipment immediately upon arrival at the installation site as follows:

- Note any visual in-transit damage to the packing crate or the equipment on the carrier's delivery slip.
- Report any concealed in-transit damage to the delivery carrier and to Intec as soon as it is discovered. When possible, take pictures for claim purposes.
- Cross-reference amounts received to amounts shipped as indicated on the packing lists forwarded with the machinery. Report shortages and/or defective material immediately to Intec customer service office.
- Intec may require defective components to be returned in order to issue credit under warranty. Do not return any items without first contacting Intec and obtaining a Return Authorization.

Disclaimer of Warranties and Limitation of Liabilities

Intec Digital Printing Systems are warranted free of defects in both materials and workmanship. Should any part of this equipment be defective, it will be repaired or replaced, at the option of the manufacturer, at no charge for parts or factory labour for a period of one (1) year from the date of installation. All warranty services are performed at the Intec factory. Replacement parts not installed at the factory will be billed to the customer at regular prices and credit will be issued when the defective parts are returned. The customer is responsible for freight on warranty parts and repairs.

This warranty is void if:

The equipment has been damaged by negligence, accident or mishandling, or has not been operated in accordance with the procedures described in the operating instructions;

or:

The equipment has been altered or repaired by other than an approved service station or factory service centre, or adaptations or accessories have been attached to the equipment that shall have adversely affected the performance, safety or reliability of the equipment.

NO OTHER WARRANTY, EXPRESSED OR IMPLIED, APPLIES to the equipment. Intec does not assume any responsibility for consequential damages occasioned by the equipment, or inconvenience or interruption in operation.

In case of unsatisfactory operation, Intec or its Dealer should be notified immediately.

Intec Technical Support

Intec Printing Solutions Limited has a dedicated and committed customer services and technical support team ready to assist you.
Our engineers and support technicians are all fully trained and are qualified to provide service and support on all the products we manufacture.

Phone: +44 (0) 1202 845960 option 5
Fax: +44 (0) 1202 845961
E-mail: support@intecprinters.com

Specifications

System Data:

Contour Cutting	Full HPGL vector cutting compatible with SMARTMark opto-electrical line sensor
Average Speed	10 feet/min | 3.04 meters/min
Web Width	4 to 8.5 inches (100 - 215 mm)
Max Frame Length	14 inches | 35.5 cm
Max Input Roll Diameter	8 inches | 20 cm
Max Output Roll Diameter	8 inches | 20 cm
Recommended Roll Length	500 feet | 153 meters
Make Ready Waste	4 feet | 1.2 meters
Cutting Technology	Pivoting carbide tip - 30, 45 & 60 degree
User Interface	Touch panel display
Test Cut Function	Yes
Warranty	Limited Liability 1 year

Network Connections:

Ethernet	• 100BASE-TX • 10BASE-T
USB	High Speed 2.0

Power Requirements:

LCF215 label finisher:	720 watts voltage input ranges 100 -240 VAC / 47-63 Hz

Dimensions and Weight:

Depth	21 inches | 53 cm
Width	31 inches | 79 cm
Height	22 inches | 56 cm
Weight	185 Lbs. | 85 Kilograms

Items Shipped Unassembled from Machine

An accessory kit is shipped with the equipment in the crate. These items are required for operating the LCF215 finisher. The tools included in this kit are specifically sized for the machine and should be stored nearby for easy access. The kit contains the following items:

Accessory Kit:

Component ID	Description	Qty
30040018	Weed Bar O-Rings	12
40239063	AC Power Cord, Country Specific	1
DT-00-11-141	Web Centring Gauge	1
DT-00-11-202	T-Handle Wrench 1.5 MM	1
PL-00-03-533	CD, Software/Documentation	1
DT-413	Cut Strip Removal Tool	1
F-045	5A Normal Blow Fuse	2
F-054	2.5 A Slow Blow Fuse	2
H03-032	Pinch Wheel Spring (Medium Tension)	4
H05-353	Ethernet Crossover Adapter	1
H05-361	Black CAT 5E Ethernet Patch Cable, 14ft	1
H05-360	USB Cable, 10ft Grey (A Male to B Male)	1
H21-021	3.0 MM Hex Key Wrench (L Short Arm)	1
H21-022	2.0 MM Hex Key Wrench (L Short Arm)	1
H21-023	1.5 MM Hex Key Wrench (L Short Arm)	1
H21-024	4.0 MM Hex Key Wrench (L Short Arm)	1
H21-010	3/32 IN Hex Wrench (L Shaped)	1
LS-179	7/64 IN Hex Wrench (Long)	1
H20-007	45 Degree Knife Blade (Red Cap)	1
H20-008	60 Degree Knife Blade (Green Cap)	1
H20-017	30 Degree Knife Blade (Blue Cap)	1
PL-00-02-865	Control Dept Knife Holder	1
PL-00-02-867	Advanced Control Dept Knife Holder (Gold)	1

If the slitter add-on was purchased, the following parts will be included as well:

CN-016-10	Slitter Blade 10pk
DT-149	Core Partition Flange

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1.0.0 Introduction

The LCF215 Digital Label Finisher is shipped assembled. However, it must be properly unpacked, installed and setup to run prior to operating. This manual will guide you through this process.

1.0.1 Safety

For your own safety, read this instruction manual before operating the equipment.

Knowledge of the machine's components and specific hazards will minimize the possibility of accidents and injury.

Wear proper clothing. Do not wear loose clothing, neckties, necklaces, or jewellery which may be caught in moving parts. Shoulder length hair and longer should be pulled back and secured at all times to prevent catching in equipment.

Keep your work area clean and well lit to prevent tripping or accidently placing arms, hands, and fingers in danger.

An Emergency Stop push button located on the front of the machine near the cutter. Do not use the E-stop to power off equipment unless there is an emergency.

1.0.2 Site Preparation

The following are guidelines for preparing the customer site for installation of the Intec equipment.

Location:

1. Provide a sturdy level area for equipment weighing 200+ lbs.
2. Provide adequate clearance around the machine to allow easy access for inspection and maintenance.
3. Ensure there is an appropriate power source and ethernet connection nearby.

Power Requirements:

Use of a HIGH QUALITY surge protector or interruptible power supply is REQUIRED by Intec. Failure to do so could affect your warranty coverage if a problem arises due to improper power connection!

Risk of Electric Shock - *The power cord is a three-conductor cable that uses a safety (earth) ground connection. The power cord must be plugged into an outlet that has an earth ground contact. NEVER plug the power cord into a two-prong outlet by using a 3=2 cord adapter.*

Risk of Electrical Fire - *NEVER allow roll or sheet goods to rub on the power cord as material may damage the cord causing an electrical fire hazard!*

Power Configuration:

Intec products are factory preset for the power requirements of the destination country. The machine configuration is indicated on the power input module as either 115V or 230V.

Changing the Fuse Configuration:

1. Disconnect the AC power cord from the fuse block on the power input end panel.
2. Open the fuse block cover with a small flat screwdriver and pull out the fuse block.

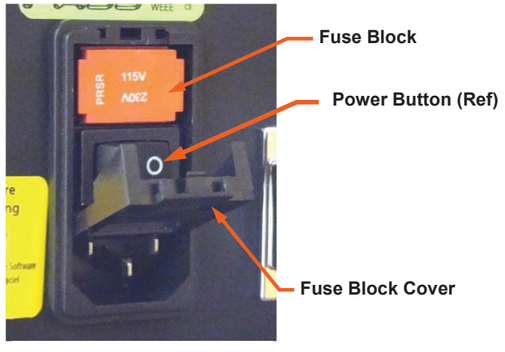


Figure 2: Fuse Block Access

1.0.2 Site Preparation

Changing the Fuse Configuration (continued):

3. Reverse the position of the fuse block so that the desired voltage will appear in the fuse block cover.

Figure 3: Fuse Block

4. Close the fuse block cover and verify that the desired voltage is showing.

Risk of Electrical Fire - *Do not change the fuse location in the fuse block. Do not put a 5-amp fuse in place of a 2.5-amp fuse. Do not put a 2.5-amp fuse in place of a 5-amp fuse.*

1.1.0 Installation of LCF215 Digital Label Finisher

1.1.1 Setup Finisher

The LCF215 Finisher is a tabletop label finishing device. Once removed from its crate, place the unit on a table that can support 200+ Lbs (90 kg).

1.1.2 Connection to PC

Do not connect the LCF215 finisher to the computer until told to do so by the installation cd.

1.1.3 Intec Printing Solutions Installation Disc

The finisher utilizes either USB interface or Ethernet connection to the computer.

The LCF215 comes with an installation CD that will walk you through connecting your equipment to your computer and installing software.

The Setup CD contains:

1. An installation program that walks you through connecting your LCF215 finisher to your computer.

2. The Remote Panel Utility program for managing finisher settings.

3. A current revision of firmware. "Firmware" is software that controls the machine functions. The firmware on this disk is provided for backup purposes and should not be installed on new machines.

4. The DirectCut printer driver. This driver has been tested with AllenCAD, CorelDRAW (versions 10-x8), Adobe Illustrator (versions 10-CC), Flexisign, and PowerCAD. It should also work with any program that sends vectors rather than bitmaps to the driver. The DirectCut printer driver allows cutting directly from windows graphics programs without requiring additional software purchases.

Note: *DirectCut requires ownership of Intec Printing Solutions Equipment to use. Requires: Windows 8, Windows Vista, or Windows XP.*

5. During installation a test cut is performed to verify communication with the finisher. (no blade or material necessary)

6. Users Manual and sample jobs.

1.2.0 Setting up your label job

Files are created to add registration marks and cutting paths to label artwork. Once this is done, a “Cut” file is created using DirectCut to send the information to the LCF215 Digital Label Finisher when the media is processed through it.

1.2.1 Explanation of SmartMark

The SmartMark™ for i-TECH cutters is an optical registration system that ensures accurate cutting of pre-printed graphics. The SmartMark™ system can recognize up to three registration marks per frame allowing adjustments for scale and skew discrepancies that may occur.

The SmartMark™ sensor recognizes the change in contrast from the background of the media to the printed mark. The sensor sends a signal when the mark is scanned by the finisher to have the software calculate the position of the scanned mark and matches it with its corresponding origin point of the cut file.

The registration mark(s) and die line(s) define the cutting area for each “Frame” of the printed label media. A registration mark and a die line must be created to use with the label artwork so that the LCF215 Finisher can cut the labels accurately. This is done by creating a new file that contains the artwork and registration mark on one layer and the die or cut line on a separate layer.

1.2.2 Registration Mark Placement and File Creation

Follow the steps below to create the new label-cutting file with the registration mark set to “origin”.

1. Open an existing working artwork file (pdf, eps, Ai, CorelDraw)

2. Make the art board height equal to the label media width. This helps to visualize the actual size of the frame on the material.

3. Name the current layer with your artwork “Artwork”.

4. Click on the rectangle tool; its properties should be set to black fill with no stroke.

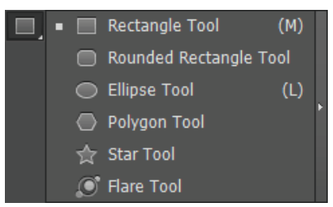
5. Click in the upper right area of the art board and create a box that is ¼” square.

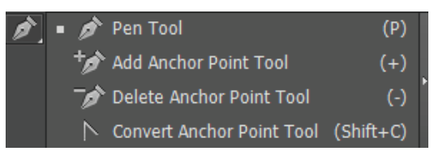
6. Create a new layer and label it “Die Line”.

7. Make the “Die Line” layer active.

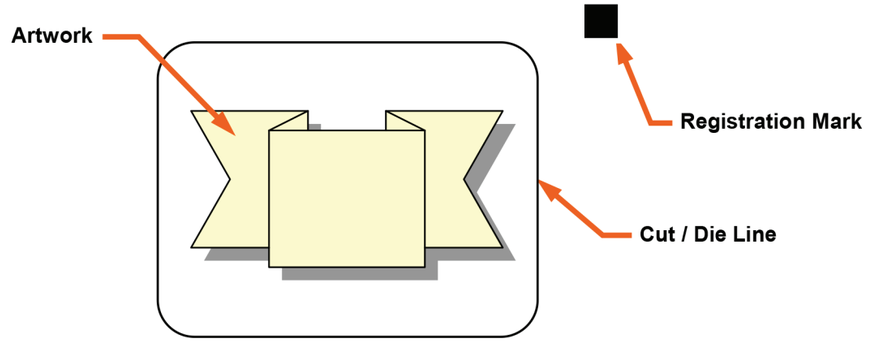
a) If you have it available from another file, cut (ctrl+X) and paste (ctrl+F) a die line to the die line layer.

b) If there is no die line file, create the die line using the shape or pen tools.





The figure below shows how the elements of the label file looks with the die line and registration mark added.



NOTE: *Die lines are created using “no fill” stroke lines. It does not matter what the stroke weight of the line is.*

8. *Once the die line has been put in the file, centre the label artwork and the cut lines (die line) within the centre of the art board.*

9. *Create a cross-hair to position the square as follows:*

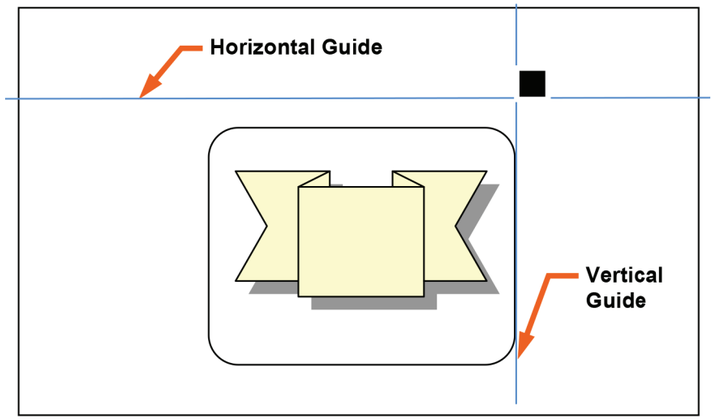
a) *Display the Ai rulers (View menu, then “show rulers”)*

b) *Click on the vertical ruler and drag it to the furthest cut line on the right side of the image.*

c) *Click on the horizontal ruler and drag it to the highest cut line on the top side of the image. Note its location and then move it up another ¼”.*

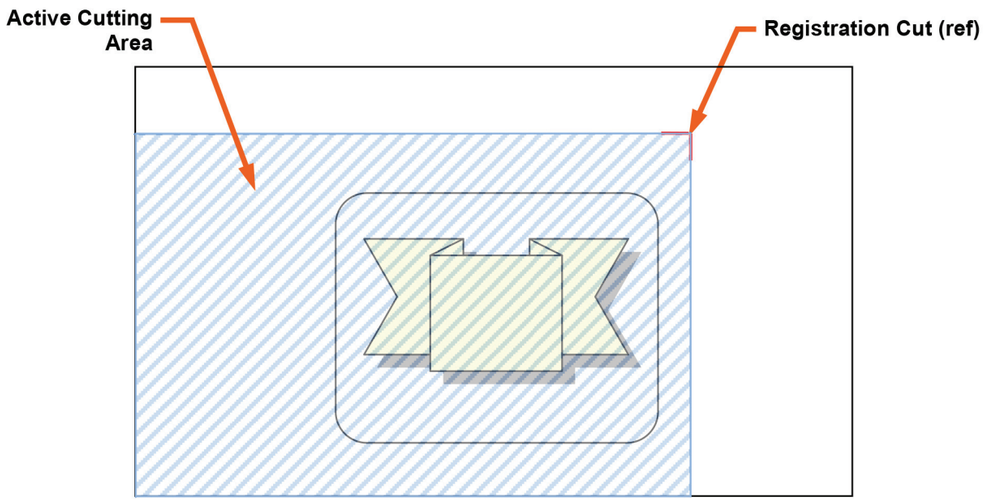
10. *Click and drag the rectangle to align its left edge with the vertical guide and its bottom edge with the horizontal guide.*

The figure below shows the placement of the registration mark with the vertical and horizontal ruler guides.



11. Click the pen tool (set its properties to a no fill stroke line)

12. Hold the Shift key down and click on the SmartMark™ at its top left corner, then on its top right corner, and then on its lower right corner. This will create a line for the registration cut, which establishes the “cut zone”.



13. Toggle the die line layer to hide its visibility.

14. Save the work as an “eps” type file.

15. Print the created SmartMarks onto the roll paper containing the artwork.

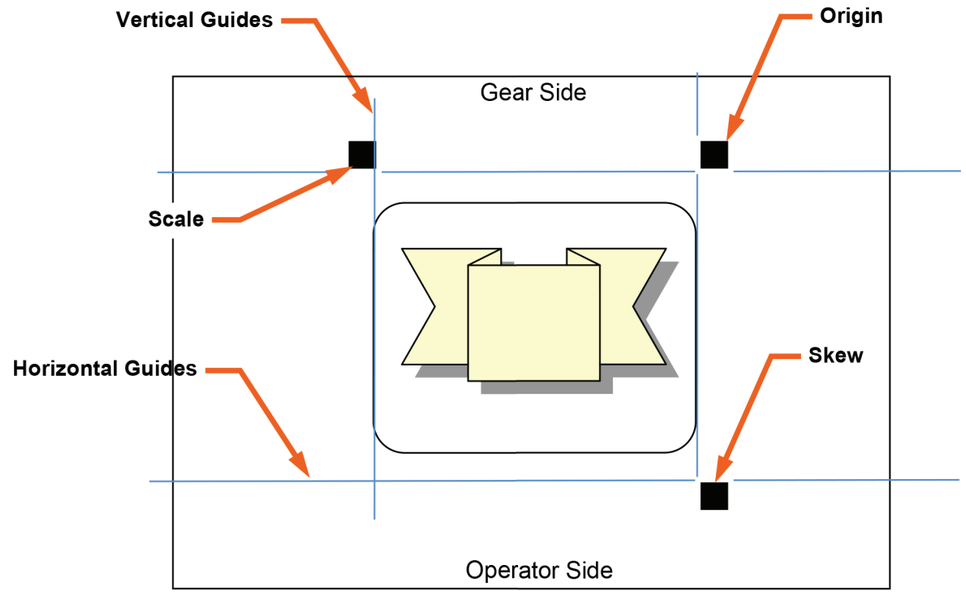
1.2.3 Multiple Registration Marks

Multiple registration marks are generally created when the print itself is skewed or if the labels require intricate cuts. It may be advantageous to use a skew or scale registration mark when multiple labels are created and cut in a single frame.

“Skew” and “Scale” marks are created in the same manner as the original registration mark but located as follows:

1. The Skew registration mark should be located flush to the die line farthest to the right and ¼” down from the lowest die line.

2. The Scale registration mark should be located flush to the die line farthest to the left, and ¼” above the topmost die line.



NOTE: *It is not necessary to add registration marks for each “label” within a frame. Only one set of marks per frame are required.*

1.2.4 Creating the “Cut” File for the Finisher

In “Registration Mark Placement and File Creation”, a file was created to add a registration mark and a defined cutting path to the label graphics file. The next step is to export or “send” this file to the finisher using the DirectCut program. This program tells the finisher where the cutting path is on the media.

1.2.4.1 Creating Plot File with Adobe Illustrator

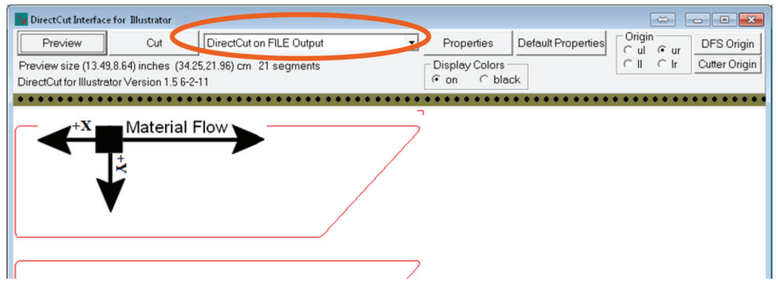
1. Open your label-cutting file (as created above) using Adobe Illustrator.

2. Open the layer window. If the layer window is not visible, you can make it visible by clicking on Window -> Layers.

3. Select the die-lines layer on the layer menu.

4. Click on File -> DirectCut to open the DirectCut program for Illustrator.

5. Verify the drop down box between the Cut and Properties button is set to the finisher, either via USB or Ethernet. Now if we hit the Cut button the computer will send the cutting path to the LCF215 Digital Label Finisher.
Before we do that we want to verify our properties in section 1.2.5 of the manual.



1.2.4.2 Creating Plot File with CorelDraw

1. Open the label-cutting file (as created above) using CorelDraw.

2. Open the object manager. If the object manager is not visible, you can make it visible by clicking on Window -> Dockers -> Object Manger.

3. Select the die lines layer on the object manager tab.
If the DirectCut tool does not appear near the view button, select Tools -> Options -> WorkSpace. Then check Intec Printing Solutions.

4. Click on the DirectCut button to open the DirectCut for CorelDraw preview window.

5. Verify the drop down box between the Cut and Properties button is set to the finisher, either via USB or Ethernet. Now if we hit the Cut button the computer will send the cutting path to the LCF215 Digital Label Finisher.
Before we do that we want to verify our properties in section 1.2.5 of the manual.

1.2.5 DirectCut Properties

Find Origin

1. Click on the properties button

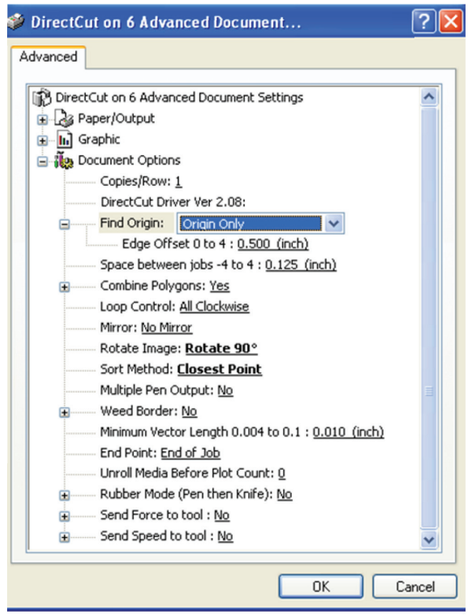
2. Select Find Origin.

3. Select the type of origin you want to use.

a) “Origin Only” is for normal use or when using a single SmartMark™.

b) “Origin Skew”, “Origin Skew Scale”, and “Origin Scale” are used for cutting artwork with more complex shapes per frame.

c) “Edge” is used for cutting blank label when cutting blank labels on unprinted material. The SmartMark™ sensor will detect the edge of the media instead of a registration mark, then offset into the media by that amount chosen by the user in the Direct Cut properties and cuts the blank labels.



Sort Method

This setting changes how the cutter moves from the end of one cut to the beginning of the next. It is recommended to use the sort method “Increasing X” for optimum output path.
Depending on the job, other options may create more efficient cut path’s.

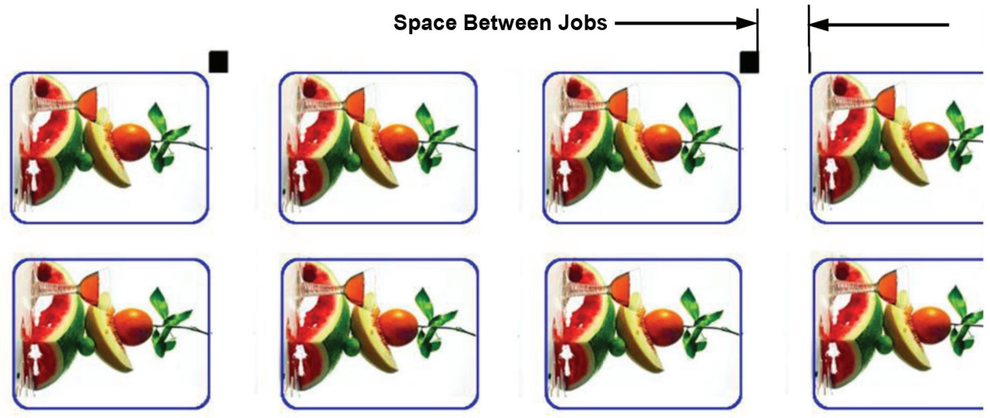
Rotation

In the preview window, select DFS origin. This moves the origin to the upper right on the screen. This matches the view you see when you look at the printed roll from the front of the LCF215. Use the rotate selection in the properties until the origin registration cut or L cut is in the upper right corner of the preview screen. Select rotation from (none, 90°, 180°, or 270°).

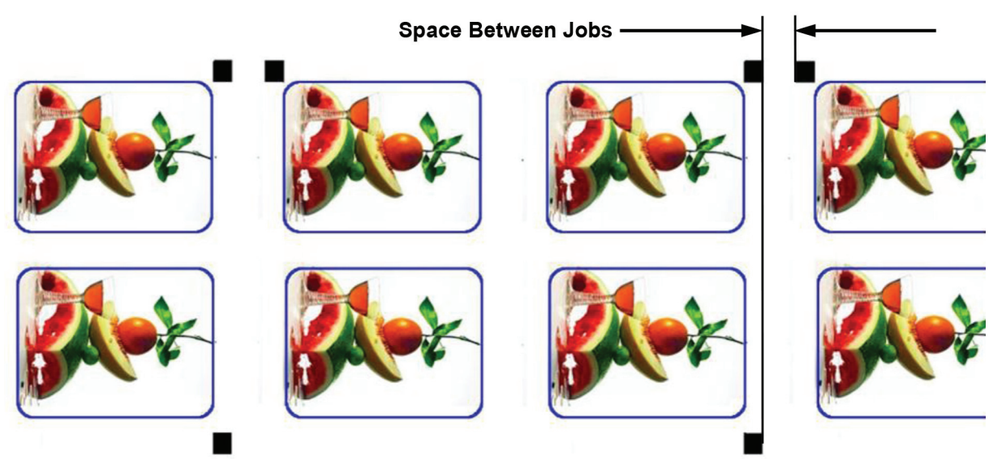
1.2.5.1 Space Between Jobs

The space between jobs tells the system how far to advance the cutting head in order to find the next frames Origin SmartMark. It is the distance between the last cut of the previous frame to the leading edge of the target of the next frame. This is set in the properties menu in section 1.2.5 of the manual.

Example: Space Between jobs with Origin SmartMark only.

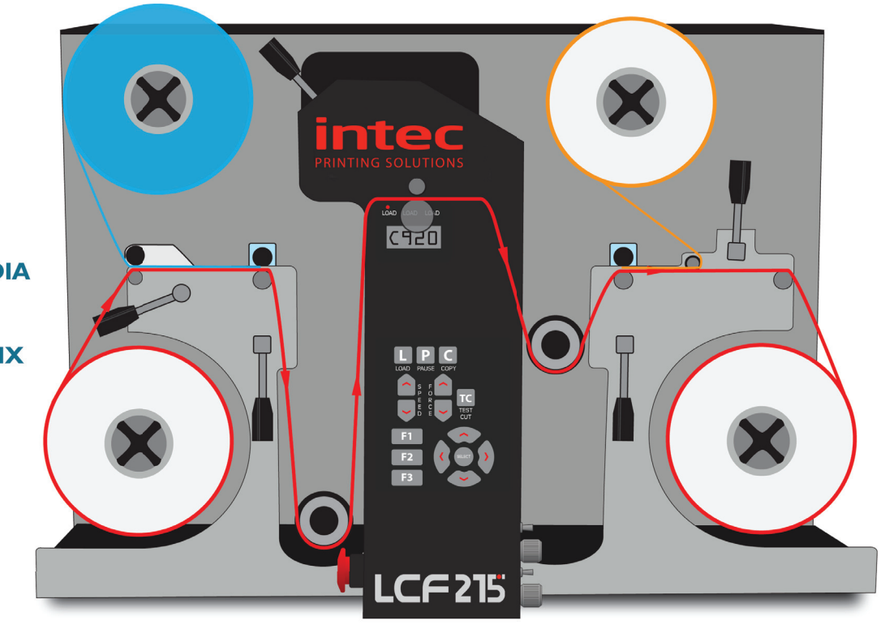


Example: Space Between jobs with Origin, Skew, Scale SmartMarks.



1.2.6 Webbing Guide for LCF215 Digital Label Finisher

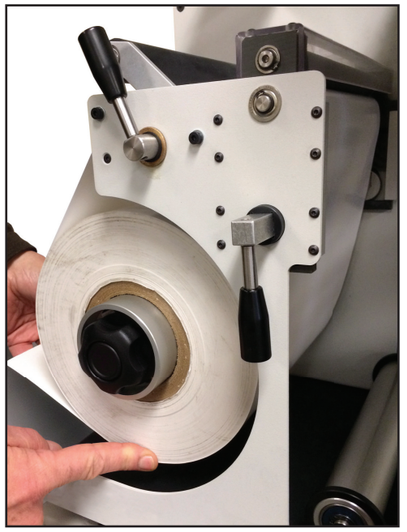
= PRINTED MEDIA
= LAMINATION
= WASTE/MATRIX



1.2.6.1 Webbing the LCF215 Digital Label Finisher

To web the LCF215 Digital Label Finisher follow the steps below:

1. Power on finisher.
2. The 4 web roller guides (black thin donuts) on accumulator arms are factory set for 8.5 in material. If using a different sized material, loosen the donuts.
3. Load label roll & centre underneath the black rubber lamination roller (Smart-Mark towards the gear side).
4. Feed label roll through laminate roller, through nip roller (make sure black lever is up) & back onto itself to check if square. See image to the right for an example.
5. Once the roll is confirmed square, lock down the nip roller by rotating the black lever to the 6 o'clock position. This will hold the material in place.



Once the LCF215 Digital Label Finisher is webbed, a test cut may be preformed to ensure the proper cut depth. The labels should peel out with ease without cutting into the liner.

1.2.6.2 Webbing the Laminate on the LCF215 Digital Label Finisher

1. Load and centre laminate onto upper left mandrel (sticky side up).

2. Pull down laminate over label roll & square with label roll

3. Fold over 1”+ of laminate onto itself as a leader, this way it will not stick to the material when you pass it through the lamination roller.

4. Feed laminate through (under) laminate roller, verify the laminate is square to printed roll, rotate black lever counter clockwise to rotate laminate roller down.

5. Feed 4-5ft of material to web the rest of the system, while doing this you can also straighten/smooth out any wrinkles in the laminate. Do this by:

   a) Press F2 button to start roll.

   b) While material is feeding, open & close laminate roller handle a couple of times to help square laminate to label roll and allow laminate to find it’s true web path. (adjust laminate roll position on mandrel if necessary)

   c) Hit F2 button to stop input nip roller from feeding.

6. Feed media down and under accumulator.

7. Feed media back up and over cutting bed.

8. Feed media under output accumulator & up through output nip. Confirm media is straight & lock down the output nip black lever.

9. Verify roll is square with all loops so far.

1.2.6.3 Webbing test for LCF215 Digital Label Finisher

This quick test will help ensure that the system is webbed as straight as possible.

1. Unlock pinch wheels on cutting platform.

2. Make sure web roller guides (black thin donuts) are loose. If preset from previous run with same roll size, try webbing test first then adjust as necessary.

3. Hit Load Button on front panel of LCF215 Digital Label Finisher, the input accumulator should drop to bottom and the output accumulator should rise to the top. Once accumulators stop moving hit the Load button a second time to disarm the system. Now the red LED next to Load on the front panel of the cutter should be off.

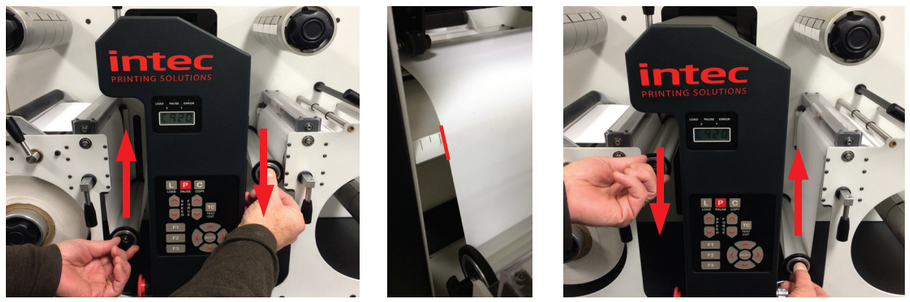
4. With the left accumulator down & right accumulator up – move up & down to check tracking. Grab each accumulator as shown in A, then move accumulators to opposite position shown in C. As you do this watch the paper at B and notice as the output accumulator goes to bottom if the web moves in either direction.

   a) If material runs straight on ruler at B, with little to no operator to gear side movement then the material is webbed straight.

   b) If material moved to operator side then move material towards operator side. To adjust hold end of material before releasing output nip black lock lever, this way the accumulator will not pull material backwards and drop to bottom. Now adjust material to operator side desired amount to square. Repeat webbing test.

   c) If material moved to gear side then move material towards gear side. To adjust hold end of material before releasing output nip black lock lever, this way the accumulator will not pull material backwards and drop to bottom. Now adjust material to gear side desired amount to square. Repeat webbing test.

A. B. C.



5. When straight (within 1/32”), adjust pinch wheels so that each wheel is approximately 0.5” from edge of material, then lock down the pinch wheels by lowering the pinch handle and tighten the web roller guides (black thin donuts).

1.2.6.4 Test Cut on LCF215 Digital Label Finisher

1. Hit load button (arms system).

2. Press and hold the down arrow button to bring out cutter carriage above the material.

3. Press the “TC” button on the front control panel to preform a test cut.

4. Weed the test cut and check for a clean cut without scoring of the liner.

5. If the cut is not deep enough increase the force and/or expose more blade. If liner is cut then reduce force and/or expose less blade. It is best to have the least amount of blade exposed to cut job and apply more force.

6. Once desired cutting force is achieved line up the red LED on the cutting head with the upper right hand corner (flush with top) of the SmartMark.

1.2.6.5 Sending Cut Files to LCF215 Digital Label Finisher

1. Launch Adobe Illustrator (using Intec AI plug-in)

2. Open label in AI (File > Open)

3. Select die-line in layers (will highlight blue)
Cut or die line is in layers dialogue box (if layers box not open, go to top menu bar & select Window > layers (confirm the 'eye' is in the left box to show cut line)

4. Go to top menu bar and select - File > Allen direct cut

5. Rotate original image on screen to match actual roll orientation in finisher (Click properties in direct cut dialogue box; change "Rotation" if necessary)

6. Load cores onto waste matrix & take-up mandrels

7. Web material under silver weed roller (narrow roller that has collapsible side so it can be removed), separate the top layer of material from the liner. Web it over silver dancer arm then attach it to the waste take up (matrix) mandrel. Now web the liner over the silver stationary roller and adhere to lower core.

8. Turn on matrix switch (silver switch on side of controls on finisher)

9. Turn on take-up switch (tension knob controls speed/tension of take up mandrel)

10. Press "cut" button in direct cut window. The finisher will cut one frame. Inspect to see that the cut is acceptable. If not, adjust force or blade depth.

11. If Space Between Jobs was set correctly, hit copy button, use arrows to set # of labels, then hit select

1.3.0 Using Accessories

1.3.1 Weed Bar

The Weed Bar is used when cutting medium to larger sized shapes. The bar is spring-loaded and can be installed or removed without using any tools.

To remove: Push the bar toward the gear side of the machine and lift it out from the operator end to release it.

To install:

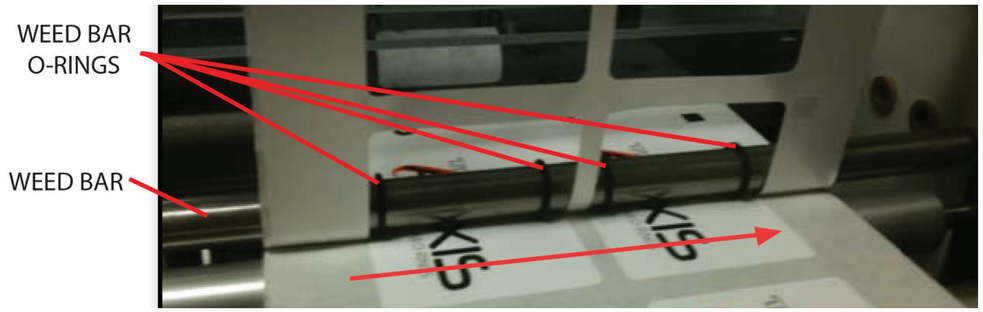
1. Take the o-rings from the accessory kit and install them onto the weed bar.

2. Insert the bar (spring end first) into its mounting hole on the gear side of the machine.

3. Push the bar toward the gear side of the machine while aligning it with the mounting hole on the operator side.

4. Let go of the bar so that it springs into place.

5. Slide o-rings into place so that they will roll over the labels or cut lines.



1.3.2 Weed Brush

The Weed Brush is primarily used when cutting smaller shapes in multiple rows. The brush is mounted on quick-release pins and can be installed or removed from the machine without using any tools. When shipped, the brush is set at its highest setting and may need to be adjusted before initial use.

To remove:

1. Pull out the quick-release pins on the operator's side of the machine.

2. Pull out the quick-release pins on the gear side of the machine.

3. Lift the brush out and set aside with pins. Reverse steps to install the brush.

Weed Brush Height adjustment:

The bristles mount to the frame using set screws in slotted holes. The position of the set screws in the slotted holes of the weed brush determine the height of the brush when installed.

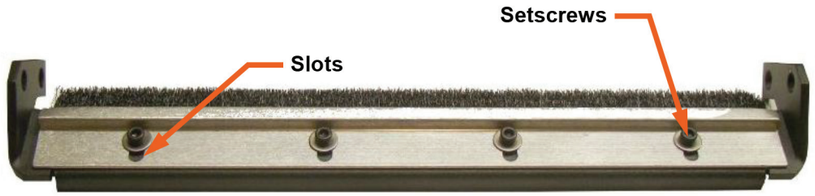
1. Remove brush from finisher

2. Turn brush over to access the set screws that hold the bristles to the frame.

3. Loosen screws and move bristles as needed.

4. Retighten set screws.

5. Reinstall brush in finisher.



1.4.0 Maintenance & Consumables

Operating maintenance performed on this machine will require the tools that are shipped in the Accessory Kit.

1.4.1 Fuses

There are two (2) spare fuses provided with the Finisher. If you have 110v AC use one 5-amp fuse. If you have 220v AC use two 2.5-amp fuses (remove the shorting clip to use two fuses).

Replacing a Fuse

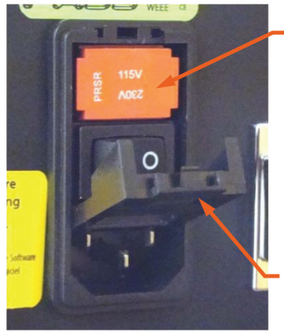
1. Disconnect the AC power cord from the fuse block on the power input end panel.

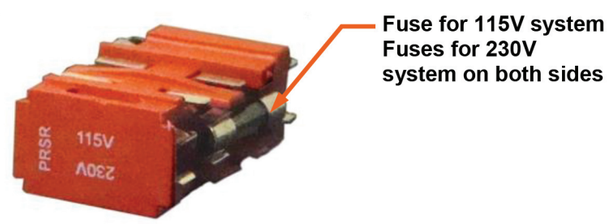
2. Open the fuse block cover with a small flat screwdriver and pull out the fuse block.

3. Remove the spent fuse and replace with a new one.

4. Orient the fuse block so that the desired voltage appears in the fuse block cover.

5. Close the fuse block cover and verify that the desired voltage is showing.



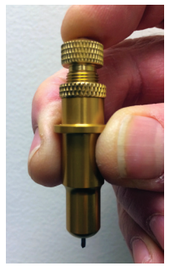


1.4.2 Changing the Knife Blade

The knife blade should be replaced when the force has been increased by more than 20 percent or the cut quality has degraded. The first sign of blade degradation usually occurs in the corners of the cut and may lead to poor weeding.

1. Remove the used blade

a) Loosen the brass thumbscrew on the carriage tool block and remove the knife holder assembly.



b) Hold the Knife Holder assembly in one hand and press the blade plunger as shown.

c) Remove the blade from the knife holder assembly.

d) Discard the blade safely.

2. Insert a new blade

a) Take out a new blade from its plastic case and remove the protective latex cap. Cap colour indicates blade angle (Red = 45° blade, Green = 60° blade, Blue = 30° Blade).

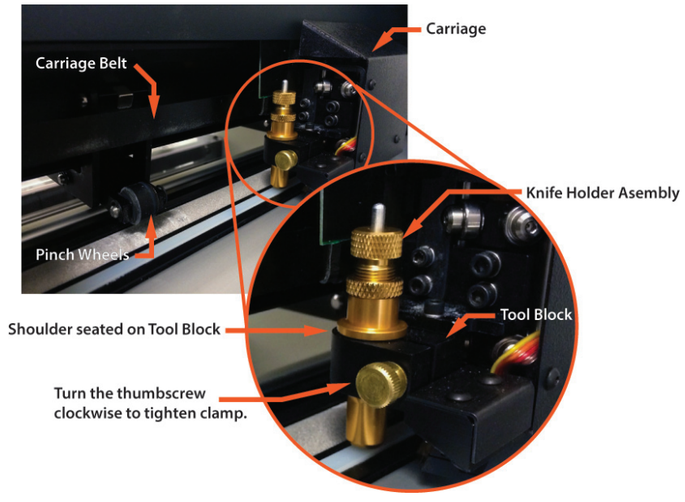
b) Carefully insert the new blade into the holder assembly until it is seated. It is not necessary to press the plunger to install the blade.

c) Turn the end cap to obtain desired blade depth.

3. Replace the Knife Holder Assembly

a) Ensure that the shoulder of the assembly is seated flush with the top of the tool block.

b) Tighten the thumbscrew on the tool block to keep the knife holder in place.



1.4.3 Changing the Cut Strip

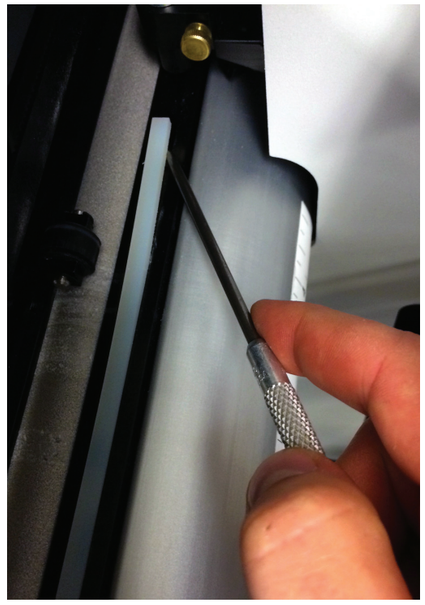
The Cut Strip should be replaced when the cut quality deteriorates.

1. Move the knife carriage to the gear side of the cutter.

2. Clean any debris from the cut strip groove before removing the existing strip.

3. Use the Cut Strip Removal Tool, found in the white accessory kit, to remove the worn strip.

a) Place the hooked end of the tool under one end of the Cut Strip



b) Pull up gently until there is enough material to pull up by hand. Cut Strips are held in place with light easy to remove adhesive.

4. Clean any debris from the groove and inspect before installing the new Cut Strip.

5. Peel the backing off the new cut strip and place in groove.

6. Press down firmly to ensure proper seating.

NOTE: *It is important to install the Cut Strip fully and evenly, otherwise material "cut through" may occur in some sections across the cutter.*

1.4.4 Cleaning the LCF215 Digital Finisher

The regularity with which the cutter needs to be cleaned is dependent on the usage, as well as the climate and contaminants in the cutter's environment. It is recommended that the following cleaning steps be done at least as often as indicated for each procedure.

⚠ CAUTION *ALWAYS disconnect the power source while cleaning any part of the machine. Keep power source disconnected until the cleaning process is completed.*

Items needed for cleaning:

□ Small bristle brush (toothbrush), soft cloths, rubber roller cleaner, mild solution of soap and water.

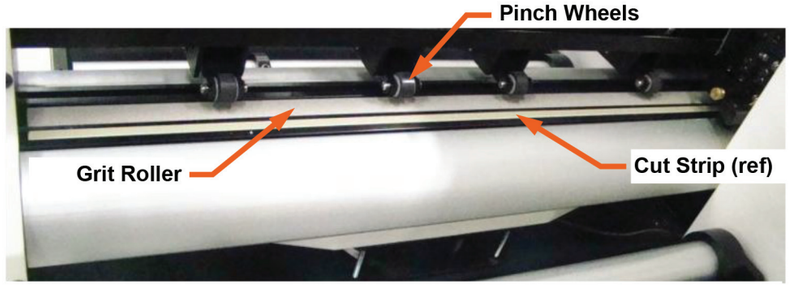
1.4.5 Bi-weekly Cleaning

Grit Rollers

The grit roller, pinch wheels, and the nips move the media through the finisher. Keeping the grit rollers clean allows the cutter to hold the media properly. Clean the grit rollers with a stiff bristled brush (e.g. toothbrush) to remove any media particles built up during cutting.

1. Disconnect power from machine

2. Disengage rubber rollers and pinch wheels from the grit rollers (handles in up position)



3. Do not use a wire bristle brush. A wire brush will damage the Grit Roller.

4. Brush the surface of the grit wheel while turning the grit roller by hand so the entire surface of the grit wheel is cleaned.

Pinch Wheels

Wipe media-related dust from the set of polyurethane pinch wheels using a soft cloth. To clean adhesive off the pinch wheels, simply use a soft cloth and rubber roller cleaner.

1.4.5 Bi-weekly Cleaning (continued)

Rubber Rollers

Clean using rubber roller cleaner and a soft cloth. Adhesive build-up may be removed using the roller cleaner and gently scraping the surface.

NOTE: *Use a rubber roller cleaner such as the type sold in office supply stores. Avoid using isopropyl or denatured alcohol on rubber parts. Alcohol will dry and harden the surfaces.*

Metal Rollers and Guides

Inspect for dust or adhesive build up. Remove dust using a soft cloth. Adhesive build-up may be removed using a small amount of Isopropyl alcohol and gentle scraping with a fingernail.

1.4.6 Monthly Cleaning

Clean the outer surface of the machine. If necessary, a mild cleaning solution (such as mild soap and water) on a damp cloth can be used to gently wipe painted surfaces clean.

⚠ CAUTION *Do not use abrasive cleaners. Abrasive cleaners will cause the paint to blister. Use a solution of mild soap and water.*

1.4.7 Annual Cleaning

Observe static discharge safety procedures that may damage sensitive electronic components. Wear a grounding strap connected to earth ground. Wear safety glasses to protect eyes. Etc.

⚠ CAUTION *ALWAYS disconnect the power source while cleaning any part of the machine. Keep power source disconnected until the cleaning process is completed.*

1. Remove rear cover

2. Use compressed air to remove dust and debris.

3. Inspect the internal circuit board assemblies and clean accumulated dust as necessary.

4. Make certain that the boards and any connectors are well seated.

5. Replace cover to original location.

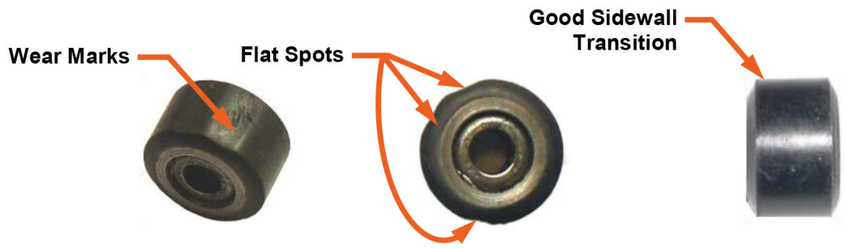
1.4.8 Pinch Wheel Maintenance

Pinch wheels are critical to the LCF215 material handling performance. They should be inspected for wear regularly and cleaned as needed. This will prolong the performance & life of the pinch wheels, however, in normal use the pinch wheels will need to be replaced in time.

The pinch wheels may need replacing when media does not track properly after guide alignment has been verified. For best tracking results, pinch wheels should be replaced as a SET.

Visually Inspect Rubber Wheel

The rubber wheel should not have any cracks or flat spots. It should be securely fastened to the aluminium hub of the wheel. The transition from the flat surface of the wheel to the “sidewall” edges of the wheel should be sharp and not rounded.



Inspect Wheel Bearings

1. Raise the pinch wheel handle to lift the pinch wheels.

2. Spin each wheel one at a time. Listen to the sound the bearing makes.
   A dry sound indicates the wheels need replacing.

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