SET UP PROCEDURES FOR THE TRC 1000

Model CC7-CS/VS

1. Place *Control Panel* and *Cutting Head* on a flat table with the back of the *Control Panel* facing the side of the *Cutting Head*. Connect the grey *DB-15 Control cable* to the connectors on the back of the *Cutter* and the back of the *Control Panel*. Plug the black *Power Cord* into the fused power receptacle on the back of the *Control Panel*. Then plug the *Power Cord* into your 110V outlet.
Be sure all connections are tight and secure!

2. Next hook up the *Air Regulator* to your air supply and set the pressure at 50 PSI. This will work on most lightweight materials. If the machine is not cutting your material then increase the pressure in 10# increments until it is making clean cuts.

3. Set the *Roll Stand* behind the *Cutter* and line it up with the *Guides* on the *Cutter*. Place one *Plastic Disc* on the *Roll Stand* and put on the roll of webbing so that the webbing rolls off the top of the roll in a counter clockwise motion. Place the other *Disc* on the *Stand* and put the *Disc Holder* lightly against the *Disc* and tighten the *Thumb Screw* lightly. If the webbing does not turn freely then loosen the *Disc Holder* a little.

STARTUP PROCEDURES

1. Turn the *Master Switch* to the "**ON**" position.
2. Adjust the *Guides Strips* to fit the webbing you are using. Do not make it to tight as to cause drag on the web.
3. Feed the webbing through the *Guides* and push it up to the *Feed Rollers* and then push the **FEED JOG** button on the *Control Panel*. This will take the webbing through the *Feed Rollers*. Jog the webbing past the *Rollers* an inch or so and press the **KNIFE JOG** button. You can also put the webbing through the *Rollers* by pushing down on the *Black Knob* and lifting the *Rollers* and pushing the webbing through by hand.
Note: If your machine is equipped with the optional cutoff switch, you must feed material under the trip rod before the guides.

KEYBOARD COMMANDS

FEED JOG	Allows you to manually operate the feed rollers.
KNIFE JOG	Allows you to manually operate the knife.
RE-SET	Allows you to clear the machine and start a new program.
STOP	Allows you to stop the machine and save all data in the memory. Also allows you to clear a data entry when programming.
ENTER	Allows you to enter program data.

SETTING FEED RATE
(for Variable Speed models only)

When the *control panel* is turned on the *LCD* will read **"FEED RATE 5-22"**.
This will determine how fast the webbing will feed through the *machine*.
5 will be the slowest and **22** will be the fastest. To enter the speed, push the number you desire and press **ENTER.**

ENTERING A PROGRAM

1. When the *Master Switch* is on the *LCD* will read "**LENGTH?**". To enter the length you want say a 10" piece just push 10 on the *Keypad* and **ENTER** to for enter. For 10 1/2" enter **10*5** and **ENTER**. Different thickness of webbing will feed at a different rate and sometimes becomes necessary to calibrate the machine for a particular type of web. You may have to program in 10.10 to get the length you want for a 10" piece.

2. After entering the length, "**HOW MANY?**" will appear on the *LCD*. Enter the number of pieces you want, example; **50 ENTER** for 50 pieces.

3. "**CUT TIME?**" will appear on the *LCD* next. This is the amount of time the *Knife* stays down to cut the web. This will vary according to the thickness and the width of the web. Example; a lightweight material may only take .10 sec to cut where a heavier material may take .250 sec to cut. Some experimentation is necessary to find the best cut time for your material. To get .10 sec cut time push ***10** after "CUT TIME" appears on the *LCD* then push **ENTER**. When you push the **ENTER** button after the cut time, all the data will appear on the *LCD* and the *Machine* begins cutting.
(You will have to experiment a little with the time to see what works best with your webbing.)

4. To stop the *Machine* during operation and not loose the data you have entered push the **STOP** button and hold it down until the *Machine* stops. If you need to make an emergency stop push **RESET** or turn the *Master Switc*h off. By using the **STOP** button you will save the program and the count. To resume, just press **ENTER** and it will continue with the program you had entered. When you use **RESET** or the *Master Switch* you will loose the program. After you have ran a program and want to run the same program again you do not have to enter the data again. Just press **ENTER** and it will run the same program and continue to keep a running count.

5. When you are through with the *Machine* turn the *Master Switch* "**OFF**".

Procedimiento para calibrar el TRC 1000

Modelo(s) CC7-CS/VS

1. Coloque el tablero de control y la cabeza de corte on una superficie lisa con la parte trasera del tablero de control hacia el lado de la cabeza de corte. Conecte el cable de control gris DB-15 al conector en la parte de atras de la cortadore y la parte trasera del tablero de control. Enchufe el cable negro al receptaculo en la parte trasers del tablero de control, entonces enchufe el cable al receptaculo de 110V.

Asegurese de que todas las conecciones esten apretadas y seguras!

2. A continuacion conencte el regulador de aire al sumionistro de aire y fije la presion a 50 PSI. Esto funciona en la majoria de los materiales lijeros. Si la maquina no esta cortando el material entonces incremente la presion en incrementos de 10 libras hasta que haga cortes limpios.

3. Coloque el rodillo-soporte atras de la cortadore y alinielo con la quias en la cortadora. Coloque un disco de plastico en el rodillo-soporte y ponga un rollo de hiliza de manera que el rollo de hiliza se desenrolla en direccion contraria a las manecillas del reloj. Coloque los otros discos en soporte y ponga el fijador del disco ligeramente en contra del disco. Apriete el tornillo de ajuste ligeramente. Si el rollo de hiliza no se desenrolla libremente, entonces afloje ligeramente el fijador del disco.

Procediemiento para comenzar

1. Pocisione el switch de control en la position "**ON**"
2. Ajuste las guias de acuerdo a la hiliza que se esta usando. No lo apriete tanto de manera que arrastre la hilaza.
3. Alimente la hilaza a traves de las guias y empujela hacia los rodillos de alimentacion, entonces empuje el boton **"Feed Jog"** en el tablero de control. Esto llevara la hilaza a traves de los rodillos de alimentacion. Alimente la hilaza hasta pasar los rodillos una pulgada y apriete el boton **"Knife Jog".** Ud. Tambien puede poner la hilaza a traves de los rodillos empujando hacia abajo el perno negro y levantando los rodillos y empujando la hilaza con la mano.

Nota: Si la maquina esta equpada con el switch opcional de apagado, se debe de alimentar el material bajo la varilla de viaje antes de las guias.

Tablero de comandos

Feed Jog	permite la operacion manual de los rodillos alimentadores
Knife Jog	permite la operacion manual de la navaja
Re-set	permite re-iniciar la maquina y comenzar un nuevo programa
Stop	permite parar la maquina y guardar los datos en la memoria.
	Tambie permite borrar una paso no deseado durante su programacion.
Enter	

Calibrando la velocidad de alimentacion

(para modelos con velocidad variable)

Cuando el tablero de control esta prendido, el LCD (display de cristal liquido) lee "Feed Rate 1-9". Esto detrmina que tan rapidola hilaza pasara a traves de la maquina. 1 = mas lenta y 9 = mas rapida. Para fijar la velocidad, empuje el numero deseado y se fijara automaticamente.

Metiendo un programa

1. Cuando el switch master esta prendido, el LCD leera **"Length?".** Para fijar el numerodeseado, por ejemplo una pieza de 10 pulgadas, entre 10 en el *tablero numerico* y apriete **Enter**. Para 10.5 entre **10*5** y **Enter**. Differente grosor de la hilaza se alimentara a diferente velocidades y a veces es necesario calaibrar la maquina para un tipo particular de hilaza. Quizas se tenga que programar en 10.10 para ebtener la pieza de 10 pulgadas.

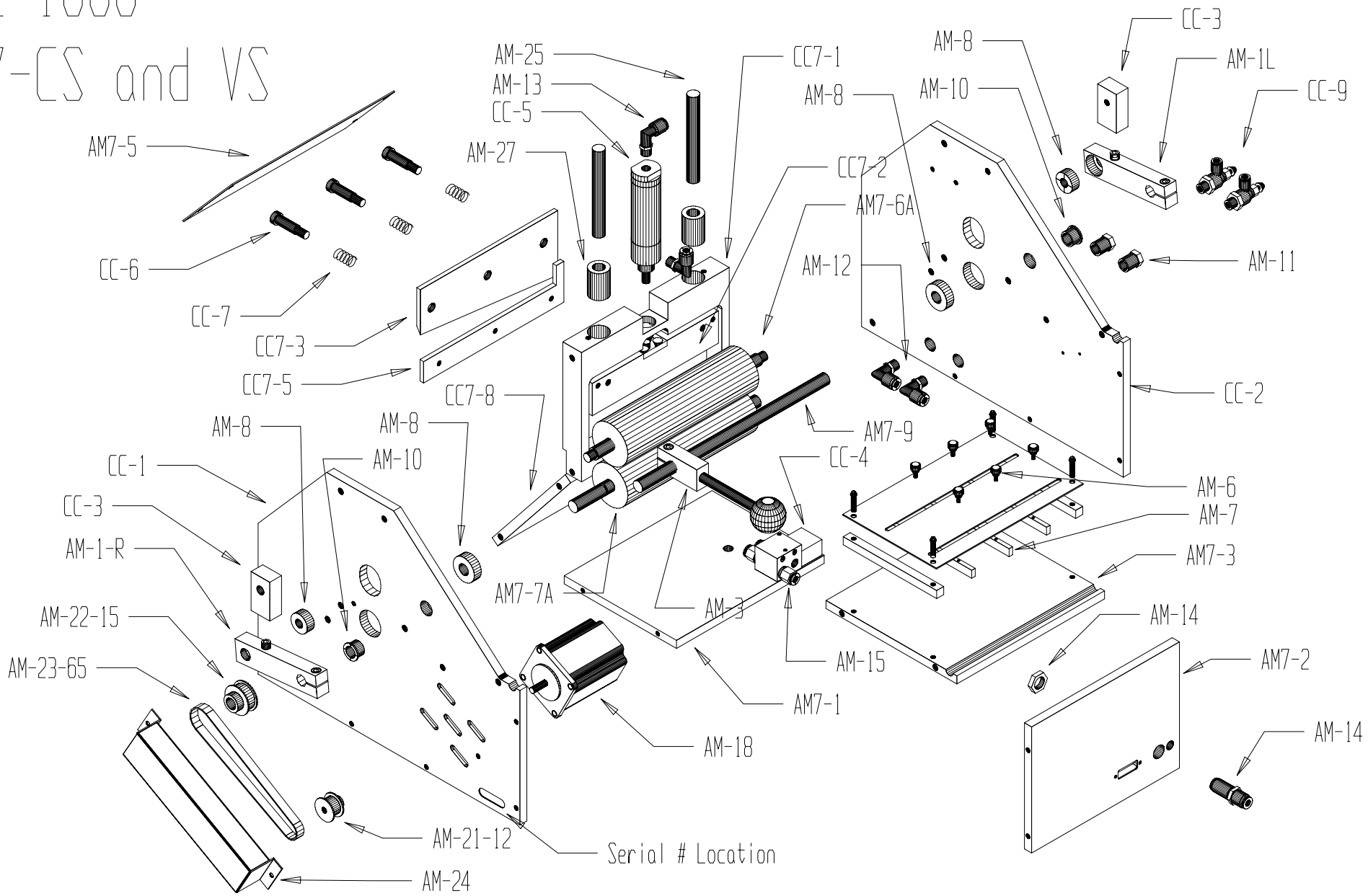
2. Despues de fijar la longitud, **"How many?"** aparecera en el LCD. Entre el numero de piezas deseadas, ejemplo: **50 Enter** para 50 piezas.

3. **"Cut Time?"** aparecera en el LCD. Esta es la duracion de tiempo que la navaja se encuentra abajo para cortar la hilaza. Esto variara de acuerdo al grosor y al ancho de la hilaza. Por ejemplo, un material ligero podria tomar 0.10 segundos para cortar, mientras que un material mas grueso puede tomar 0.250 segundos para cortar. Es necesario experimentar un poco para encontrar el mejor tiempo de corte para su material. Para obteuer 0.10 segundos tiempo de corta, entre ***10** despues de que **"Cut Time?"** aparece en el LCD, entonces ente **Enter**. Cuando se aprieta en boton Enter despues de tiempo de corte, toda la informacion aparecera ene le LCD y ma maquina comienza a cortar. (Se requerira algo de experimentacion para hallar la mejor situacion para su hilaza)

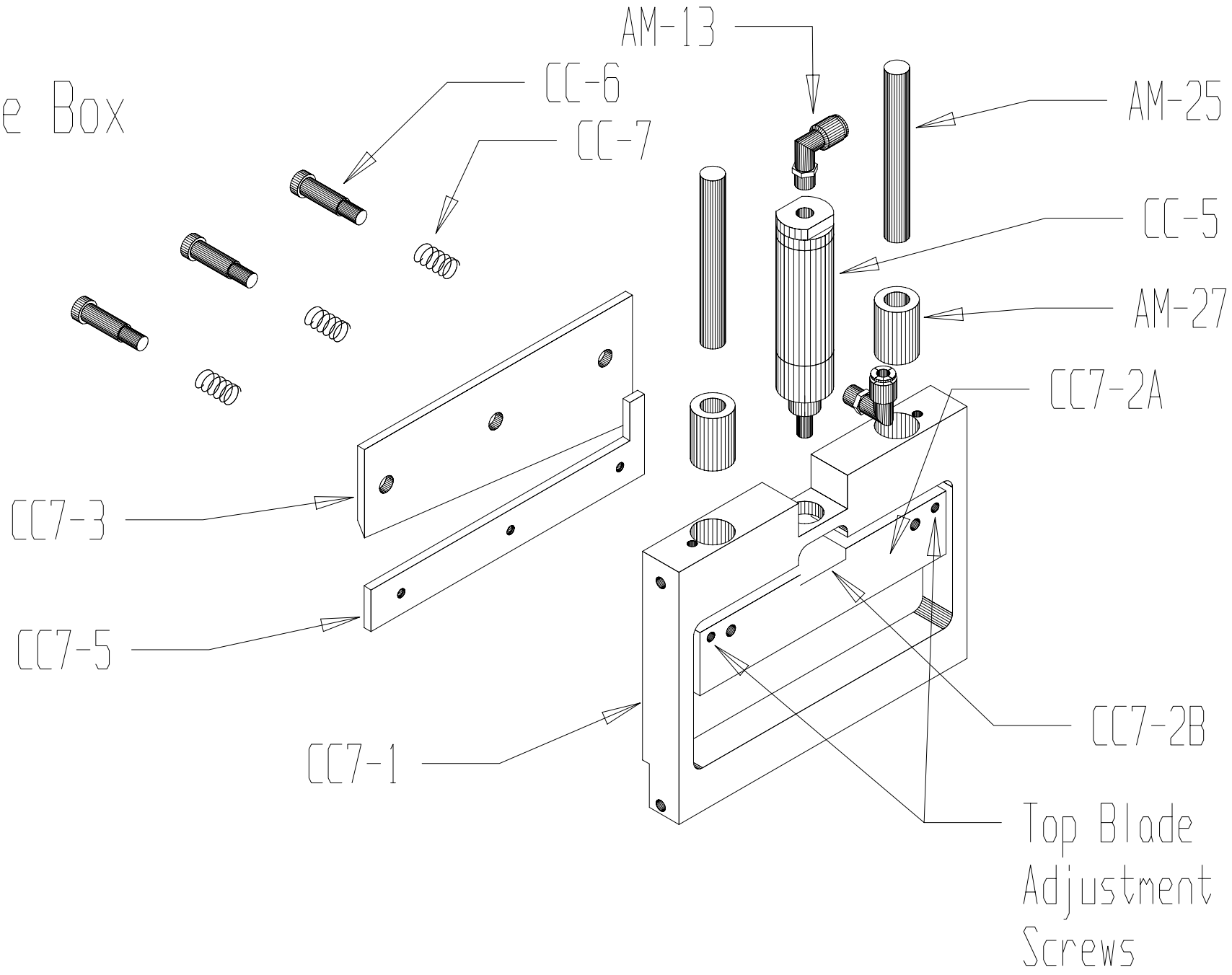
4. Para parar la maquinadurante la operacion, sin perder la informacion fijada, apriete el boton de **Stop** y mantengalo apretado hasta que la maquina para completamente.. Si se necesita hacer una parada de emergencia apriete **Reset** o apague el switch master. Mediante el use del boton **Stop**, no se perdera el programs y la cuenta. Para reanudar, apriete **Enter** y continuara con el programa previamente indicado. Cuando de usa **Reset** o el switch master, se perdera el programa. Despues de que se ha corrido un programa y quiere correr el mismo programa otra vez, no se necesita meter la informacion nuevamente. Simplemente apriete **Enter** y correra el mismo programa y continuara una cuenta corrida.

5. Cuando acabe de usar la *maquina* apague el *master switch* **"OFF"**

TRC 1000
CC7-CS and VS

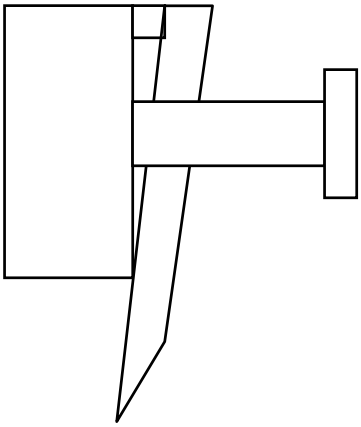


TRC 1000
CC7 Knife Box

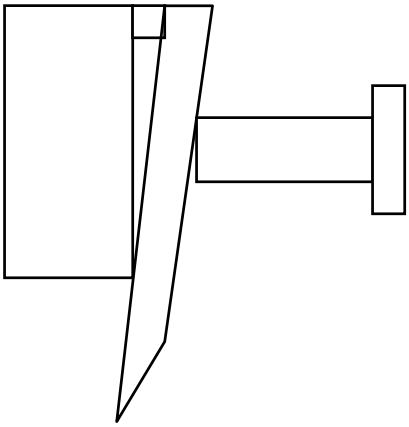


Note:

When replacing blades, make sure that shoulder of bolt goes through the holes in the blade and not against the outside of blade. Being on the outside of the blade increase the wear rate.



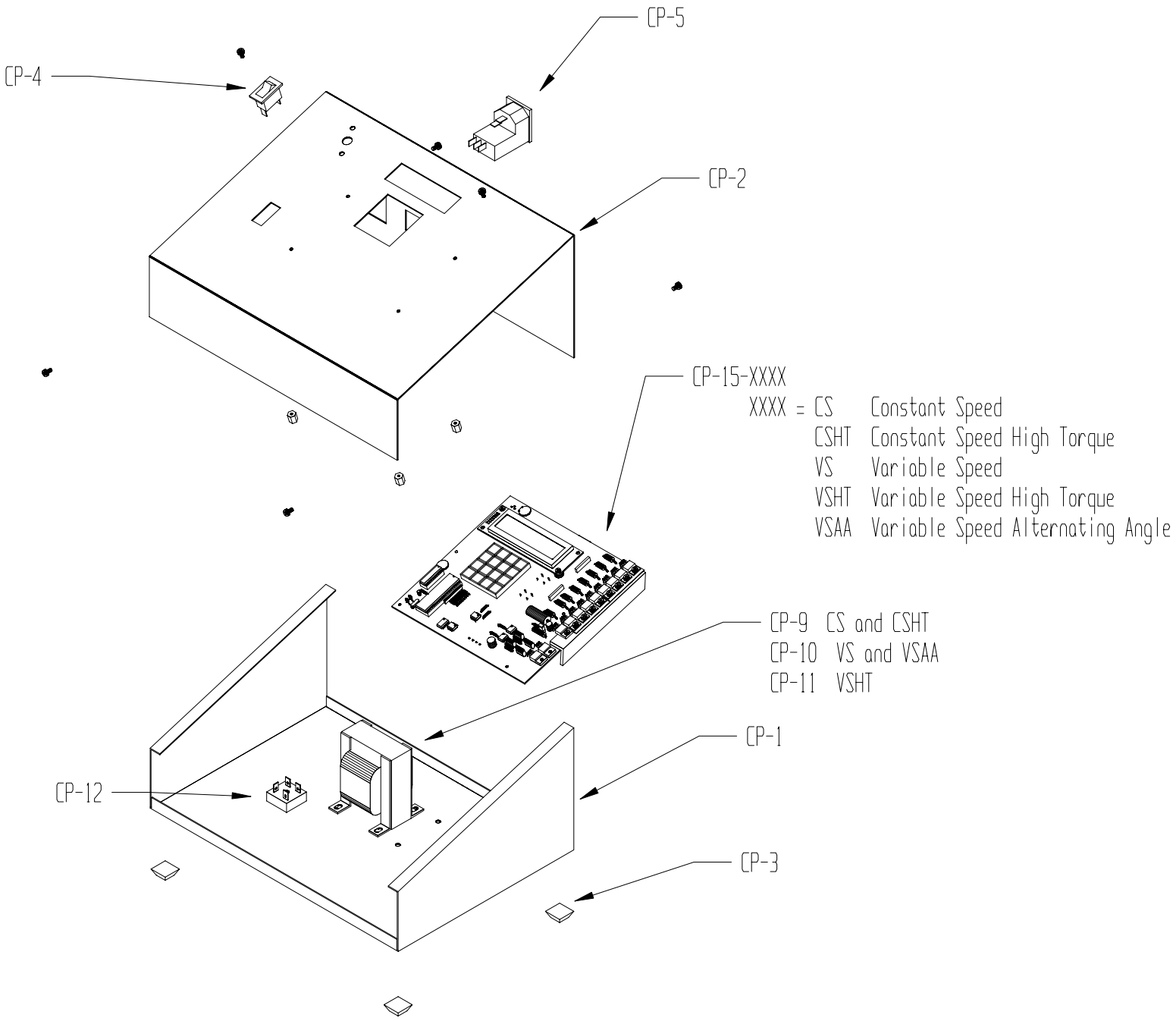
Like This



Not this

Thanks

Jon


CP-5
CP-4
CP-2
CP-15-XXXX
XXXX = CS Constant Speed
CSHT Constant Speed High Torque
VS Variable Speed
VSHT Variable Speed High Torque
VSAA Variable Speed Alternating Angle
CP-9 CS and CSHT
CP-10 VS and VSAA
CP-11 VSHT
CP-1
CP-12
CP-3

Periodic Maintenance

Proper operation of your *TRC-1000* can be maintained by periodic cleaning, lubrication and adjustment of the *Cutting Unit*.

Linear Shafts/Bushings and *Air Cylinder shafts* should be kept clean of dust, lent and other foreign substances. These points should also be lubricated periodically with a light weight oil, such as sewing machine oil.

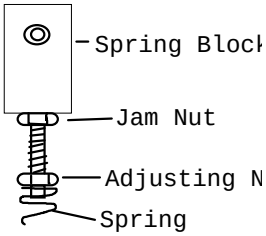
Keep *Drive* and *Tension Rollers* clean of foreign matter. Proper *spring* tension is also important to machine accuracy. Too much pressure causes excessive drag, and too little will cause material slippage.

Drive Belt and *Pulleys* should be checked for slippage and looseness.

The *Cutting Blade* and Groove on the *Cutting Plate* should be scraped clean.

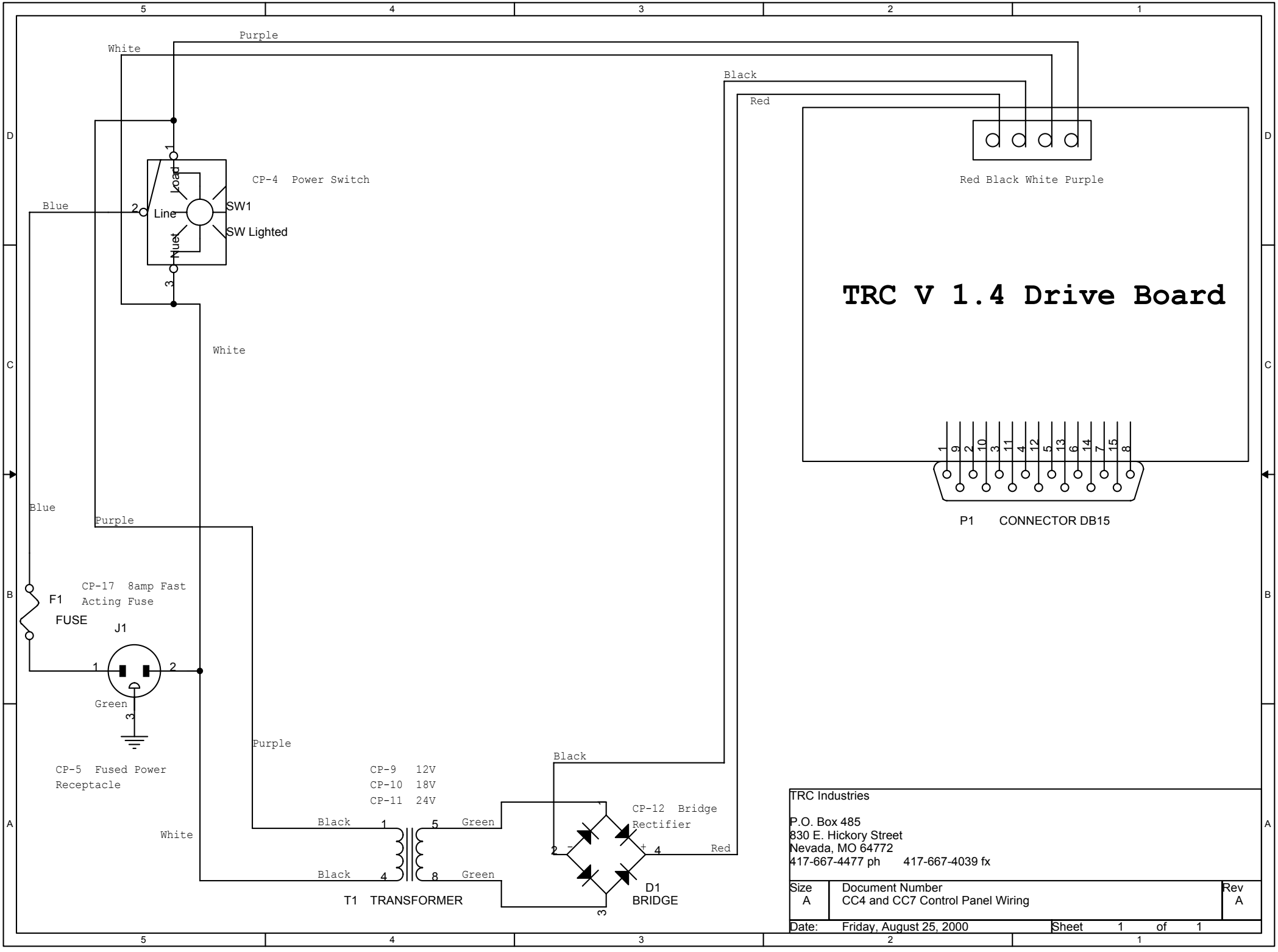
Periodically check all *screws* for loosening.

Spring Tension Adjustment



1) Loosen jam nut.
2) Screw bolt in or out with adjusting nut to decrease/increase spring pressure on top roller. (adjust both sides evenly.)
3) Snug jam nut.

Note: Excessive roller tension promotes feed roller wear and motor load!



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Size	Document Number	Rev
A	CC4 and CC7 Control Panel Wiring	A

Date: Friday, August 25, 2000 Sheet 1 of 1

TRC Industries

Factory Warranty Registration Card

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Atten: Jon

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