

Zip10_M

Operation and Maintenance Manual

01-07-10 onwards



CASLON
L·I·M·I·T·E·D

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Specifications

Maximum Paper Size:	225mm x unlimited	9" x unlimited
Minimum Paper Size:	150mm x 80mm	5.0" x 5.0"
Paper thickness:	120gsm – 400gsm 0.1mm – 0.50mm	
Cutting Speed:	100 finished cards in 1 minute (10 sheets run 10-up with a scissor cut between cards) 6000 finished cards per hour	
Cross Cut Method:	Programmable guillotine	
Maximum Cross Cuts per Sheet:	99	
Minimum Size of Cross Cut Gutter:	2mm	0.080"
Recommended Bottom Trim Off:	4mm – 10mm	0.160" - 0.3937"
Centre Slit Gutter:	6mm	0.237"
Inline Cut Method:	Rotary, spring loaded slitting knives	
Maximum Paper Capacity:	~ 25mm	~ 1"
Feeding Method:	Friction, top feed	
Delivery Method:	Removable receiving tray	
Physical Size: (including feed tray)	410mm long x 350mm wide x 280mm high	16.1" long x 13.8" wide x 11" high
Shipping Size:	530mm long x 500mm wide x 410mm high	20.9" long x 19.7" wide x 16.1" high
Net Weight:	24 kilos	53 lbs
Shipping Weight:	25 kilos	55 lbs.
Power:	AC 230V, 50 Hz	
Auxiliary Parts supplied with machine:	Instruction Manual Power Cord Delivery Tray Waste Tray Vernier Caliper Screwdriver Allen Key	

Safety Information

- Read and understand all instructions in this manual before attempting installation, operation or general maintenance of the Zip10M.
- Use only a grounded electrical outlet when connecting the Zip10M to a power source. If you are unsure, check with a qualified electrician – see “Important information before you start” below.
- Observe all warnings and instructions marked on the Zip10M.
- Unplug the Zip10M from wall outlets before cleaning or maintenance.
- Do not install or operate the Zip10M near water or whilst you are wet.
- Make sure the Zip10M is installed on a secure and stable surface.
- Make sure the power cord does not obstruct walkways near the Zip10M.
- Keep long hair and jewellery clear whilst operating the Zip10M.
- Never operate the Zip10M with any guarding removed.
- Always disconnect the power to the Zip10M whilst not in use.
- If you are in any doubt about the operation of the Zip10M, please call your local service agent.

Important information before you start

- The Zip10M is a microprocessor-controlled machine. As such, the Zip10M must be connected to a dedicated, clean power supply. The Zip10M may be unable to perform correctly and consistently if it is connected to a power supply with other equipment.
- A power surge protector should be used with the Zip10M to protect the electronics. Electronics that are damaged due to power surges are not covered under the standard warranty.
- The user is solely responsible to assure that the Zip10M is not connected to the wrong voltage. Damage caused by incorrect voltage hook-up is not covered under the standard warranty.
- We recommend that the Zip10M box and packing materials be kept. While service parts are available from your dealer and can typically be easily replaced in the field, it may be necessary to return the Zip10M to the factory for complex service. The Zip10M box and packing material have been designed to protect the machine from normal handling during transportation.

Product Recycling and Disposal

European Union - Disposal Information for Commercial Users



Application of this symbol on your equipment is confirmation that you must dispose of this equipment in compliance with agreed national Procedures.

In accordance with European legislation end of life electrical and electronic equipment subject to disposal must be managed within agreed procedures.

Prior to disposal please contact your local dealer or Xerox representative for end of life take back information.

European Union - Disposal Information for Domestic Users



Application of this symbol on your equipment is confirmation that you should not dispose of the equipment in the normal household waste stream.

In accordance with European legislation, end of life electrical and electronic equipment subject to disposal must be segregated from household waste.

Private households within EU Member States may return used electrical and electronic equipment to designated collection facilities free of charge. Please contact your local disposal authority for information.

In some Member States when you purchase new equipment your local retailer may be required to take back your old equipment free of charge. Please ask your retailer for information.

Countries not within the European Union

Please contact your local waste authorities and request disposal information.

Operator Controls

Power:

This is a green Led that indicates that the mains power is connected to the machine.

Count:

This is a dual function switch.

Operation Mode – Pressing this button will allow the operator to adjust the sheet count for the next job. Any number from 000 – 999 can be set. The machine will run the entered number of sheets and then stop. The display will show the number of sheets remaining during operation.

Programming Mode – Pressing this button during programming will move the display cursor to the right. Each press moves the cursor once and will scroll round when reaching the right hand side.

Mode:

This is a dual function switch.

Operation Mode – Pressing this button will allow the operator to scroll through the 10 programs within the operating memory.

Programming Mode – Pressing this button during programming will move the display cursor down to the next row of information. Each press moves the cursor down one row and will scroll through to the next 2 lines when reaching the bottom.

Enter:

Operation Mode – Pressing this button will allow the operator to enter program 9 or 10 for editing. It is also used to select the required program when scrolling through the program menu.

Programming Mode – Pressing this button during programming will save the data entered and return the machine to the operating mode.

Start:

This is a dual function switch.

Operation Mode – Pressing this button will start the machine running.

Programming Mode – Pressing this button during programming will increase the number on the display, indicated by the flashing cursor.

Stop:

This is a dual function switch.

Operation Mode – Pressing this button will stop the machine running immediately. When the 'Start' button is pushed the machine will continue in operation from where it was stopped.

Programming Mode – Pressing this button during programming will decrease the number on the display, indicated by the flashing cursor.

General Operation

- Make sure that the Waste Collection Box, Delivery Tray, Extended Infeed Support and all guards are properly installed on the Zip10M before operation.
- The top guard MUST fit properly on the tie bar and location screws or the safety switch will not be activated.
- The Waste Collection Box MUST be located correctly under the delivery tray or the safety switch will not be activated.
- The main power switch, located on the feed end/operator side of the machine, is used to turn the Zip10M "ON". Once power has been turned on, the Zip10M will go through a self-test sequence. At the end of this self-test, the Zip10M will be ready to operate. The last set of program parameters that were used on the Zip10M will automatically be recovered from memory. The display screen will read, "STOP". This unit also houses an 8A, 20mm fuse.
- Pressing the "START" button initialises the program selected and the feed wheels and machine operation will commence. The machine will continue to feed sheets until the feed tray is empty, the sheet count has been reached or the "STOP" button is pushed.
- Pressing the "STOP" button will deactivate the operation of the machine even if a sheet is being processed through. To restart the operation of the Zip10M press the "START" button. If the machine was stopped during a sheet the sheet will be completed without any loss of registration.
- If the program required is not displayed, pressing the "MODE" button will scroll through the 10 programs until the required program is reached. When the correct program is reached it can be selected by pressing the "ENTER" button.
- If an error occurs, the Zip10M will sound a warning and stop the machine. To clear the error, follow the procedure indicated on the front panel display screen or refer to the "Errors" section in this manual. The Zip10M will not operate until the error message has been cleared.

Cross Cutting / Guillotine Section

- The Zip10M uses a programmable control and a guillotine cutter to cut the sheet into sections. The programmable controls are easy to set-up and adjust. Scissor or gutter cut formats can be programmed and produced on the Zip10M.
- Refer to the Program Details and Selection for set up.
- There is no need to remove any screws on this section. The Cross Cutting / Guillotine Section is factory set and should not require adjustment. Make sure only qualified engineers carry out adjustments to this part of the Zip10M.

Feeder Section

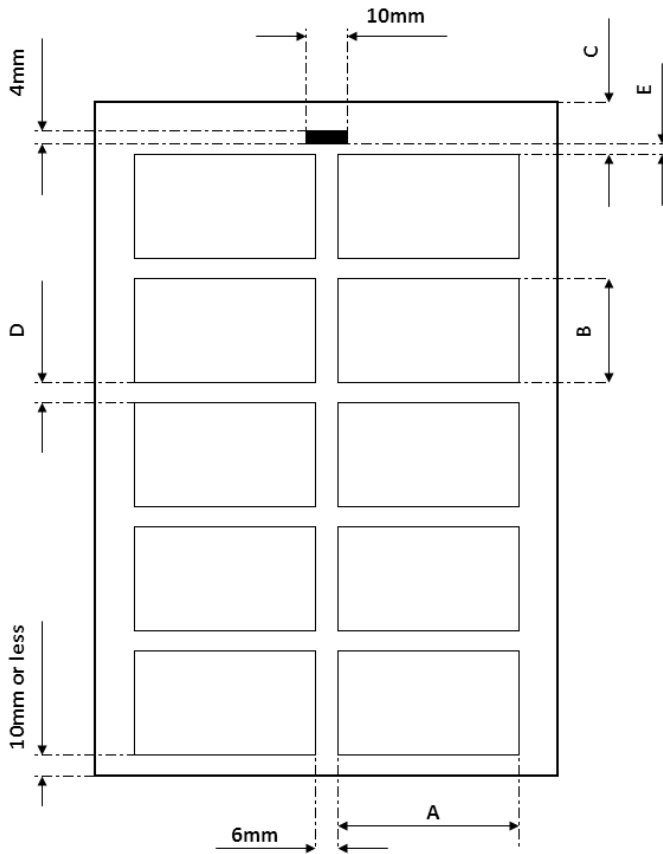
- The Zip10M uses a friction feeder that feeds from the top. As such, sheets should be slightly shingled and aired before being placed in the feeder. The feed tray should be pushed down and the lead edge of the sheets should be placed against the fixed head lay in the machine.
- The feed tray is sprung loaded upwards against the feed wheels. This spring pressure can be adjusted by unlocking the pressure control knob on the non-operator side of the machine. Once loosened, the knob can be moved left or right to increase or decrease the pressure. Moving left increases the pressure and moving right decreases the pressure. More pressure is required for thicker stocks and less pressure for thinner stocks.
- The side guides are controlled by one lockscrew situated on the operator side of the feeder. Unlocking this allows the pair of side guides to move together and be adjusted for different widths of stock. You may also need to move the outer feed wheels if they obstruct the movement of the side guides.
- The whole feed tray can be moved 5mm each way from the centre point of the machine. This adjustment is controlled by a black knob situated on the operator side of the feeder and has indicators to show the direction of movement. This allows the operator to adjust the sheet if the print is off centre.
- ***Important:***
The feed wheels must be cleaned from time to time to remove dirt and any glazing.
- To adjust for different widths of paper unlock the side guides and position them as required. Ensure that the guides are not too tight or too loose. The side guides move independently to allow for printing that is off centre. Red indicators on the machine and feed tray indicate the centre point for cutting.

Rotary Slitting Section

- The Zip10M uses slitting blades mounted in a removable cassette to slit the paper as it passes through the machine.
- ***Important:*** Before removing or installing a blade cassette, turn the main power switch to the "OFF" position.
- Changing the dimension between the slitting blades requires the blade cassette to be removed from the machine. Remove the top cover and release the 2 lower locking screws that hold the cassette in position. The upper screws are fixed locators so the cassette should slide upwards and out of the machine.
- To install a new cassette, reverse the process making sure the gear on the cassette matches the drive gear on the machine. Ensure that the upper screws locate correctly when installing the blade cassette and always fit the locking screws.
- To adjust the cutting blade width, first remove the cassette as described above. Remove the scrap deflector plate to allow greater access to the mechanism. Release the pressure on the sprung loaded wheel by pushing it away from the fixed cutting blade. The sprung cutter should locate on the dowel pin and release the pressure on the fixed blade. The fixed blade can now be adjusted by loosening the Allen screw and setting the required distance with the Vernier Caliper. When the correct cutting width has been set on the fixed blade, the sprung blade can be released to engage with the fixed blade. The same procedure is repeated for the other side. Always ensure that the scrap deflector is located correctly next to the blade mechanism.

Note: Additional cassettes can be purchased at any time to negate the need for adjustment.

Program Details and Templates



The diagram to the left shows the layout for the Zip10M.

Below the layout are grids which show the dimensions for the most popular two sizes of cards.

Use these grids when setting up your software to ensure correct positioning of the printed image.

- A = Card Width**
- B = Card Height**
- C = Top Margin - Lead Edge**
- D = Horizontal Gutter**
- E = Top Margin—Mark**

Zip10M - 55mm Cutting Template (A4)						
Program	Registration	A mm	B mm	C mm	D mm	E mm
01	Mark	70 - 99	55	-	0	2
02	Lead Edge	70 - 99	55	12	0	-
03	Mark	70 - 99	55	-	2	2
04	Lead Edge	70 - 99	55	6	2	-
05	Mark	70 - 99	140	-	0	2
06	Lead Edge	70 - 99	140	10	0	-
07	Mark	70 - 99	140	-	2	2
08	Lead Edge	70 - 99	140	6	2	-
09	Mark	70 - 99	25 - 999.9	-	0 - 999.9	0 - 999.9
10	Lead Edge	70 - 99	25 - 999.9	0 - 999.9	0 - 999.9	-

Zip10M - 50mm Cutting Template (A4)						
Program	Registration	A mm	B mm	C mm	D mm	E mm
01	Mark	70 - 99	50	-	0	25
02	Lead Edge	70 - 99	50	40	0	-
03	Mark	70 - 99	50	-	2	15
04	Lead Edge	70 - 99	50	30	2	-
05	Mark	70 - 99	140	-	0	2
06	Lead Edge	70 - 99	140	10	0	-
07	Mark	70 - 99	140	-	2	2
08	Lead Edge	70 - 99	140	6	2	-
09	Mark	70 - 99	25 - 999.9	-	0 - 999.9	0 - 999.9
10	Lead Edge	70 - 99	25 - 999.9	0 - 999.9	0 - 999.9	-

Program Selection & Programming

The Zip10M has 8 fixed programs and 2 fully adjustable operator programs. The templates for the programs are shown on the previous page and show the dimensions for both the 50mm and 55mm version machines.

Pressing the "MODE" button will scroll through all of the 10 programs. Stopping at the program required (1-8) and pressing "ENTER" will automatically load it into the operating memory. For programs 9 and 10, pressing "ENTER" will load the parameters onto the display for editing.

Programs 9 and 10 can be edited within the parameters shown on the previous page.

Both programs require four pieces of information to be entered before a job can be run.

1. "No.:" = The number of pieces to be cut out along the length of each sheet.
Note:
If you are running two rows of five-up business cards on the sheet then the value of "No.:" would equal 5.
2. "Length:" = The length of each piece to be cut out along the length of each sheet.
Note:
If you are producing a 50mm high business card then the value of "Length:" would equal 50.00
3. "Margin:" = Lead Edge or Mark - the space between the lead edge of the sheet and the first cut (dimension 'C') or the space between the back edge of the mark and the first cut (dimension 'E').
Note:
If the first cut is 6mm from the lead edge of the sheet then the value of "Margin:" would equal 6.00
4. "Gutter:" = The size of gutter to be removed between each individual piece on the sheet.
Note:
If you are using a 2mm gutter between business cards to remove a bleed then the value of "Gutter:" would equal 2.00. If no gutter needs to be removed the value of "Gutter:" would equal 0.0

Important: The recommended trim off from the tail edge of the sheet is between 4mm - 10mm (0.160" - 0.3937"). Tail edge trim off that is too long may hang up in the guillotine causing the Zip10M to display an error (see page 11). If this occurs, turn the power "OFF". Remove the top guard and remove the tail edge trim off scrap. Ensure that the recommended tail trim off dimension is established when laying out the sheet prior to printing.

Important: The Zip10M paper handling rollers that convey the stock through the machine are designed to handle a specific thickness of paper. If the paper is thicker or thinner, there may be a slight difference in the programmable cut off length. If the paper is thicker, the cut off length is usually longer. If the paper is thinner, the cut off length is usually shorter. After running the first sheet, check the cut off size and make any adjustments required in the program.

To edit program 9 or 10:

A sample job of 10 Business Cards to view (2 columns of 5) on an A4 sheet.
 Top Margin 9mm
 Business Card Height 55mm
 No Cross Cut Gutter
 Using Program 10

Action	Process	Display
Turn Zip10M on	Machine will initialise	#09 User define card mark STOP 000
Press "MODE" until Program 10 is reached	Display shows each program in turn	#10 User define card no mark STOP 000
Press "ENTER"	Display shows first 2 pieces of program information and the cursor is on 0	No. = 05 Length = 050.0mm
Press "↓"	Accepts number of cards as 5 and moves cursor to 0 on next row	No: = 05 Length: = 050.0mm
Press "→" x 2	Moves cursor to unit position	No: = 05 Length: = 050.0mm
Press "+" x 5	Increases unit from 0 to 5	No: = 05 Length: = 055 .0mm
Press "↓"	Accepts height of card as 57mm And displays next 2 pieces of program information	Margin: = 005.0mm Gutter: = 002.0mm
Press "→" x 2	Moves cursor to unit position	Margin: = 005.0mm Gutter: = 002.0mm
Press "+" x 4	Increases unit by 4 to 9	Margin: = 009.0mm Gutter: = 002.0mm
Press "↓"	Accepts the top margin as 9mm and moves cursor to 0 on next row	Margin: = 009.0mm Gutter: = 002.0mm
Press "→" x 2	Moves cursor to unit position.	Margin: = 009.0mm Gutter: = 002.0mm
Press "—" x 2	Decreases the Gutter by 2 to 0	Margin: = 009.0mm Gutter: = 000.0mm
Press "ENTER"	Save current programming	#10 User define card no mark STOP 000

Sheet Count Programming

The sheet counter will display the current number of sheets remaining in the count. On reaching zero, the count will reset to the programmed value. To clear the count set the program to zero.

To set a sheet count of 35

Action	Process	Display
Press "COUNT"	Cursor will move to Sheet Count	#10 User define card

		no mark STOP 000
Press "➡" x 1	Cursor will move to tens digit	#10 User define card no mark STOP 000
Press "⊕" x 3	Increase sheet count by 30	#10 User define card no mark STOP 030
Press "➡" x 1	Moves cursor to unit position	#10 User define card no mark STOP 030
Press "⊕" x 5	Increases unit from 0 to 5	#10 User define card no mark STOP 035
Press "ENTER"	Save current programming	#10 User define card no mark STOP 035

Display / Error messages

Message	Meaning	Action
"WARNING! No Cover"	Top guard is not in place correctly	<ul style="list-style-type: none"> • Replace Top guard
"WARNING! No box"	<ul style="list-style-type: none"> • Waste Collection Box not in place correctly 	<ul style="list-style-type: none"> • Replace Waste Collection Box • Check Microswitch
"Load paper error!" STOP key to reset . . .	Paper stuck or jammed in the feeder.	<ul style="list-style-type: none"> • Clear paper • Check microswitch
"Paper-Sensor error!" Turn power off	<ul style="list-style-type: none"> • Problem between sensor & cutting unit. • Paper not correctly positioned. • Excess drag on paper caused by paper side guides too tight pressure incorrect 	<ul style="list-style-type: none"> • Clear jammed paper. • Adjust side guides • Adjust feeder pressure. • Switch power off and back on again
"Paper cutting error!" Turn power off	<ul style="list-style-type: none"> • Guillotine cutter is jammed. • Paper may be too thick. • Multiple sheets fed through feeder. Cutting cycle has not completed. 	<ul style="list-style-type: none"> • Inspect and clear cutter jam. • Check stock thickness. • Eliminate multiple feed problems. • Switch power off and back on again
"Paper jam in cutter!" Turn power off	<ul style="list-style-type: none"> • Paper trim off stuck in cutter. 	<ul style="list-style-type: none"> • Clear jam. • Switch power off and back on again

Maintenance / Troubleshooting

Sensor – Make sure that all sensors are free from dust and other contamination. To clean, wipe with a soft cotton rag.

Rollers – Paper dust and ink residue will accumulate of the rollers causing inaccurate feeding. To clean, wipe with lint less rag. Spirit can be used but do not use Ketone or highly volatile solvents.

Problem	Remedy
Unable to feed card	<p>Check paper feed side guides are not too tight. These can be adjusted with the locknuts on each side.</p> <p>Increase spring pressure</p> <p>Check stock for excessive static</p>
Card strips caught in cutter	<p>Turn off machine first</p> <p>Remove strips with a non metallic object</p> <p>Check that the end cut off strip is less than 10mm</p>
Feeding more than one card at a time	<p>Check paper feed side guides are not too loose. These can be adjusted with the locknuts on each side.</p> <p>Reduce spring pressure</p> <p>Check stock for excessive static</p>
Cross Cutter does not cut	<p>Check that card is below maximum thickness – see page 2</p> <p>Tighten the 3 Pressure Adjustment Rollers to increase contact between blades</p> <p>Check the sensor under rear cover (call service agent for advice)</p>
Poor cut quality from Rotary Side Slitters	<p>Check for off cuts caught around the blades</p> <p>Check the height of the blade guard and adjust. The cassette will need to be removed for this.</p>

Important

Turn off Power and disconnect machinery from electrical supply before removing any guards.

Discharging Static Electricity from the Stock

Static electricity is generated by the printing process and paper stocks sliding in and out of contact with each other. This may cause some paper handling problems as below:

Multiple sheet feeding

Cut waste not falling into the Waste Collection Box

Cut waste sticking to cutter blades

Erratic stacking in Delivery Tray

It is important to reduce the amount of static electricity in your card stock.

For laser printed stock, wait for 15 minutes before cutting to allow static to discharge.

Keep air between printed stocks to help static to discharge.

Do not stack printed cards too high.

Ideal operating conditions for the least amount static is above 50% humidity.

Make sure that your Zip10M is earthed.

Consumables

Feed Board

Replace when dirty or when there is visible damage

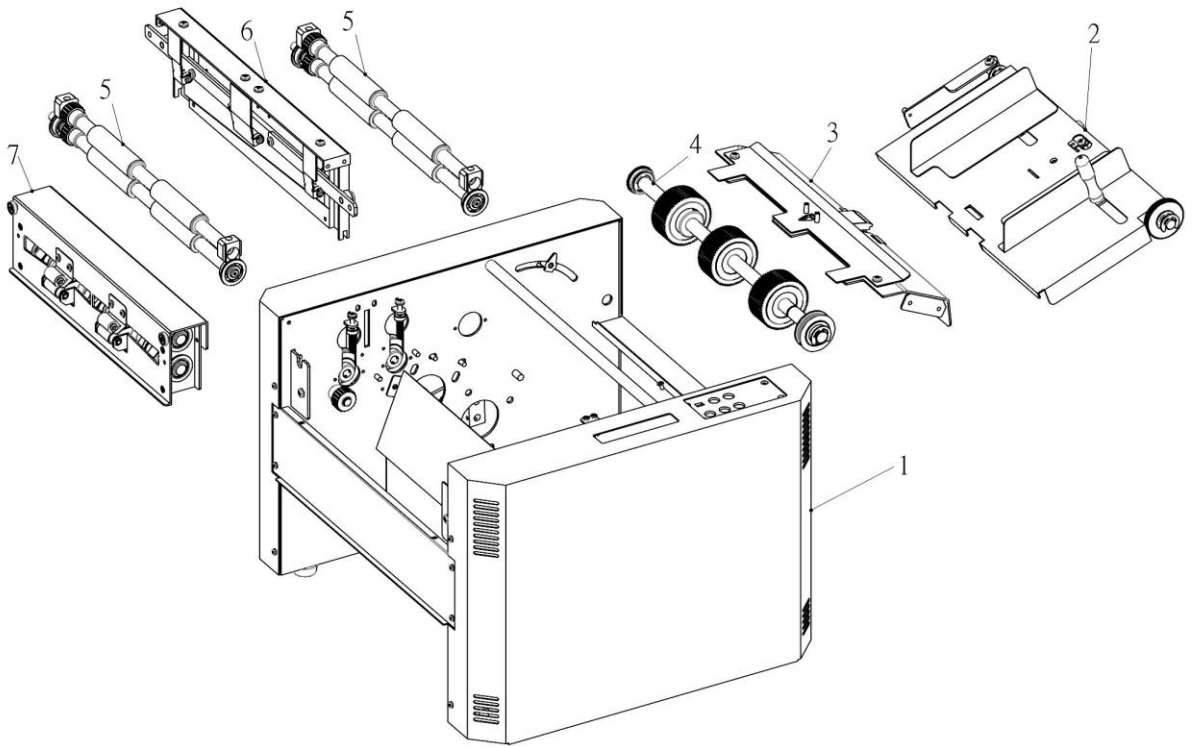
Rubber Feed Rollers

Replace when dirty or when there is visible damage

Cross Cutter Blade

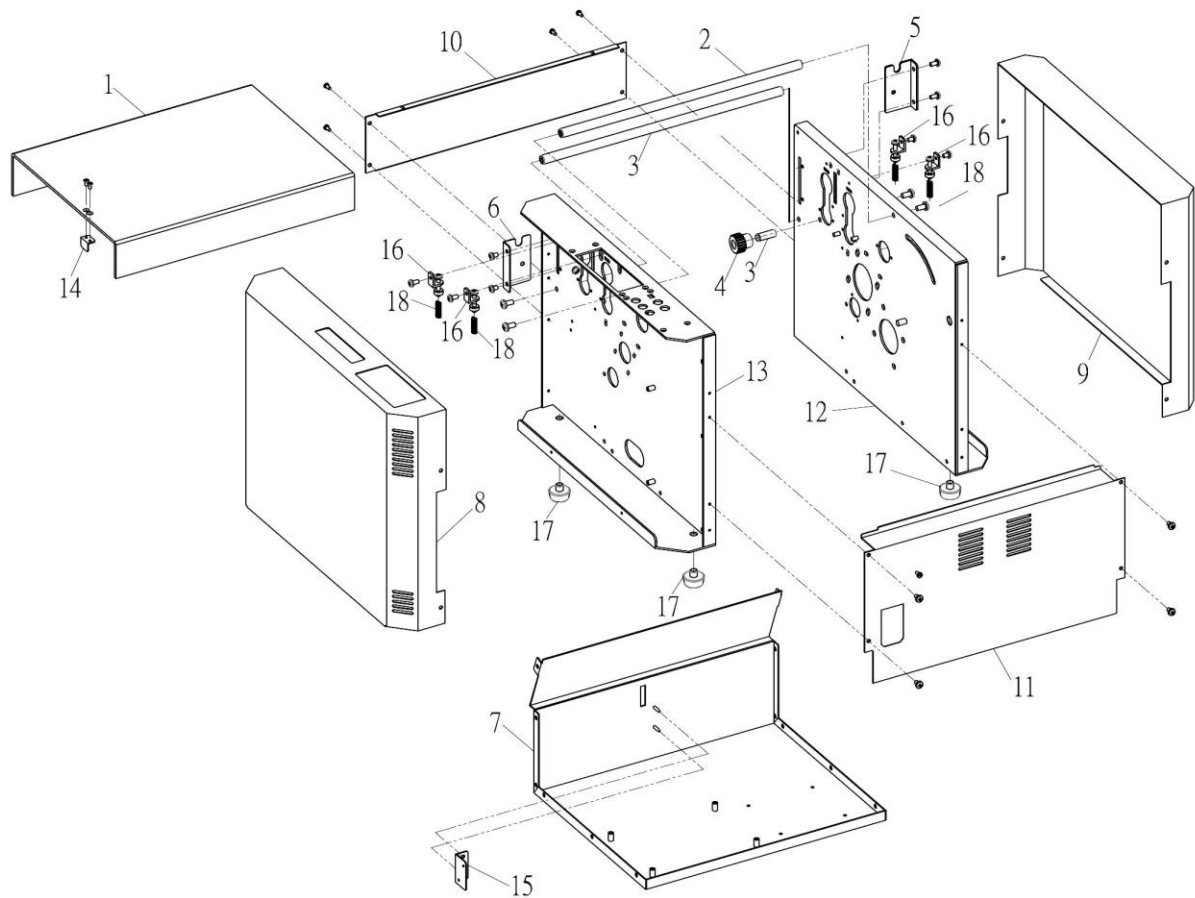
Suggested life – 5,000,000 cuts. Contact your local agent.

Overall Drawing



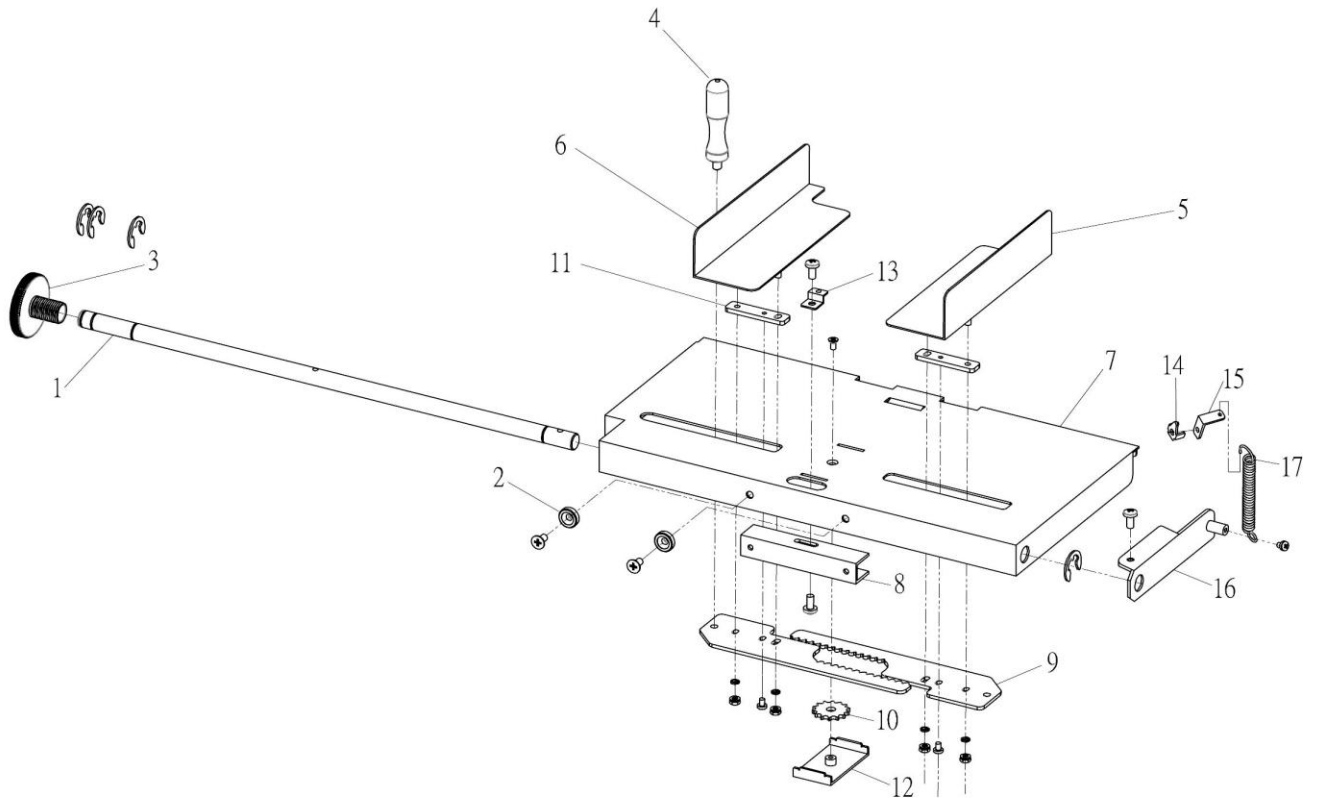
INDEX	PARTS No.	DESCRIPTION	Q'TY	Remarks
1		Chassis	1	
2		Feed Table	1	
3		Separation Guide	1	
4		Feed Roller Assembly	1	
5		Transmit Roller	2	
6		Guillotine Cutter Assembly	1	
7		Slit cassette Assembly	1	

Chassis Drawing



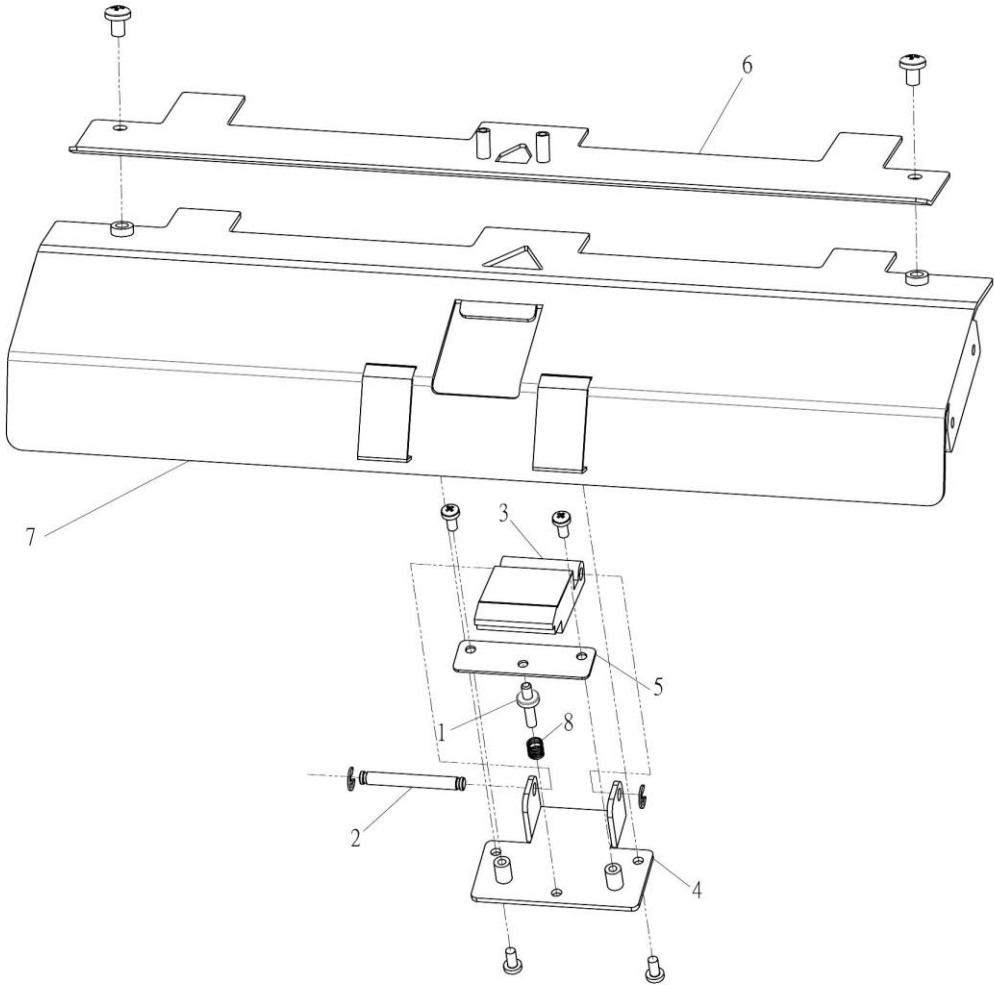
INDEX	PARTS No.	DESCRIPTION	Q'TY	Remarks
1	E1002	Acrylic cover	1	
2	K1057	Shaft	2	
3	K1064	Gear shaft	1	
4	K1098	Gear	1	
5	K2011-1	Sillter fixed plate-R	1	
6	K2011	Sillter fixed plate-L	1	
7	K2012	Seal plate	1	
8	K2020	Cover-R	1	
9	K2021	Cover-L	1	
10	K2022	Rear Closure Cover	1	
11	K2023	Front Closure Cover	1	
12	K2035	Frame-R	1	
13	K2036	Frame-L	1	
14	K2039	Sensor plate	1	
15	K2054	Sensor plate	1	
16	K2085	Spring plate	4	
17	FT0810	Foot Pad	4	
18	SP0406C	Spring-C	4	

Feed Table Drawing



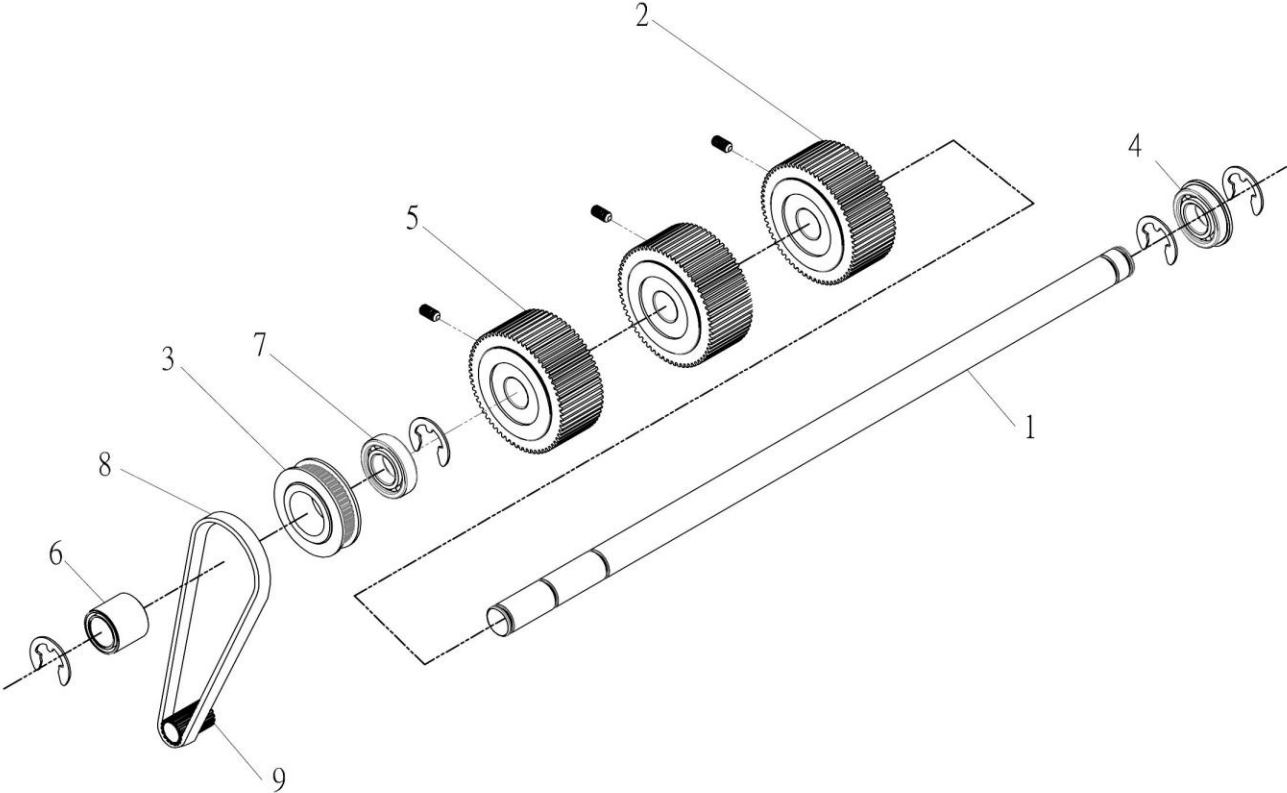
INDEX	PARTS No.	DESCRIPTION	Q'TY	Remarks
1	K1058	Shaft	1	
2	K1103	Extension lock	2	
3	K1105	Turn Knob	1	
4	K1110	Screw Rod	1	
5	K2016	Guide plate R	1	
6	K2017	Guide plate L	1	
7	K2031	Paper Tray	1	
8	K2102	U Plate	1	
9	K2106	Gear plate	2	
10	K2107	Gear	1	
11	K2108	Gasket	2	
12	K2109	Guide plate	1	
13	K2111	Indicator	1	
14	K2029	Pressure label	1	
15	K2030	Pressure plate	1	
16	K2033	Bracket	1	
17	SP0720-T	Spring-T	1	

Separation Guide Drawing



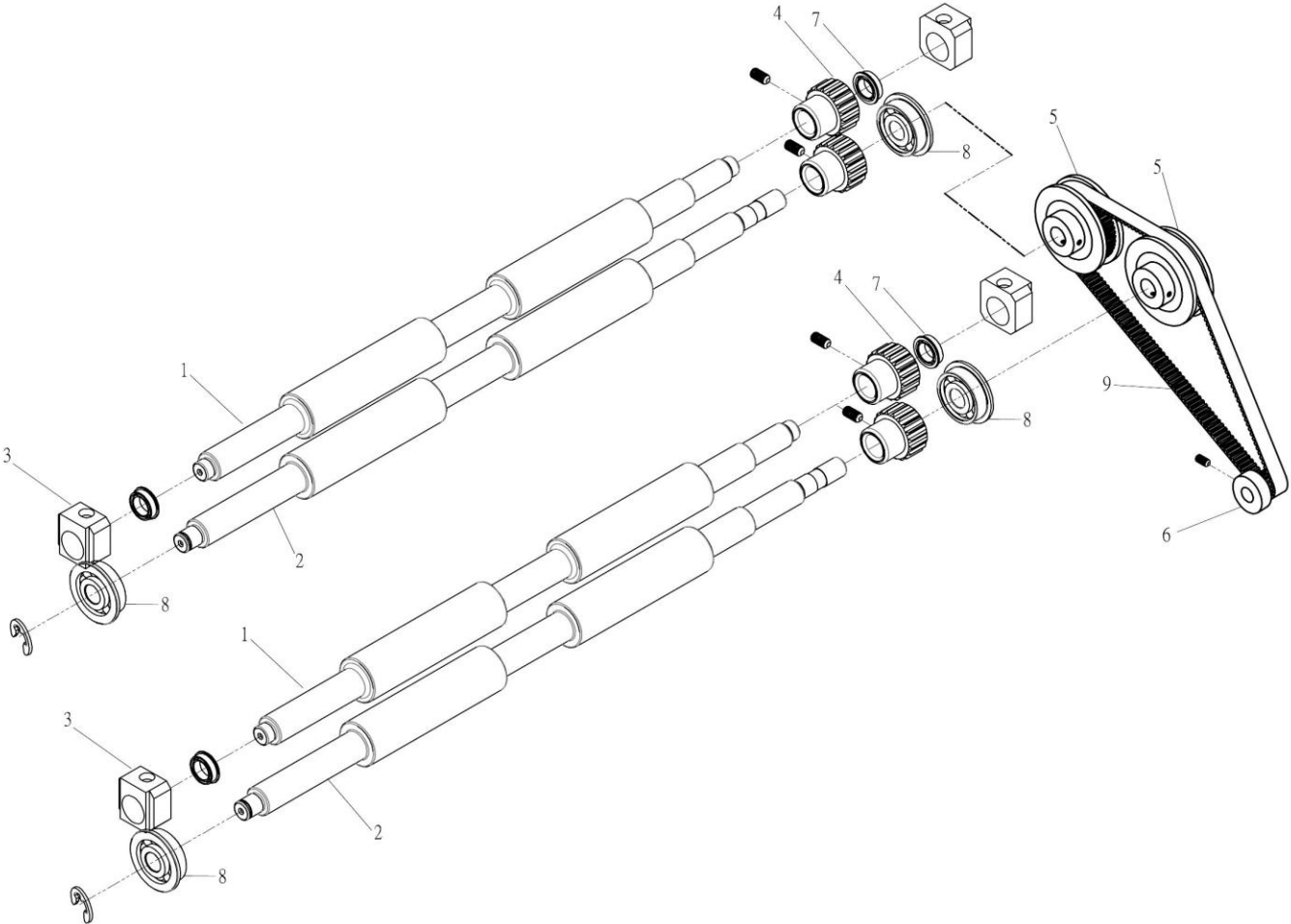
INDEX	PARTS No.	DESCRIPTION	Q'TY	Remarks
1	K1096	Shaft	1	
2	K1097	Shaft	1	
3	K1111	Separator base	1	
4	K2008	Separator block	1	
5	K2009	Plate	1	
6	K2014	Lid	1	
7	K2024	Paper guide plate	1	
8	SP0405C	Spring-C	1	

Feed Roller Assembly Drawing



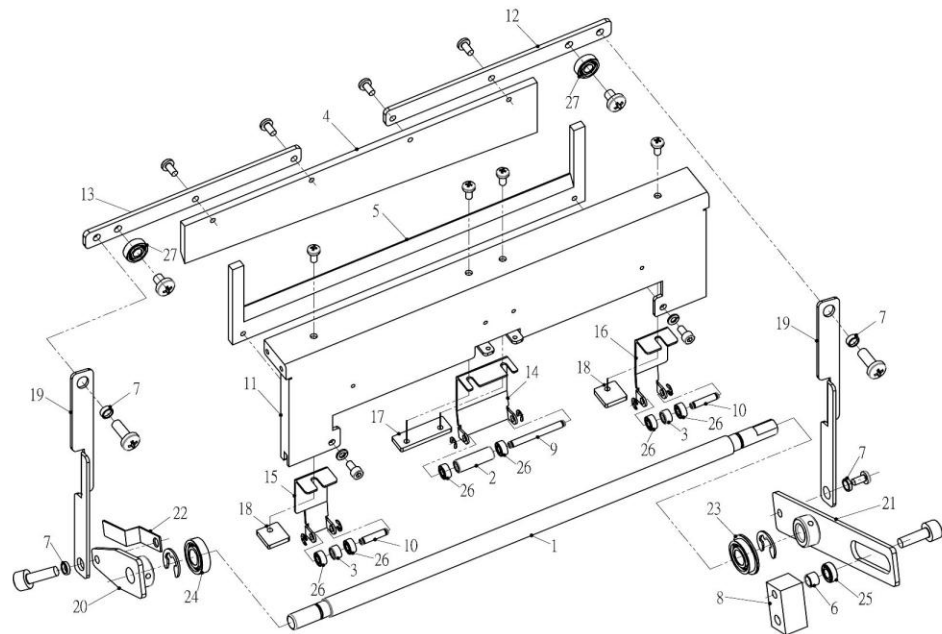
INDEX	PARTS No.	DESCRIPTION	Q'TY	Remarks
1	K1055	Shaft	1	
2	PU058	Rubber	3	
3	K1094	Pulley	1	
4	F6901	Bearing-F6901	1	
5	K1093	Roller	3	
6	FC12	Bearing-FC12	1	
7	6901	Bearing-6901	1	
8	MXL102-64	Timing belt-102	1	
9	K1088	Pulley	1	

Transmit Roller Drawing



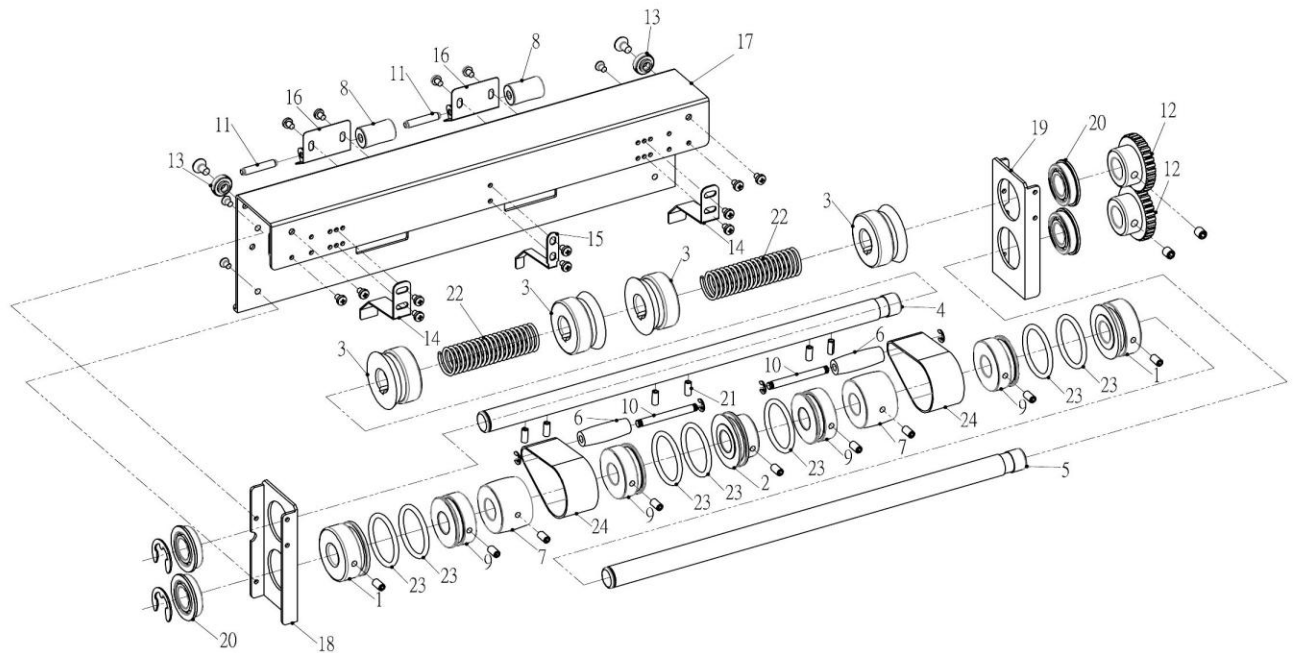
INDEX	PARTS No.	DESCRIPTION	QTY	Remarks
1	K1053	Upper Roller	2	
2	K1054	Lower Roller	2	
3	K1086	Bearing Block	4	
4	K1087	Gear	4	
5	K1089	Pulley	2	
6	K1092	Pulley	1	
7	F1280	Bearing-F1280	4	
8	F608	Bearing-F608	4	
9	MXL132-64	Timing belt-132	1	

Guillotine Cutter Assembly Drawing



INDEX	PARTS No.	DESCRIPTION	Q'TY	Remarks
1	K1056			
2	K1071	Bushing-Middle	1	
3	K1072	Bushing-Side	2	
4	K1073	Upper Blade	1	
5	K1074	Lower Blade	1	
6	K1077	Ring	1	
7	K1078	Ring	4	
8	K1082	Block	1	
9	K1090	Bearing shaft-Middle	1	
10	K1091	Bearing shaft-Side	2	
11	K2007	Cutter Base	1	
12	K2037	Mounting Bracket - R	1	
13	K2038	Mounting Bracket - L	1	
14	K2068	Pressure plate	1	
15	K2069	Pressure plate-L	1	
16	K2070	Pressure plate-R	1	
17	K2075	Fix Spacer - Middle	1	
18	K2076	Fix Spacer - Side	2	
19	K2079	Plate	2	
20	K2080	Link Plate - L	1	
21	K2081	Link Plate - R	1	
22	K2084	Sensor plate	1	
23	F6900	Bearing-F6900	1	
24	6900	Bearing-6900	1	
25	1260	Bearing-1260	1	
26	684	Bearing-684	6	
27	696	Bearing-696	2	

Slit Cassette Assembly Drawing



INDEX	PARTS No.	DESCRIPTION	Q'TY	Remarks
1	K1045	Slit Blade - Lower	2	
2	K1046	Slit Blade - Center	1	
3	K1048	Slit Blade - Upper	4	
4	K1049	Shaft - Upper	1	
5	K1050	Shaft - Lower	1	
6	K1060	Roller - Lower	2	
7	K1061	Pulley	2	
8	K1062	Roller -Upper	2	
9	K1063	Pulley	4	
10	K1099	Eject Roller - Lower	2	
11	K1100	Eject Roller - Upper	2	
12	K1101	Gear	2	
13	K1104	Lock Ring	2	
14	K2001	Scrap Guide - Side	2	
15	K2002	Scrap Guide - Middle	1	
16	K2003	Mounting Plate	2	
17	K2004	Cassette Bracke	1	
18	K2005	Bracket - L	1	
19	K2006	Bracket - R	1	
20	F6901	Bearing-F6901	4	
21	SS03508	Pin 3.5 x 8	6	
22	SP1356C	Spring-C	2	
23	OR2631	O-ring	6	
24	OR3840	Conveyor	2	