

SET UP PROCEDURES FOR THE TRC 1000

Model HC5-VSAA

Alternating Angle

Place control cabinet and cutter on a flat table with the back of the control cabinet facing the side of the cutter. There are two connectors and one cable coming out the back of the cutter. Plug the gray cables into the matching receptacle on the back of the control box and the back of the cutter. Plug the black cord into the three prong outlet on the back of the control box. Then plug the control box into your 110v outlet.

Next hook up the air regulator to your air supply and set the pressure at 35 PSI.

Set the roll stand behind the cutter and line it up with the guides on the cutter. Place one disc on the 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.

Start up Procedures

1. Turn master switch to **ON** position
2. Set the temperature control knob to 3-3.5 and allow 10-15 min. for the knife to heat up. **NEVER ALLOW THE KNIFE TO BECOME RED HOT AS THIS MAY CAUSE THE WEBBING TO CATCH ON FIRE.**

Use just enough heat to cut the webbing and to keep the knife blade burned clean. You will have to experiment with the webbing you use to find the exact temperature that works best.

3. Adjust the webbing guides to fit the webbing you are using. Do not make it too tight as to cause drag on the web.
4. Feed the webbing through the guides and push it up to the feed rollers and then push the Feed Roller Jog button on the control box. This will take the webbing through the feed rollers. Take the webbing past the rollers an inch or so. 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.

Note: When cutting opposing angles, the material must be in center of the machine to get even lengths. If the material is off center to one side, every other piece that is cut will be long and the next piece would be short.

Keyboard commands

ENTER allows you to enter data

* = Decimal point

FEED JOG Allows you to manually jog the feed rollers

KNIFE JOG Allows you to manually jog the knife

RESET Allows you to reset the machine and erase all data

STOP Allows you to stop the machine and save all data. This also serves as the (-) sign for negative angles.

Setting Feed Rate

When the control cabinet is turned on the LCD will read **FEED RATE 1-9**. This will determine how fast the material is fed through the machine. When you push **ENTER** the machine will automatically home the angle head.

FIRST ANGLE will appear on the LCD .Type the angle you want ." 0" will give you a straight cut or you can type in whichever degree you need.

SECOND ANGLE will appear on the LCD. This will be the "-" angle . To get the - angle push the **STOP** button . This will act as the - sign. **STOP 45** will give you a -45 degree cut.

Entering Length

LENGTH will appear on the LCD. Type in the length you want. 10.5 will give you 10 1/2 inches. All lengths are in inches with a maximum length of 50 feet.

CUT TIME will appear on the LCD . This is the amount of time the knife will stay down. On lightweight poly pro web you will only need about .50 sec. Some trial and error will have to be used to determine the best cut time for your material.

HOW MANY will appear on the LCD . This is the number of pieces you want to cut. If you 100 pieces type **100 ENTER**. When you push the **ENTER** button the machine will automatically start. Just before you push the **ENTER** button it is a good idea to JOG the material through the Knife and push the **KNIFE JOG** and start with a clean cut. When the machine has cut the number of pieces it will automatically stop. If you wish to run the same program just push **ENTER** and you will run the same program again and keep a running count.

SET UP PROCEDURES FOR THE TRC 1000

Model HC5-VSAA

Alternating Angle AA 3.0

Place control cabinet and cutter on a flat table with the back of the control cabinet facing the side of the cutter. There are two connectors and one cable coming out the back of the cutter. Plug the gray cables into the matching receptacle on the back of the control box and the back of the cutter. Plug the black cord into the three prong outlet on the back of the control box. Then plug the control box into your 110v outlet.

Next hook up the air regulator to your air supply and set the pressure at 35 PSI.

Set the roll stand behind the cutter and line it up with the guides on the cutter. Place one disc on the 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.

Start up Procedures

1. Turn master switch to **ON** position
2. Set the temperature control knob to 3-3.5 and allow 10-15 min. for the knife to heat up. **NEVER ALLOW THE KNIFE TO BECOME RED HOT AS THIS MAY CAUSE THE WEBBING TO CATCH ON FIRE.**

Use just enough heat to cut the webbing and to keep the knife blade burned clean. You will have to experiment with the webbing you use to find the exact temperature that works best.

3. Adjust the webbing guides to fit the webbing you are using. Do not make it too tight as to cause drag on the web.
4. Feed the webbing through the guides and push it up to the feed rollers and then push the Feed Roller Jog button on the control box. This will take the webbing through the feed rollers. Take the webbing past the rollers an inch or so. 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.

Note: When cutting opposing angles, the material must be in center of the machine to get even lengths. If the material is off center to one side, every other piece that is cut will be long and the next piece would be short.

Keyboard commands

ENTER allows you to enter data

* = Decimal point

FEED JOG Allows you to manually jog the feed rollers

KNIFE JOG Allows you to manually jog the knife. This also serves as the (-) sign for negative angles.

RESET Allows you to reset the machine and erase all data

STOP Allows you to stop the machine and save all data.

Setting Feed Rate

When the control cabinet is turned on the LCD will read **FEED RATE 5-22**. This will determine how fast the material is fed through the machine. When you push **ENTER** the machine will automatically home the angle head.

FIRST ANGLE will appear on the LCD .Type the angle you want ." 0" will give you a straight cut or you can type in whichever degree you need.

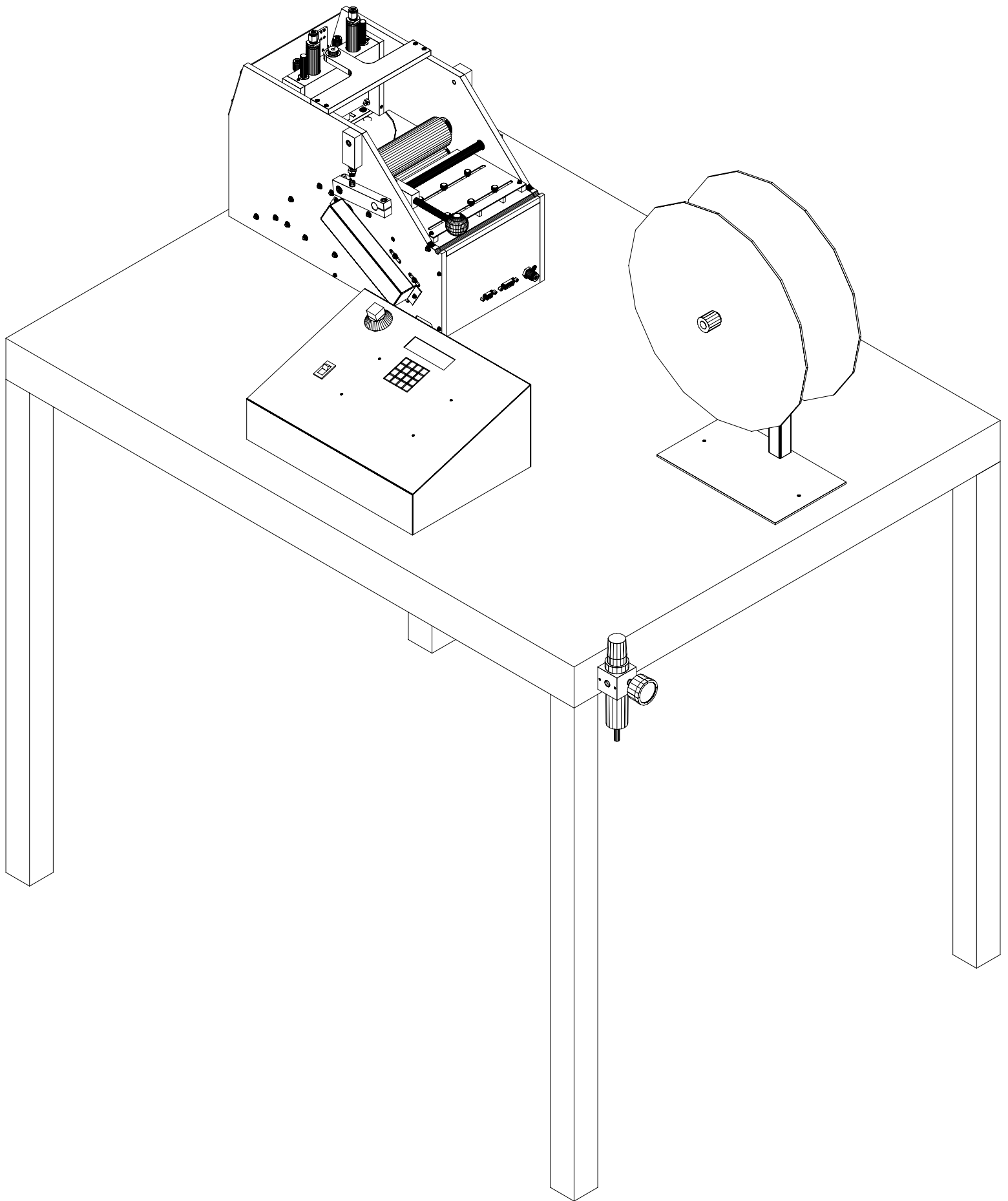
SECOND ANGLE will appear on the LCD. This will be the "-" angle . To get the - angle push the **KNIFE JOG** button . This will act as the - sign. **KNIFE JOG 45** will give you a -45 degree cut.

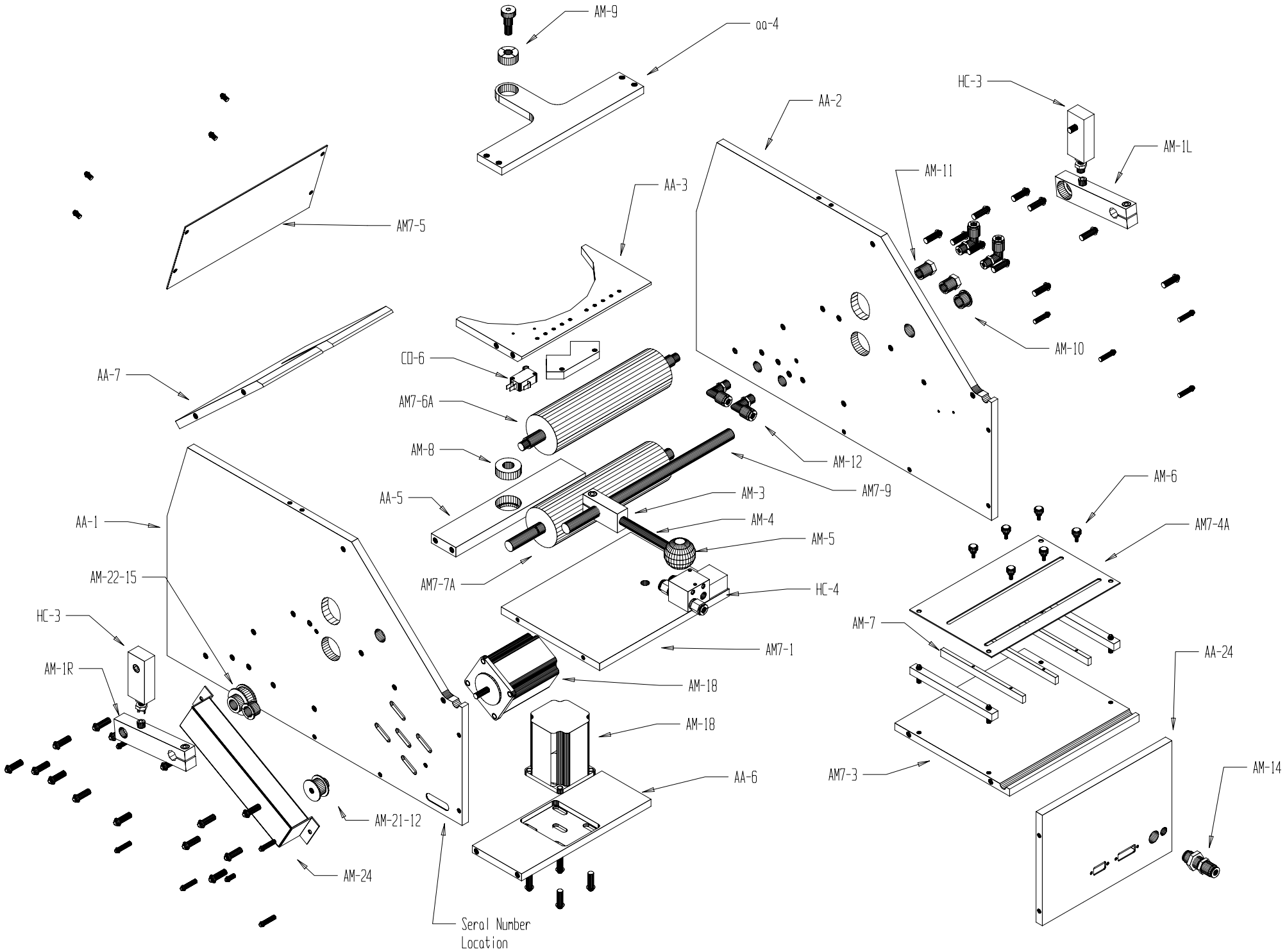
Entering Length

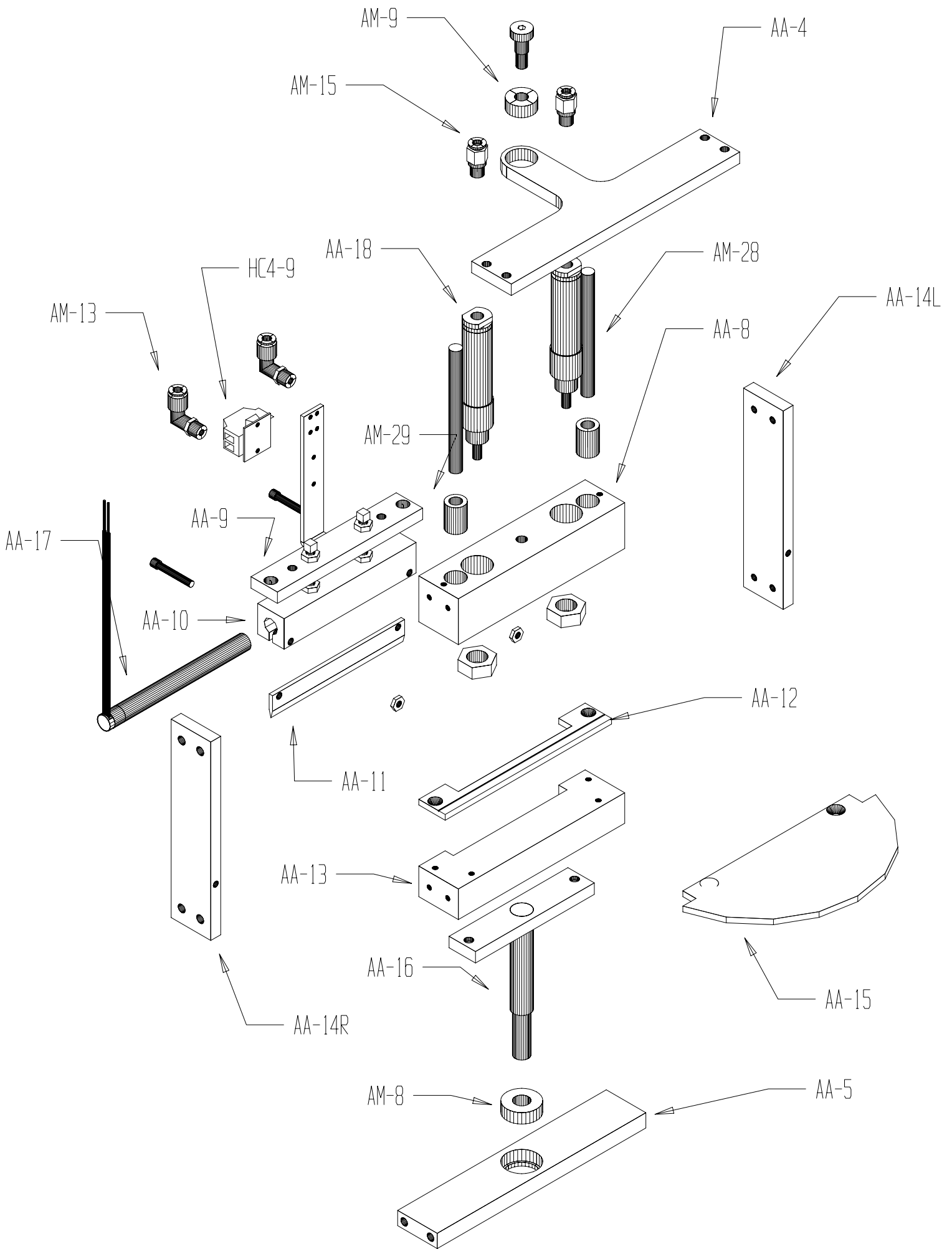
LENGTH will appear on the LCD. Type in the length you want. 10.5 will give you 10 1/2 inches. All lengths are in inches with a maximum length of 50 feet.

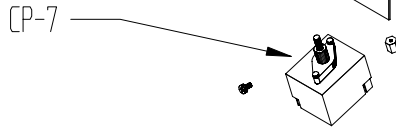
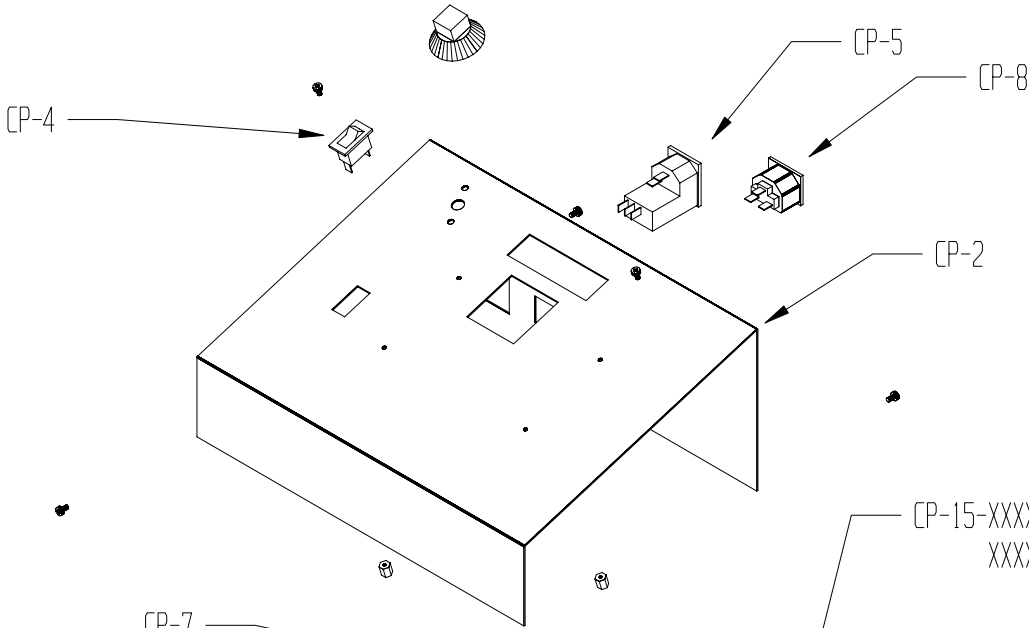
CUT TIME will appear on the LCD . This is the amount of time the knife will stay down. On lightweight poly pro web you will only need about .50 sec. Some trial and error will have to be used to determine the best cut time for your material.

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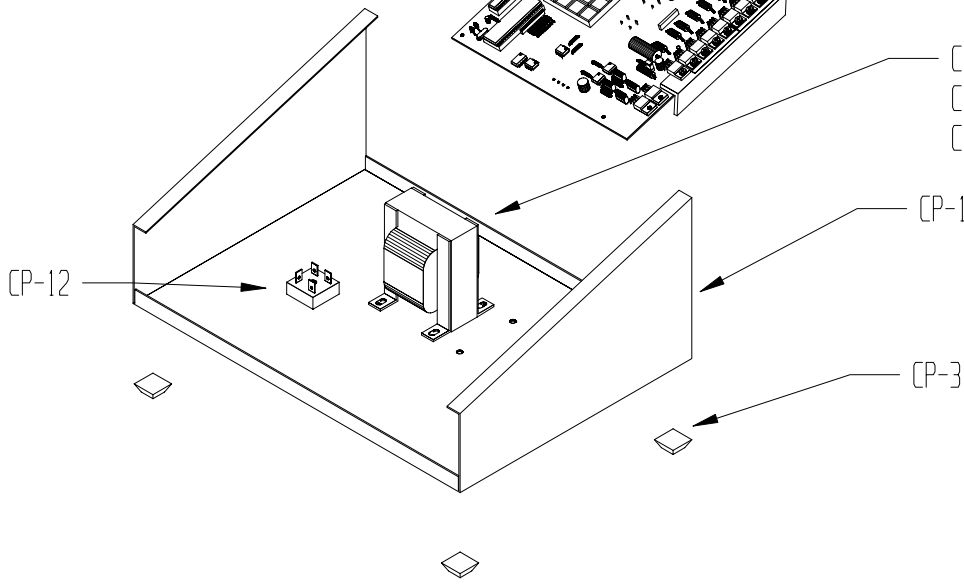








CP-15-XXXX
 XXXX = CS Constant Speed
 CSHT Constant Speed High Torque
 VS Variable Speed
 VSHT Variable Speed High Torque
 VSAA Variable Speed Alternating Angle



CP-9 CS and CSHT
 CP-10 VS and VSAA
 CP-11 VSHT

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, lint and other foreign substances. These points should also be lubricated periodically with a light weight oil, such as sewing machine oil.

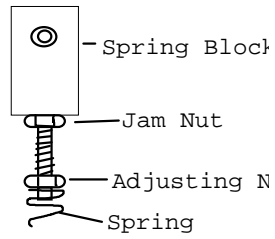
Keep *Drive* and *Tension Rollers* clean of foreign matter. Proper *spring* tension is also important to machine accuracy. Too much pressure causes excessive drag, and too little will cause material slippage.

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!

AA Angle Adjustment



Start by removing the guard plate. There are (4) screws that hold it in place.



With the angle motor de-energized, check to make sure that the angle head can be moved to the -45 degree position and it stays where you put it.



Also check the +45 degree position. If it moves after you let go, then either the air lines or the heater cord are too short and are pulling the head out of position. Also check that there is no slack in the movement. You should feel slight resistance as soon as you move the head either direction.

This is very important.

If there is slack in the movement, refer to the chain adjustment procedure at the end of this section.



Remove the secondary guides by taking out the two screws that secure each of them.



Next, remove the rotating guide plate, by taking out the two countersunk screws that secure it.



Removing the rotating guide plate reveals the angle stops and the “home” position microswitch.



Enter a feed rate of 10 and press enter.



The angle head will then index to the home position. It should move and contact the switch and stop. If the angle head bounces several times, it is not contacting the switch or there is a fault in that circuit.



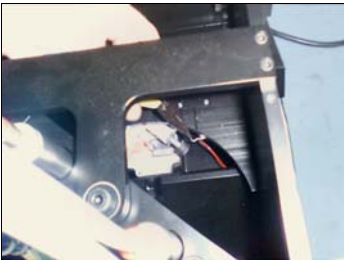
Using a 45 degree block, check to see that the angle head indexed to the +45 degree position correctly.



Once the initial 45 degrees is attained in the home position, Enter 0 for the first angle and 0 for the second angle.



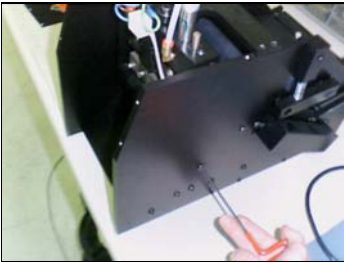
This should move the angle head to 0 degrees position. Use a 90 degree block to check this



If the angle head did not index properly, use a small pair of needle-nose pliers to bend the arm on the microswitch to adjust it. It may be necessary to move the angle stop bumper to get correct indexing. Press reset the control, move the angle head to about 0 degrees and repeat the last five steps until 0 degrees is attained.

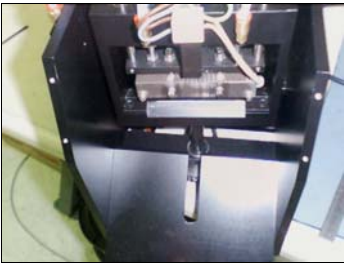


Use a 7/16" open end wrench to adjust the angle stops. From 45/-45 degree positions there should be about .050" between the angle stop and the knife box

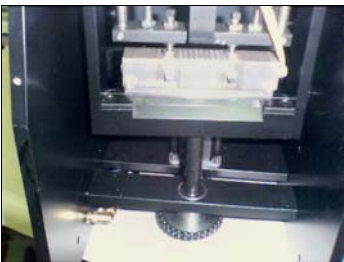


Chain adjustment Procedure

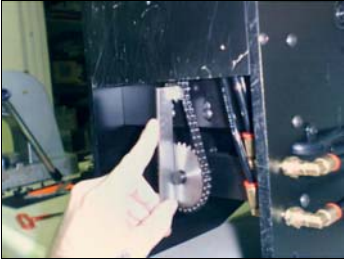
Remove the 4 screws that secure the chute plate.



Remove chute plate by sliding down and out.



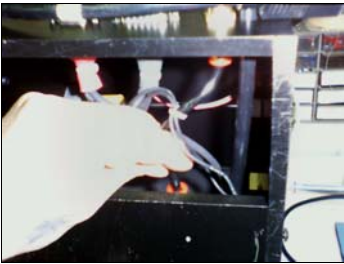
This will expose the angle drive chain and sprockets.



Stand cutting head on end and check the sprockets for proper alignment with a straight edge. The sprockets should be in the same plane.



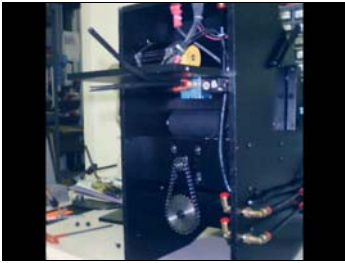
Check the slack in the chain by pressing in on one side. There should be very little deflection.



If the chain needs to be adjusted, you should remove the incoming air line from the air valve by pushing in on the red ring of the fitting and pull out on the hose.



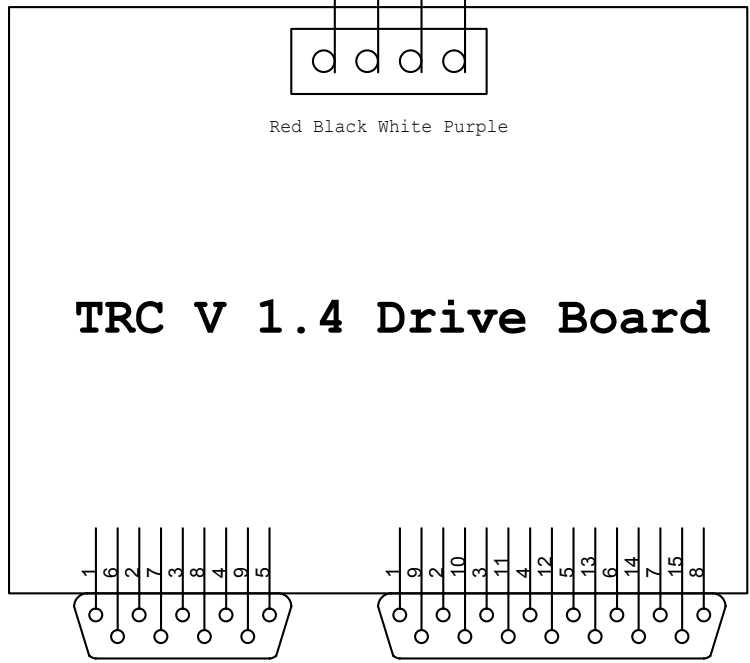
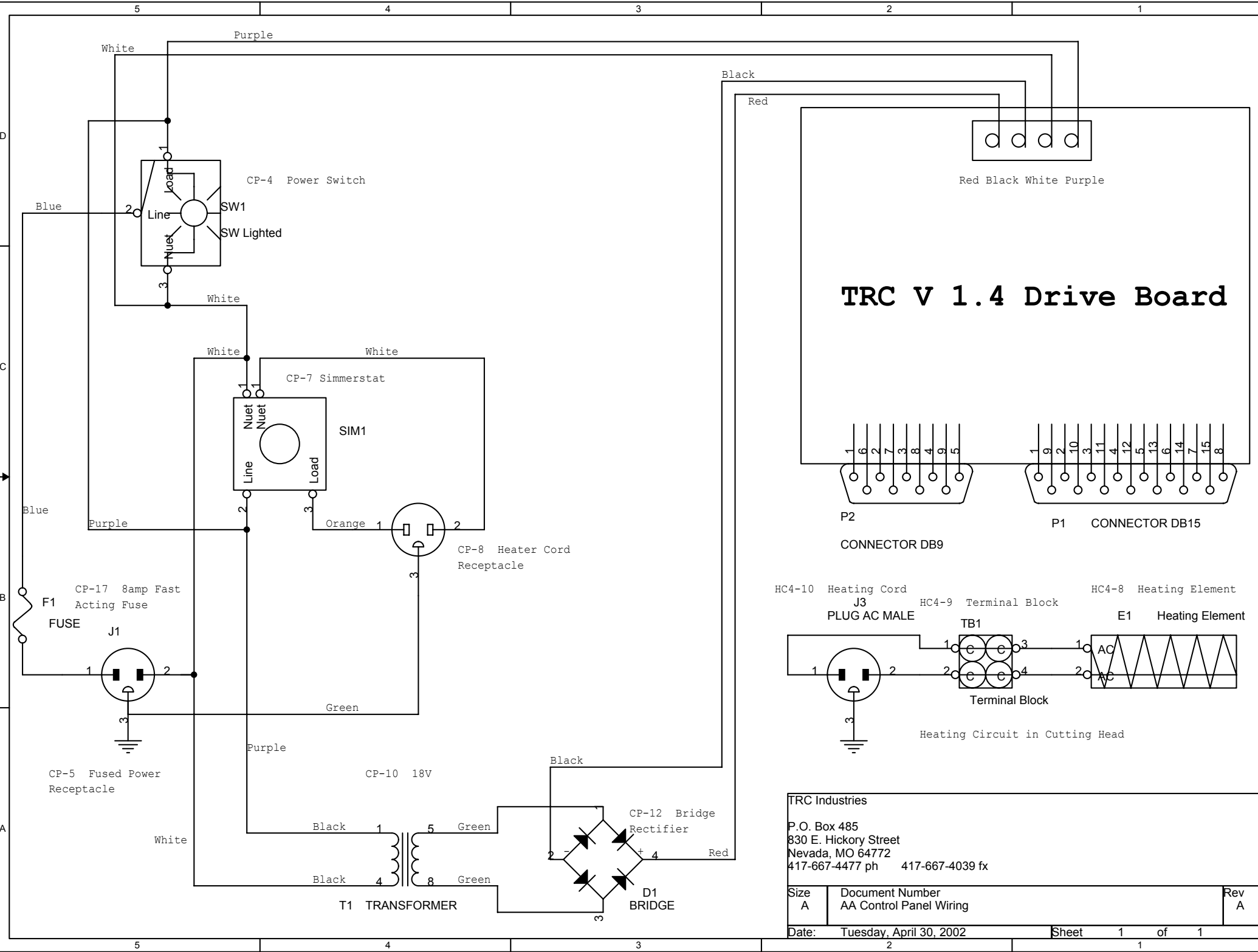
Also disconnect the air hoses from the swivle 90's on the inside of the machine.



Take out the two lower screws from the base plate and loosen the two upper screws. This will allow the base plate to be tilted up and out for better access to the motor mounting screws. Then tighten up one of the screws to hold it in position.

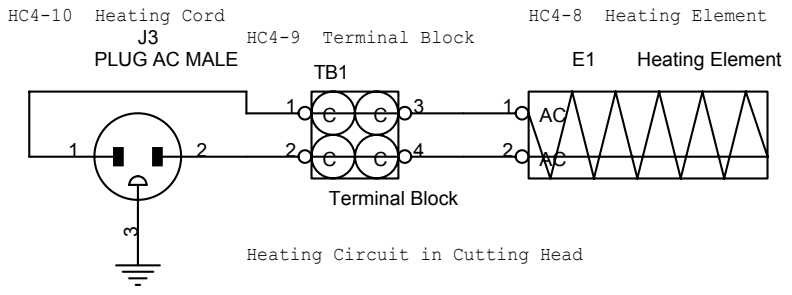


To adjust motor, loosen the 4 screws that secure the motor. Pull the motor up from above. Then tighten the screws evenly. Try to hold the motor flat against the mounting plate while tightening the screws to avoid tilting the motor and sprocket out of alignment. Do not over-tighten screws and break the mounting ears on the motor. Once again, no slack in the chain is the desired result. Check the sprockets for proper alignment and re-assemble cutting head.



TRC V 1.4 Drive Board

P2 CONNECTOR DB9
P1 CONNECTOR DB15



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Size A	Document Number AA Control Panel Wiring	Rev A
Date: Tuesday, April 30, 2002		Sheet 1 of 1

TRC Industries

Factory Warranty Registration Card

Company Name _____
Address _____
City, ST, Zip _____

Phone _____ Email Address _____
Fax _____ Website _____
Contact Person _____

Date Purchased _____ Dealer Name _____
P.O. # _____ Address _____
Model _____ City, ST, Zip _____
Serial # _____
Phone _____
Fax _____
Salesman _____

Mail to:
TRC Industries
P.O. Box 485
Nevada, MO 64772

or Fax to 417-667-4039

Atten: Jon

Please visit our Page on the Internet at
<http://www.trcind.com>
or email us at
register@trcind.com