

# Ledco 30" Automatic Cutter

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Provided By

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*When Image Matters.*

# 30" AUTOCUTTER PROBLEM DIAGNOSTIC CHARTS

| Symptom   | Possible Causes  | Possible Remedies  | Procedure Number           | Skill Level  |
|---|--|--|----------------------------|--|
| Digital display doesn't light up.   | No power.  | Check power cord.  | 1                          | *  |
|   |  | Check power switch position.   | 2                          | *  |
|   |  | Check for engaged emergency stop switch.   | 3                          | *  |
|   |  | Check for open housing door.   | 4                          | *  |
|   |  | Check main fuse.   | 5                          | **   |
|   |  | Check for wires that are disconnected, broken or shorting out.   | 7                          | **   |
|   |  | Check main switch.   | 8                          | ***  |
|   |  | Check proximity switches.  | 9                          | ***  |
|   |  | Check main power relay.  | 10                         | ***  |
|   |  | Digital display lights up but there are no characters.   | Keypad did not initialize. | Allow ten seconds in between turning machine off and turning machine on. |
| "Enter Password:" is displayed on the digital display.  | Pressing Esc. Button when not prompted and pressing a program button after.  | Only press Esc. Button when prompted.  |                            |  |
|   |  | You will have to turn machine off for ten seconds to reboot and turn it back on to return to original screen.  |                            |  |
| Turn on machine and display is mostly 0's.  | Pressing Esc. Button when not prompted.  | Only press Esc. Button when prompted   |                            |  |
|   |  | You will have to turn machine off for ten seconds to reboot and turn it back on to return to original screen.  |                            |  |
|   | Turning on machine or machine losing power while either the front dancer bar is in fully up position or the top cover is open. | Either close the top cover or loosen web and allow dancer bar to lower. Then turn machine off for ten seconds to reboot then turn it back on to return to original screen. |                            |  |
| Material feeds and pauses but doesn't cut; and feeds and pauses again but doesn't cut, and so on. | Clutch is not activating.  | Check wire connection to clutch.   | 11                         | **   |
|   |  | Check wire connection to control.  | 12                         | **   |
|   | Clutch is slipping.  | Check for clutch slippage and removing clutch.   | 13                         | ***  |

Skill Level Index: \* Basic, End-User \*\* Intermediate or Dealer \*\*\* Advanced or Servicing Dealer/Technician



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| Symptom   | Possible Causes   | Possible Remedies   | Procedure Number | Skill Level |  |
|---|---|---|------------------|-------------|--|
| Material feeds and blade activates but the material is partially cut or not cut at all.                 | Material to be cut is creased in a way that it wedges between the cutting blades and pries them apart not allowing them to shear. | Do not allow sheets to stack one on top of the other between laminator and cutter.                                |                  |             |  |
|   |   | If cutting single side lamination use single side lamination attachment.  | 14               | *           |  |
|   | Cutting blades are dull.  | Remove cutting blades and remount with new cutting edges in place.  | 15               | ***         |  |
| Machine doesn't cut square.   | Material being feed into laminator out of square.   | Adjust feed guides or autofeeder to feed square into laminator.   |                  |             |  |
|   | Material running through cutter off center.   | Set to run material through center of machine.  |                  |             |  |
|   | Cutter feed side guides not adjusted properly.  | Adjust feed side guides.  | 16               | *           |  |
|   | Cutting blades are dull.  | Remove cutting blades and remount with new cutting edges in place.  | 15               | ***         |  |
| Machine is not cutting accurately.  | Material being feed into laminator out of square.   | Adjust feed guides or autofeeder to feed square into laminator.   |                  |             |  |
|   | Material being laminated doesn't have a gap or not enough gap between one to another.   | Adjust autofeeder to leave enough gap to allow for nose and tail trim distance.                                   |                  |             |  |
|   |   | When hand feeding allow enough gap to allow for nose and tail trim distance.                                      |                  |             |  |
|   | Cutter feed side guides not adjusted properly pinching web tightly between them.  | Adjust feed side guides.  | 16               | *           |  |
|   | Laminated material to be cut is stacked on top of itself between laminator and cutter, causing drag on the web.                   | Do not run too much material to be cut onto the floor in between laminator and cutter before starting the cutter. |                  |             |  |
|   |   | Adjust speed on cutter.   | 17               | *           |  |
|   | Rubber rolls are dirty causing them to lose traction.   | Clean rubber rolls.   | 18               | *           |  |
| Something coming in contact with material between the laminator and the cutter causing drag on the web. | Move anything that may cause interference with the web between the laminator and the cutter.                                      |   |                  |             |  |
| continued on next page  |   |   |                  |             |  |

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# 30" AUTOCUTTER PROBLEM DIAGNOSTIC CHARTS

| Symptom   | Possible Causes   | Possible Remedies  | Procedure Number | Skill Level |
|---|---|--|------------------|-------------|
|   | Web pulls tight between laminator and cutter causing rubber rolls to skid.                    | Make sure the cutter feed table is at the same level as the laminator feed table or lower, allowing the front dancer to work properly. |                  |             |
|   |   | Make sure web travels below dancer bar and above front idler tube.   |                  |             |
|   | Rubber roll drive belt is loose or worn.  | Check, adjust, and/or replace rubber roll belt.  | 19               | **          |
|   | Material running through cutter off center.<br>Fiber optic sensor out of adjustment.          | Set to run material through center of machine.<br>Adjust fiber optic sensor.   | 20               | **          |
| Push start button and material feeds but doesn't stop and cut.                          | Machine control is in wrong mode.   | Check upper left corner of interface for current mode setting and set to proper mode if necessary.                                     |                  |             |
|   | Fiber optic sensor out of adjustment.   |  | 20               | **          |
| Machine is stopped and you try to enter values but nothing works.                       | The controller is paused.   | Loosen web between cutter and laminator enough to lower front dancer to bottom position.   |                  |             |
|   |   | Close top safety cover.  |                  |             |
| I hear chattering, squealing and the web between the cutter and the laminator is tight. | The rubber rolls are skidding or the pulley is spinning on the belt on the rubber roll drive. | Make sure the cutter feed table is at the same level as the laminator feed table or lower, allowing the front dancer to work properly. |                  |             |
|   |   | Make sure web travels below dancer bar and above front idler tube.   |                  |             |

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