

Instruction manual, machine 97 mk110im198l000

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This instruction manual is intended as a reference guide.  
It supplements the Cepak course and cannot be a substitute for the course.  
The technical data on the machine is based on the status at the time of market launch and naturally cannot include subsequent modifications.  
Cepak customer service will be happy to provide more information if anything is unclear or if you find the available is incomplete or inapplicable.  
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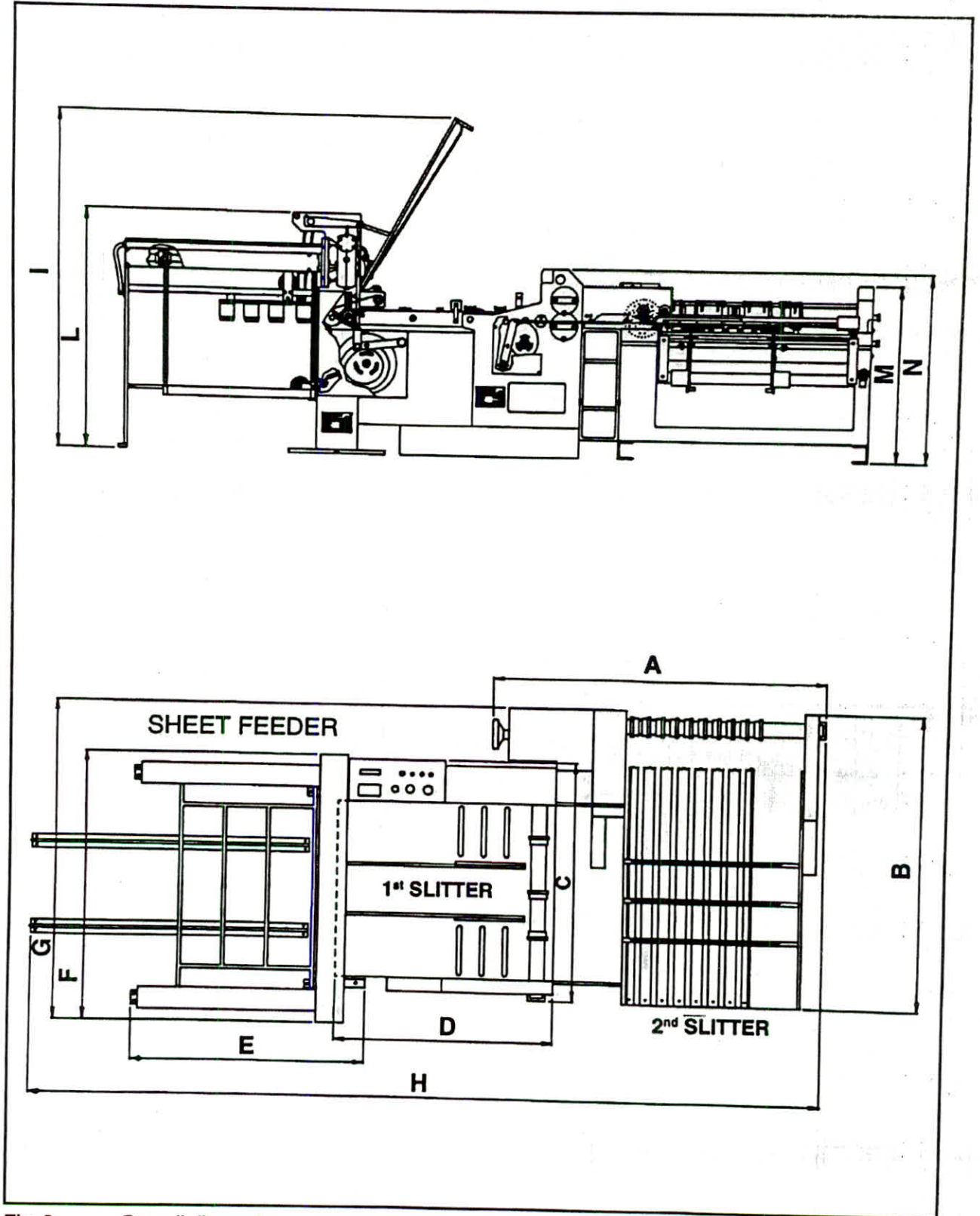


Fig. 2 Overall dimensions

**2.2.1.2 Technical data**

- $\pm 0.04$  mm. squaring accuracy achieved on a 140 mm. blank height
- $\varnothing 110$  mm. chromium-plated and ground cutter-holder arbors, tolerance of  $\pm 2$  micron
- $\varnothing 172.5$  mm. tungsten carbide cutters quickly removable to the right
- First slitter sheet dimension width 510 - 1160 mm. (1200 mm. on request)
- Minimum blank height 68 mm. standard (special down to 42 mm.)
- Sheet thickness 0,12 - 0,4 mm.
- Production speed 8/40 sheets per minute (special version up to 50 sheets per minute)
- Production speed depends on:
  - sheet width;
  - sheet thickness;
  - number of developments on slitter.
- Accuracy of squaring depends on:
  - quality of tinfoil;
  - tinfoil thickness;
  - production speed;
  - can size diameter.
  
- Absorbed power 5 Kw
- Air consumption 4,5 - 6,3 NI/sec.
- Working pressure 58 psi (4 bar)
- Maximum pressure 87 psi (6 bar)

**Note**

If more than 10 cuts are handled on the first / second slitter operation and / or the tinfoil thickness is 0,4 mm., special cutters of 172,7 mm. external diameter must be fitted in order to prevent the bending of a shaft.

**2.2.2 Maximum speed table**

Slitter system	CAN Ø in (mm)	Development slitter operation	Sheet thickness (mm)	Can type	Sheet per minute
CAR	52	5	0,25-0,28	Aerosol	50
CAR	52	6	0,25-0,28	Aerosol	40
CAR	52	5	0,17	Food prod.	38
CAR	65	5	0,17	Food prod.	38
CAR	65	4	0,17	Food prod.	42
CAR	73	4	0,16	Food prod.	42
CAR	84	3	0,17	Oil	40
CAR	84	4	0,19	Oil	30
CAR	99	3	0,2	Food prod.	35
CAR	109	3	0,2	Paint	32
CAR	155	2	0,24	Food prod	20
FFS	152	2	0,24	Food/paint	40
FFS	155	1	0,24	Food/paint	46
FFS	165	1	0,24	Paint/oil	46
FFS	165	2	0,24	Paint/oil	40
FFS	250	1	0,30	Pails	40

Tab.1 Production Speed Table - Maximum sheet output per minute

### 2.2.3 Placing the nameplates

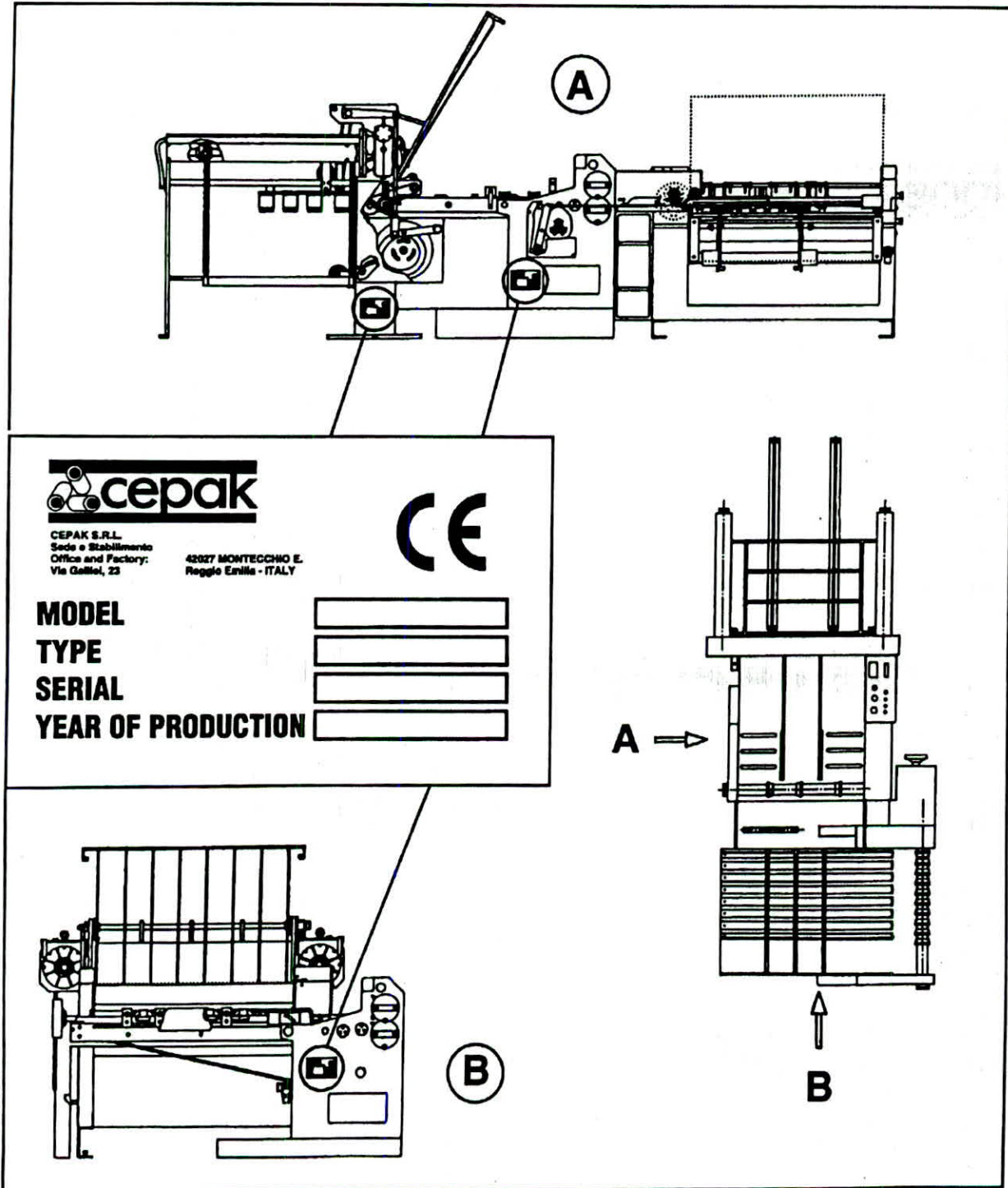


Fig. 3 Name plates

### 9.2.1 Installation and alignment

1. Check if shock, impact or humidity have damaged the machine in transit
2. The floor on which the machine is installed must be strong, free of vibrations, smooth and horizontal.
3. Position the slitter according to lay out
4. Align the second slitter table bearing in mind the lay out of a body blank transfer system , i e. body blank conveyor or robotic transfer system.  
When taking measurements use the welder fixed guides as reference points
5. Align and lock the first slitter table to the second slitter spacer box (pos. A fig. 33) with four 20MA bolts.  
Center the aligner key (pos. B fig. 33) with adjuster bolts located under the slitter legs. No anchoring to the floor is required. Thanks to its weight the machine will remain stable even during operation.
6. Screw up the racks (pos. C fig. 33) which guide the blank discharge unit.  
Before locking up the racks make sure that:
  - roller unit has been mounted
  - approx. clearance between the side plates and the racks is 0.2 mm.
7. Align the sheet feeder and fit two  $\varnothing 20$  mm. side pins (pos. A fig. 34)  
To compensate for surface irregularities use register bolts on the front legs and the base.
8. Anchor the sheet feeder using the holes near the register holes. (pos. C fig. 34)

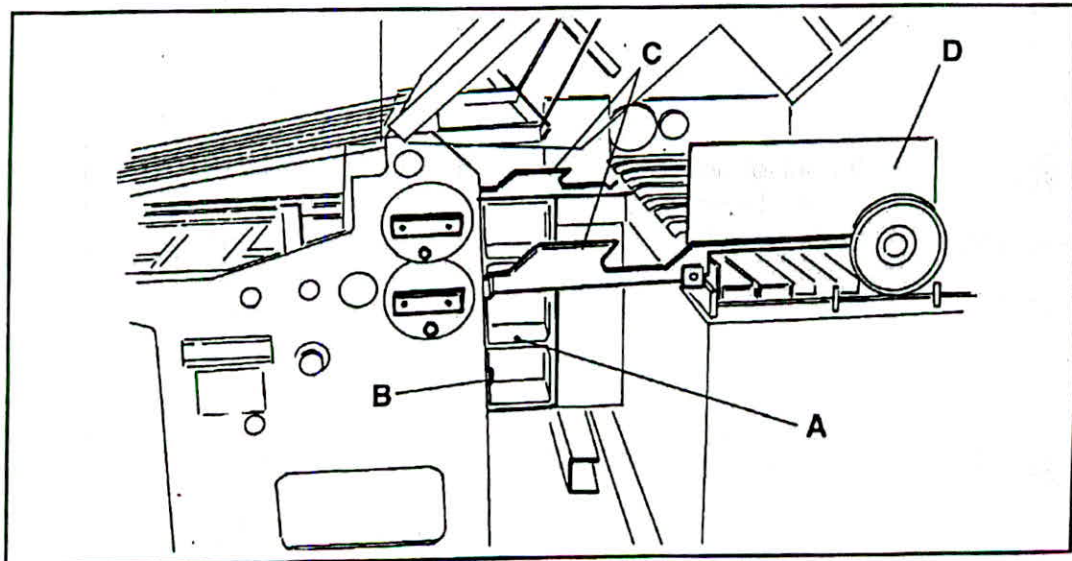
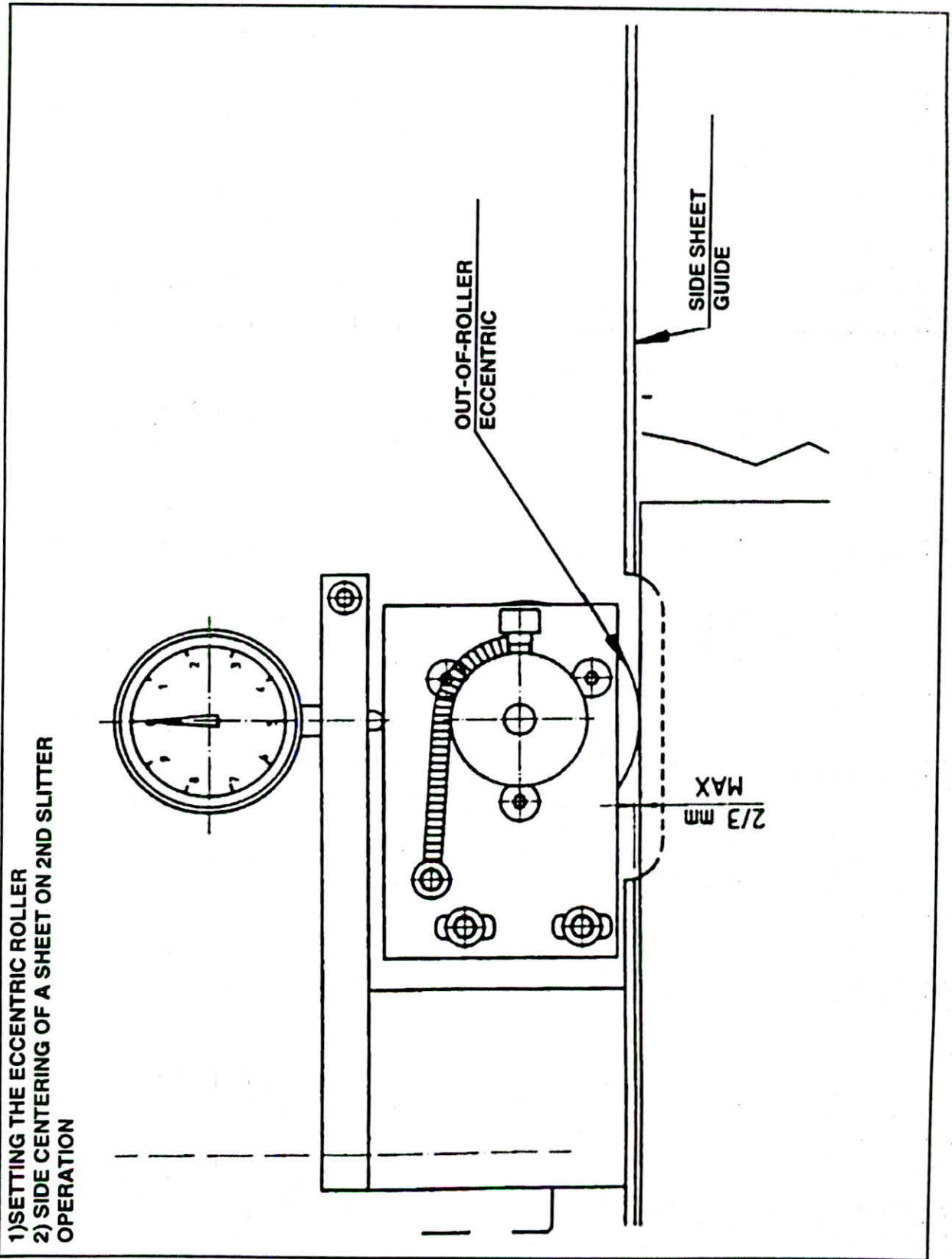


Fig. 33 First slitter alignment



1) SETTING THE ECCENTRIC ROLLER  
2) SIDE CENTERING OF A SHEET ON 2ND SLITTER OPERATION

*19/10 Juc*



**4.7.5.1. Setting the fixed bar**

1. Set the stainless steel strip support plates (Pos. A Fig. 24) so that the two side plates are parallel to the outer cuts; space equally the rest of the plates. If a sheet is cut in the centre set one plate in the centre.
2. Using the handwheel (Pos. V Fig. 23) feed out the sheet 2 cm. from the discharge roller (pos. B fig. 34).
3. Fit the scrap tools onto the stainless steel plates (Pos. A Fig. 24)  
Position the plates as close as possible to the cutter edge.
4. Fix the support sheet bars (Pos. C Fig. 24) in line with the cuts on the first slitter peration (Draw S for three strips, Draw K for a half cut sheet and Draw U for a whole sheet).

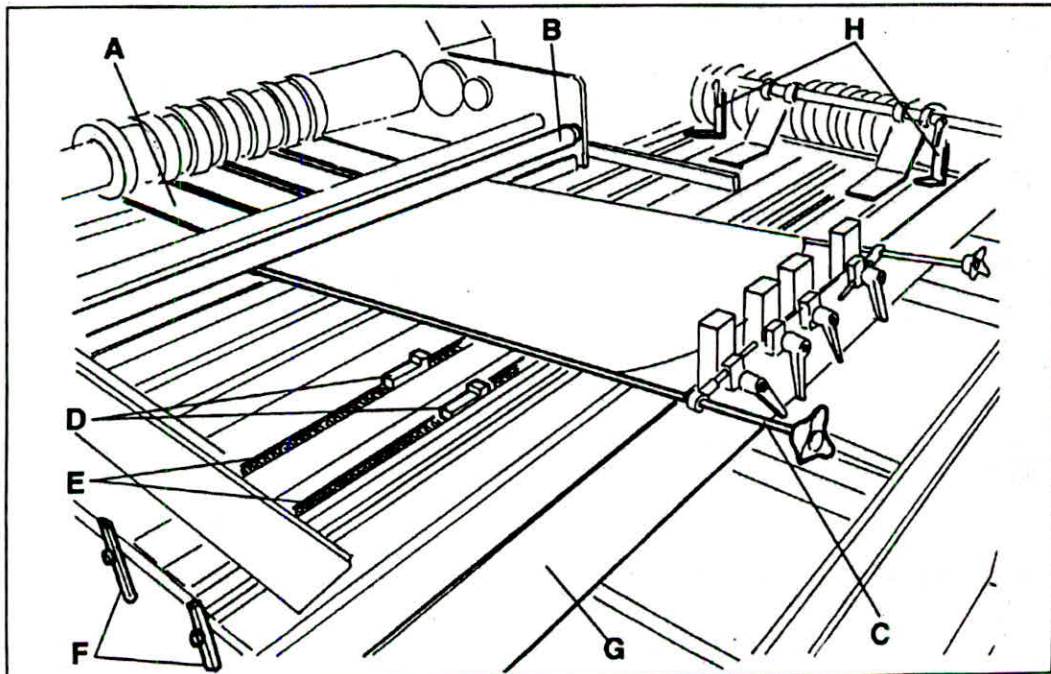


Fig. 24 Setting the fixed bar

5. Fit one of the gear units, i. e. G4 or G6 gear, depending on the sheet size (See Table 2)
6. Remove or fit the feed dogs (Pos. D Fig. 24) spaced out according to Table 2
7. Set the conveyor chains (Pos. E Fig. 24) in the centre of a sheet ; space the chains one from another minimum 12 cm. / maximum 50 cm..

To do this proceed as follows:

- slacken the four screws of the dragging chain pinion
- slacken the clamping screws of the chain guide bushing.
- slacken the conveyor chains
- set the chain guides

Now tighten all screws and set the feather keys of the chain pinions.

Stretch the conveyor chains with tie-rods (Pos. F fig. 24)

8. Set the side guides (Pos. G Fig. 24) and leave a 50 - 70 mm. sheet clearance

**Note**

**Do not set the guide too close to the sheet because the sheet may cut the rubber cover on the B roller (Fig. 24)**

9. With the handwheel (Pos. V Fig. 23) move the sheet forward and let it drop onto the second slitter table.
10. Slacken the clamping screws of the coupling box and remove the joint (pos. G fig. 36).
11. Set the feed teeth at approximately 30 cm. from the rear edge of the sheet.



Fig. 24 Setting the fixed bars

**Nota**

**This setting depends on the slitter speed; the higher is the speed the more distant are the feed teeth.**

12. Fit the joint (Pos. G Fig. 23)

The side clearance between the joint and the nylon ring must be 1-2 mm.

13. Tighten the clamping screws of the coupling box.

**4.7.5.2 Setting the electromagnets**

Set the electromagnets in the centre of a strip.

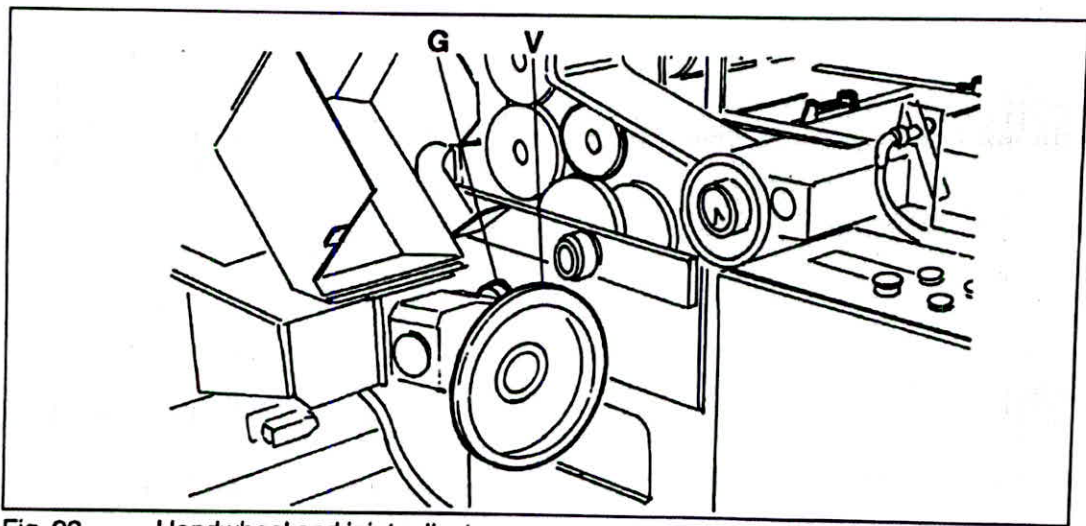


Fig. 23 Handwheel and joint adjuster

STRIPS	SECOND SLITTER GEAR	FEED TEETH DISTANCE (pitch)	TEETH DISTANCE (mm)	TOTAL PITCH
2	G4	32	508	256
3	G4,5	24	381	240
2	G5	40	635	240
WHOLE SHEET	G5	80	1270	240
RAIL TILT AND CAM DROPPING SYSTEM				
4	G4	16	254	240
5	G5	16	254	240
6	G6	16	254	240

Tabella 2 Second "FFS" slitter gear units