

Spangle Mis Cuts & Out of Round Cuts

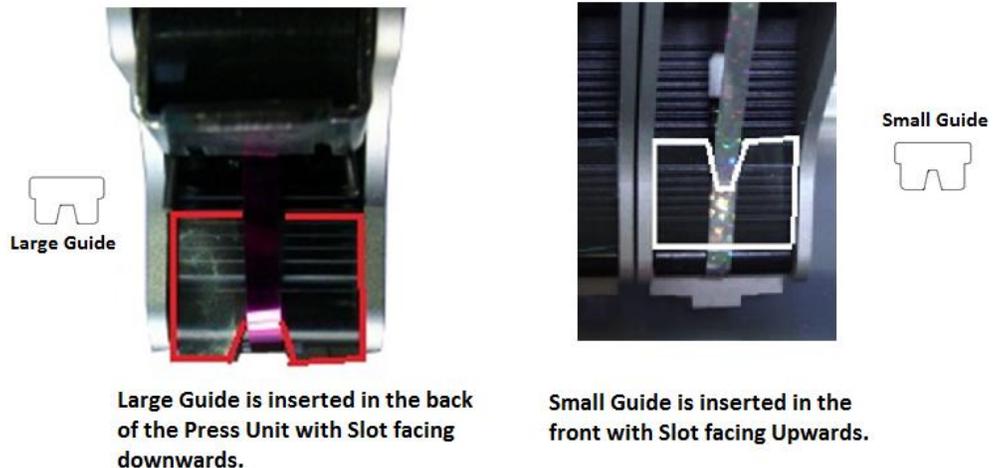
Crescent moon cutting can be caused by a few possibilities. First we have to know in which way the spangle tape is being mis-cut. Going to the rear of the machine and unwinding some length of the waste reel and inspecting the mis-cuts, they will reveal either a left and right mis-cut, or a double cutting front to back on the tape (See image below)



If spangle tape is mis-cutting side to side, check to ensure the Plastic guides are inserted straight and that the spangle tape is correctly interfacing with the guides to disallow the spangle from moving side to side which will cause the spangle tape to be cut from its side.

Feeder Guides are used to ensure the Spangle tape that is being fed through the Press unit does not shift side to side which can cause partial mis-cuts of the spangle side to side as shown below. Ensure that the Guides are in place on the front and the back and that the guides are straight and not at an angle.

The front plastic guide is inserted with the slot facing upwards where the back plastic guide is facing downwards.



Most common mis-cuts are front to back or what appears to be the punch making two cuts with little tape movement through the press unit area. A few things that can cause this is

1) Dirty Feed roller which can cause the Spangle tape not to be pushed out towards the waste reel.

Go to the rear of the machine and look at the Black Roller where the spangle tape comes out of the press unit towards the waste reel. There may be oil built up on the black roller that can cause the spangle tape not to come out of the press unit area correctly causing the tape to be punched twice near the same area as the first punch. Push the Tension lever down and clean the Black Rubber Roller with a paper towel dabbed in some alcohol.

2) The Waste reel being over full of used spangle tape.

If the waste reel gets overfilled with used spangle tape. The feed motor will struggle to pull the spangle tape through and onto the waste reel. Remove the waste reel and find the side with 1 Phillip screw. Remove that screw and pull the used spangle tape off and discard it, Tape the wasted spangle from the tension roller to the black center core of the reel and re-assemble.

3) The amount of Feed of the spangle is set incorrectly for the size of the spangle cut.

Your machine originally was set up so Unit #1 & #2 are for 2mm Spangle cuts, #3, 4, & 5 are for 3mm Cuts and Press Unit #6 is your 4mm cuts or 5mm if ordered that way. When spangle is being pulled through the punch, the feed motor located at the back is pulling the spangle tape a certain length so that the punching of the spangle tape is not too close to the previous punch holes, as well as to not allow too much waste in length between cuts. The adjustment of the feed length is as below. Simply Unit Change to that Press Unit and Press FEED and ensure the Feed Length is set correctly.

**2mm = 28 feed length 3mm = 38 feed length 4mm = 49 feed length
5mm = 59**

If you change the set up of the press units on the machine for example instead of having 2mm punches on Unit 1 and 2 and you put a 3mm in place 1 or 2 instead of the 2mm, then a feed length of 28 with a 3mm punch may result in not enough spangle tape being pulled through for each punch out causing a double cutting which will look like half moons.

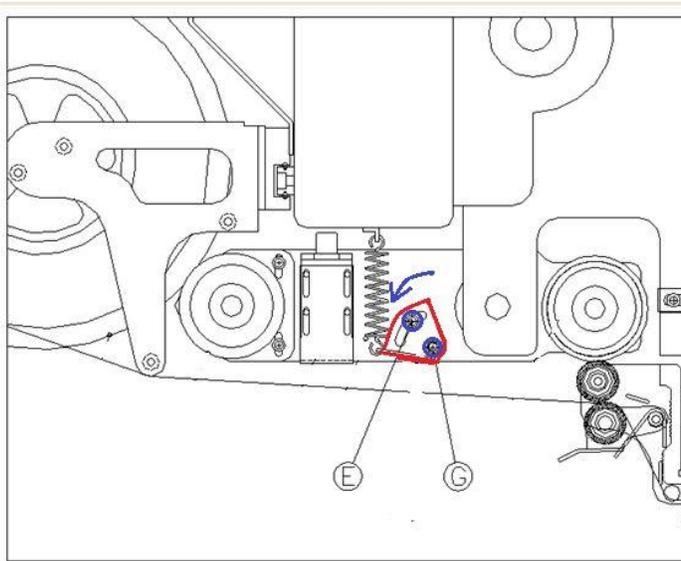
**** For 5.0 mm Spangles, use a Large Guide in the front and Rear of the Press Unit. ****

4) Tension Spring needs to be adjusted,

There is a spring attached to the feed motor to apply tension to the feed rollers on the back of the press unit, if the spring is too loose then not enough pressure for the feed rollers to move the spangle through to the waste reel. Grab the Allen Wrenches from the tool box provided and Press UNIT CHANGE and dial up to change to #6 (This will make it easier to access the tension spring to adjust it).

When adjusting the tension spring plate, Only adjust $1/8^{\text{th}}$ at a time and test to see if mis-cuts has been resolved. If necessary adjust another $1/8^{\text{th}}$ at a time until cuts are circular.

Create a test design of a circle only 4" in diameter and spangle spacing at around 30 (Spacing large enough so that this design can be used with all size spangle cuts).



Color change to Unit #6 to gain better access to the Tension Spring Adjustment.

Place you thumb on the tension plate (Outlined in Red)

- 1) Loosen the two 3mm Allen Screws slightly
- 2) Lower the tension plate by about 1.0mm and Re-tighten the Allen Screws.

Tension plate will be difficult to depress as there is a spring holding it up, Use 2 people if necessary, one to depress the tension plate changing it 1mm at a time and the other to tighten the Allen screws.

Re-adjust by 1.0mm if necessary until the spangle cut correctly.



Spangles Mis-Cutting front to back and double cutting.

With the Press Unit mounted with your spangle tape, Roll the Metal roller and see if the spangle tracks center as it comes through.

If not check to ensure the right Plastic Guides are mounted correctly,

And check the levelness of the Rubber roller with the metal roller

Metal Roller

Rubber Roller

