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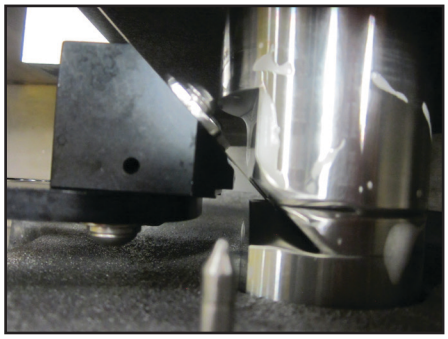
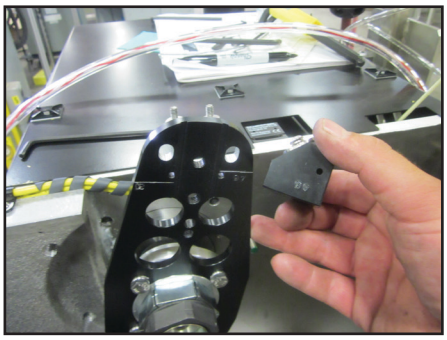
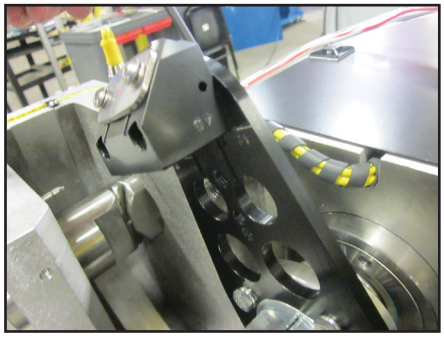
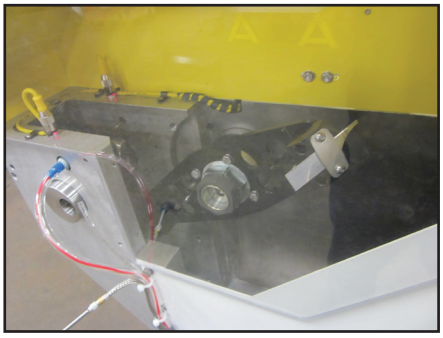
USER GUIDE

UGE104-0816

Addendum for

Angle Cutting with CSC Series Servo Cutter

Please record your equipment's model and serial number(s) and the date you received it in the spaces provided.

It's a good idea to record the model and serial number(s) of your equipment and the date you received it in the User Guide. Our service department uses this information, along with the manual number, to provide help for the specific equipment you installed.

Please keep this User Guide and all manuals, engineering prints, and parts lists together for documentation of your equipment.

Date:

Manual Number: UGE104-0816

Serial Number(s):

Model Number(s):

DISCLAIMER: Conair shall not be liable for errors contained in this User Guide or for incidental, consequential damages in connection with the furnishing, performance or use of this information. Conair makes no warranty of any kind with regard to this information, including, but not limited to, the implied warranties of merchantability and fitness for a particular purpose.

Angle Cutting Features, Setup, and Use (custom ordered)

This addendum is designed to help operators with the angle cutting features of the CSC Servo Cutter. Below, three various setups are shown for angle cutting. Contact Conair Service with any application questions. 814-437-6861.

Setup #1 for 90 degree and 45 degree angles, bushing bore 0.342-inch.

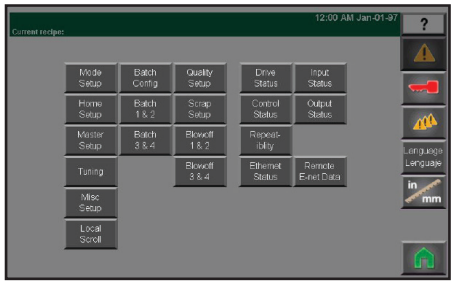
Part Description	duro-meter	ID	OD	Length	Rate	cut/ min	Frost?	Angle 1	Angle 2	bushing	Opposed angles or alternate?	Cutter Mode	#of blades on Cutter Arm
.187 ID x .312 OD x 34", Frosted, Angle	68	0.187	0.312	34	2117.6	35.3	frost	45	90	.425	No Scrap created Not opposed	On Demand Encoder mode	360 degree mode
.187 ID x .312 OD x 34", Frosted, Angle	68	0.187	0.312	34	2117.6	35.3	frost	45	90	.425	No Scrap created Not opposed	On Demand Encoder mode	360 degree mode
.187 ID X .312 OD X 96", Angle Cut	68	0.187	0.312	96	500.0	8.3		45	90		No Scrap created Not opposed	On Demand Encoder mode	360 degree mode

This setup includes 1 set of custom bolt-together three piece cutter bushings with air feed assist and round bore for 45 degree angle cutting on one end and straight 90 degree cut on other end, non opposed.

.187 ID x .312 OD x 34", Frosted, Angle — 54 CPM
On Demand Encoder Mode — 360 degree mode

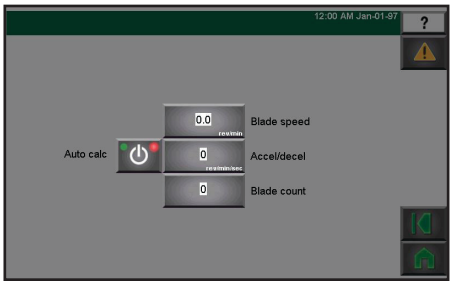
.187 ID x .312 OD x 34", Frosted, Angle — 35 CPM
On Demand Encoder Mode — 360 degree mode

.187 ID X .312 OD X 96", Angle Cut — 35 CPM
On Demand Encoder Mode — 360 degree mode



Page Menu - Misc Setup

The Misc Setup screen is accessed by selecting Misc. Setup on the Page Menu screen



Misc. Setup - Blade Count

The 360/180 cut is set on the Misc Setup screen.

360 Blade count set to 1
180 Blade count set to 2

(Continued)

Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

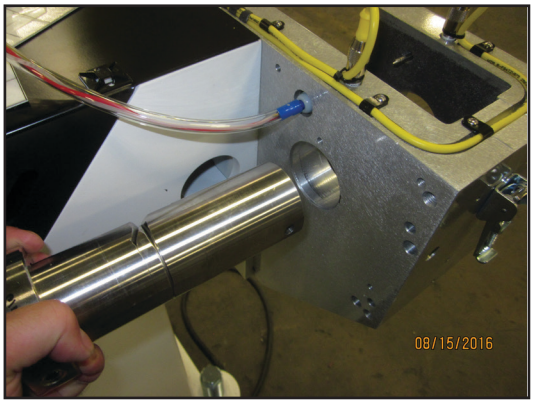
Before making any changes to the blades or bushings of the CSC Cutter, always disconnect and lockout the main power of the unit. Only qualified technicians should perform tasks that require opening the cutting chamber of the CSC Cutter.

⚠ CAUTION: Sharp Blades

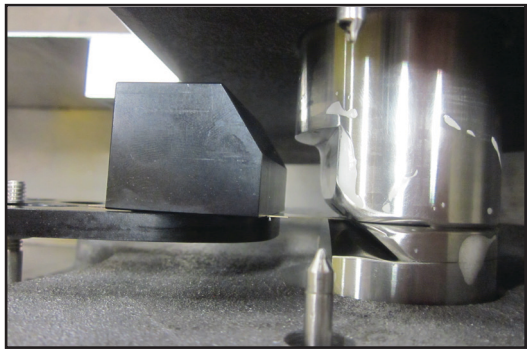
Most injuries occur when equipment is turned off and operators are making adjustments and handling sharp blades. Always use caution when working with cutting blades.

Contact Conair
Parts and Service
Phone 800-458-1960
From outside of the
United States,
Call: 814-437-6861

1 **Mount 90 degree cutting fixture to blade arm.**



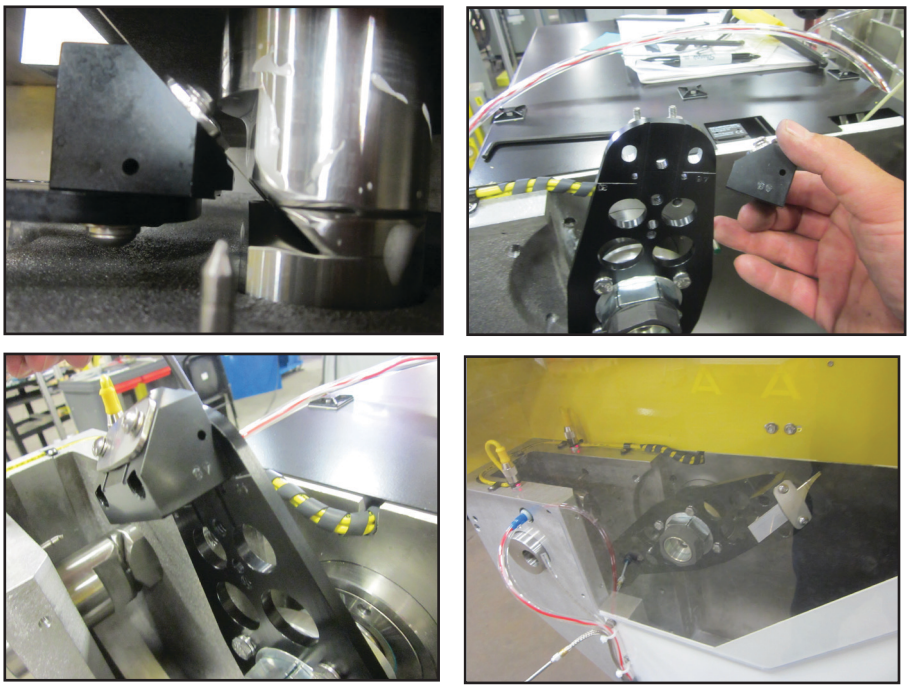
0.342-inch bore 3-piece cutter bushings



90 degree blade arm fixture

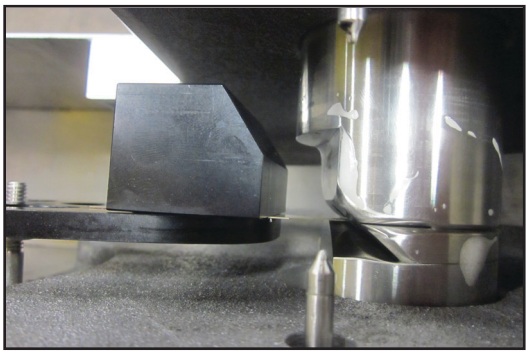
Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

2 **Mount 45 degree cutting fixture to opposite end of blade arm..**

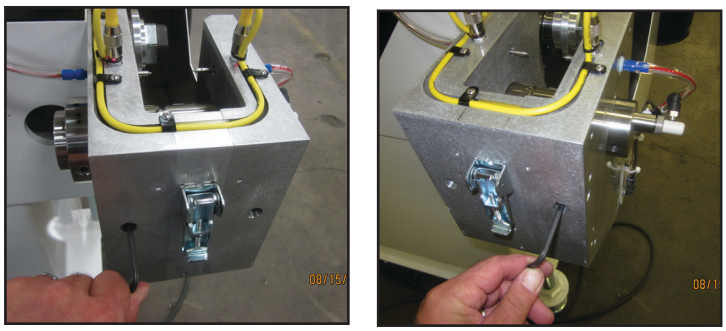


45 degree blade arm fixture

3 **Slide bushing assembly into bushing holder, and mate to 90 degree blade,** being sure the blade goes through the gap without blade deflection.

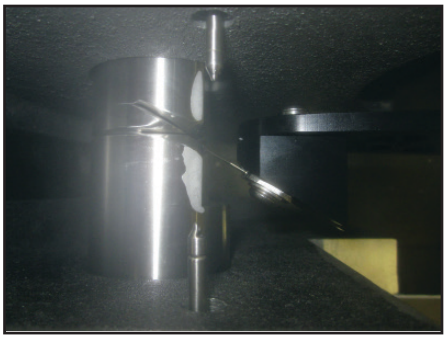


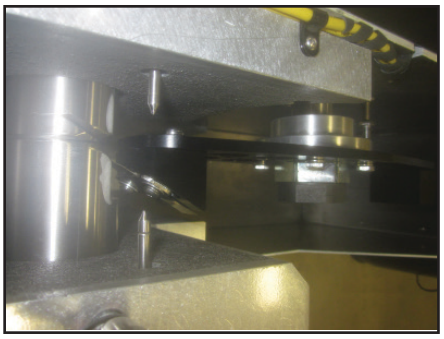
4 **Lock bushing assembly into the bushing holder using both socket set screws.**



Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

5 **Rotate blade arm fixture to test alignment of 45 degree blade.** You may note a slight rubbing of blade on the bushings, but should pass through with slight pressure.





6 **Rotate blade arm to test both cuts and confirm bushings are locked in place.**

7 **Power up and turn power to CSC Cutter on.**

8 **Set cut length to 34 inches.**

9 **String up tube in process and begin cutting.**

Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

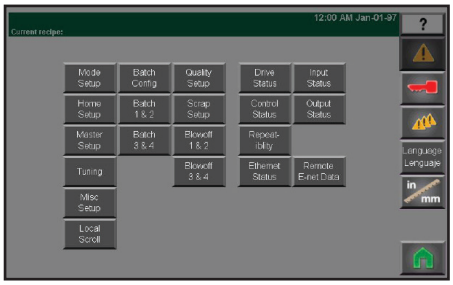
Set Up #2 for 45 and 90 degree angles, bushing bore 0.280-inch

Part Description	duro-meter	ID	OD	Length	Rate	cut/ min	Frost?	Angle 1	Angle 2	bushing	Opposed angles or alternate?	Cutter Mode	#of blades on Cutter Arm
.125 ID x .250 OD x 15", Frosted, Angle	70	0.125	0.250	15	2880.0	48.0	frost	45	90		No Scrap created Not opposed	On Demand Encoder mode	360 degree mode
.125 ID x .250 OD x 30", Frosted, Angle	70	0.125	0.250	30	2400.0	40.0	frost	45	90		No Scrap created Not opposed	On Demand Encoder mode	360 degree mode

This setup includes 1 set of custom bolt-together three piece cutter bushings with air feed assist and round bore for 45 degree angle cutting on one end and straight 90 degree cut on other end, non opposed.

.125 ID x .250 OD x 15", Frosted, Angle — 48 CPM
On Demand Encoder Mode — 360 degree mode

.125 ID x .250 OD x 30", Frosted, Angle — 40 CPM
On Demand Encoder Mode — 360 degree mode



Page Menu - Misc Setup

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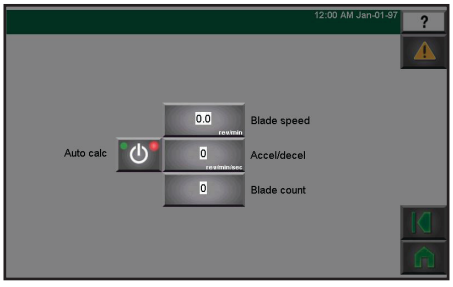


Misc. Setup - Blade Count

The 360/180 cut is set on the Misc Setup screen.

360 Blade count set to 1
180 Blade count set to 2

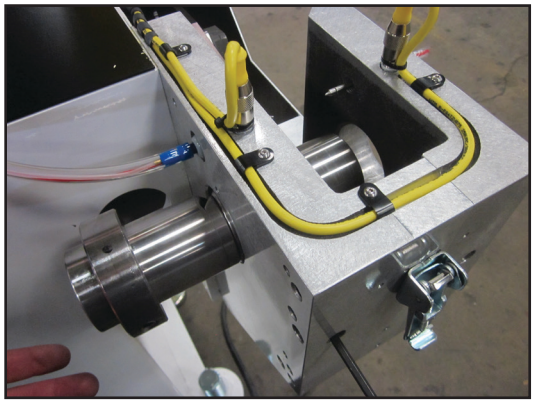
Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

Before making any changes to the blades or bushings of the CSC Cutter, always disconnect and lockout the main power of the unit. Only qualified technicians should perform tasks that require opening the cutting chamber of the CSC Cutter.

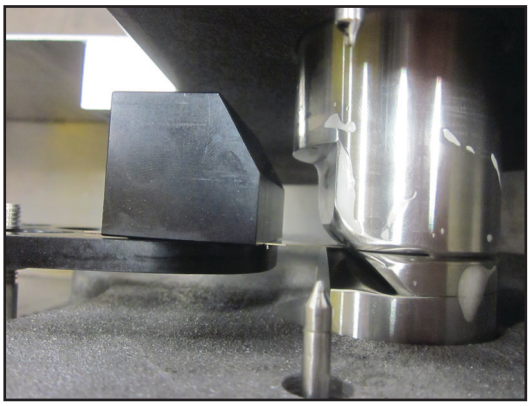
⚠ CAUTION: Sharp Blades

Most injuries occur when equipment is turned off and operators are making adjustments and handling sharp blades. Always use caution when working with cutting blades.

1 **Mount 90 degree cutting fixture to blade arm.**



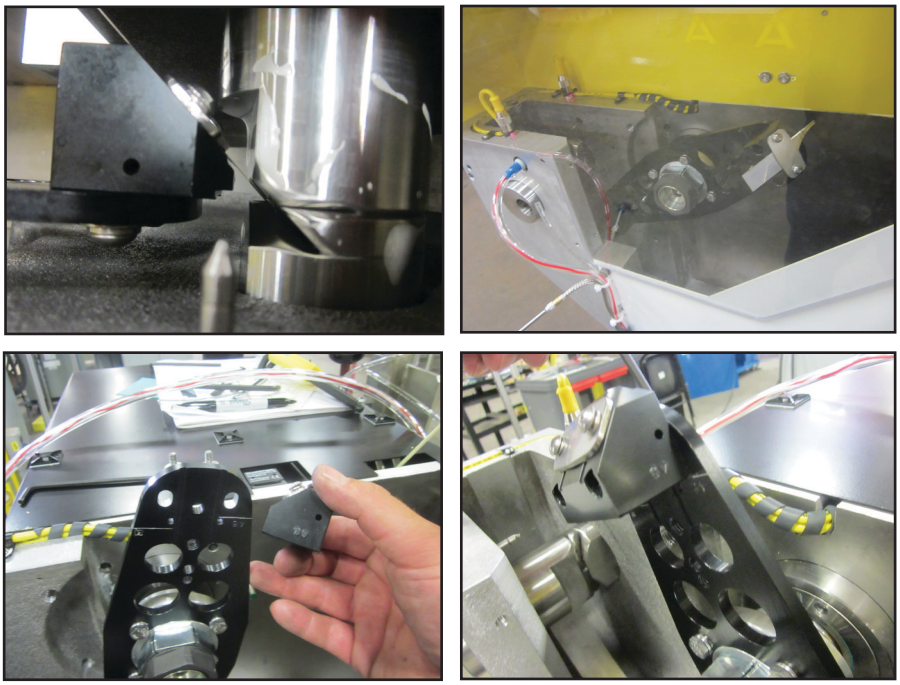
0.280-inch bore 3-piece cutter bushings



90 degree blade arm fixture

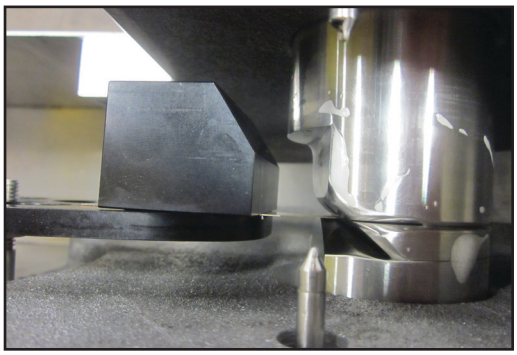
Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

2 **Mount 45 degree cutting fixture to opposite end of blade arm.**

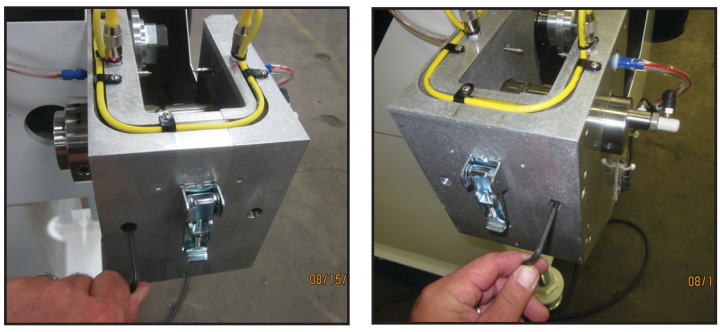


45 degree blade arm fixture

3 **Slide bushing assembly into bushing holder, and mate to 90 degree blade,** being sure the blade goes through the gap without blade deflection.

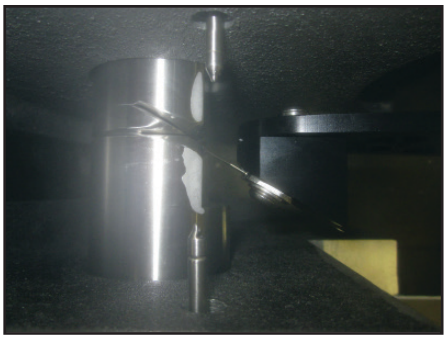


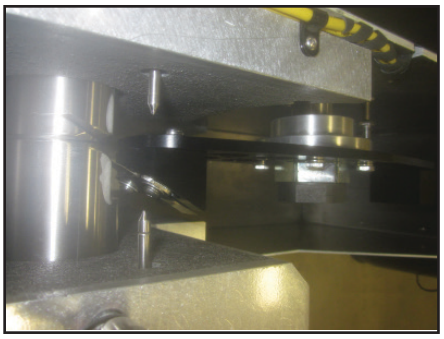
4 **Lock bushing assembly into the bushing holder using both socket set screws.**



Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

5 **Rotate blade arm fixture to test alignment of 45 degree blade.** You may note a slight rubbing of blade on the bushings, but should pass through with slight pressure.





6 **Rotate blade arm to test both cuts and confirm bushings are locked in place.**

7 **Power up and turn power to CSC Cutter on.**

8 **Set cut length to 15 or 30 inches.**

9 **String up tube in process and begin cutting.**

Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

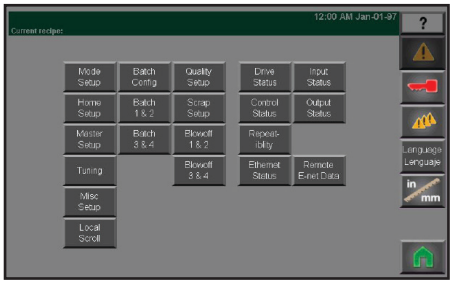
Set Up #3 for 30 degree angles bushing bore 0.160-inch

Part Description	duro-meter	ID	OD	Length	Rate	cut/ min	Frost?	Angle 1	Angle 2	bushing	Opposed angles or alternate?	Cutter Mode	#of blades on Cutter Arm
.073 x .105 x 15.5", Angle Cut, Frosted	80	0.073	0.105	15.5	9290.3	154.8	frost	30	30		? Not op-posed? = One blade	On Demand Encoder mode	360 degree mode
.081 x .127 x 22", Angle Cut, Frosted	80	0.081	0.127	22	4909.1	81.8	frost	30	30		? Not op-posed? = One blade	On Demand Encoder mode	360 degree mode

This setup includes 1 set of custom bolt-together two piece cutter bushings with air feed assist and round bore for 30 degree angle cutting on one end and same angle on other end, non opposed, including angle attachments for blade arm with two required for balance.

.073 ID x .105 OD x 15.5", Frosted, Angle — 55 CPM
On Demand Encoder Mode — 360 degree mode

..081ID x ..127 OD x 22", Frosted, Angle — 82 CPM
On Demand Encoder Mode — 360 degree mode



Page Menu - Misc Setup

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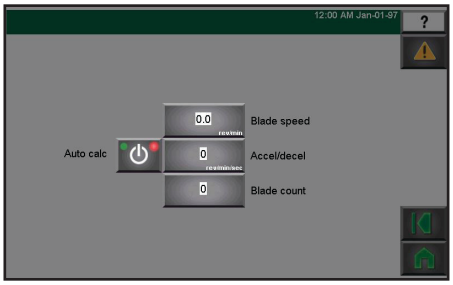


Misc. Setup - Blade Count

The 360/180 cut is set on the Misc Setup screen.

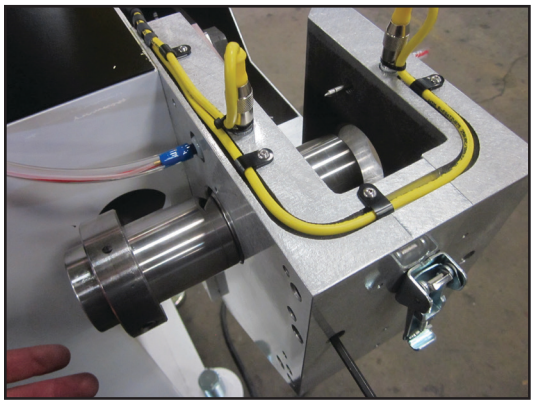
360 Blade count set to 1
180 Blade count set to 2

Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

Before making any changes to the blades or bushings of the CSC Cutter, always disconnect and lockout the main power of the unit. Only qualified technicians should perform tasks that require opening the cutting chamber of the CSC Cutter.

⚠ CAUTION: Sharp Blades

Most injuries occur when equipment is turned off and operators are making adjustments and handling sharp blades. Always use caution when working with cutting blades.



0.160 bore two-piece cutter bushings

30 degree blade arm fixture

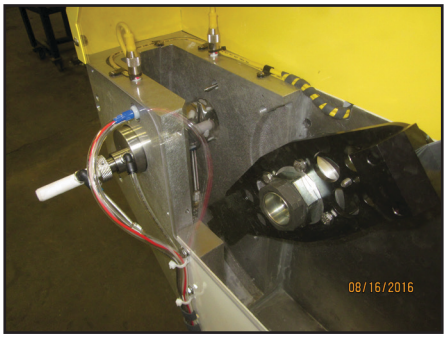
Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

1 **Mount 30 degree cutting fixture to blade arm.**

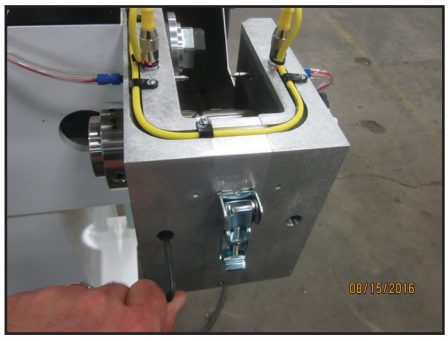
2 **Mount 30 degree cutting fixture to blade arm.**

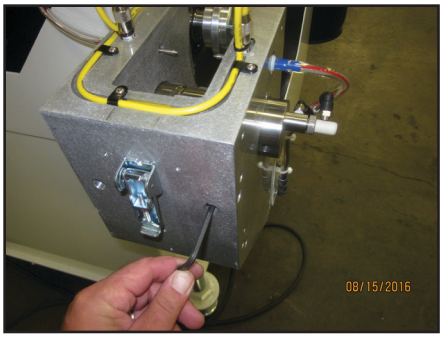
NOTE: Only mount one blade to one of the 30 degree fixtures. Leave the other mounted fixture bladeless, to serve only as a counterweight for balance.

3 **Slide bushing assembly into bushing holder, and mate to 30 degree blade,** being sure the blade goes through the gap without blade deflection.



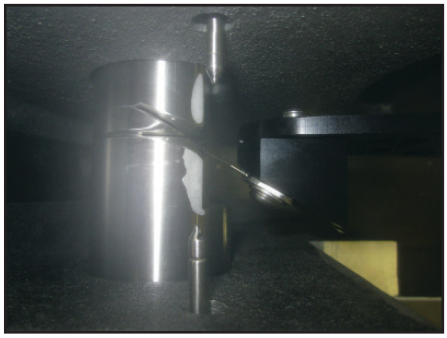
4 **Lock bushing assembly into the bushing holder using both socket set screws.**

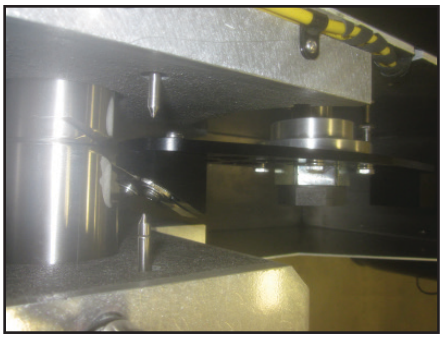




Angle Cutting Features, Setup, and Use (custom ordered) (Continued)

5 **Rotate blade arm fixture to test alignment of 30 degree blade.** You may note a slight rubbing of blade on the bushings, but should pass through with slight pressure.





6 **Rotate blade arm to test the cut and confirm bushings are locked in place.**

7 **Power up and turn power to CSC Cutter on.**

8 **Set cut length to 15.5 or 22 inches.**

We're Here to Help

Conair has made the largest investment in customer support in the plastics industry. Our service experts are available to help with any problem you might have installing and operating your equipment. Your Conair sales representative also can help analyze the nature of your problem, assuring that it did not result from misapplication or improper use.

Additional manuals and prints for your Conair equipment may be ordered through the Customer Service or Parts Department for a nominal fee.
Most manuals can be downloaded free of charge from the product section of the Conair website.
www.conairgroup.com

How to Contact Customer Service

To contact Customer Service personnel, call:

✎ **NOTE:** Normal operating hours are 8:00 am - 5:00 pm EST. After hours emergency service is available at the same phone number.

From outside the United States, call: 814-437-6861

You can commission Conair service personnel to provide on-site service by contacting the Customer Service Department. Standard rates include an on-site hourly rate, with a one-day minimum plus expenses.

Before You Call...

If you do have a problem, please complete the following checklist before calling Conair:

- ❒ Make sure you have all model, control type from the serial tag, and parts list numbers for your particular equipment. Service personnel will need this information to assist you.
- ❒ Make sure power is supplied to the equipment.
- ❒ Make sure that all connectors and wires within and between control systems and related components have been installed correctly.
- ❒ Check the troubleshooting guide of this manual for a solution.
- ❒ Thoroughly examine the instruction manual(s) for associated equipment, especially controls. Each manual may have its own troubleshooting guide to help you.

Equipment Guarantee

Conair guarantees the machinery and equipment on this order, for a period as defined in the quotation from date of shipment, against defects in material and workmanship under the normal use and service for which it was recommended (except for parts that are typically replaced after normal usage, such as filters, liner plates, etc.). Conair's guarantee is limited to replacing, at our option, the part or parts determined by us to be defective after examination. The customer assumes the cost of transportation of the part or parts to and from the factory.

Performance Warranty

Conair warrants that this equipment will perform at or above the ratings stated in specific quotations covering the equipment or as detailed in engineering specifications, provided the equipment is applied, installed, operated, and maintained in the recommended manner as outlined in our quotation or specifications.

Should performance not meet warranted levels, Conair at its discretion will exercise one of the following options:

- Inspect the equipment and perform alterations or adjustments to satisfy performance claims. (Charges for such inspections and corrections will be waived unless failure to meet warranty is due to misapplication, improper installation, poor maintenance practices, or improper operation.)
- Replace the original equipment with other Conair equipment that will meet original performance claims at no extra cost to the customer.
- Refund the invoiced cost to the customer. Credit is subject to prior notice by the customer at which time a Return Goods Authorization Number (RGA) will be issued by Conair's Service Department. Returned equipment must be well crated and in proper operating condition, including all parts. Returns must be prepaid.

Purchaser must notify Conair in writing of any claim and provide a customer receipt and other evidence that a claim is being made.

Warranty Limitations

Except for the Equipment Guarantee and Performance Warranty stated above, Conair disclaims all other warranties with respect to the equipment, express or implied, arising by operation of law, course of dealing, usage of trade or otherwise, including but not limited to the implied warranties of merchantability and fitness for a particular purpose.