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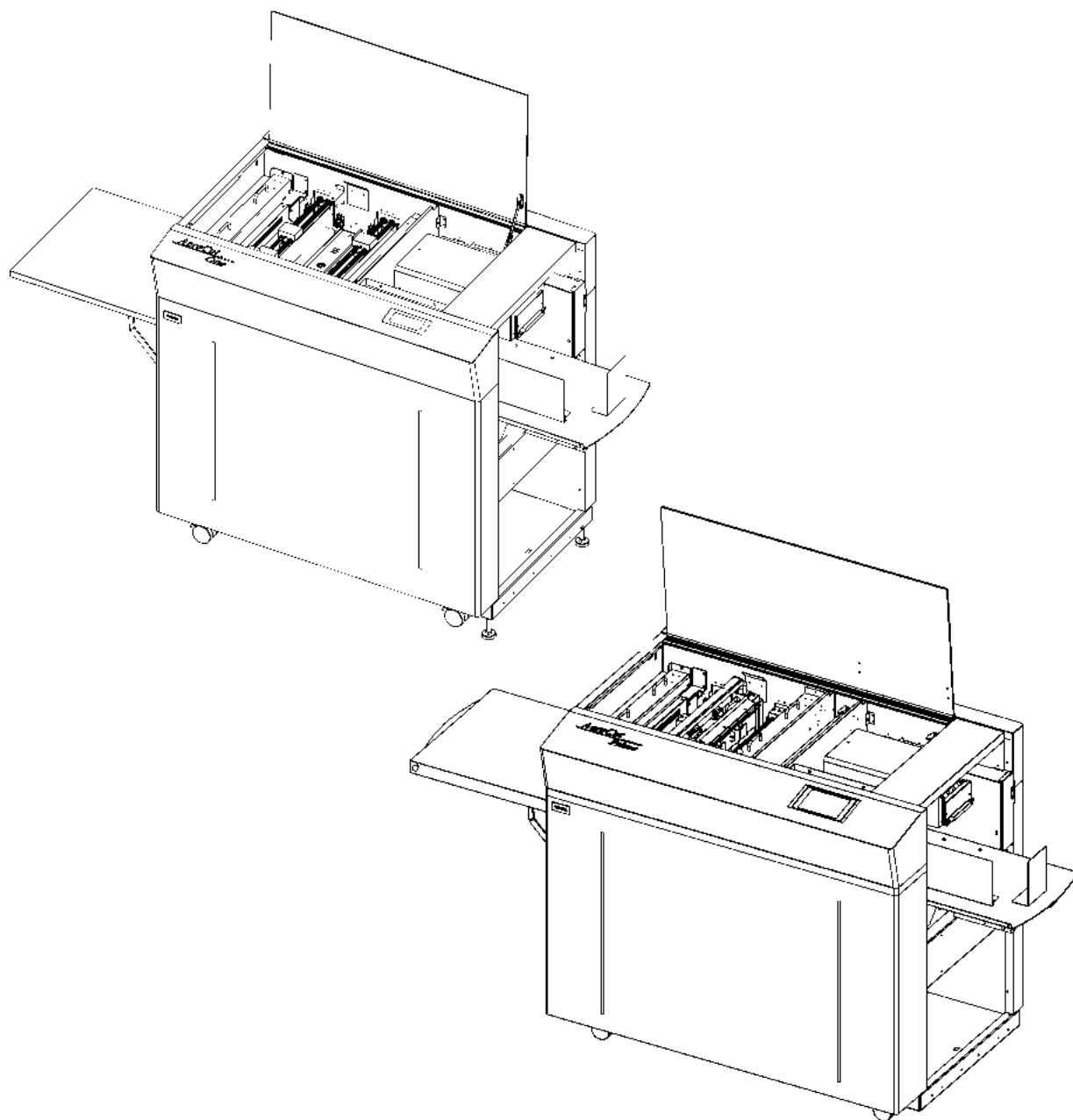
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UCHIDA

AeroCut Prime/One/Velocity

SERVICE MANUAL



V 1.01

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Record of change

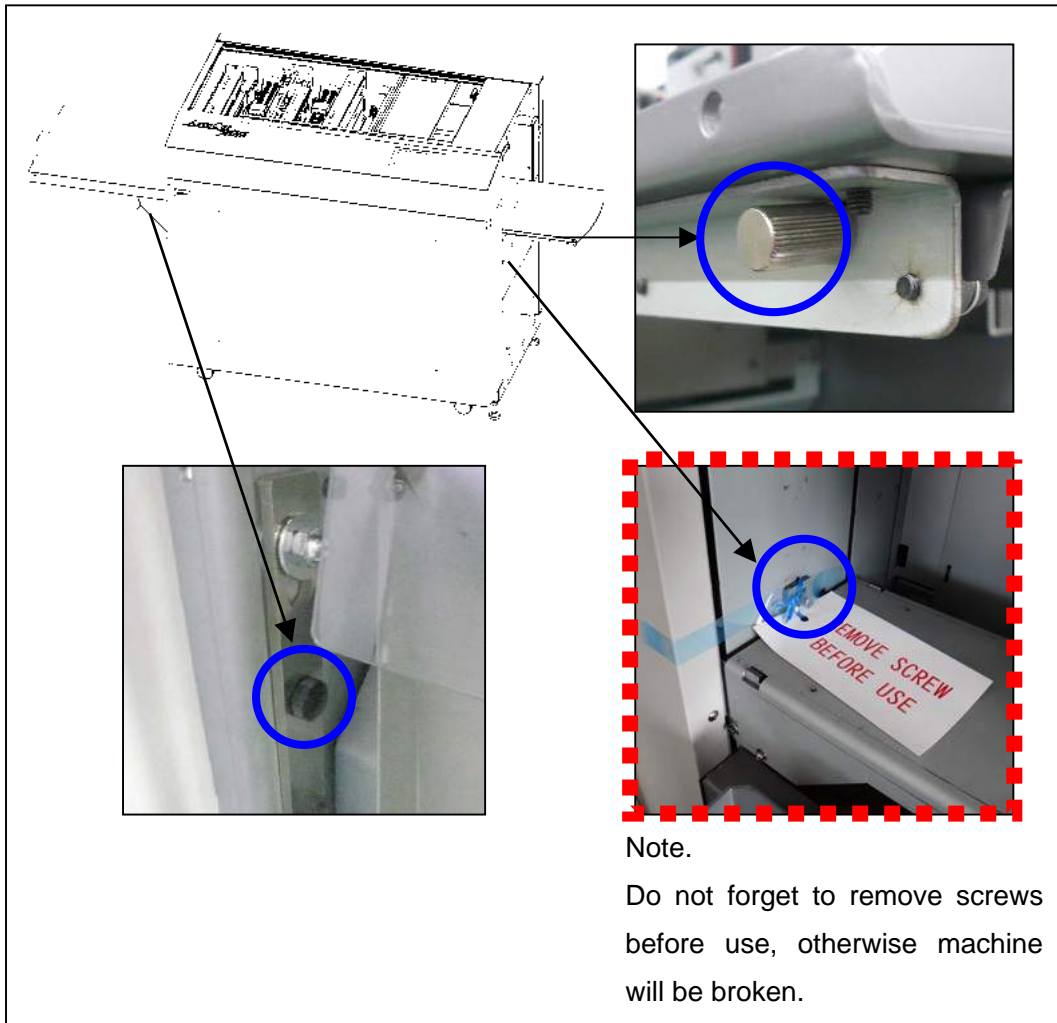
No.	Date	Contents of change	Expected date to change
5			
4			
3			
2			
1	2017/02/20	Slitter adjustment. (Page 36) PCB setting. (Page 51,53)	2017/02

1. Installation

1- (1)Installation

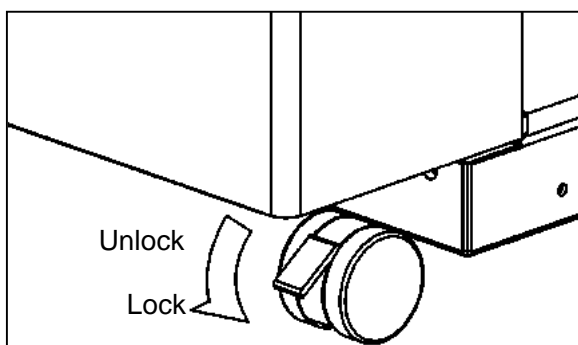
(a) Fixing screw

The fixing screws shown on below images must be removed before use.

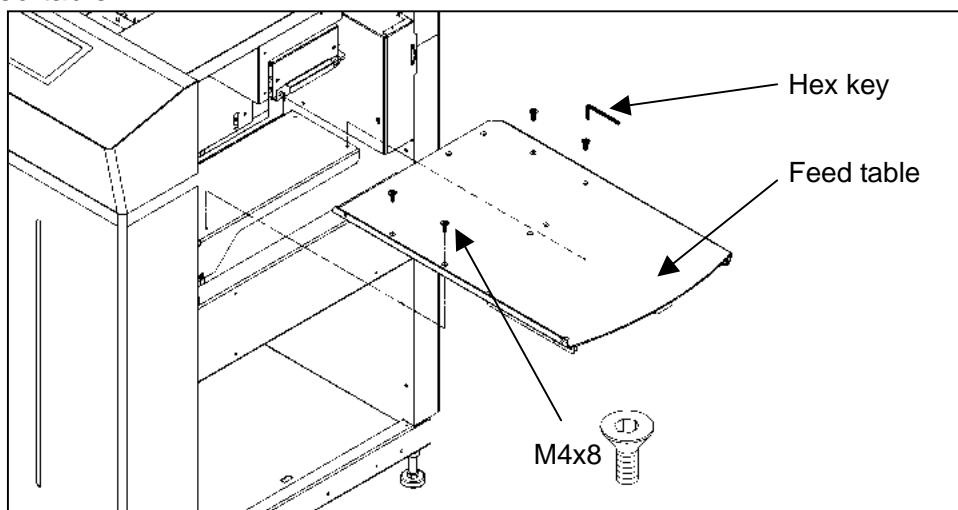


(b) Caster

Please be sure to lock a caster brake.

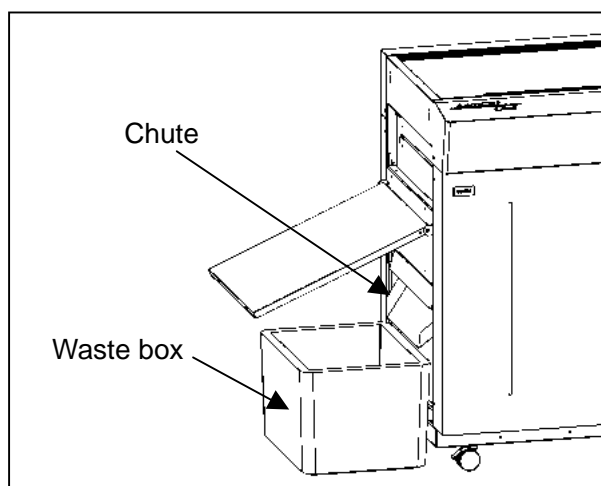


(c) Feed table

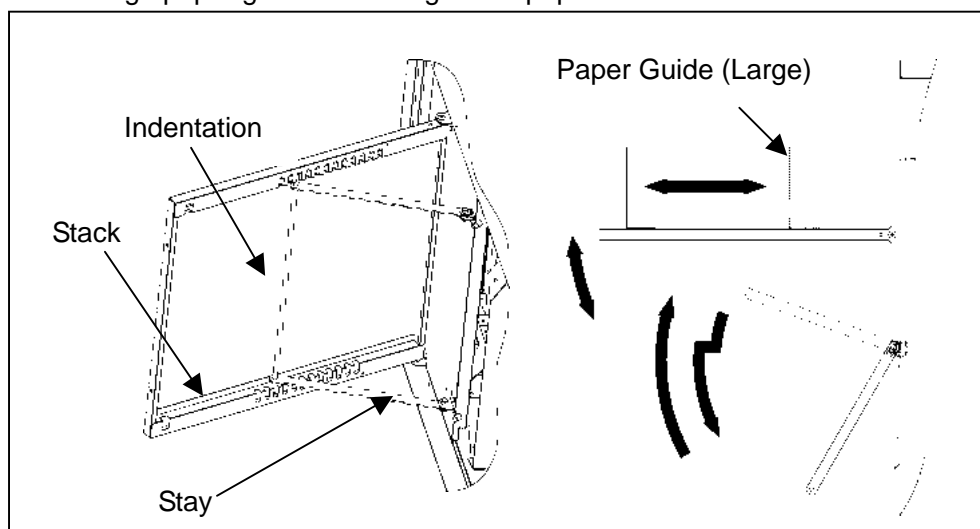


(d) Stacker and Waste box

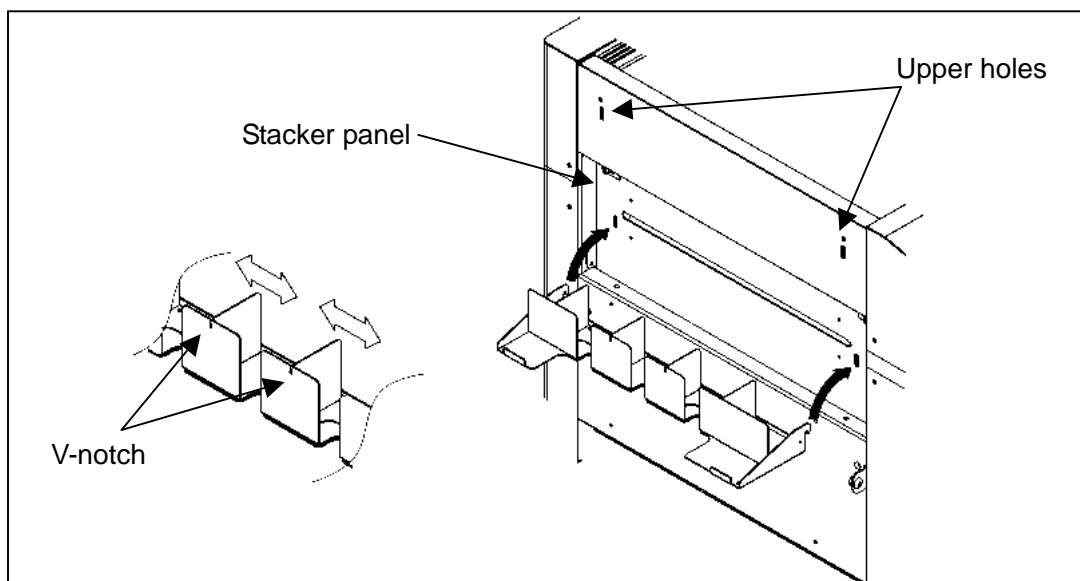
- ① Place the Waste box under the Chute.



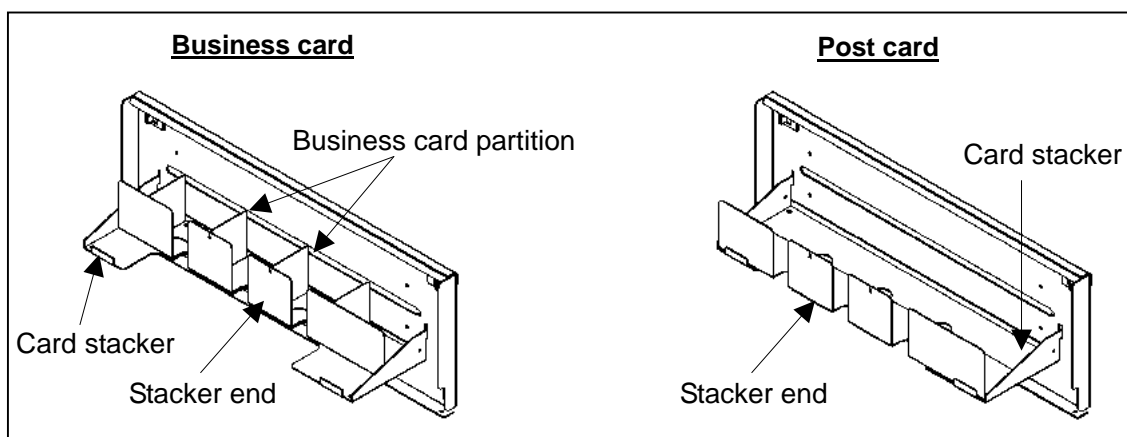
- ② Open the stacker and set the stays in the indentation of the back of the stacker at an appropriate angle to allow smooth paper ejection.
- ③ Adjust the large paper guide according to the paper size.



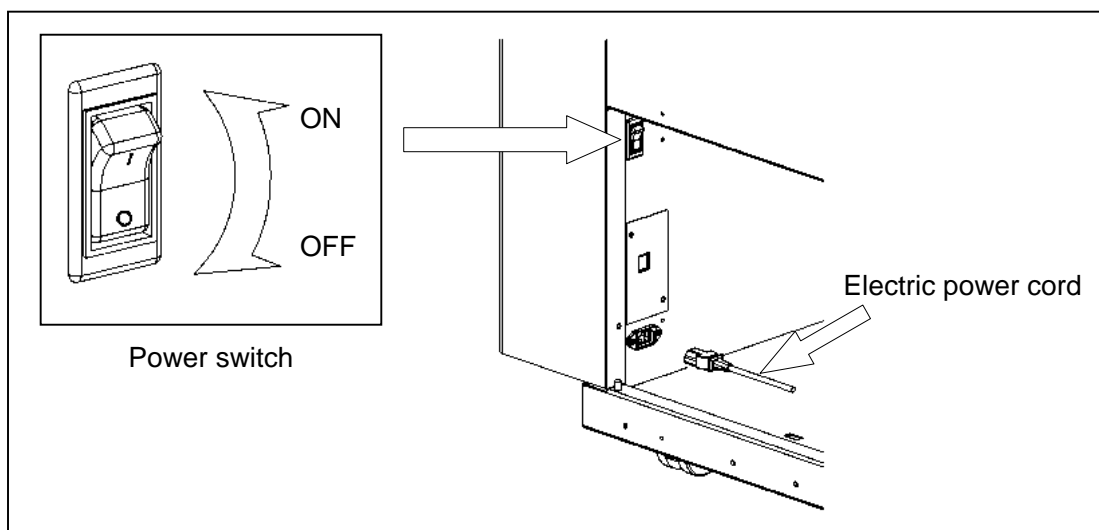
- ④ Hang the business card stacker to the Stacker panel.
- ⑤ Find the V- notch to see where to put the business card partition.
- ⑥ When it is not used, it may be hooked to the upper holes in the stacker panel.



- ⑦ Change the settings of the stacker according to the cut pattern.



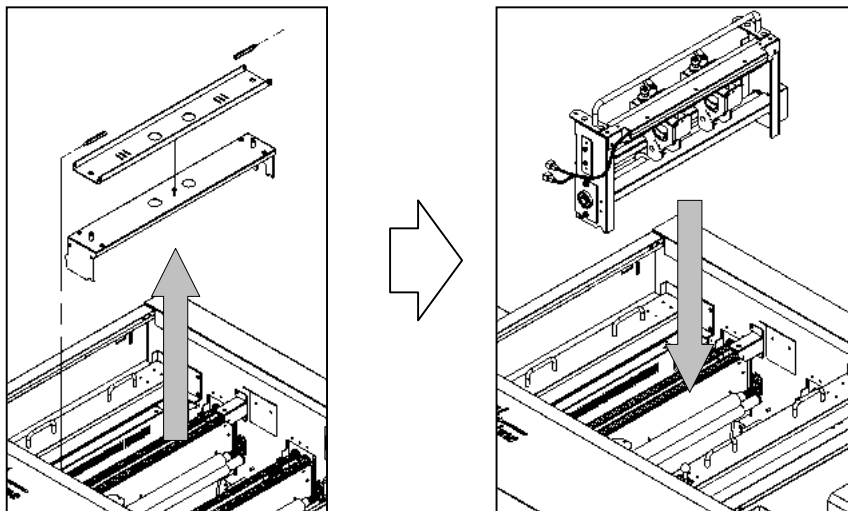
(e) Electric-power



1- (2)Installing options

(a) Y-perforator

- ① Remove the delivery guide.



Note.

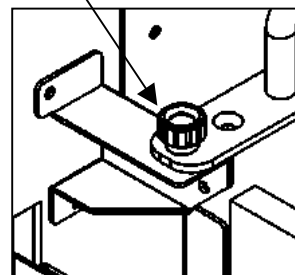
In case Perforator unit is not set in the machine, please attach the delivery guide instead in order to avoid paper jam.

- ② Attach Y-Perforator unit.

- Be sure to hold the perforator with both hands and attach it as shown in the figure.

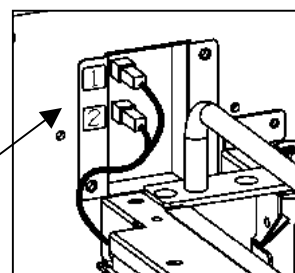
- Fasten knobs to fix the position of the unit.

Knob

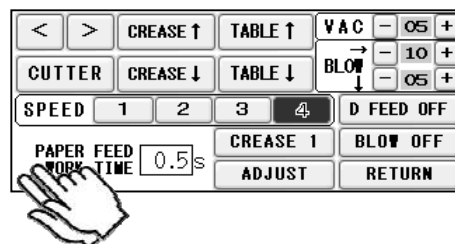
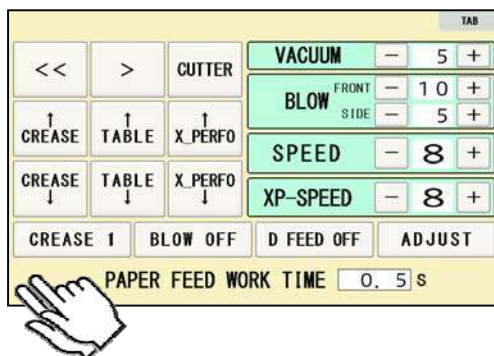


- Put the connectors into sockets according to the numbers shown.
(Prime)

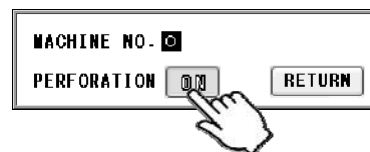
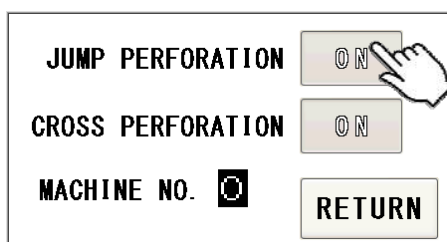
Connector



- ③ Double tap on bottom left corner of MANUAL/SPEED screen.



- ④ Activate **JUMP PERFORATION** (Prime)
Activate **PERFORATION** (One/Velocity)



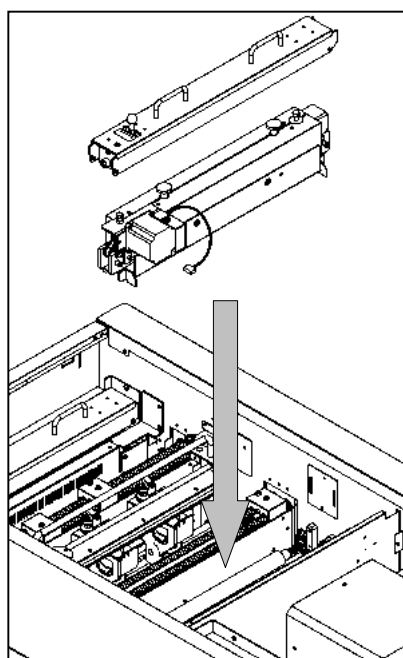
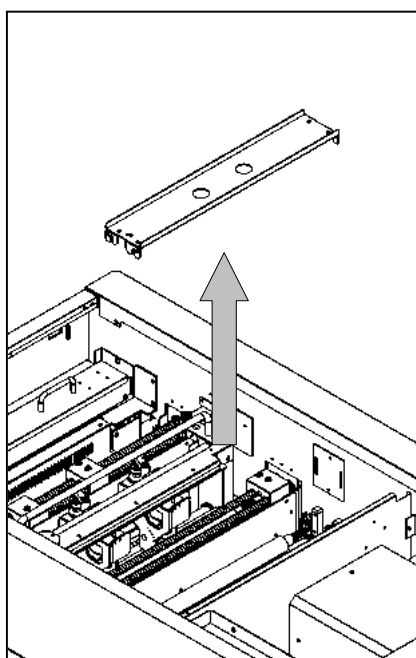
- ⑤ Reboot the machine before use.

(b) X-perforator

- ① Remove the delivery guide.

Note.

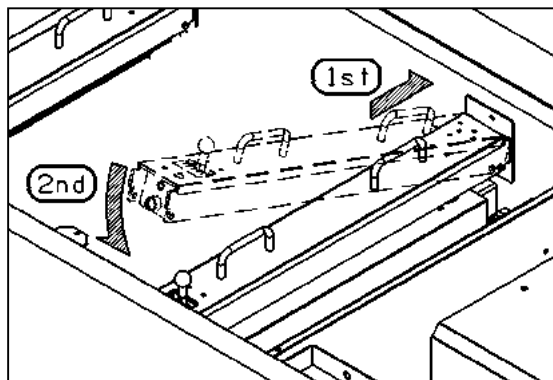
In case Perforator unit is not set in the machine, please attach the delivery guide instead in order to avoid paper jam.



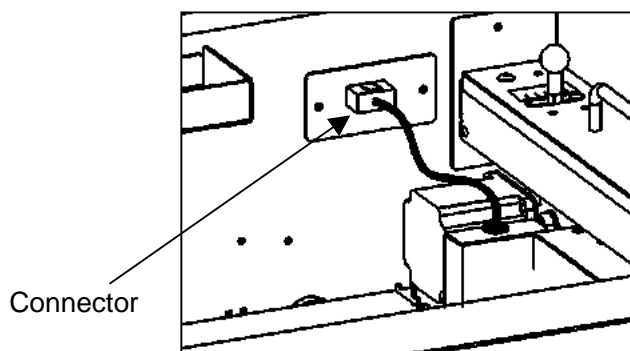
② Attach X-Perforator unit.

• Upper part

Ensure to hold the perforator with both hands and attach it with pushing it against the counter-operation side as shown in the figure.



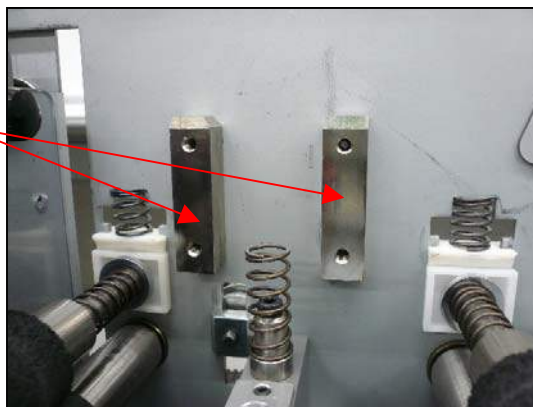
• Don't forget to connect cables.



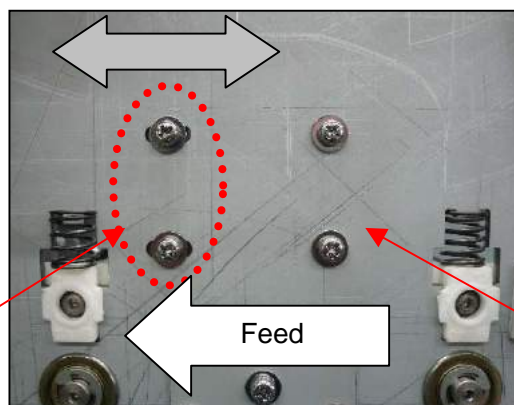
③ Adjust the width of unit guide if necessary.

• The width of unit guide can be adjusted by moving guide which is attached paper ejection side from side to side.

X-perforator unit
guide

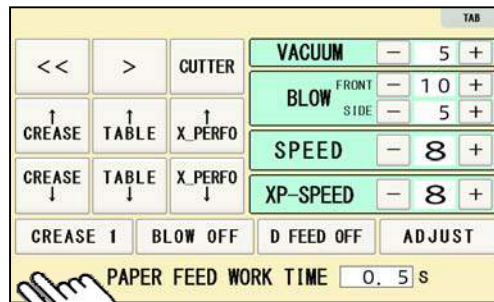


Paper ejection side

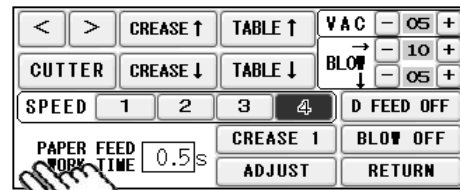


Paper feeding side

- ④ Double tap on bottom left corner of MANUAL/SPEED screen.

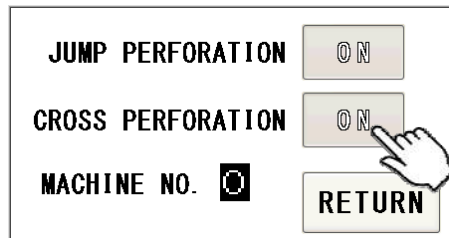


Double-Click



Double-Click

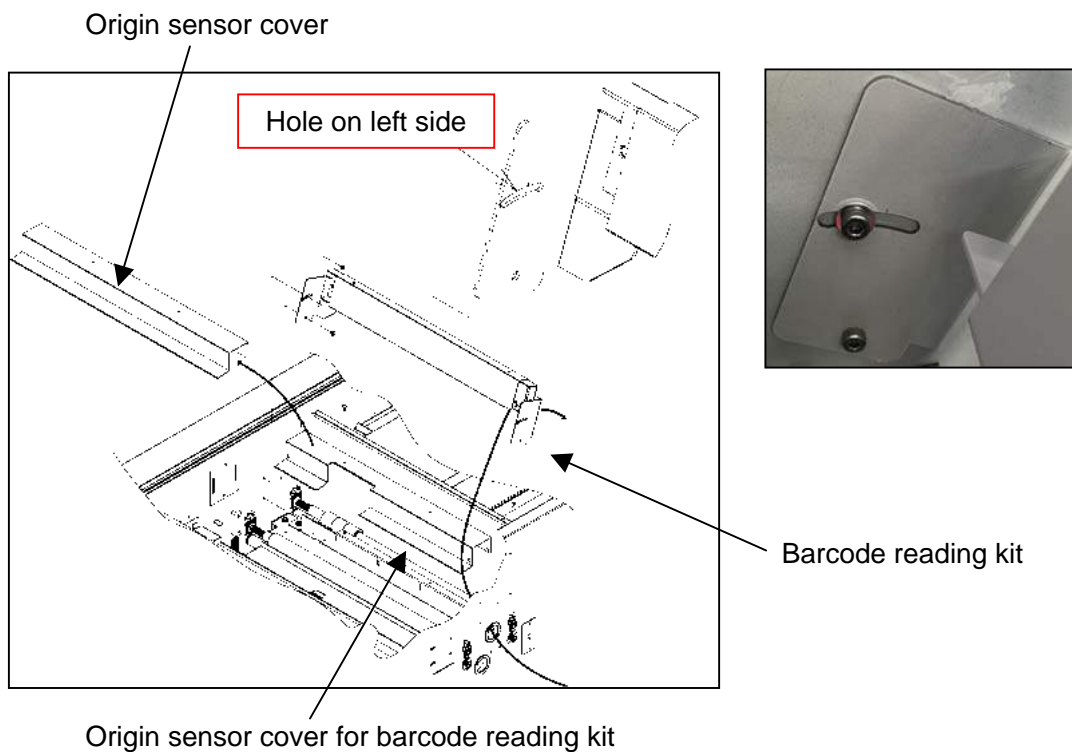
- ⑤ Activate **CROSS PERFORATION**



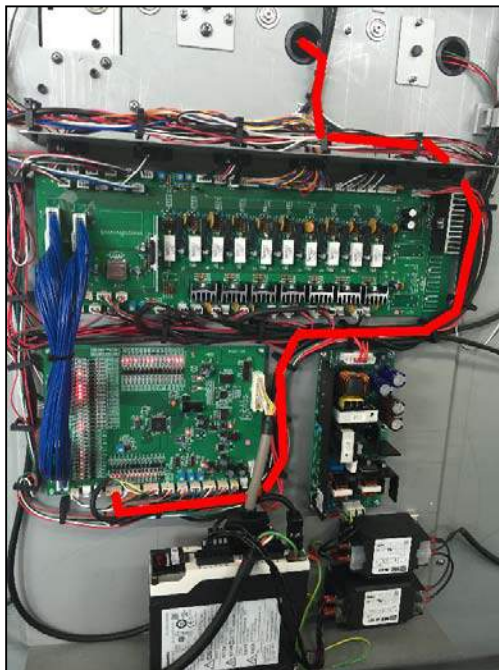
- ⑥ Reboot the machine before use.

(c) Barcode reader

- ① Replace the Origin Sensor Cover with the Origin Sensor Cover for the Barcode Reading Kit, and attach the Barcode Reading Kit to the machine.
- ② Fix the Barcode Reading Kit so that a hole on left side will be placed towards the top.
- ③ Position should be as below picture.

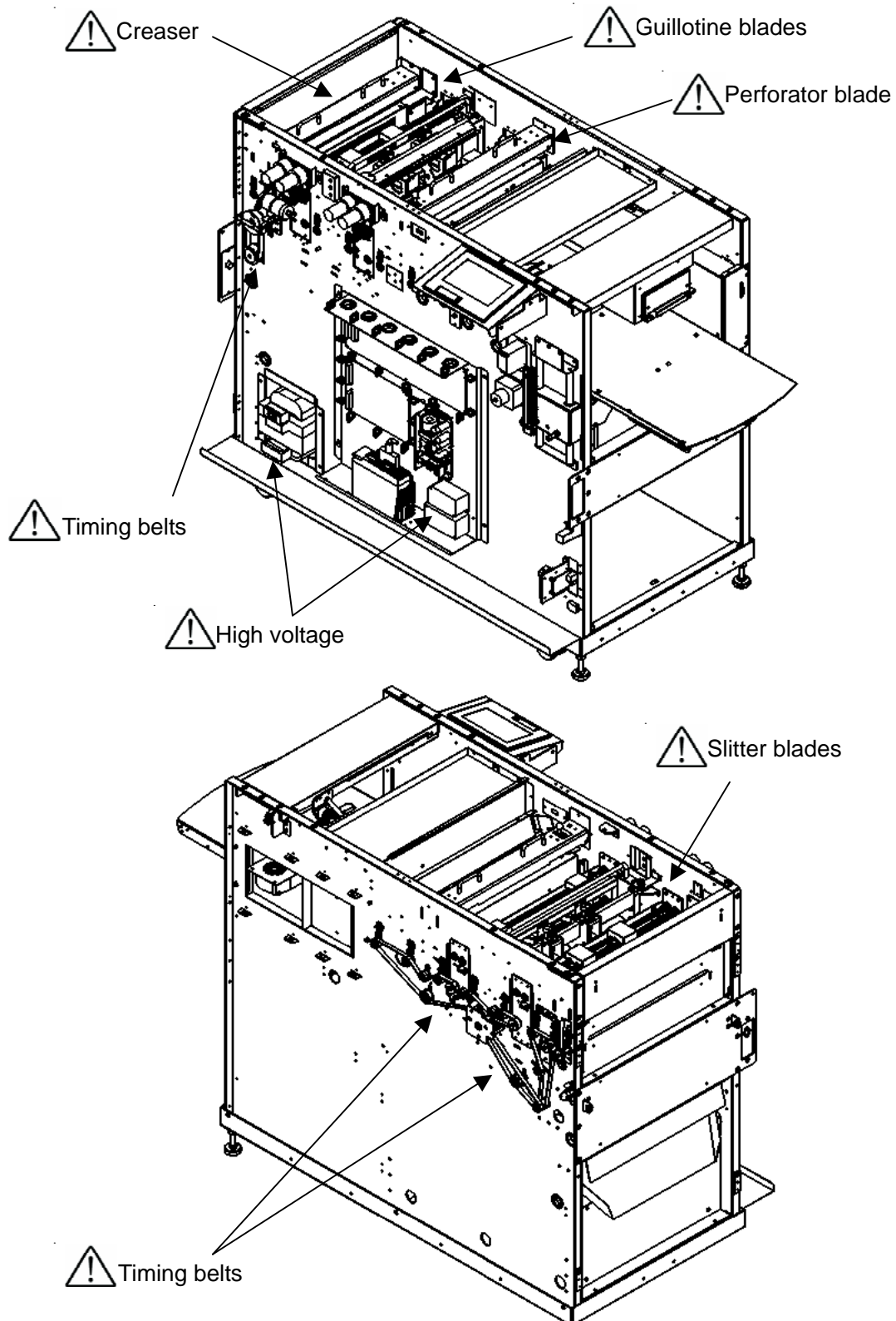


- ④ Connect the cables according to the red line as shown on below picture.
- ⑤ The Barcode Reading Kit should be connected to CN19 on the CPU board.



2. General instruction

(a) Caution



(b) Necessary tools

- C-clip ring pliers



To replace slitler blades

- Maintenance kit

Pipe
(For slitters)



To replace slitler blades

Program update tool



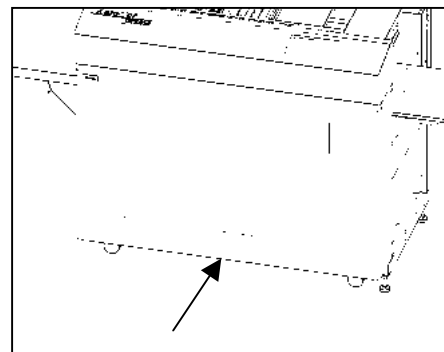
Roller remover



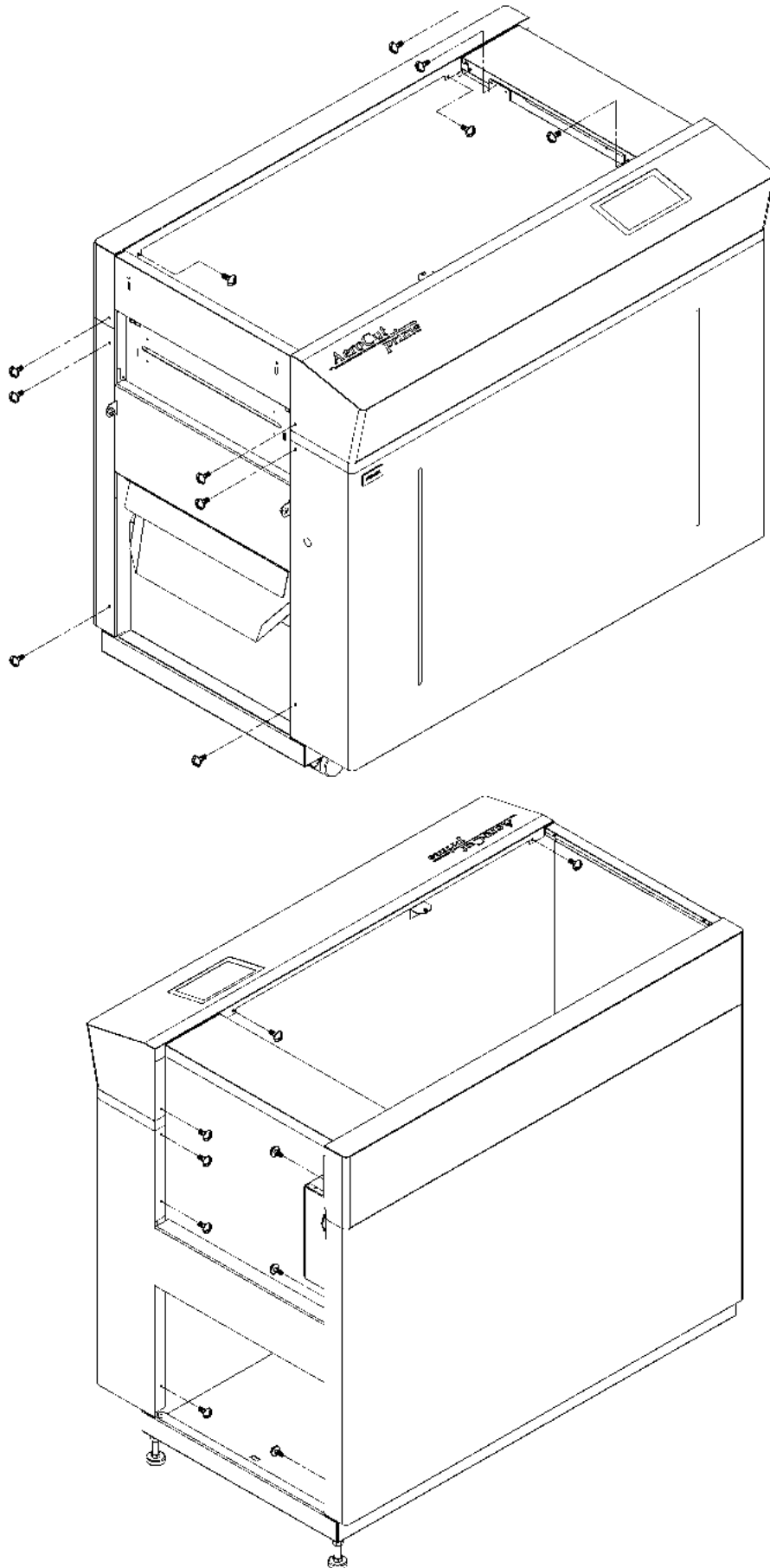
To cleaning roller

(c) Factory setting

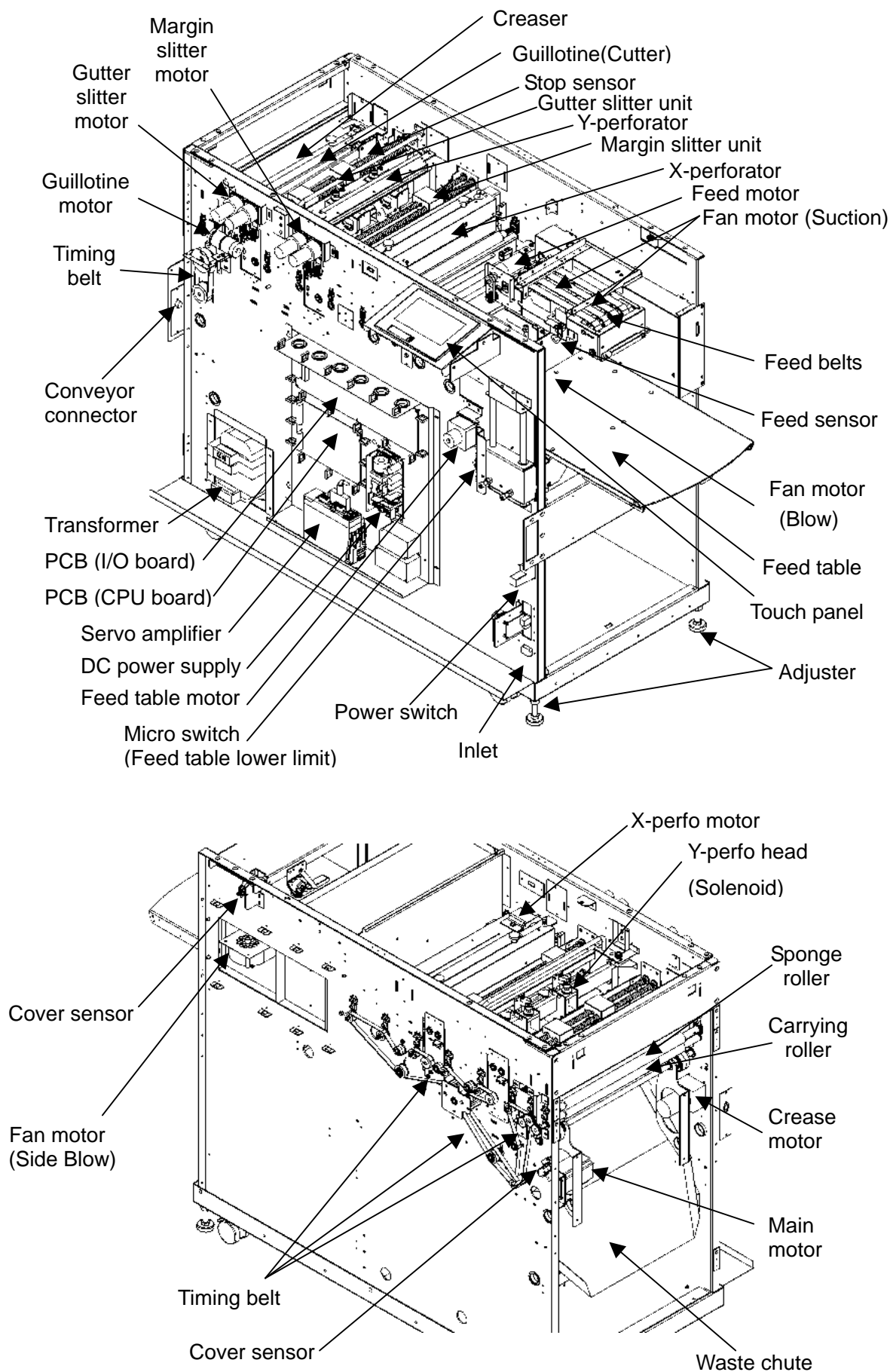
Factory setting sheet is attached inside of the front cover.



(d) Remove covers



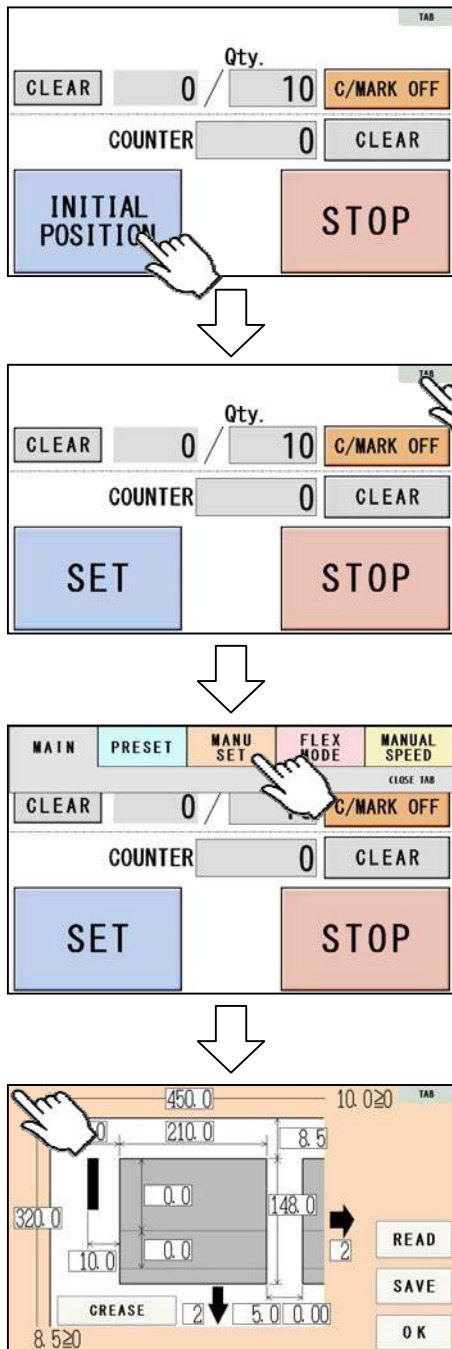
(e) Names of parts



3. Touch panel operation

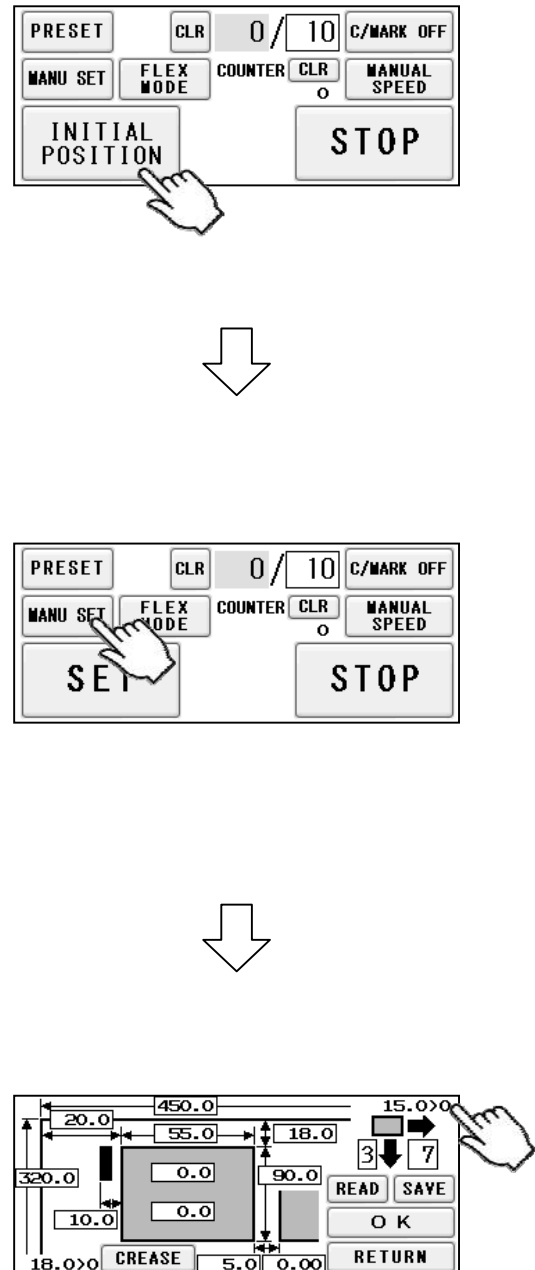
3- (1) SERVICE MENU

AeroCut Prime

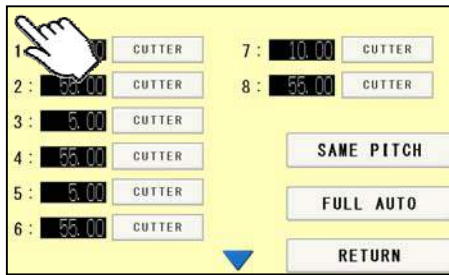


Double click at the top left corner.

AeroCut One / Velocity



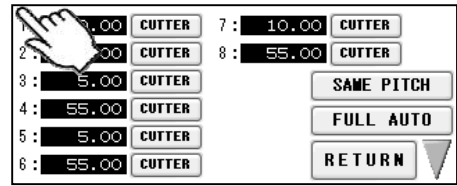
Double click at the top right corner.



Double click at the top left corner.



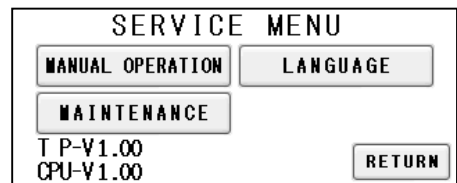
Enter the service password.



Double click at the top left corner.



Enter the service password.



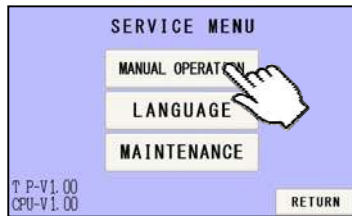
Program Vesion

TP-V stands for Version of the Touch Panel image.

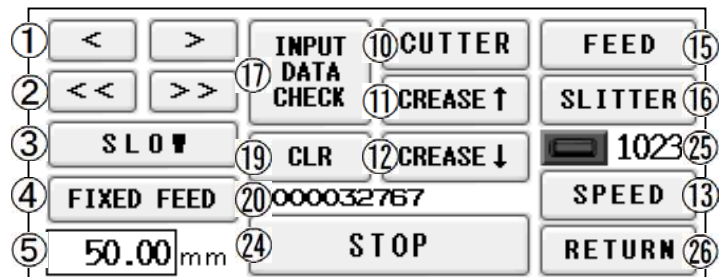
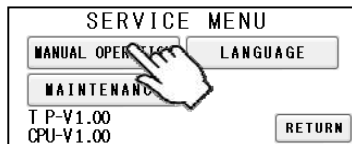
CPU-V stands for Version of the CPU board program.

3- (2) MANUAL OPERATION Screen

AeroCut Prime



AeroCut One / Velocity



- ① Carrying roller will rotate.
- ② Carrying roller will rotate. (Continuous)
- ③ The speed of Carrying roller can be adjusted to two levels (SLOW or FAST).
- ④ Carrying rollers will rotate at input length. [mm]
- ⑤ Enter the dimension of Fixed feed.
- ⑥ X-Perfo blade will move toward far side from an operator.
- ⑦ X-Perfo blade will move toward near side from an operator.
- ⑧ X-Perfo blade will move to specified point .[mm]
- ⑨ Input moving distance of X-Perfo blade.[mm]
- ⑩ Guillotine will move once.
- ⑪ Crease will move upper limit.
- ⑫ Crease will move lower limit.
- ⑬ Go to SPEED screen.
- ⑭ X-Perfo blade will move to initial position.
- ⑮ Go to FEED Operation Screen.
- ⑯ Go to SLITTER Operation Screen.
- ⑰ Go to INPUT DATA CHECK screen.

- ⑮ SV OFF: the state where the servo motor does not respond to any orders.

SV ON: the state where the servo motor responds to all orders.

- ⑯ Reset the counter for servo movement to zero.
- ⑰ Counter for servo movement.
- ⑱ Switch ON/OFF of each Y-Perfo
- ⑲ Check operation of X-Perfo. Count times of operation.
- ⑳ Check operation of jump function of Y-Perfo. Count times of jumping.
- ㉑ Stop all operations. Of note, Cutter and Crease will move to the upper limit.
- ㉒ Double Feed Detection

Transmittance of the double feed sensor is shown as an integer between 0 and 1023.
The number 1023 represents the state in which there is no sheet under the sensor, while the number closer to zero indicates that thicker sheets have been detected by the sensor.



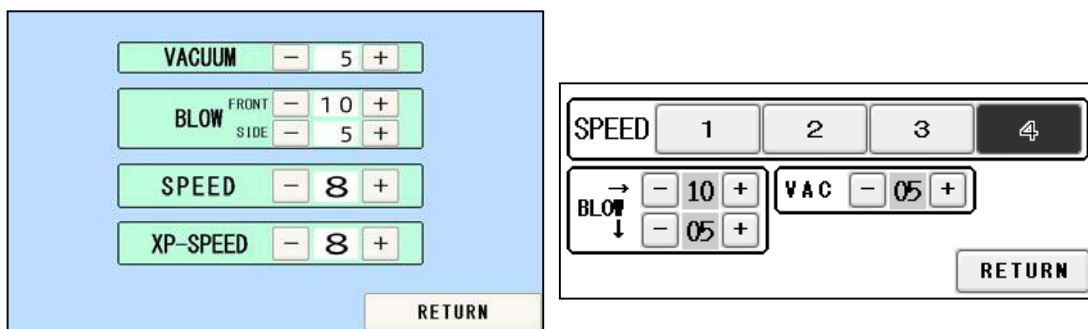
: paper sheets are being loaded.



: no paper sheets loaded.

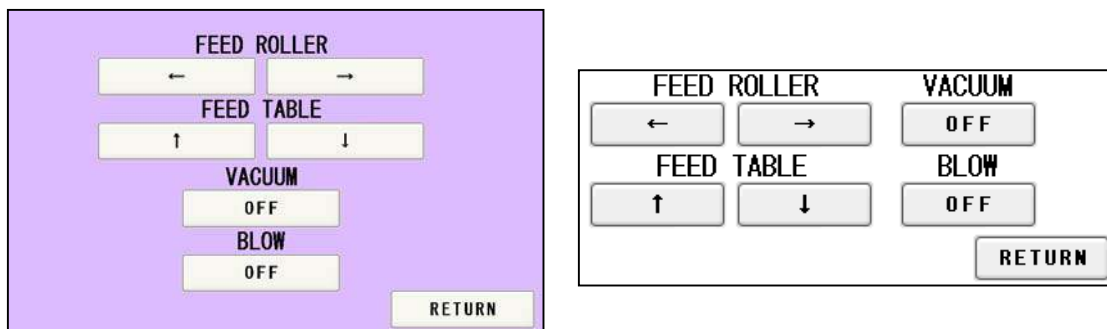
- ㉓ Return to SERVICE MENU Screen.

3- (3) SPEED Screen



- ① Regarding suction adjustment and speed change, refer to “5.1 Adjustments on the paper feed” in Operation Manual.

3- (4) FEED Operation Screen



- ① FEED ROLLER ⇔
- : Feed belt will rotate positively by pressing this once. It will stop by pressing it again.
- : Feed belt will rotate negatively by pressing this once. It will stop by pressing it again.
- ② FEED TABLE
- : FEED TABLE will move upward while this is being pressed.
- : FEED TABLE will move downward while this is being pressed.
- ③ VACUUM ⇔
- Vacuum motor will be turned ON and OFF.
- ④ BLOW ⇔
- Blow motor will be turned ON and OFF.
- ⑤ RETURN
- Return to Manual Operation Screen.

3- (5) SLITTER Operation Screen

③ CURNT POS -30.00 ↑ ↓	① CURNT POS -30.00 ↑ ↓
④ CURNT POS 400.00 ↑ ↓	② CURNT POS 400.00 ↑ ↓
RETURN	

① CURNT POS

The values of Slitter's current positions are shown.

② ↑、↓

↑ : Slitters will move to the end while this is being pressed.

↓ : Slitters will move to the front while this is being pressed.

③ RETURN

Return to Manual Operation Screen.

3- (6) INPUT DATA CHECK Screen

① PPR L /EDGE SENS 1	⑧ INPUT SENS	⑭ SLITTER ENCODER 2B
② C/MARK SENS	⑨ TBL LW/LMT SW	⑮ SLITTER ENCODER 3A
③ PPR L /EDGE SENS 2	⑩ FD TBL UP /SENS	⑯ SLITTER ENCODER 3B
④ CUTTER UP /LMT SW	⑪ SERVO ALERT	⑰ SLITTER ENCODER 4A
⑤ SLTR 1 HM POS	⑫ SERVO POSITIONED	⑱ SLITTER ENCODER 4B
⑥ SLTR 2 HM POS	⑬ SERVO ENCODER A	⑲ CRSR UP/SENS
⑦ SLTR 3 HM POS	⑭ SERVO ENCODER B	⑳ CRSR LW/SENS
⑧ SLTR 4 HM POS	⑮ SLITTER ENCODER 1A	㉑ XPERFO ORIGIN SENS
⑨ CVR SENS A	⑯ SLITTER ENCODER 1B	㉒ XPERFO EXIST
⑩ CVR SENS B	⑰ SLITTER ENCODER 2A	㉓ OP CONVEYER
⑪ DOUBLE FEED SENSOR		㉔ RETURN

ON
OFF

① PPR L /EDGE SENS	⑤ SLTR 3 HM PO	⑨ TBL LW/LMT SW
② C/MARK SENS	⑥ SLTR 4 HM PO	⑩ FD TBL UP /SENS
③ PPR L /EDGE SENS	⑦ CVR SENS	⑮ CRSR UP/SENS
④ CUTTER UP /LMT SW	⑧ CVR SENS	⑯ CRSR LW/SENS
⑤ SLTR 1 HM PO	⑪ SERVO ALER	⑲ INPUT SENS
⑥ SLTR 2 HM PO	⑫ SERVO POSITIONED	㉔ RETURN

① PPR L/EDGE SENS 1 (Origin sensor)

The sensor lamp will be turned off when shielded and turned on when transmitted.

The lamp on the screen will be turned on when shielded and turned off when transmitted.



② C/MARK SENS (Cut mark sensor)

The sensor lamp (orange) will be turned on when detecting black color and turned off with no detection.

The lamp on the screen will be turned on when detecting black color and turned off with no detection.

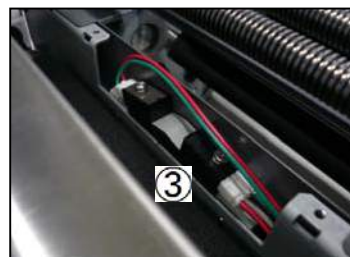
How to adjust. (👉 Page50)



③ PPR L/EDGE SENS 2 (Stop sensor)

The sensor lamp will be turned on when shielded and turned off when transmitted.

The lamp on the screen will be turned on when shielded and turned off when transmitted.



④ CUTTER UP/LMT SW

The lamp on the screen will be turned on when the switch is on.



⑤ SLTR 1-4 HM POS

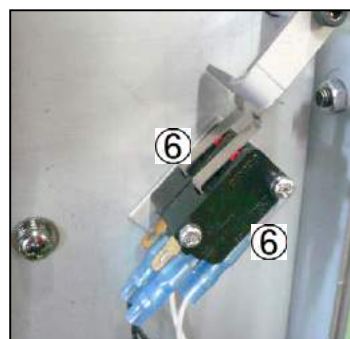
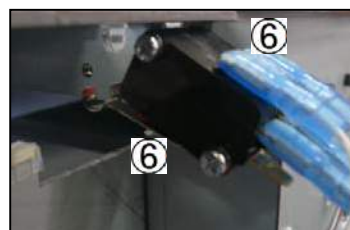
The sensor lamp will be turned off when shielded and turned on when transmitted.

The lamp on the screen will be turned on when shielded and turned off when transmitted.



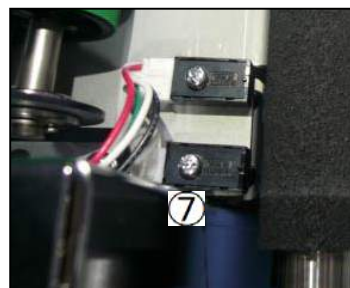
⑥ COVER SENS A, B

The sensor lamp will be turned off when shielded and turned on when transmitted. The lamp on the screen will be turned off when shielded and turned on when transmitted.



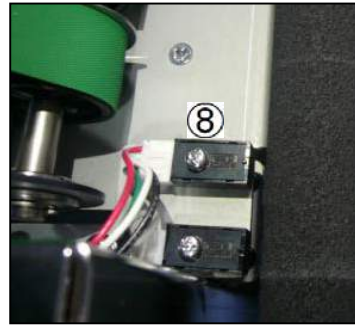
⑦ DOUBLE FEED SENSOR

The lamp on the screen will be turned off when shielded and turned on when transmitted.



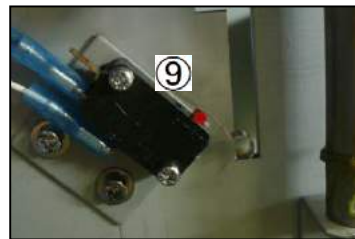
⑧ INPUT SENS

The lamp on the screen will be turned on when shielded and turned off when transmitted.



⑨ TBL LW/LMT SW

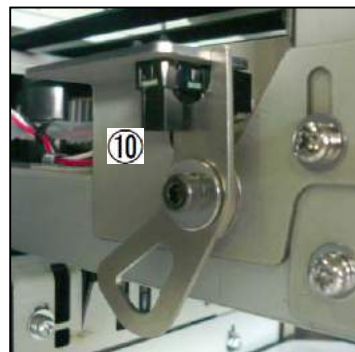
The lamp on the screen will be turned on when switched on.



⑩ FD TBL UP/SENS

The sensor lamp will be turned off when shielded and turned on when transmitted.

The lamp on the screen will be turned off when shielded and turned on when transmitted.



⑪ SERVO ALERT

The lamp will be turned on if an error occurs on the servo motor; the lamp stays off when no error condition exists.

⑫ SERVO POSITIONED

The lamp stays on while the servo motor is not running and stays off while the motor is running.

⑬ SERVO ENCODER A, B

These are encoders for detecting the position of the servo motor.

⑭ SLITTER ENCODER 1~4 A, B

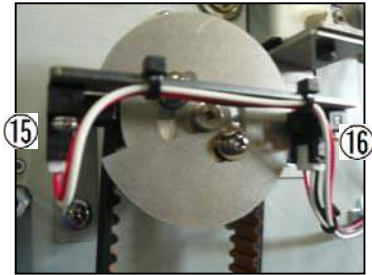
These are encoders for detecting the positions of slitter motors.

⑮ CRSR UP/SENS

⑯ CRSR LW/SENS

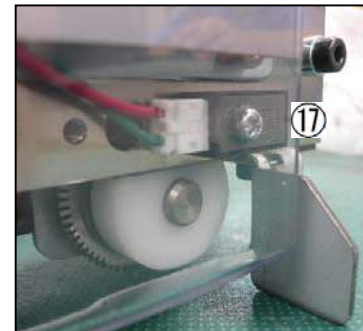
The sensor lamp will be turned off when shielded and turned on when transmitted.

The lamp on the screen will be turned off when shielded and turned on when transmitted.



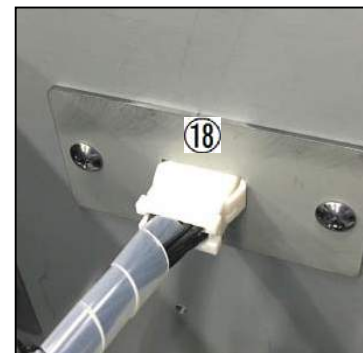
⑰ XPERFO ORIGIN SENS

The lamp on the screen will be turned on when shielded and turned off when transmitted.



⑱ XPERFO EXIST

The lamp on the screen turns on when the harness is connected to the machine. It turns off when the harness is disconnected.



⑲ OP CONVEYER

The lamp on the screen turns on when the harness is connected to the machine. It turns off when the harness is disconnected.



⑳ RETURN

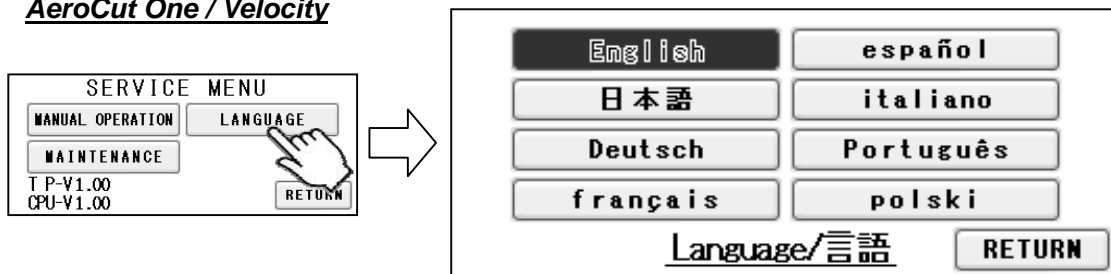
Return to Manual Operation Screen.

3- (7) LANGUAGE Screen

AeroCut Prime



AeroCut One / Velocity

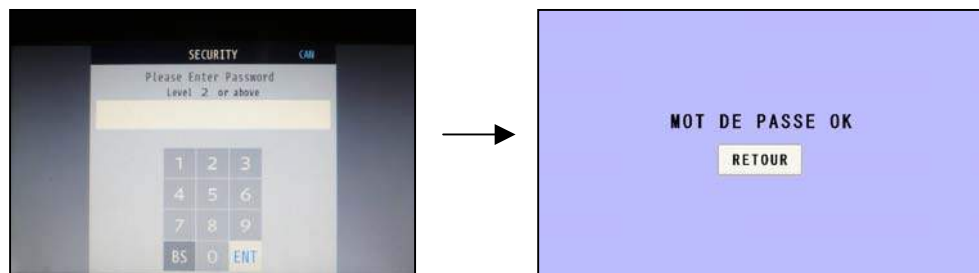


① Language

Select an appropriate language. The language of the touch panel will switch on. English is selected at the time of shipment.

(Languages that are not available at present cannot be selected)

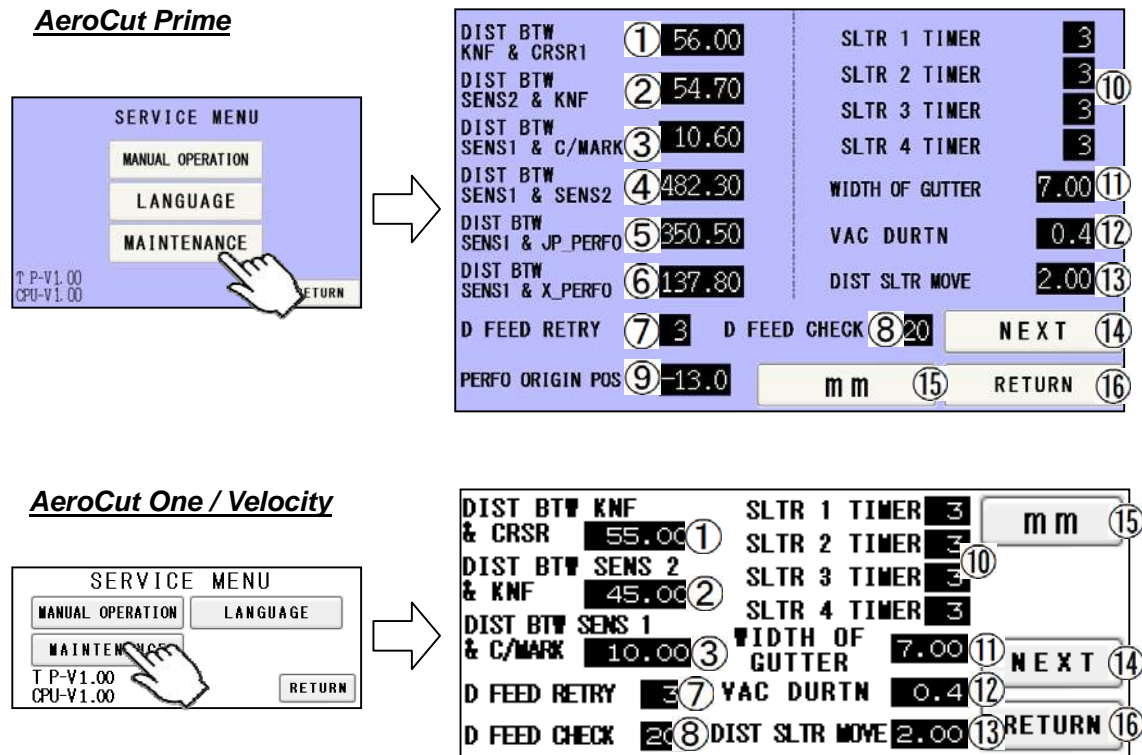
A FRENCH LANGUAGE PASSWORD is set for switching to French. Enter the password for switching.



② RETURN

Return to Service menu Screen.

3- (8) MAINTENANCE Screen



- ① Distance between guillotine and creaser. [mm]
- ② Distance between stop sensor and guillotine. [mm]
- ③ Distance between origin sensor and Cutmark sensor. [mm]
- ④ Distance between origin sensor and stop sensor. [mm]
- ⑤ Distance between origin sensor and Y-Perfo. [mm]
- ⑥ Distance between origin sensor and X-Perfo. [mm]
- ⑦ Total number of re-feed in case double feed is occurred. [times]
- ⑧ The number of times that the machine checks double-feed. [times]
- ⑨ Initial position of X-Perfo.
- ⑩ Speed of slitter unit movement when fine adjusting slitter positions.
- ⑪ Width of gutter. →Default setting, do not change.
- ⑫ Paper vacuuming time when the feed table is lifted to the upper limit. [sec]
- ⑬ Distance between targeted positions and the points where slitter units start fine adjustment when changing slitter positions.
- ⑭ Go to Maintenance Screen 2
- ⑮ This is to set either mm or inch as the measurement input unit.
- ⑯ Return to Service menu Screen.

① CUTTER	12321	SLITTER 1 INITIAL POS	-31.05	
② CREASE	2016	SLITTER 2 INITIAL POS	399.75	⑥
③ COUNT	2328	SLITTER 3 INITIAL POS	-34.15	
		SLITTER 4 INITIAL POS	402.85	
SLTR1	2 : 13	JUMP PERFORATION	ON	⑦
④ SLTR2	1 : 23	CROSS PERFORATION	ON	⑧
SLTR3	1 : 32			
SLTR4	2 : 10	MACHINE NO.	0	⑨
⑤ TABLE	5 : 15			
			PREV	⑩

① CUTTER	12321	SLITTER 1 INITIAL POS	-30.00	
② CREASE	2016	SLITTER 2 INITIAL POS	399.75	⑥
③ COUNT	2328	SLITTER 3 INITIAL POS	-34.15	
		SLITTER 4 INITIAL POS	402.35	
SLTR1	2 : 13			
④ SLTR2	1 : 23	MACHINE NO.	0	⑨
SLTR3	1 : 32			
SLTR4	1 : 10	PERFORATION	ON	⑦
⑤ TABLE	5 : 15			
			PREV	⑩

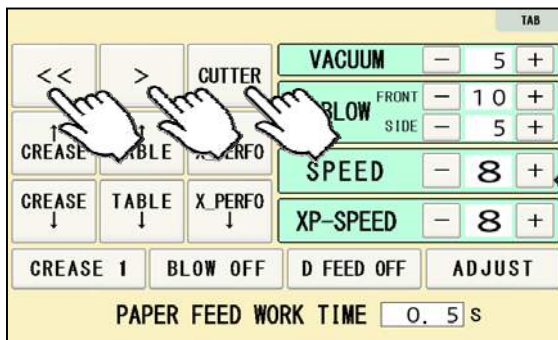
- | | |
|--|------------------|
| ① Total number of processed Guillotine. [times] | } Not changeable |
| ② Total number of processed Crease. [times] | |
| ③ Total number of processed paper. [sheets] | |
| ④ Operation time of Slitter 1~4. [hours : minutes] | |
| ⑤ Operation time of Feed table. [hours : minutes] | |
| ⑥ Slitter 1~4 Initial position. [mm] | |
| ⑦ Switch to activate/inactivate an optional unit (Y-Perfo) | |
| ⑧ Switch to activate/inactivate an optional unit (X-Perfo) | |
| ⑨ Machine Number. | |
| ⑩ Return to Maintenance Screen 1. | |

4. Paper jam

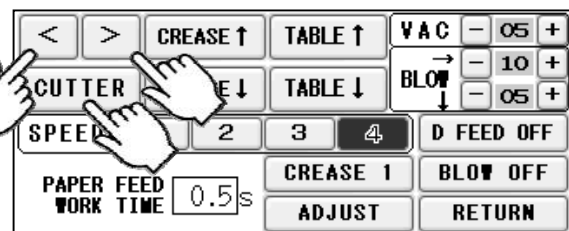
- ① Enter MANUAL CONTROL screen, press < > buttons to inch the rollers forward/backward and remove the jammed paper.

If paper is stuck around the guillotine section, press CUTTER to cycle the guillotine to chop jammed paper.

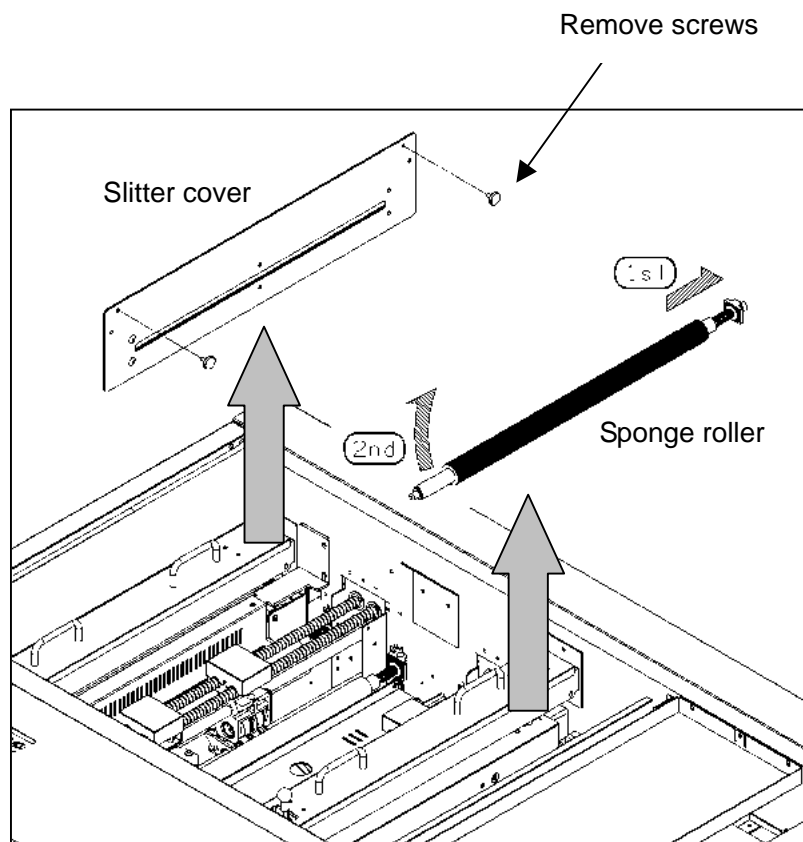
MANUAL CONTROL screen



MANUAL CONTROL screen

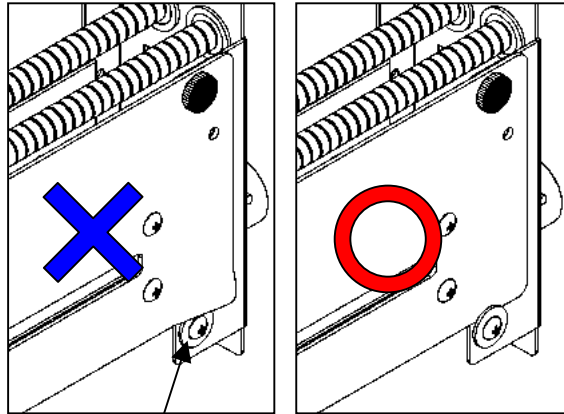


- ② Detach Sponge roller and Slitter cover if necessary, and remove jammed paper.



Note.

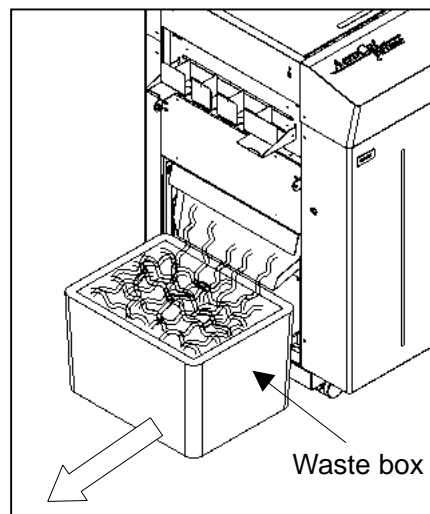
Do not attach Slitter cover on Washer and Screw. This may cause paper jam.



Washer & screw

Note.

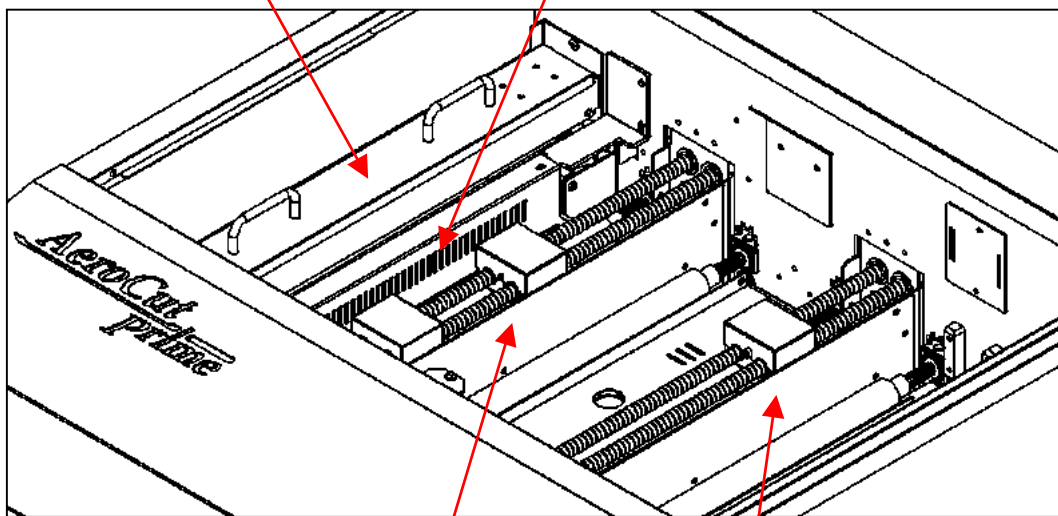
Remove paper in waste box before the waste bin becomes full. It may cause paper strips remain inside the machine and cause paper jam.



Note.

If paper jam often occurs, make sure that paper strip is not left in the indicated sections.

- Inside of Slitter head
- Inside of Guillotine cover
- Inside of Crease

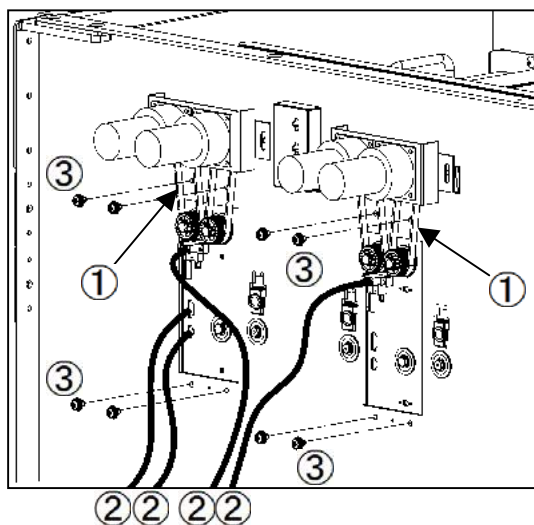


5. Replacement of parts

5- (1) Slitter Unit

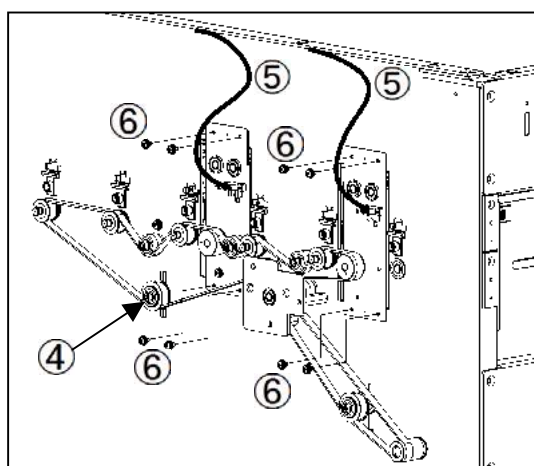
Front side

- ① Remove Timing Belt from pulley.
- ② Disconnect the harness.
- ③ Remove screws.



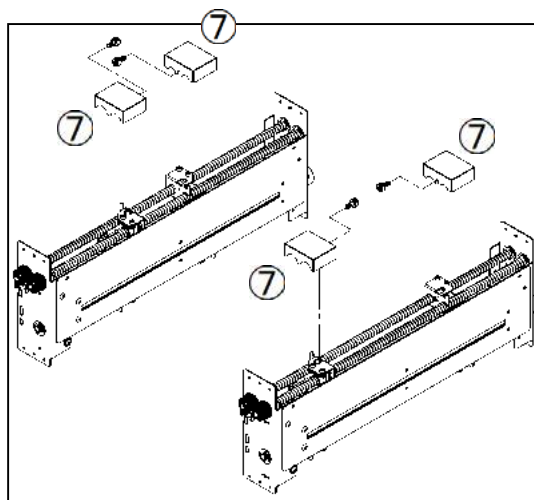
Back side

- ④ Loosen Idler and remove Timing Belt.
- ⑤ Disconnect the harness.
- ⑥ Remove screws.

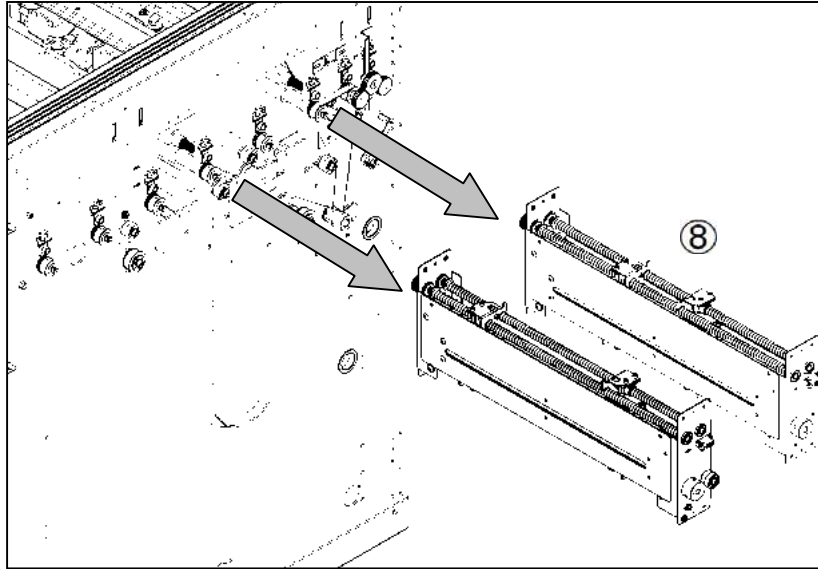


In side

- ⑦ Remove screws and cover.

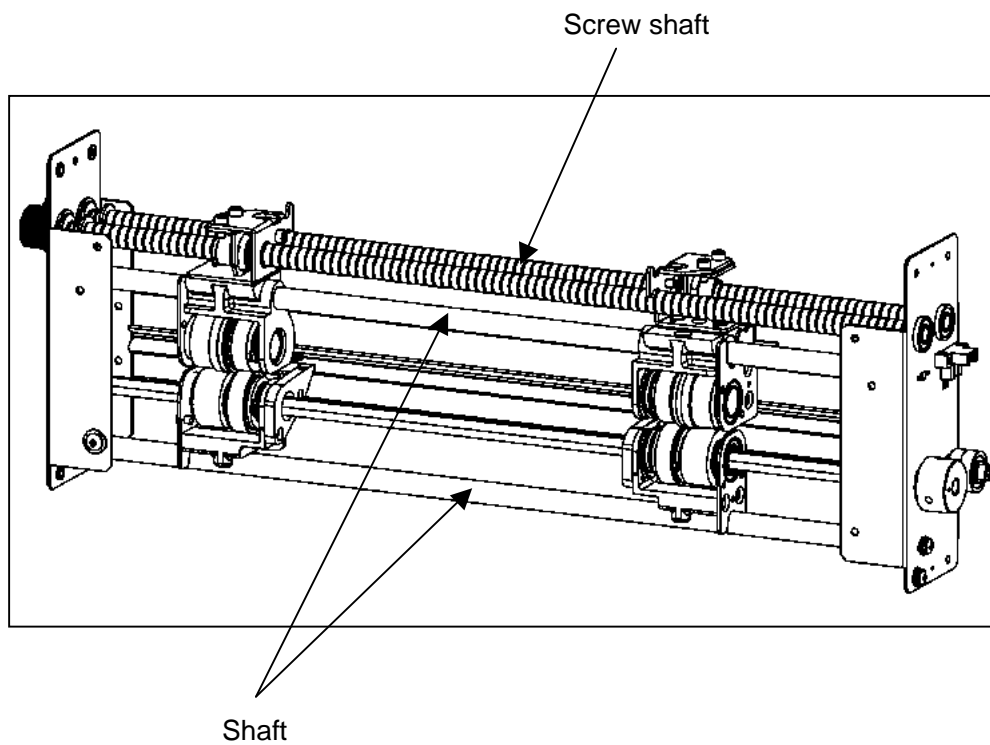


⑧ Pull Slitter Units out.



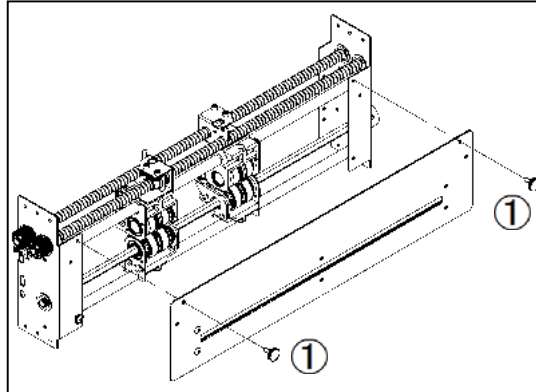
Note.

Shaft and Screw shaft shown on below figure might get rusty if touched by bare hands.
Put gloves on hands when you detach slitter shaft.

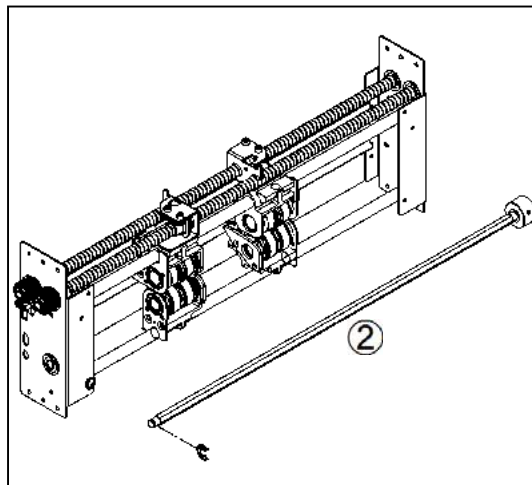


5- (2) Slitter head

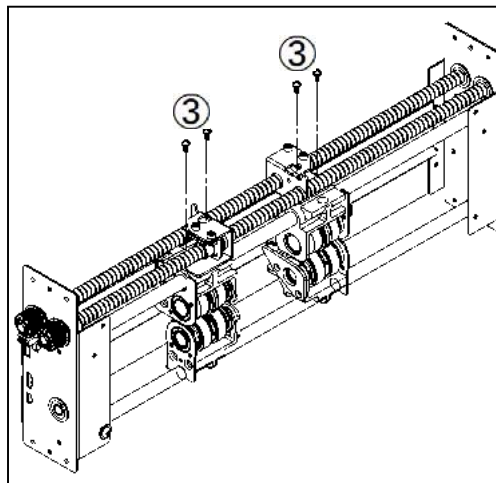
- ① Remove screws and cover.



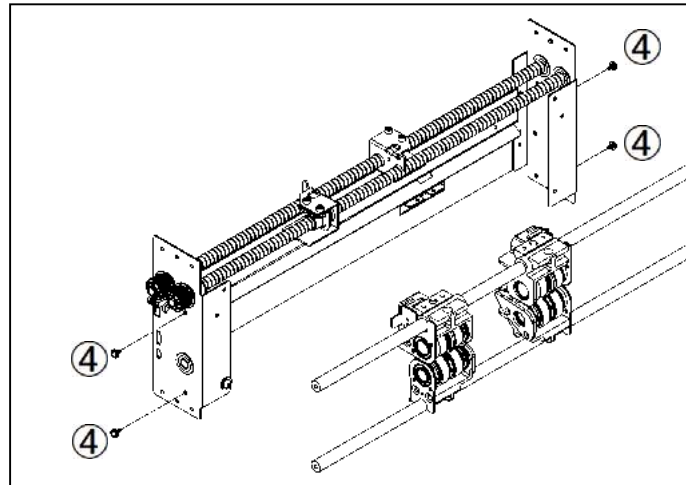
- ② Remove Retaining ring-E.
Pull Idler Shaft out.



- ③ Remove screws.

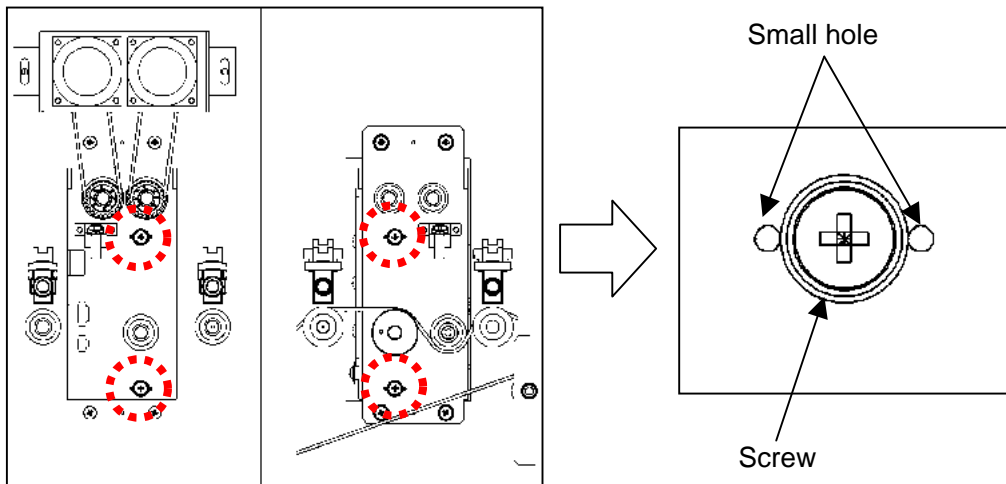


④ Remove screws.



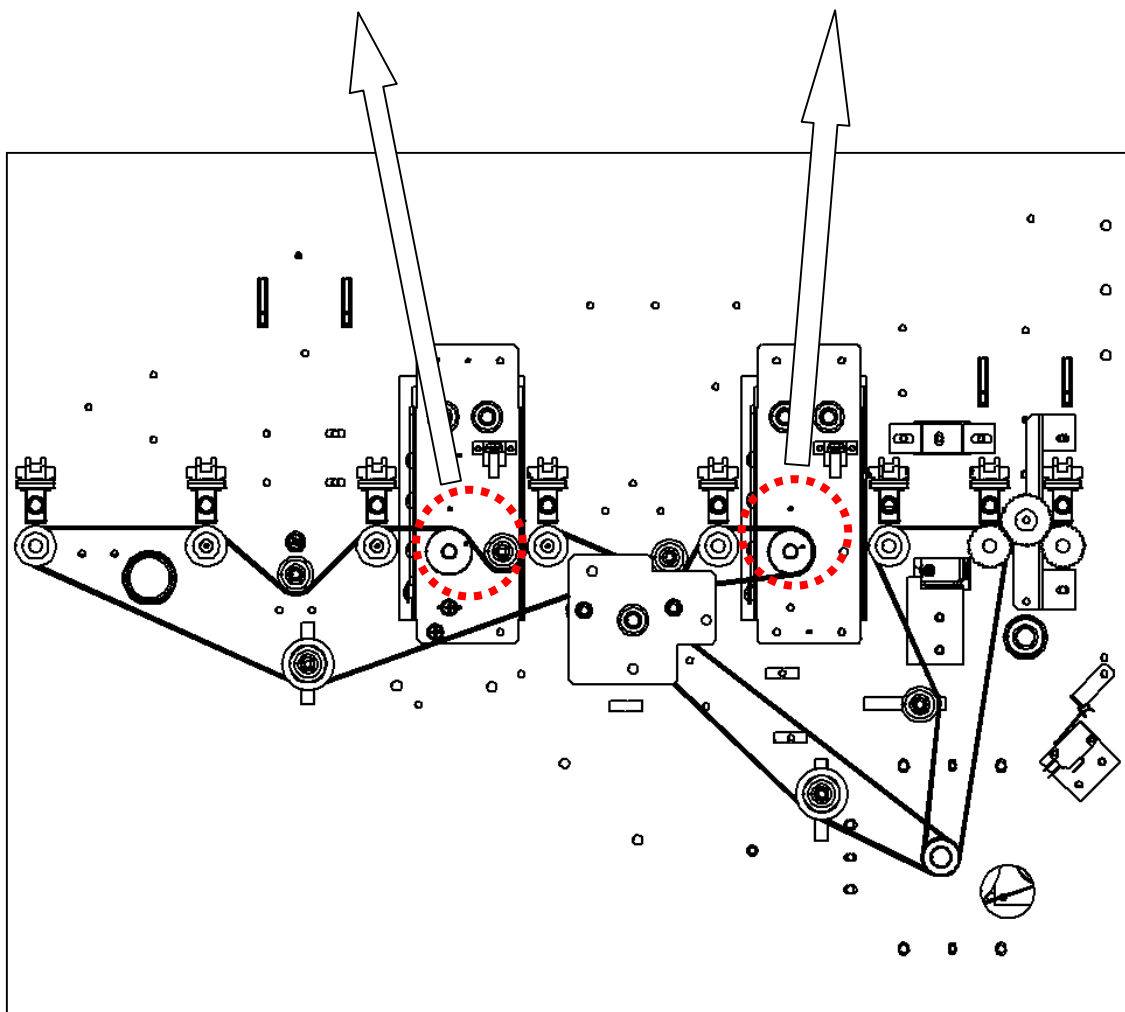
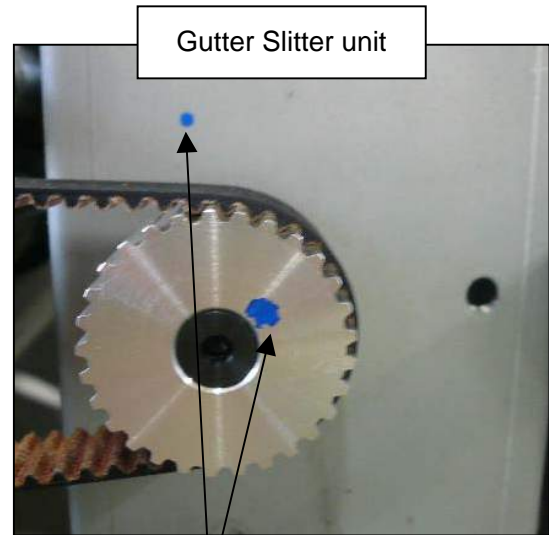
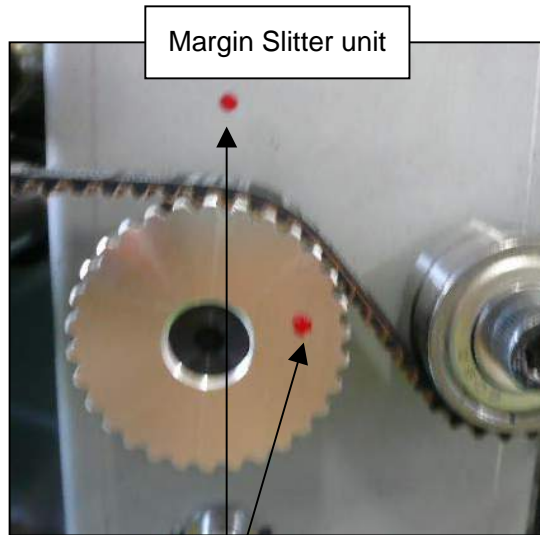
Note.

When fixing the shafts, tighten the screw in the center position



Note.

There are 2 different types of idler shaft, mentioned on procedure ②, used on Margin Slitter Unit and Gutter Slitter Unit. Refer to the marks as shown on below images to avoid putting wrong idler shaft.

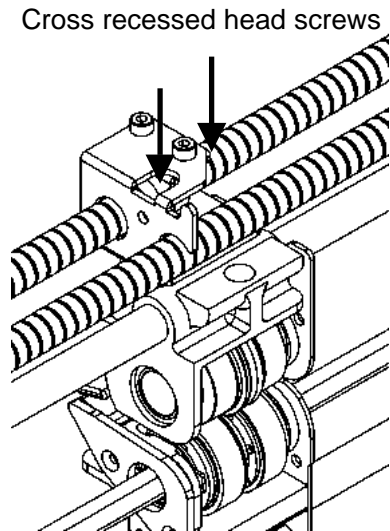


Note.

Movement of slit head is not good.
..Especially when a slit movement is heavy.

Please operate slit head to find
the position where the movement is heavy.

Please stop slit head and
loosen "cross recessed head screws",
then tighten it again.



Note.

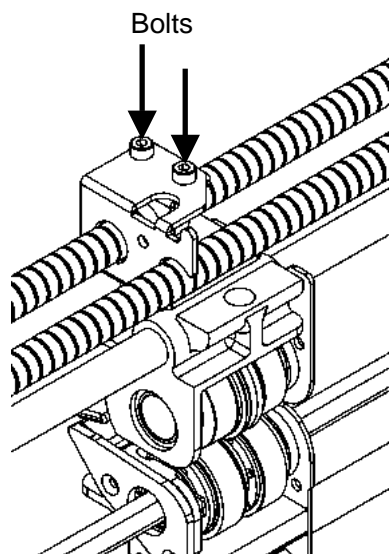
It sounds strange while a slit unit is moving.
..Especially when it sounds strange.

Please operate slit head to find
the position where it sounds strange.

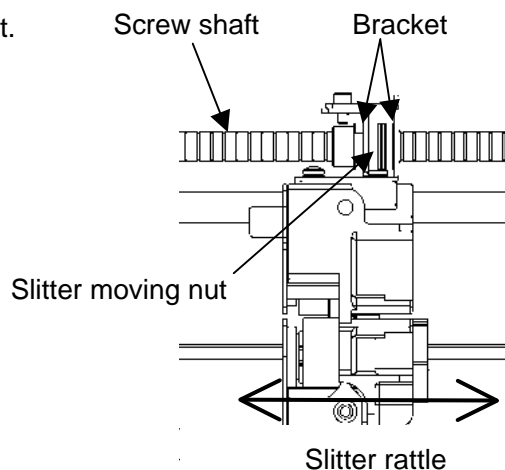
Please stop slit head and
loosen "Bolts", then tighten it again.

When "Bolts" is tighten, please be careful
not to make any space between
"Slitter moving nut" and "Bracket".

This space may happen "slitter rattle"
so that it could make inaccurate cutting
by slit unit.

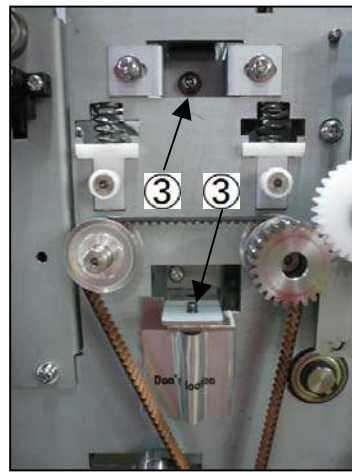
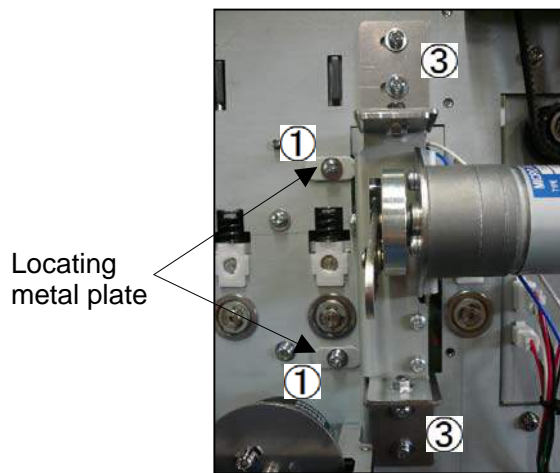
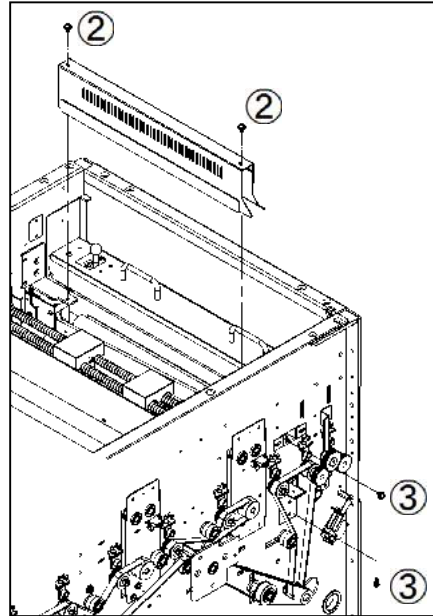
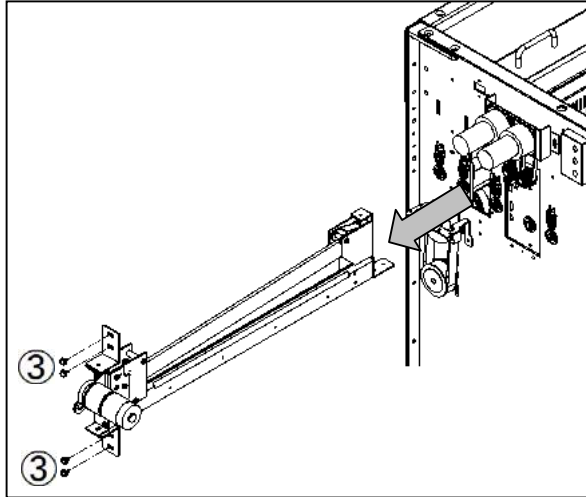


For more smooth movement of slit unit,
please put some of silicone oil on screw shaft.
When it is done, please be careful not to put
silicone oil on carrying roller. Oil on carrying
roller might cause inaccurate cutting result.



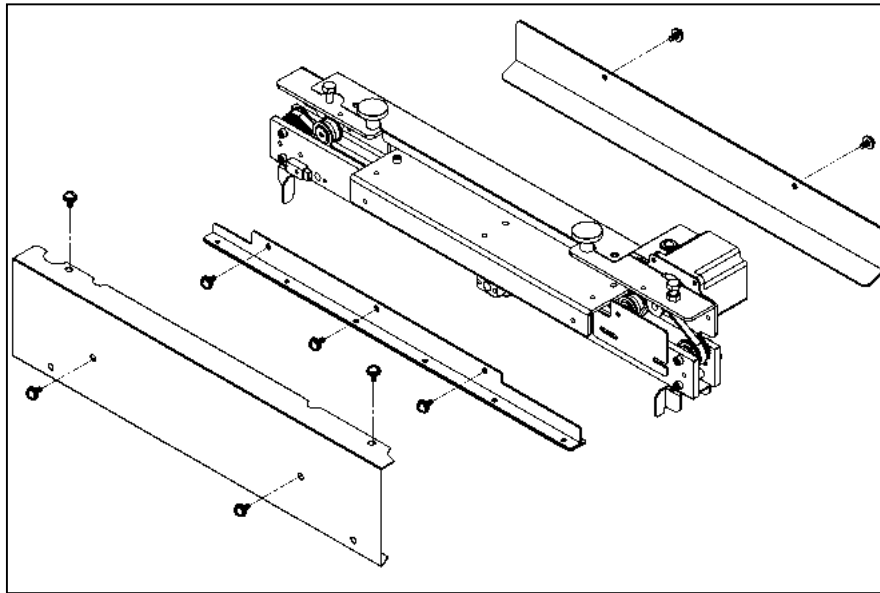
5- (3) Guillotine Unit

- ① Check if the locating metal plate is in contact with the cutter unit.
This will be a mark for reattachment.
- ② Remove screws and Guillotine Cover.
- ③ Remove screws and pull Guillotine Unit out.



5- (4) X-perforator blade

- ① Remove covers.

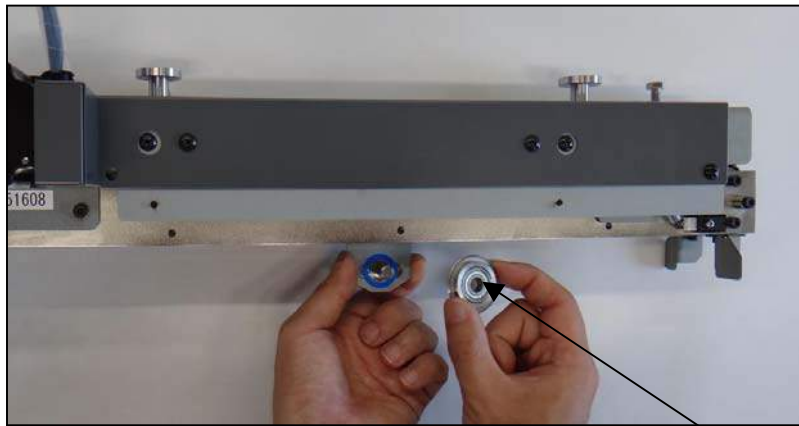
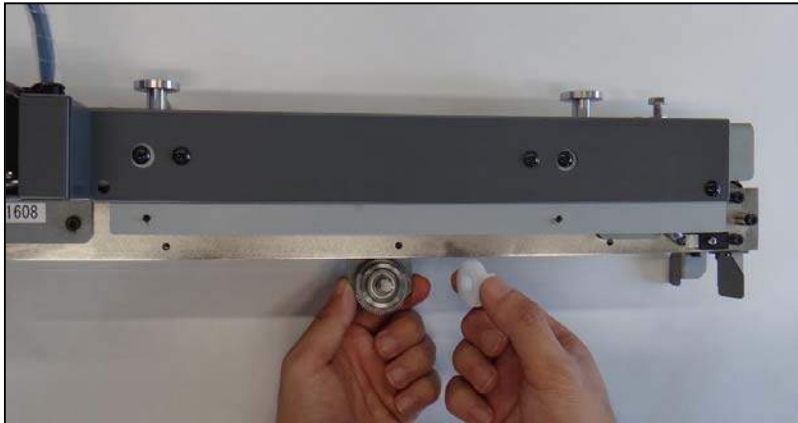


- ② Move Perforation blade holder to the center by hand. Be careful not to touch Perforation blade.



Perforation
blade holder

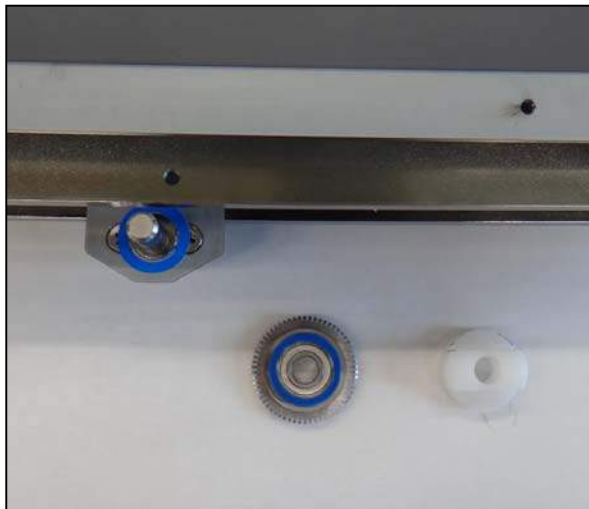
- ③ Remove blade by pulling Perforation blade holder down.



Perforation blade

Note.

Attach Blade in shown way that blue rings should be together.



OK

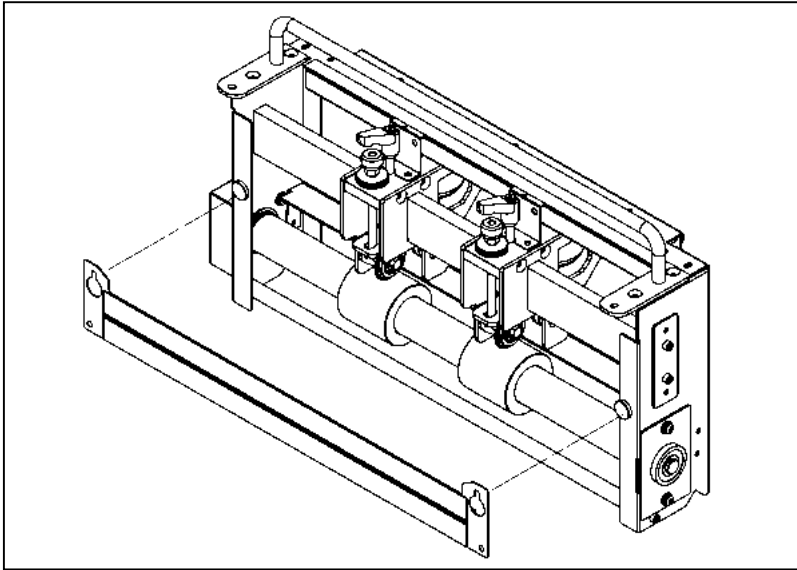


NG

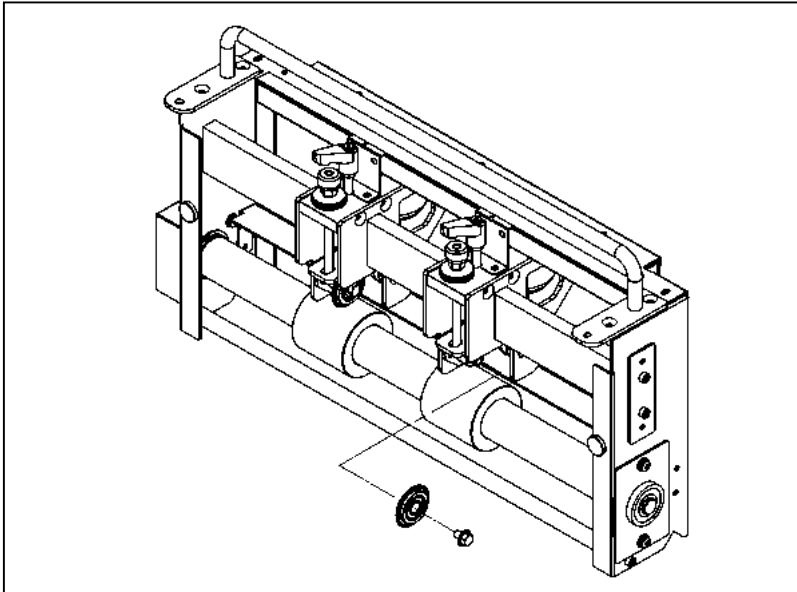


5- (5) Y-perforator blade

- ① Remove covers.



- ② Remove blades.

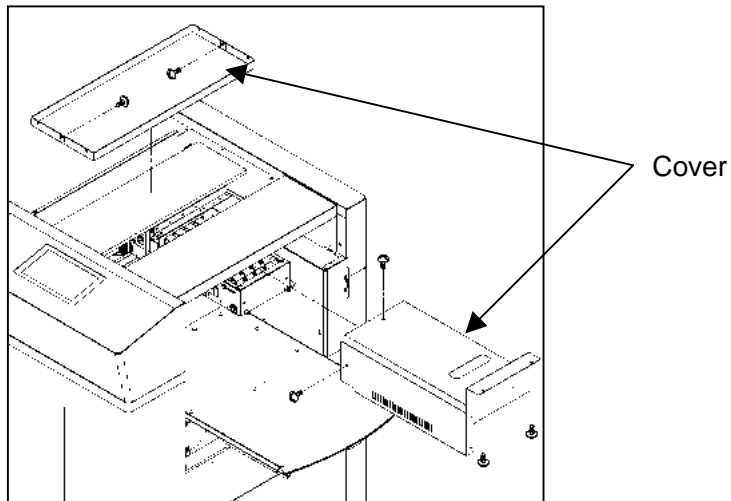


Note.

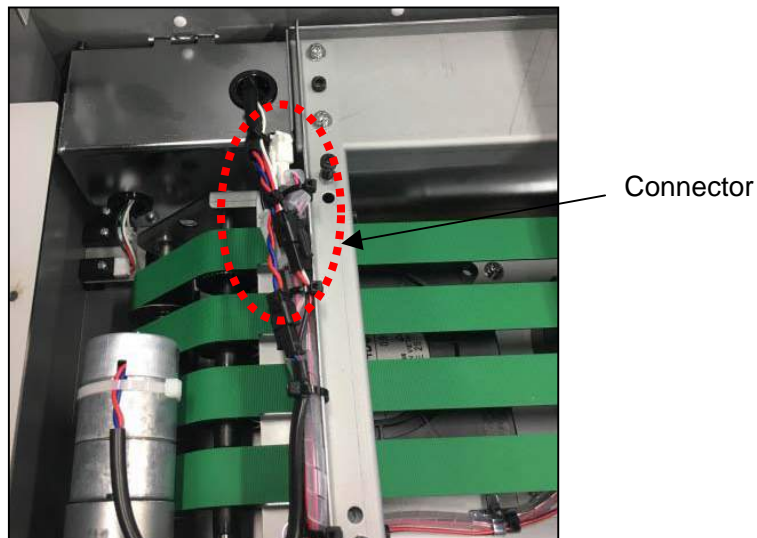
Blade is double sided.

5- (6) Feed belt Unit

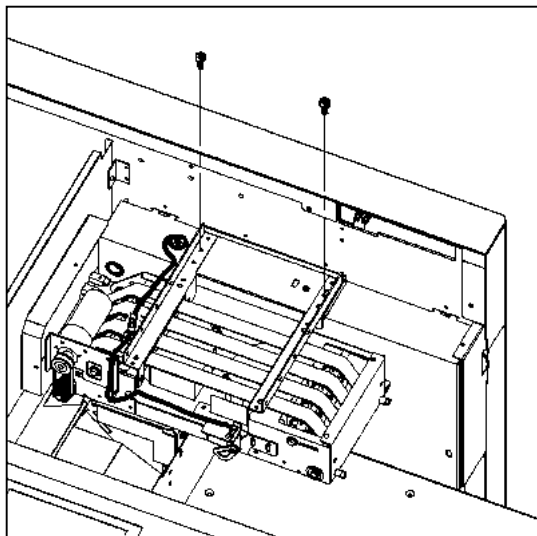
- ① Remove screws and cover.



- ② Disconnect the harness.



- ③ Feed belt unit can be removed after bolts are removed.



6. Adjustment

6- (1) Feed settings

(a) Blower

Standard Value

				TAB	
<<	>	CUTTER	VACUUM	-	5 +
↑ CREASE	↑ TABLE	↑ X_PERFO	BLOW	FRONT - 10 +	
↓ CREASE	↓ TABLE	↓ X_PERFO		SIDE - 5 +	
			SPEED	-	8 +
			XP-SPEED	-	8 +
CREASE 1	LONG BLOW	D FEED MID	ADJUST		
PAPER FEED WORK TIME			0. 5 s		

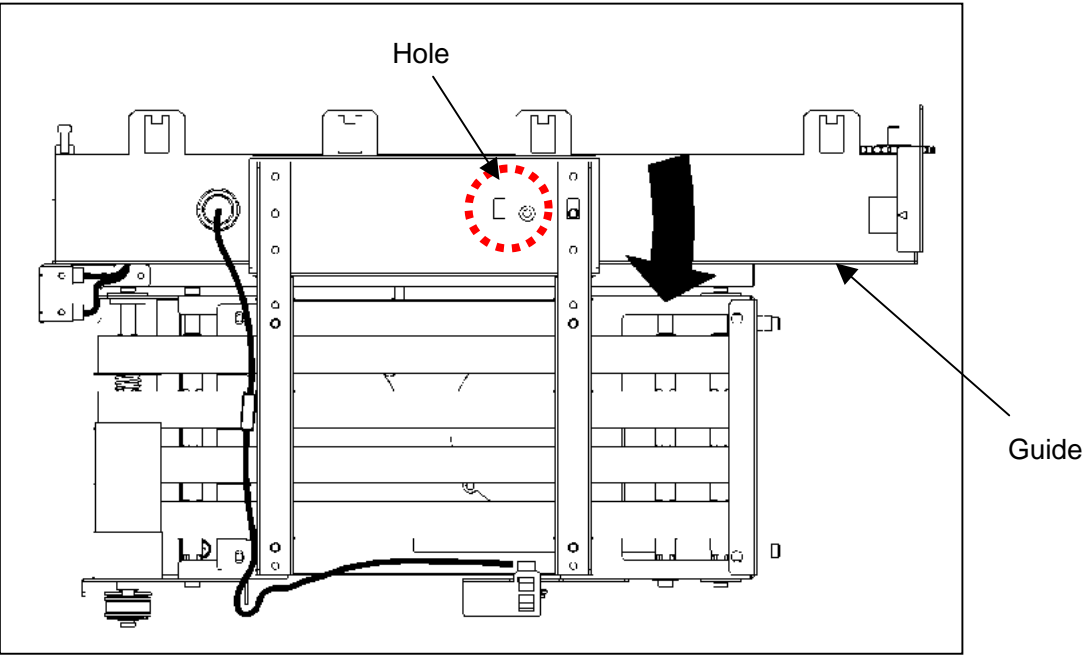
Input 10 in case paper is too heavy to feed.

There will be possibility of double feed if paper is too thin. In this case, input 5.

Ensure that LONG BLOW is shown on the screen. There is possibility of empty feed.

(b) Aligner

- ① Check angle of aligner by position of a hole in below picture when attaching the feed belt unit.

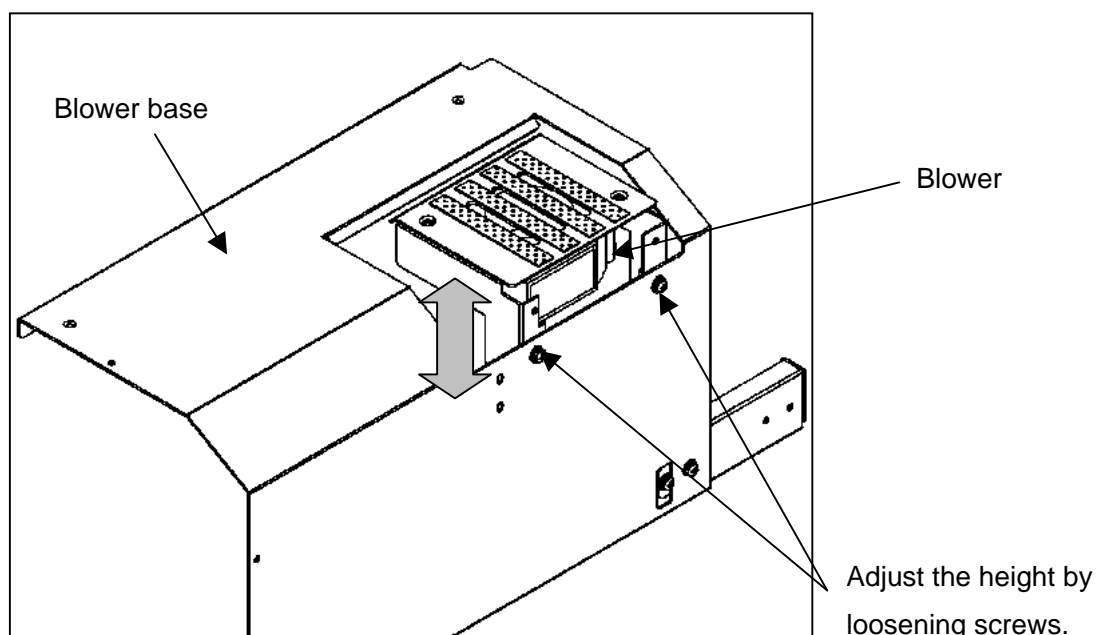


- ② It is factory setting if Feed belt unit is attached so that a small hole contacts a big hole.

Hole position			
Status	Default (FactorySetting)	—	Parallel to Guide
Effectiveness of Aligner	High	Low	None

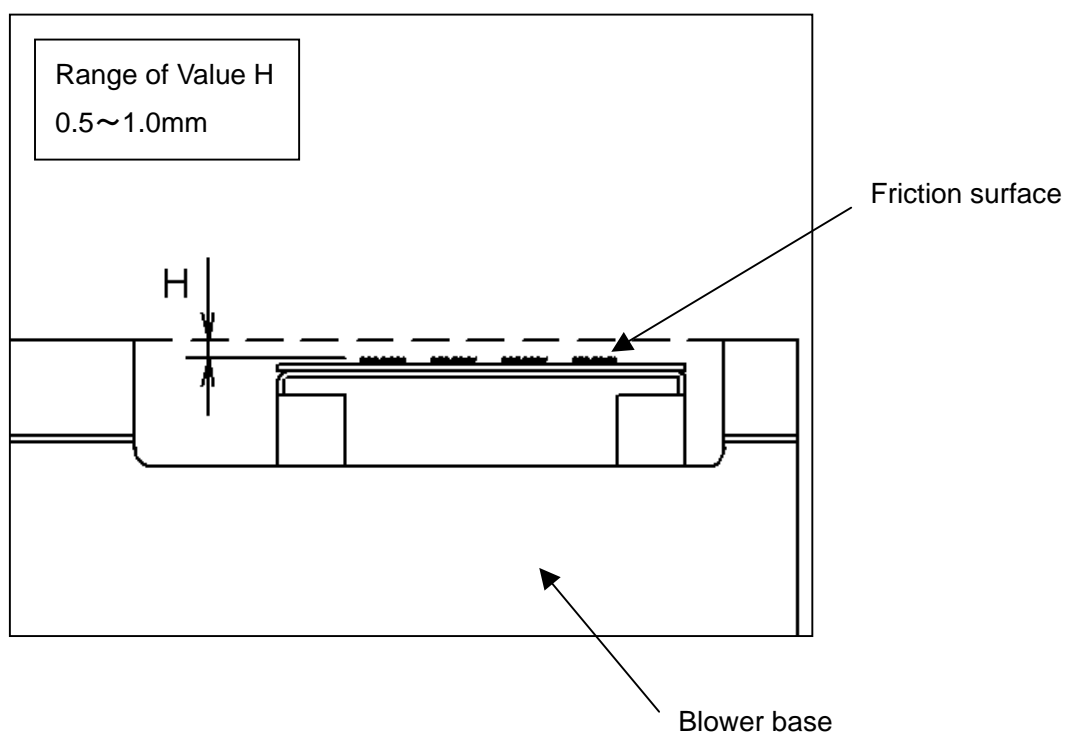
(c) Feed area mechanical adjustments

(1) Lower Blower position

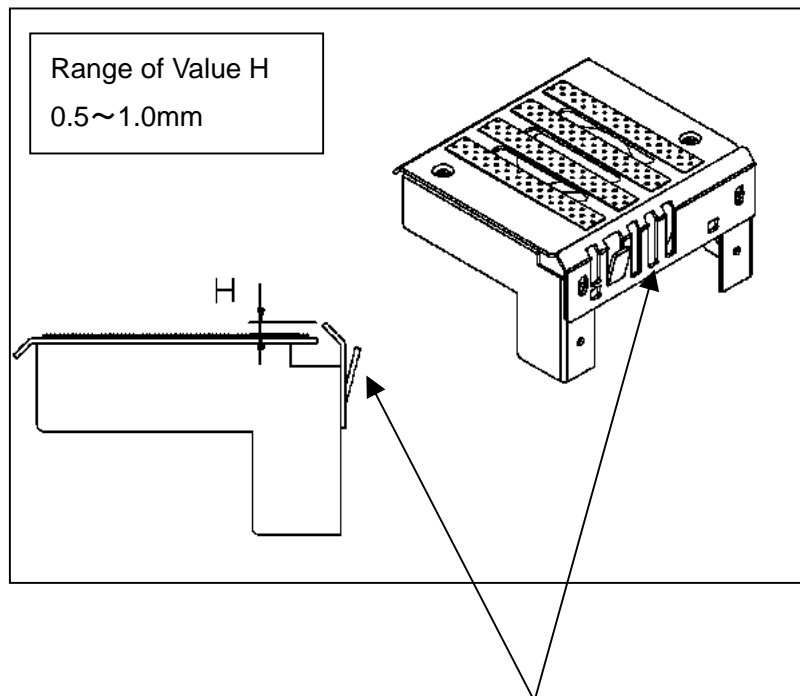
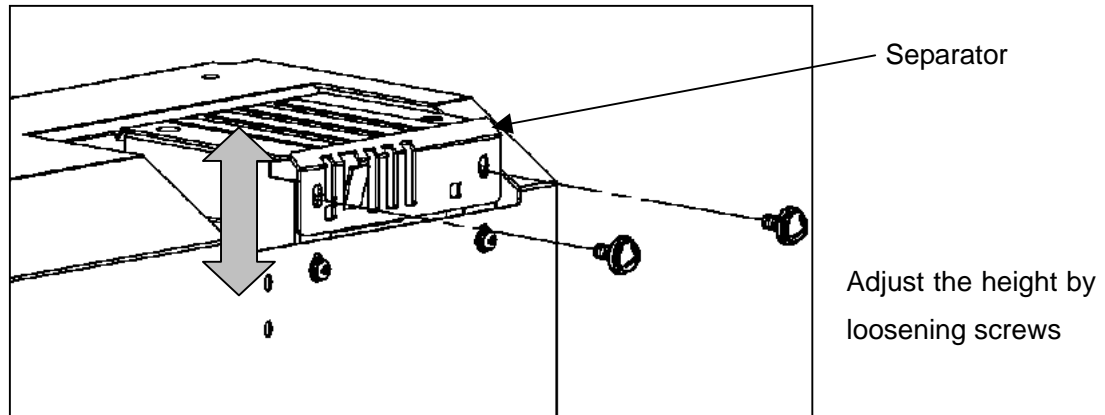


Note.

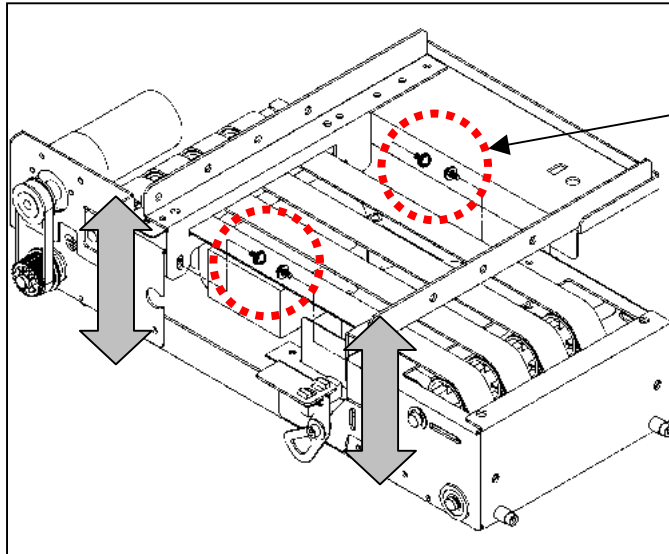
Do not remove screws because blower will drop.



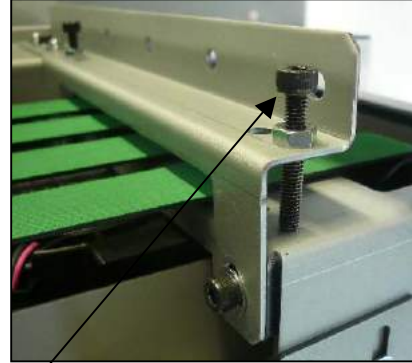
(2) Separator position



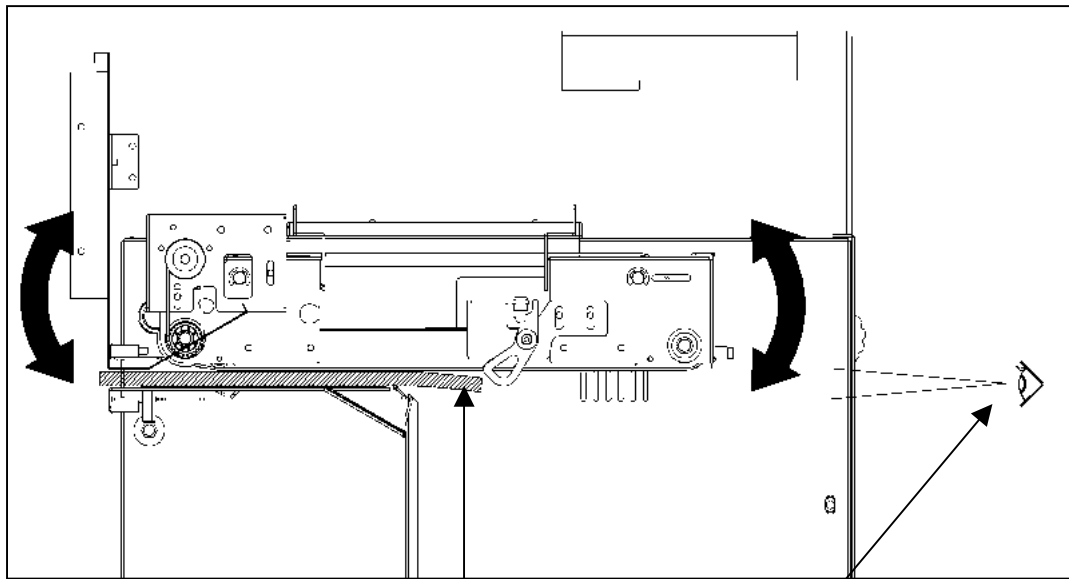
(3) Feed belt unit position



Adjust the height by
loosening screws

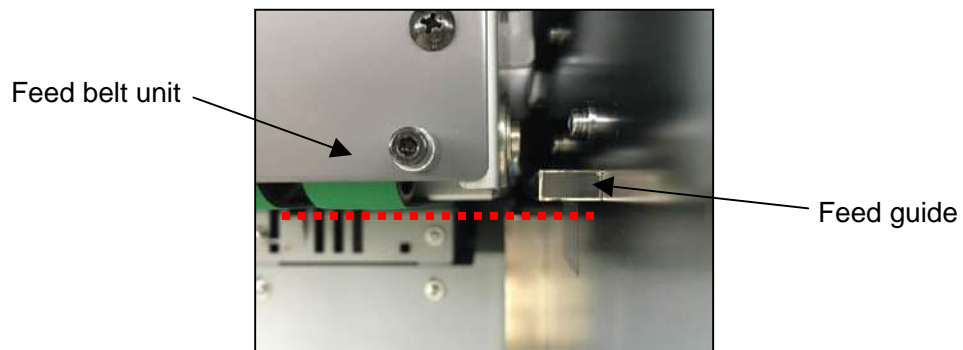


Adjust bolts
This will be a mark for reattachment.



Lift and fix Feed belt unit with 2mm
thick paper inserted as above figure.

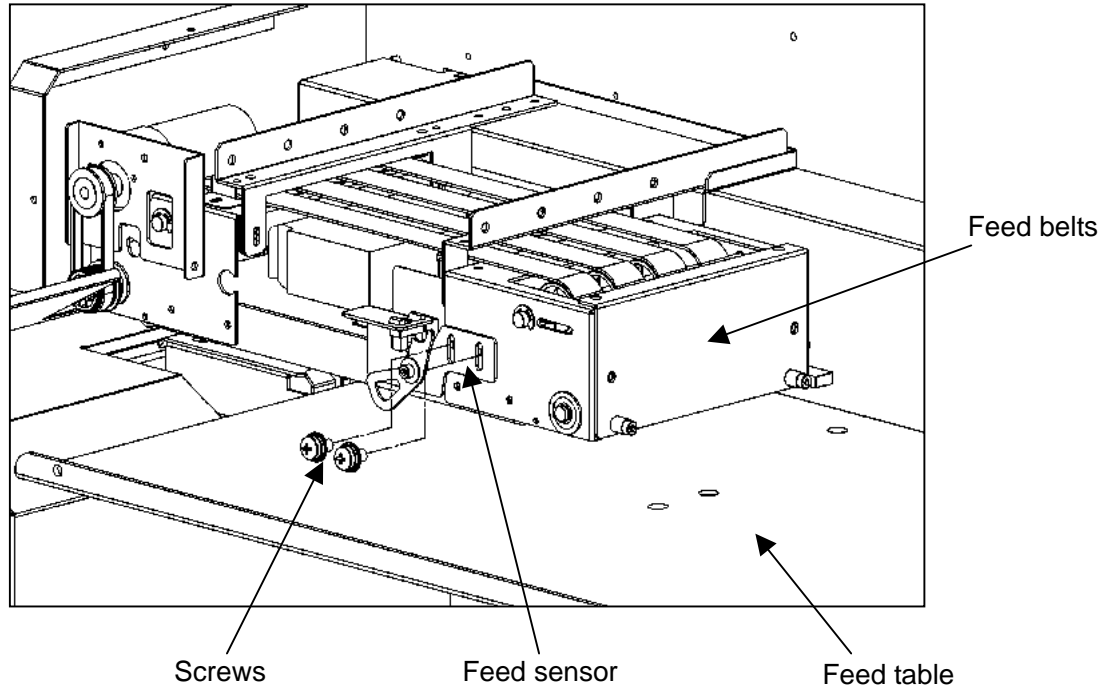
Ensure that it is parallel to
the Feed guide by sight.



(4) Feed sensor position

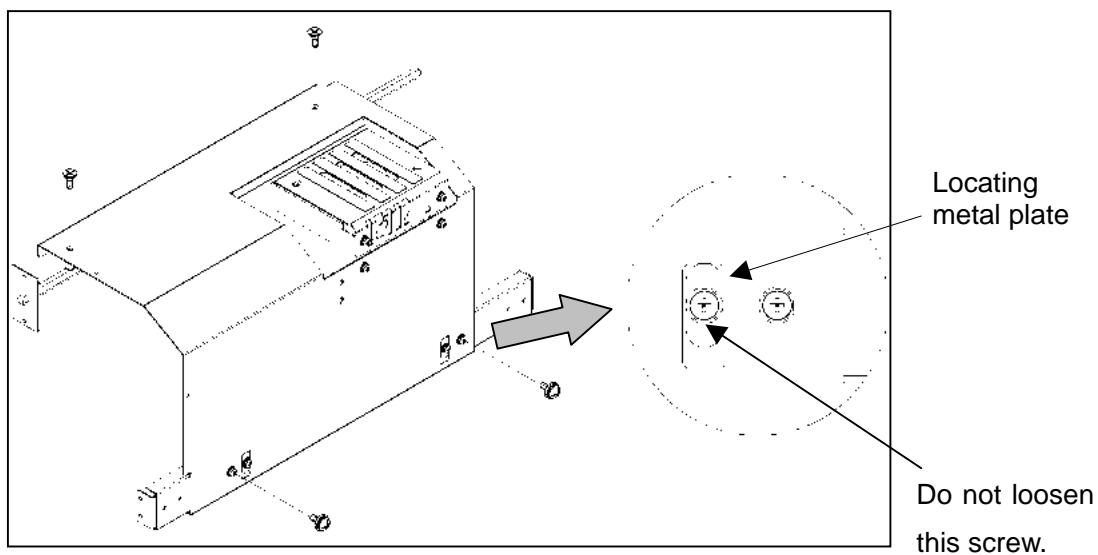
When the feed table is upper dead point, the proper gap between the feed table and the feed belt is $2 \pm 0.5\text{mm}$ ($0.08'' \pm 0.02''$).

Loosen the screws and adjust the position of the feed sensor properly.

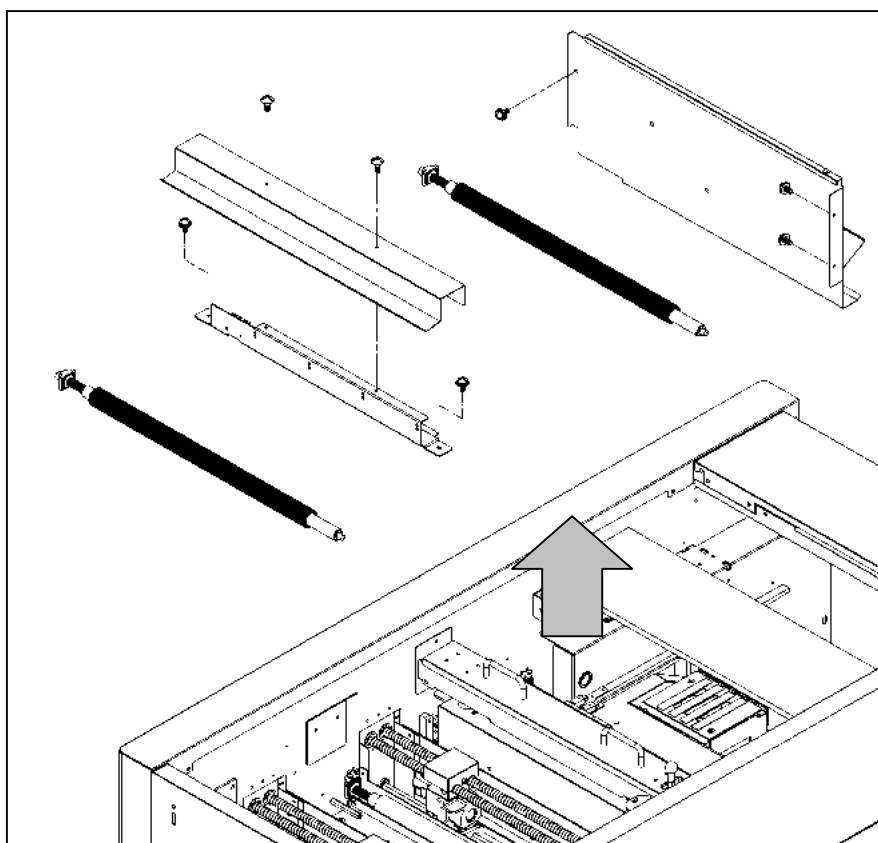


(5) Parallelism of basement

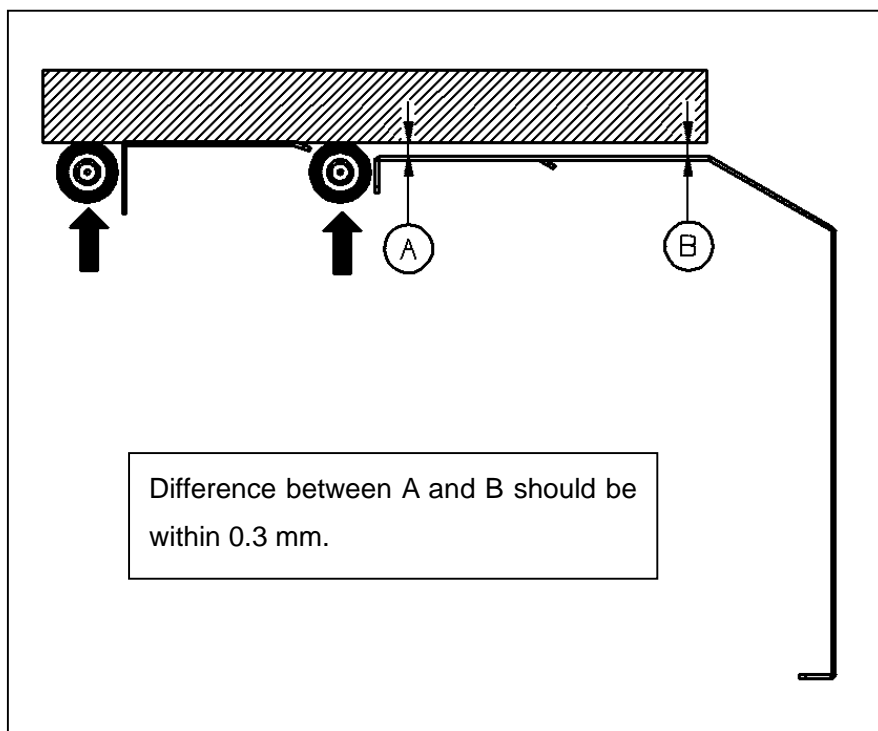
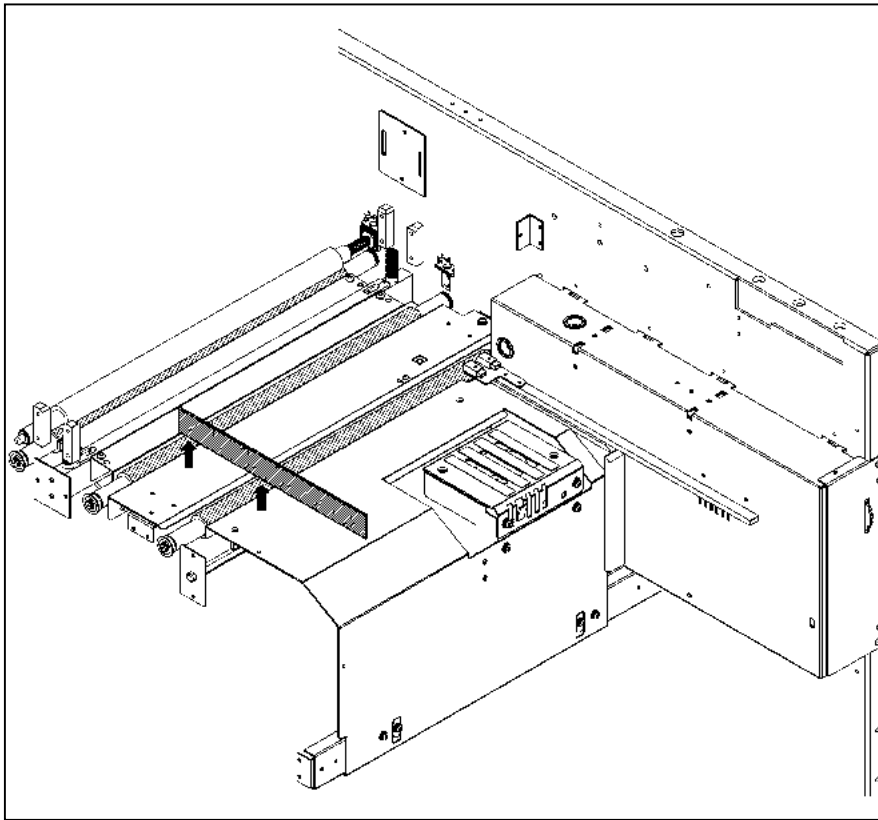
- ① In case that you detached the basement for the purpose of parts replacement etc., the basement can be attached parallel by pressing the base against Locating metal plate.
(Ensure that the basement is put on Locating metal plate when you detach it)



- ② Please detach this part below in case that the upper surface of the basement is not parallel.



- ③ Settle a reference from two delivery rollers and adjust parallelism of the base with tolerance within 0.3 mm between A and B.

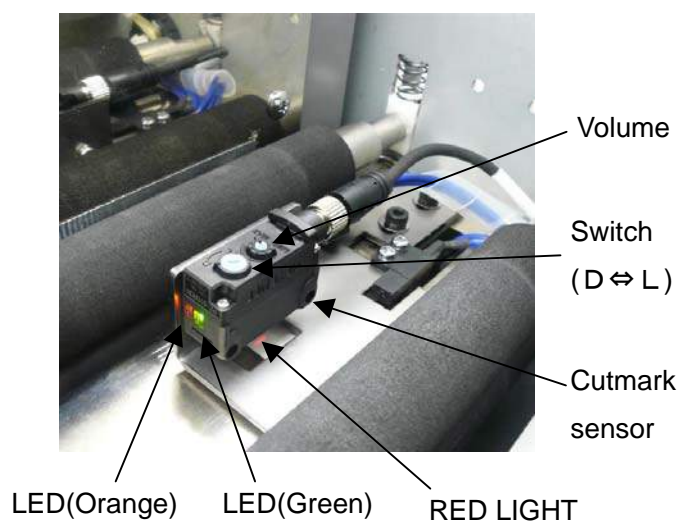


6- (2) Cut mark sensor

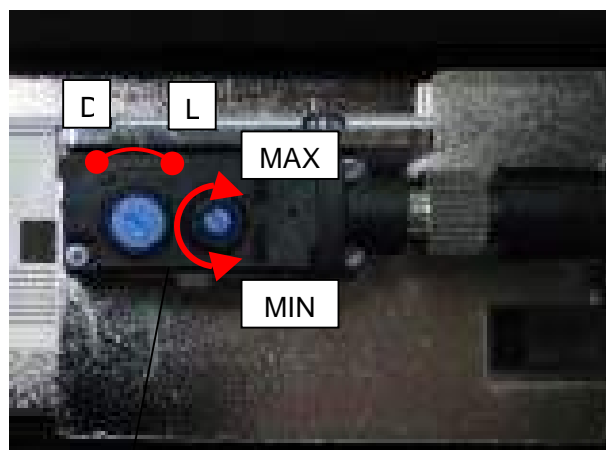
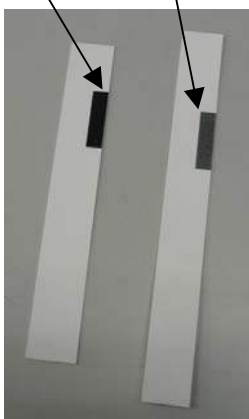
- ① Remove the sensor cover.
- ② Adjust the switch at "D" (D⇔L).
- ③ Shine the red light on the TEST MARK (GRAY).
- ④ Turn the volume from "MAX" to "MIN" slowly.
Stop at the position where both orange LED and green LED light.
- ⑤ Ensure that the orange LED lights when it senses the TEST MARK (GRAY) and the orange LED does not light when it senses the white part of the TEST MARK.

In addition to above, ensure that the green LED lights at all times.

(If the green LED lights off sometime, the sensor may detect cut marks inconsistently.)



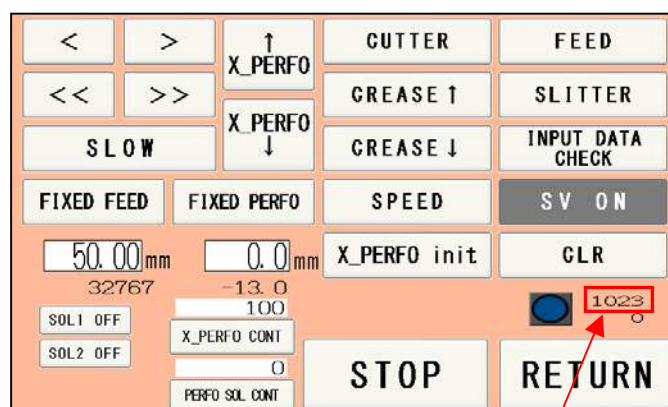
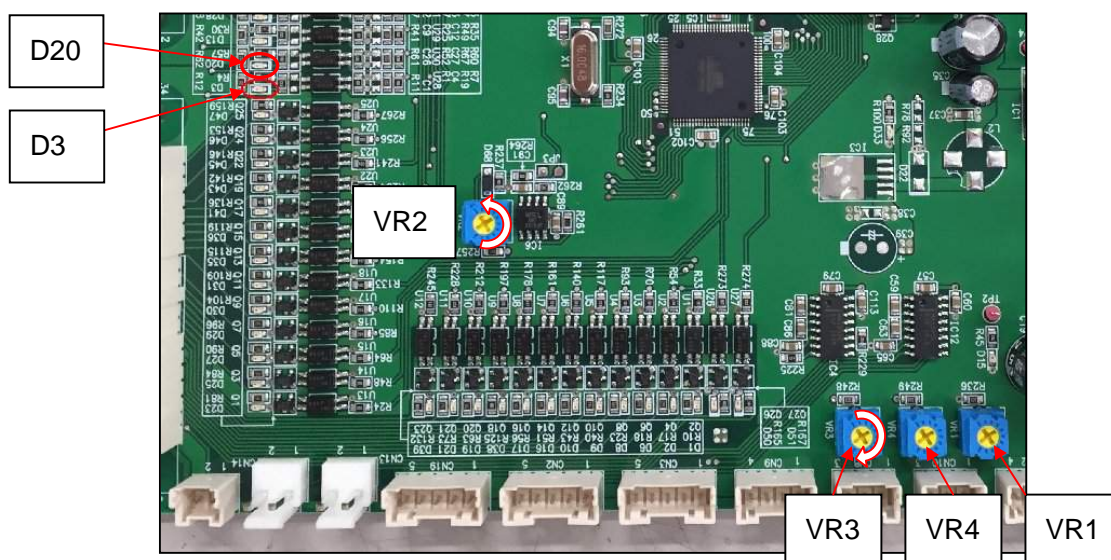
TEST MARK (Black)
TEST MARK (Gray)




Adjust it with a narrow Minus-head screwdriver.

6- (3) PCB setting (AeroCut Prime)

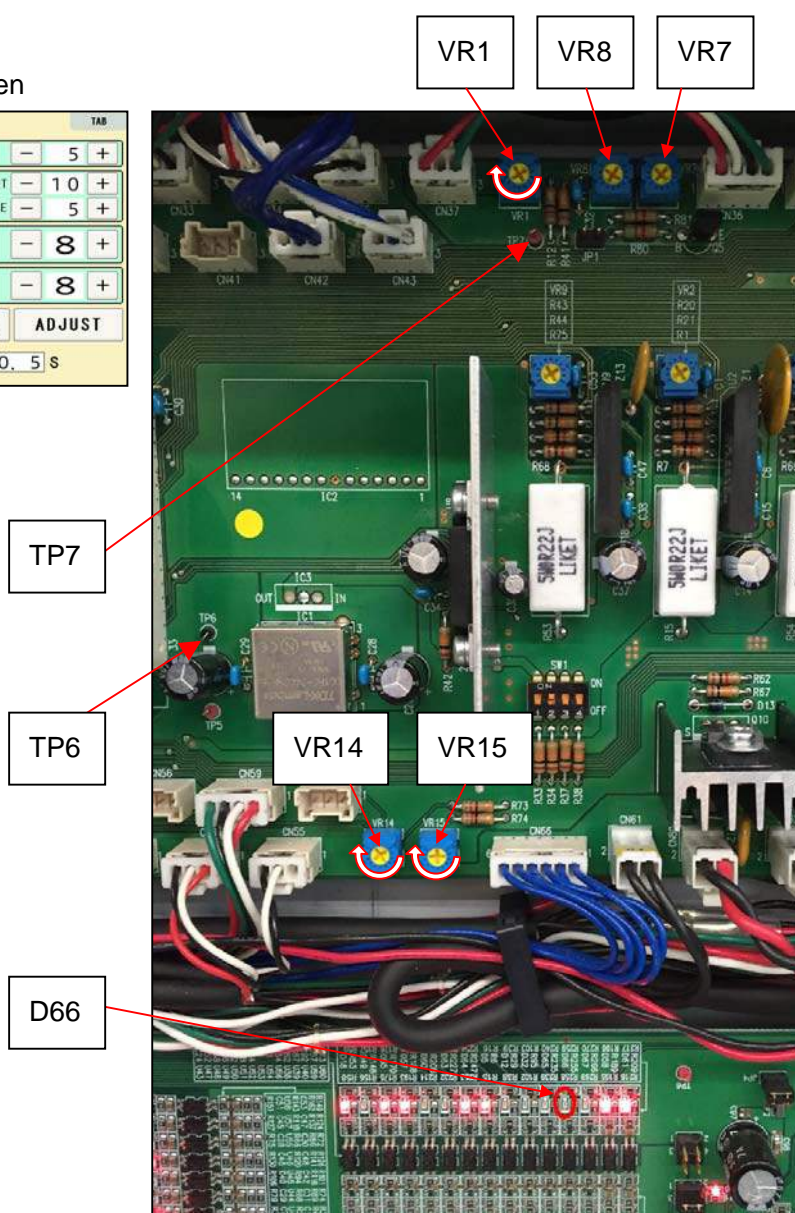
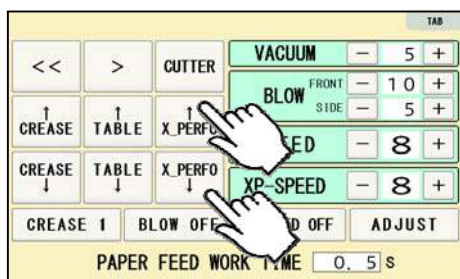
Subject	How to adjust
Origin Sensor	Turn VR3 fully in clockwise. ⚠
Stop Sensor	Turn VR4 on CPU Board in clockwise with paper (77gsm). When D20 on CPU board turns off, turn VR3 in clockwise for two division from this position. ⚠
Double Feed Sensor	Turn VR2 on CPU Board fully in anticlockwise. Adjust VR1 on CPU Board with paper (126gsm) so that Double feed detection counter on Manual Operation Screen shows approximately 500. After this procedure, ensure that Double feed detection shows more than 40 with paper (350gsm). If this value is less than 40, adjust volume so that it shows more than 40.



Double feed counter

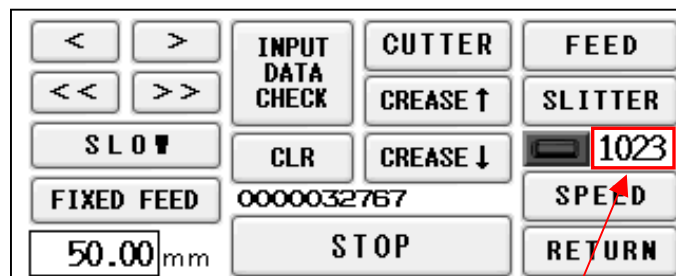
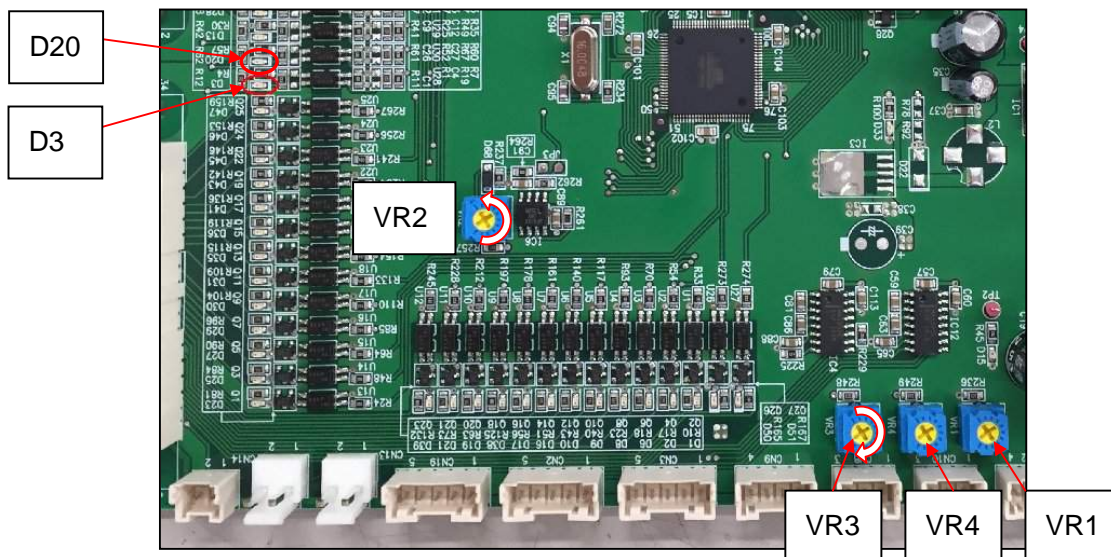
Subject	How to adjust
Feed Sensor	Turn VR15 fully in clockwise. 
Pulse Motor Driver for Cross perforation	Adjust voltage to 0.310V by turning VR8 on I/O Board with attaching a voltmeter to TP6 and TP7 and pressing X_PERFO which is shown on MANUAL CONTROL screen. After that adjust voltage to 0.100V by turning VR7 on I/O Board without pressing any button.
Origin Sensor for Cross perforation	Turn VR1 fully in clockwise.
No subject	Turn VR14 fully in clockwise.

MANUAL CONTROL screen




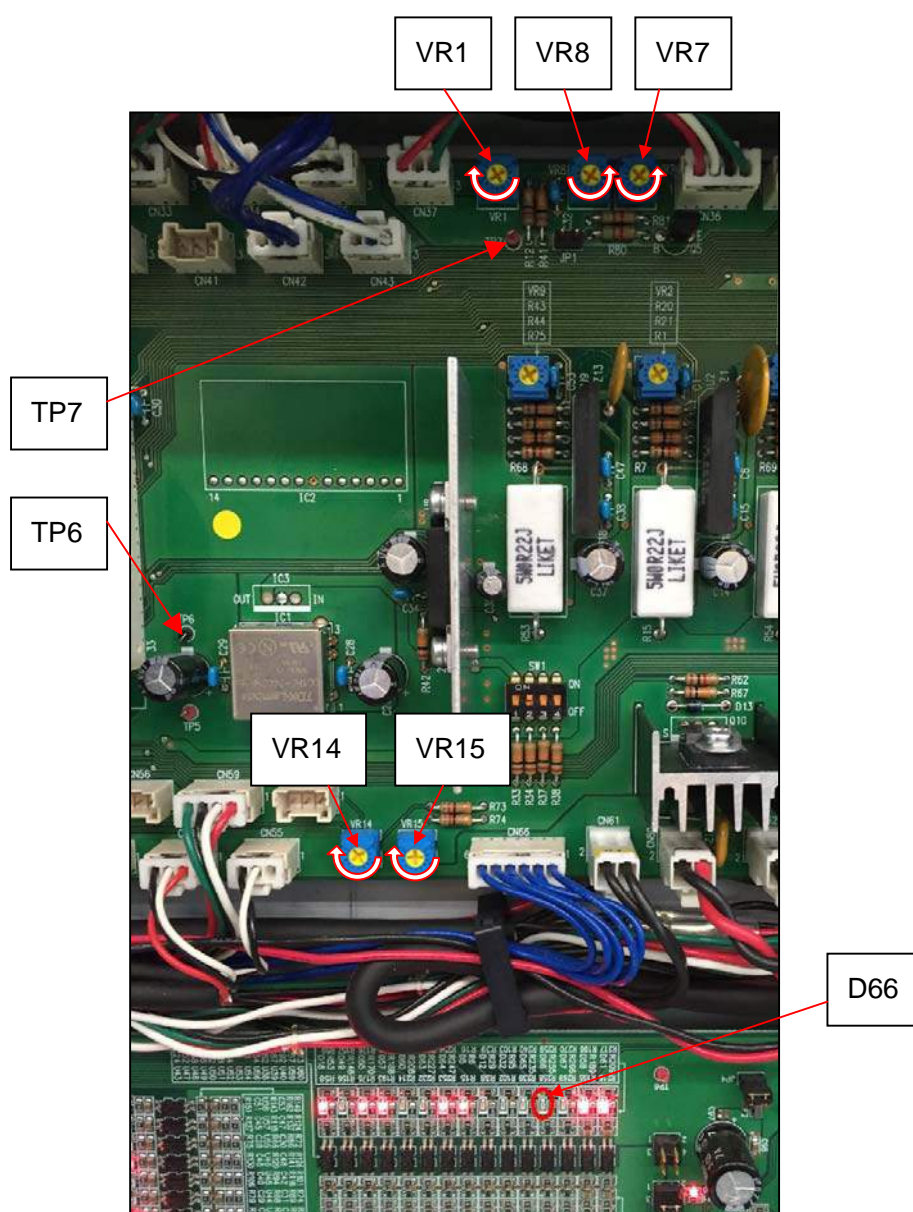
6- (4) PCB setting (AeroCut One/Velocit)

Subject	How to adjust
Origin Sensor	Turn VR3 fully in clockwise. ⚠
Stop Sensor	Turn VR4 on CPU Board in clockwise with paper (77gsm). When D20 on CPU board turns off, turn VR3 in clockwise for two division from this position. ⚠
Double Feed Sensor	Turn VR2 on CPU Board fully in anticlockwise. Adjust VR1 on CPU Board with paper (126gsm) so that Double feed detection counter on Manual Operation Screen shows approximately 500. After this procedure, ensure that Double feed detection shows more than 40 with paper (350gsm). If this value is less than 40, adjust volume so that it shows more than 40.



Double feed counter

Subject	How to adjust
Feed Sensor	Turn VR15 fully in clockwise. 
Pulse Motor Driver for Cross perforation	Not available on AeroCut One/Velocity. Turn VR7 and VR8 on I/O Board fully in anticlockwise.
Origin Sensor for Cross perforation	Not available on AeroCut One/Velocity. Turn VR1 fully in clockwise.
No subject	Turn VR14 fully in clockwise.



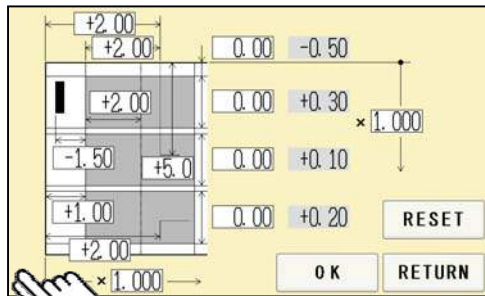
6- (5) Accuracy adjustment

(a) Length adjustment

- ① Regarding Length adjustment, refer to “5.5.2 If the cut measurement does not match the input value” in Operation Manual.
- ② Overwrite the initial setting value when you finished adjustment. .

AeroCut Prime

ADJUST screen



Double-Click



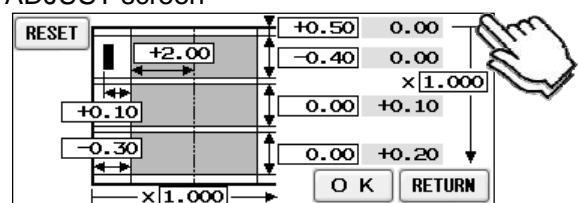
Enter the service password.



AeroCut One / Velocity

ADJUST screen

Double-Click

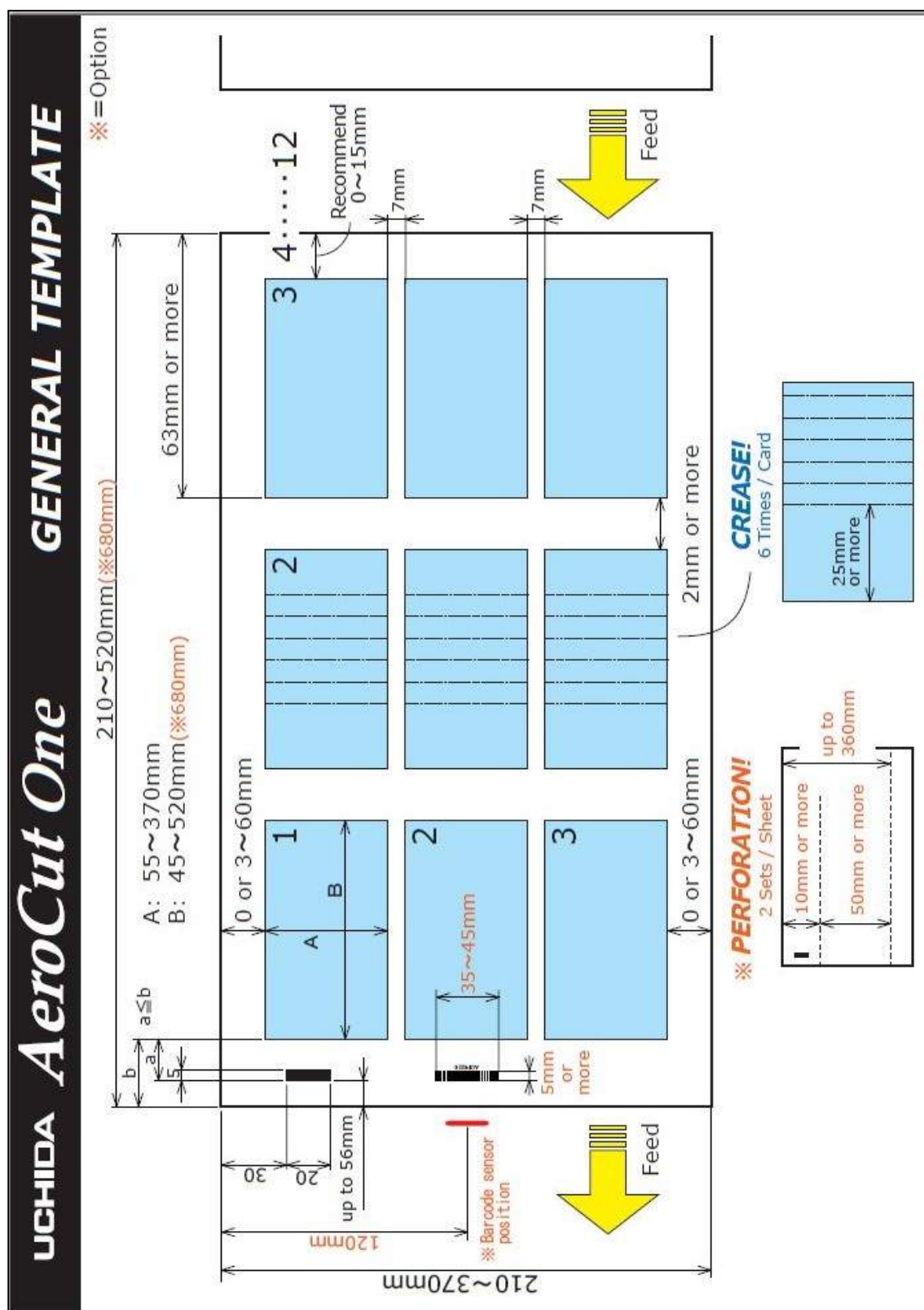


Enter the service password.

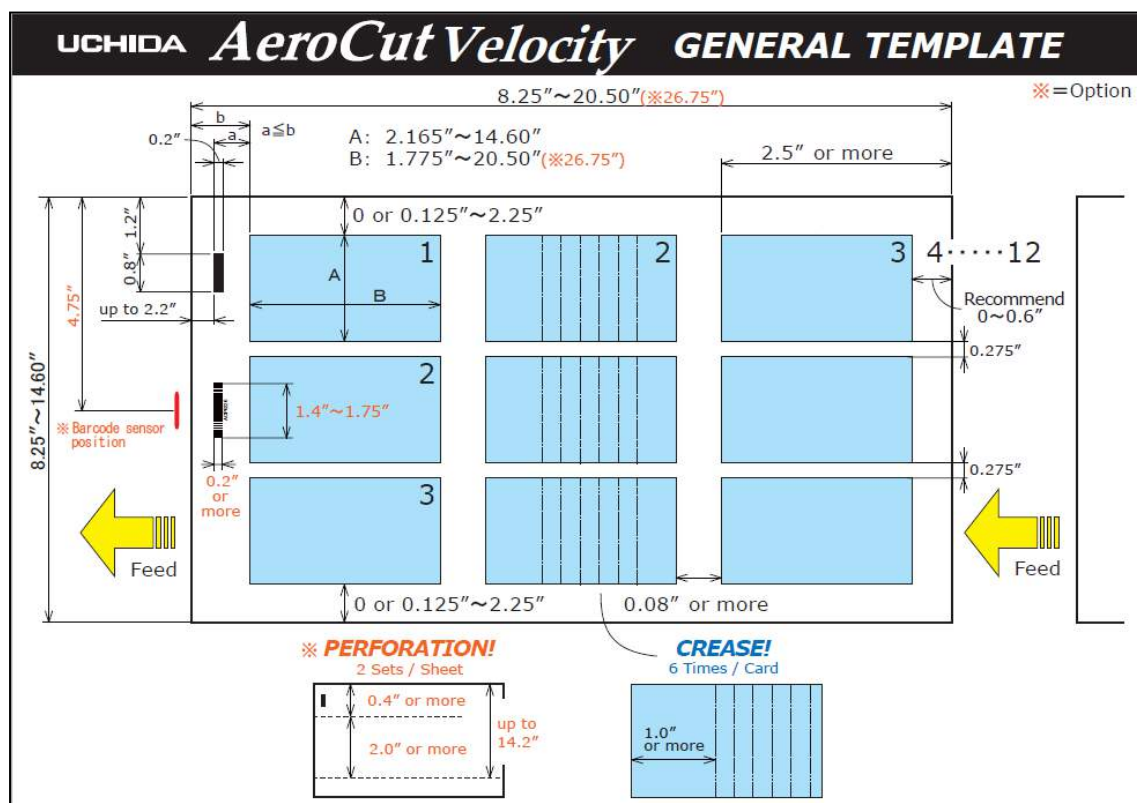
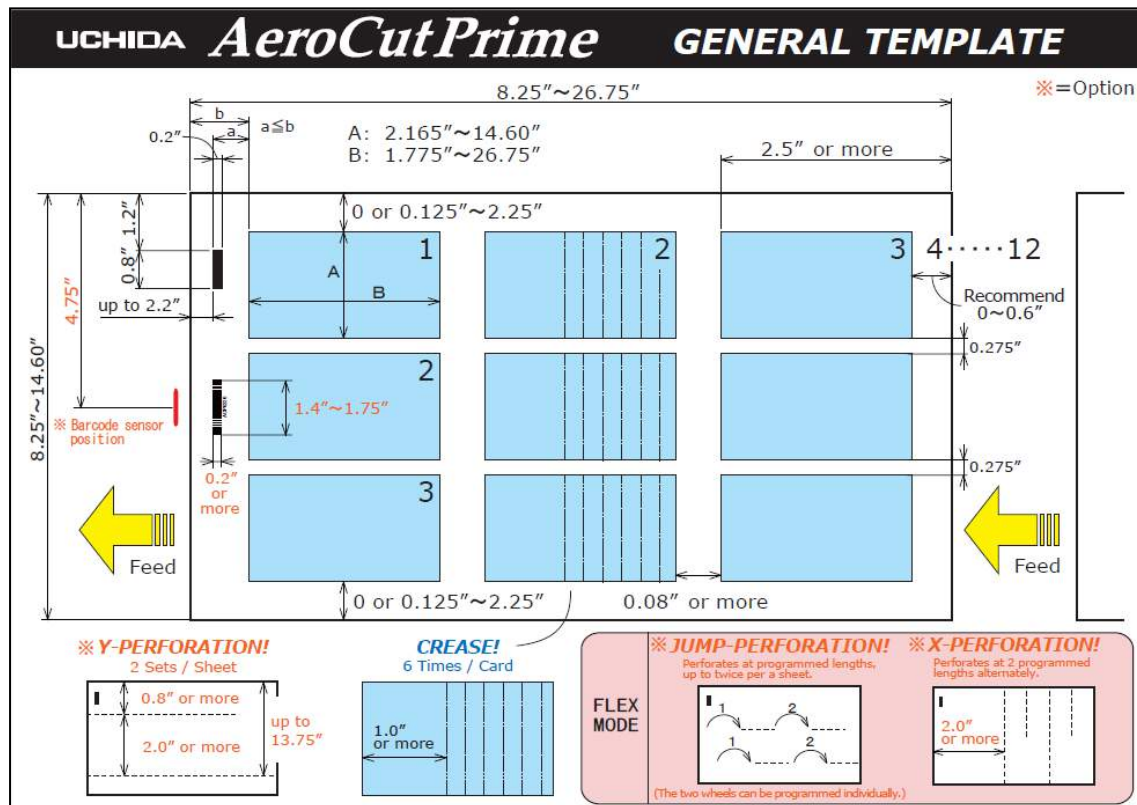


- ③ The values shown on the screen will be 0 after overwriting.
The $\times 1.000$ (length magnification) part will not become $\times 1.000$ by double-clicking the top-right corner (will not be stored internally).
- ④ If you prefer to reset values to factory settings, amend values shown on the Service Menu screen according to data which is attached inside of the front cover.
(☞ Page13)

7- (2) One general template



7- (3) General template(inch)



7- (4) How to use barcode

(a) Contents of Barcode

Type : CODE128

Detail : 7 digits as listed order below.

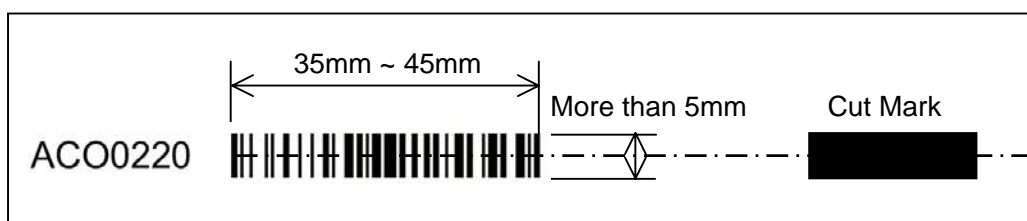
Machine	Aero	Cut	Prime or One	Machine No. 0~9 ※	3 digits MANUSET : 001~100 FLEXMODE : 101~150 PRESET※ : 200~552
Prime	A	C	P	0~9	001~552
One/Velocity			O		

※ : If PRESET job is selected, it is possible to run a job even if Machine No. is different.

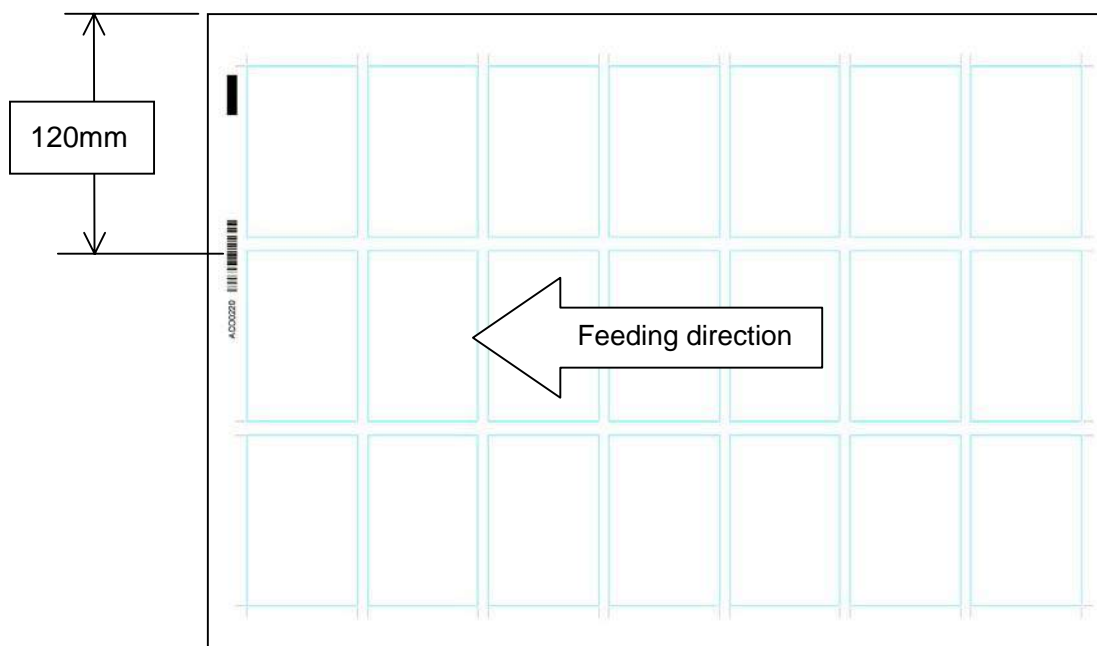
(b) How to print

Barcode should be printed at almost the same level of Cut Mark and its length must be more than 5mm.

The width of barcodes must be within a range of 35mm to 45mm.



The center of a barcode should be put on 120mm from the further paper edge.



(c) How to set Machine No.

Double tap on bottom left corner of MANUAL/SPEED screen.

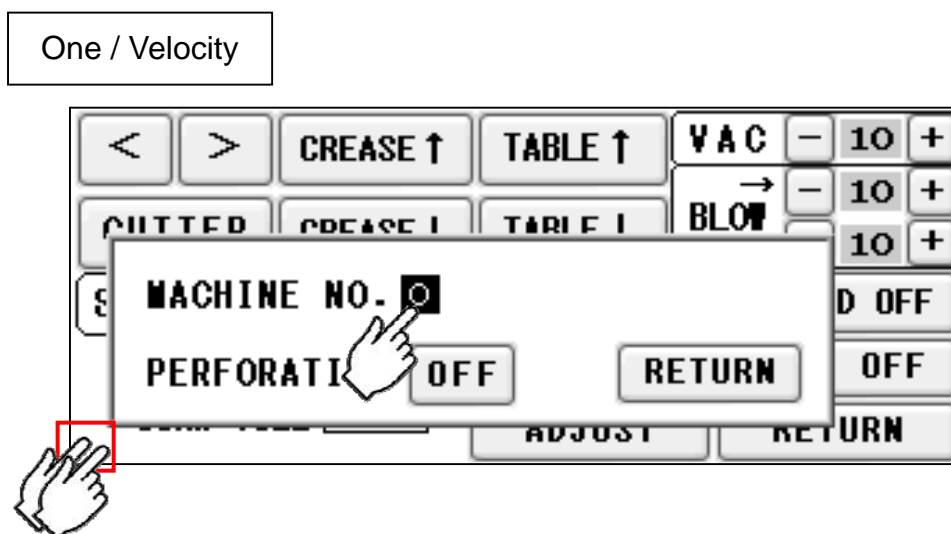
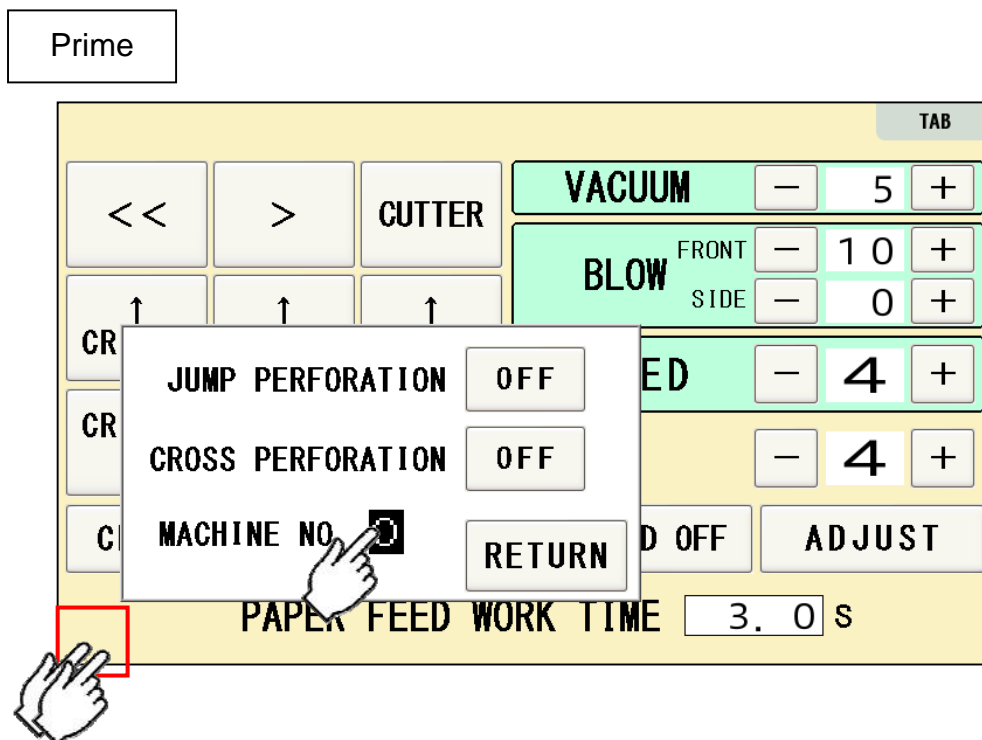
After a new window shows up, input a number from a range of 0 to 9 as the Machine No.

if a user has several machines and every machine has different data.

This number should be used to identify multiple machines.

If it is not necessary to identify, it does not matter if this Machine No. is same.

Factory setting is 0.



(d) Barcode with USERDATA

Barcode is used to call up USERDATA from memory.

Therefore, in case USERDATA is not pre-programmed in memory, it is impossible to call up data and operate.

Note that if there is a difference between USERDATA and the actual contents of printed materials, printed materials will not be finished correctly.

Using barcode without Plug-in Software

- ① Create a job program by MANUSET or FLEXMODE, and memorize it as USERDATA.
(Refer to Operation Manual 3.5 SAVE / READ)
- ② Refer to USERDATA No. (3 digits) and create 7 digits Barcode.(Ex: If USERDATA No. is 10, machine is Prime and Machine number is 0, Barcode should be ACP0010.)
- ③ According to the section 1. Detail of Barcode, put the barcode on an artwork and print.
- ④ Set the prints and select **Barcode Job Check** or **Barcode Job Change** on the screen.
Then press the **START**.

Using barcode with Plug-in Software

- ① After starting Illustrator or InDesign, create job program by Plug-in and save it into AeroCut. (Refer to Operation Manual of Plug-in (2)-(d)-③)
- ② Tick Barcode and press OK. Then barcode is generated and put on the artboard automatically.
- ③ Print the artwork.
- ④ Set the prints and select **Barcode Job Check** or **Barcode Job Change** on the screen.
Then press the **START**.

(e) PRESET Job Number list

Metric			
350x500		SRA3	
NO.	Description	NO.	Description
200	BUSINESS CARD 55x85	220	BUSINESS CARD 55x85
201	BUSINESS CARD 50x85	221	BUSINESS CARD 50x85
202	BUSINESS CARD 55x90	222	BUSINESS CARD 55x90
203	BUSINESS CARD 50x90	223	BUSINESS CARD 50x90
204	PHOTO L 88.9x127	224	PHOTO L 88.9x127
205	PHOTO 2L 127x178	225	PHOTO 2L 127x178
206	SRA3 320x450	226	SRA3_DIV 3
207	A3 297x420	227	SRA3_DIV 4
208	A4 210x297	228	A3 297x420
209	A5 148x210	229	A4 210x297
210	A6 105x148	230	A5 148x210
211	CD JACKET 120x120	231	A6 105x148
212	CD JACKET 120x240	232	CD JACKET 120x120
213	CREASE 250	233	CREASE 225
216	A4 210x297 PERFO 148.5	234	A4 210x297 PERFO 148.5
A3		A4(landscape)	
NO.	Description	NO.	Description
240	BUSINESS CARD 55x85	260	BUSINESS CARD 55x85
241	BUSINESS CARD 50x85	261	BUSINESS CARD 50x85
242	BUSINESS CARD 55x90	262	BUSINESS CARD 55x90
243	BUSINESS CARD 50x90	263	BUSINESS CARD 50x90
244	PHOTO L 88.9x127	264	PHOTO L 88.9x127
245	PHOTO 2L 127x178	265	PHOTO 2L 127x178
246	A3_DIV 3	266	A4_DIV 3
247	A3_DIV 4	267	A4_DIV 4
248	A4 210x297	268	A5 148x210
249	A5 148x210	269	A6 105x148
250	A6 105x148	270	CD JACKET 120x120
251	CD JACKET 120x120	271	CREASE 148.5
252	55x170 CREASE 85	272	CD JACKET 120x240
253	55x180 CREASE 90	273	55x170 PERFORATE 55
254	CREASE 210	274	50x170 PERFORATE 55
255	A4 210x297 PERFO 148.5	275	55x180 PERFORATE 55
		276	50x180 PERFORATE 55

Metric			
A4 (portrait)		SUPER B	
NO.	Description	NO.	Description
280	BUSINESS CARD 55x85	440	BUSINESS CARD 55x85
281	BUSINESS CARD 50x85	441	BUSINESS CARD 50x85
282	BUSINESS CARD 55x90	442	BUSINESS CARD 55x90
283	BUSINESS CARD 50x90	443	BUSINESS CARD 50x90
284	PHOTO L 88.9x127	444	PHOTO L 88.9x127
285	PHOTO 2L 127x178	445	PHOTO 2L 127x178
286	A6 105x148	446	SRA3 320x450
287	CD JACKET 120x120	447	A3 297x420
288	55x170 CREASE 85	448	A4 210x297
289	55x180 CREASE 90	449	A5 148x210
290	A4 210x297 PERFO 148.5	450	A6 105x148
291	55x180 PERFORATE 55	451	LEGAL 215.9x355.6
292	50x180 PERFORATE 55	452	LETTER 215.9x279.4
		453	CD JACKET 120x120
		454	CREASE 241.3
		455	A4 210x297 PERFO 148.5
LEDGER		LEGAL	
NO.	Description	NO.	Description
460	BUSINESS CARD 55x85	480	BUSINESS CARD 55x85
461	BUSINESS CARD 50x85	481	BUSINESS CARD 50x85
462	BUSINESS CARD 55x90	482	BUSINESS CARD 55x90
463	BUSINESS CARD 50x90	483	BUSINESS CARD 50x90
464	PHOTO L 88.9x127	484	PHOTO L 88.9x127
465	PHOTO 2L 127x178	485	PHOTO 2L 127x178
466	LETTER 215.9x279.4	486	LEGAL_DIV 2
467	LEDGER_DIV 3	487	LEGAL_DIV 3
468	LEDGER_DIV 4	488	LEGAL_DIV 4
469	LEGAL 215.9x355.6	489	LETTER 215.9x279.4
470	CD JACKET 120x120	490	CD JACKET 120x120
471	CREASE 215.9	491	CD JACKET 120x240
472	55x170 CREASE 85	492	CREASE 177.8
473	55x180 CREASE 90	493	55x170 PERFORATE 55
474	55x170 PERFORATE 55	494	50x170 PERFORATE 55
475	50x170 PERFORATE 55	495	55x180 PERFORATE 55
476	55x180 PERFORATE 55	496	50x180 PERFORATE 55
477	50x180 PERFORATE 55		

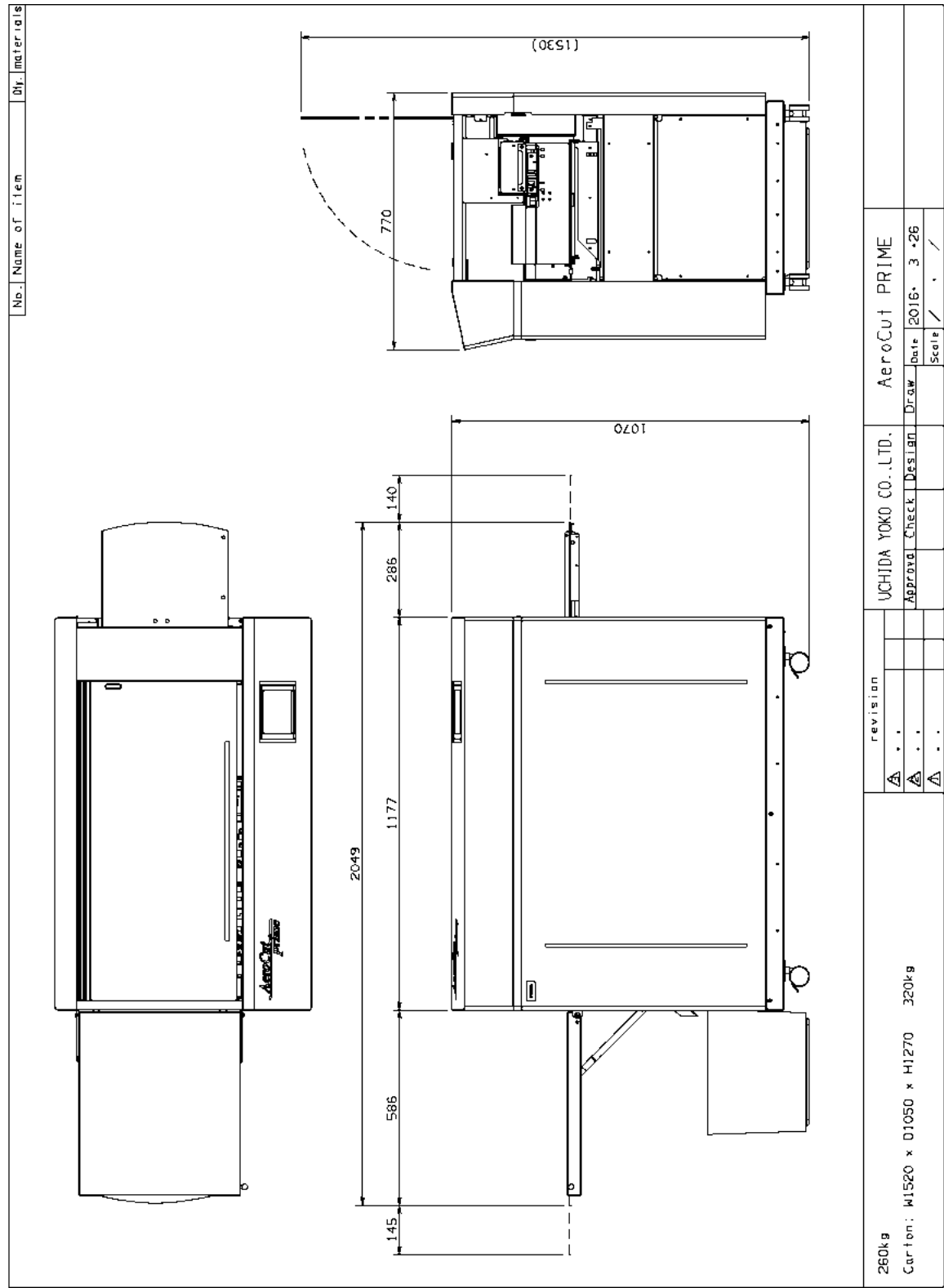
Metric			
OFICIO		LETTER (landscape)	
NO.	Description	NO.	Description
500	BUSINESS CARD 55x85	520	BUSINESS CARD 55x85
501	BUSINESS CARD 50x85	521	BUSINESS CARD 50x85
502	BUSINESS CARD 55x90	522	BUSINESS CARD 55x90
503	BUSINESS CARD 50x90	523	BUSINESS CARD 50x90
504	PHOTO L 88.9x127	524	PHOTO L 88.9x127
505	PHOTO 2L 127x178	525	PHOTO 2L 127x178
506	OFICIO_DIV 2	526	LETTER_DIV 2
507	OFICIO_DIV 3	527	LETTER_DIV 3
508	OFICIO_DIV 4	528	LETTER_DIV 4
509	LETTER 215.9x279.4	529	CD JACKET 120x120
510	CD JACKET 120x120	530	CD JACKET 120x240
511	CD JACKET 120x240	531	CREASE 139.7
512	CREASE 165.1	532	55x170 PERFORATE 55
513	55x170 PERFORATE 55	533	50x170 PERFORATE 55
514	50x170 PERFORATE 55	534	55x180 PERFORATE 55
515	55x180 PERFORATE 55	535	50x180 PERFORATE 55
516	50x180 PERFORATE 55		
LETTER (portrait)			
NO.	Description		
540	BUSINESS CARD 55x85		
541	BUSINESS CARD 50x85		
542	BUSINESS CARD 55x90		
543	BUSINESS CARD 50x90		
544	PHOTO L 88.9x127		
545	PHOTO 2L 127x178		
546	CD JACKET 120x120		
547	55x170 CREASE 85		
548	55x180 CREASE 90		
549	55x170 PERFORATE 55		
550	50x170 PERFORATE 55		
551	55x180 PERFORATE 55		
552	50x180 PERFORATE 55		

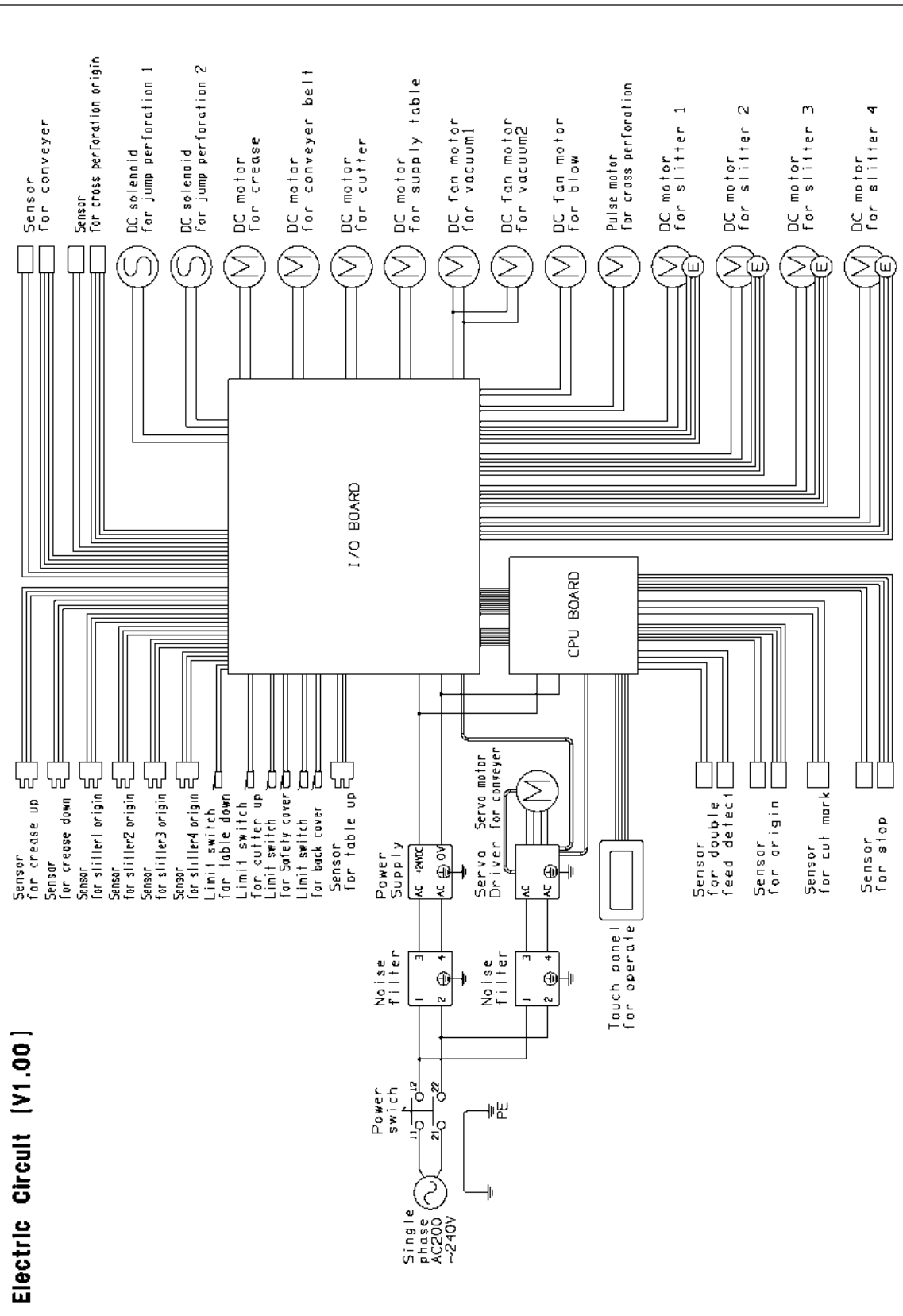
Inch			
SUPER B		ARCH-B	
NO.	Description	NO.	Description
320	BUSINESS CARD 2"x3.5"S	340	BUSINESS CARD 2"x3.5"S
321	BUSINESS CARD 2"x3.5"D	341	BUSINESS CARD 2"x3.5"D
322	BUSINESS CARD 3.5"x4"	342	BUSINESS CARD 3.5"x4"
323	PHOTO L 3.5"x5.0"	343	PHOTO L 3.5"x5.0"
324	PHOTO 2L 5.0"x7.0"	344	PHOTO 2L 5.0"x7.0"
325	POST CARD 3.0"x5.0"	345	ARCH-B_DIV 2
326	POST CARD 3.5"x5.5"	346	ARCH-B_DIV 3
327	POST CARD 4.0"x6.0"	347	ARCH-B_DIV 4
328	POST CARD 8.0"x10.0"	348	POST CARD 3.0"x5.0"
329	LEGAL 8.5"x14.0"	349	POST CARD 3.5"x5.5"
330	LETTER 8.5"x11.0"	350	POST CARD 4.0"x6.0"
331	LABEL 4.25"x5.0"	351	POST CARD 8.0"x10.0"
332	CD JACKET 4.7"x4.7"	352	LEGAL 8.5"x14.0"
333	CD JACKET 4.7"x9.44"	353	LETTER 8.5"x11.0"
		354	LABEL 4.25"x5.0"
		355	CD JACKET 4.7"x4.7"
		356	CD JACKET 4.7"x9.44"
LEDGER		LEGAL	
NO.	Description	NO.	Description
360	BUSINESS CARD 2"x3.5"S	380	BUSINESS CARD 2"x3.5"S
361	BUSINESS CARD 2"x3.5"D	381	BUSINESS CARD 2"x3.5"D
362	BUSINESS CARD 3.5"x4"	382	BUSINESS CARD 3.5"x4"
363	PHOTO L 3.5"x5.0"	383	PHOTO L 3.5"x5.0"
364	PHOTO 2L 5.0"x7.0"	384	PHOTO 2L 5.0"x7.0"
365	LETTER 8.5"x11.0"	385	LEGAL_DIV 2
366	LEDGER_DIV 3	386	LEGAL_DIV 3
367	LEDGER_DIV 4	387	LEGAL_DIV 4
368	POST CARD 3.0"x5.0"	388	POST CARD 3.0"x5.0"
369	POST CARD 3.5"x5.5"	389	POST CARD 3.5"x5.5"
370	POST CARD 4.0"x6.0"	391	POST CARD 8.0"x10.0"
371	POST CARD 8.0"x10.0"	392	LETTER 8.5"x11.0"
372	LEGAL 8.5"x14.0"	393	LABEL 4.25"x5.0"
373	LABEL 4.25"x5.0"	394	CD JACKET 4.7"x4.7"
374	CD JACKET 4.7"x4.7"	395	CD JACKET 4.7"x9.44"
375	CD JACKET 4.7"x9.44"		

Inch			
LETTER (landscape)		LETTER (portrait)	
NO.	Description	NO.	Description
400	BUSINESS CARD 2"x3.5"S	420	BUSINESS CARD 2"x3.5"S
401	BUSINESS CARD 2"x3.5"D	421	BUSINESS CARD 2"x3.5"D
402	BUSINESS CARD 3.5"x4"	422	BUSINESS CARD 3.5"x4"
403	PHOTO L 3.5"x5.0"	423	PHOTO L 3.5"x5.0"
404	PHOTO 2L 5.0"x7.0"	424	PHOTO 2L 5.0"x7.0"
405	LETTER_DIV 2	425	POST CARD 3.0"x5.0"
406	LETTER_DIV 3	426	POST CARD 3.5"x5.5"
407	LETTER_DIV 4	427	POST CARD 4.0"x6.0"
408	POST CARD 3.0"x5.0"	428	POST CARD 8.0"x10.0"
409	POST CARD 3.5"x5.5"	429	LABEL 4.25"x5.0"
410	POST CARD 4.0"x6.0"	430	CD JACKET 4.7"x4.7"
411	POST CARD 8.0"x10.0"		
412	LABEL 4.25"x5.0"		
413	CD JACKET 4.7"x4.7"		
414	CD JACKET 4.7"x9.44"		

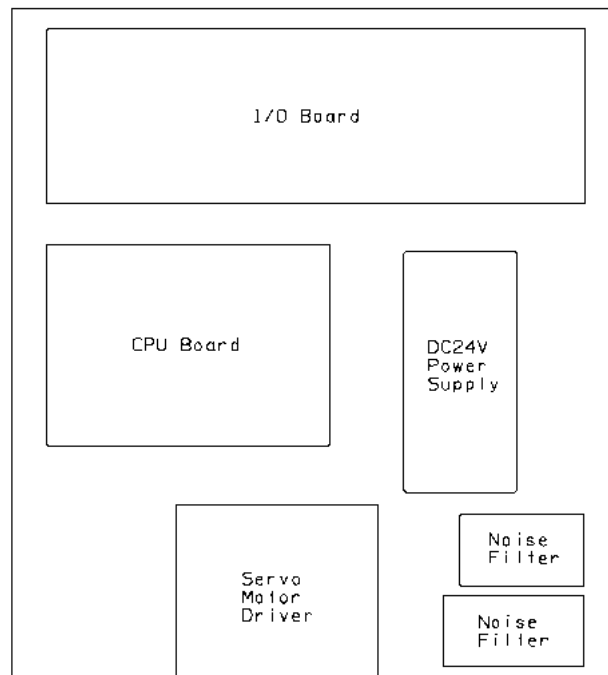
8. Electricity related

8- (1) Equipment, Electric circuit, and parts





Electric Parts



8- (2) Board Details

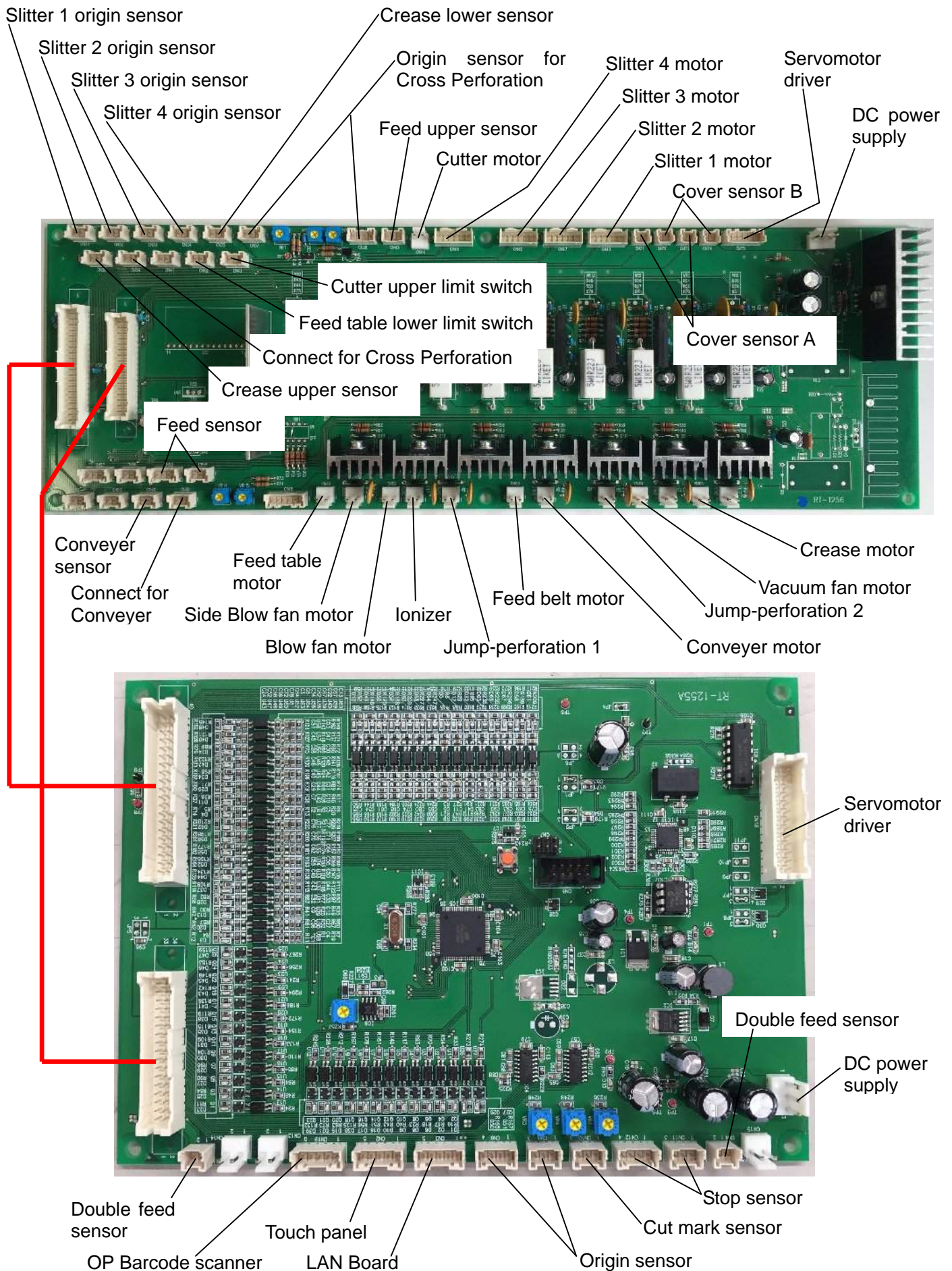
① CPU BOARD



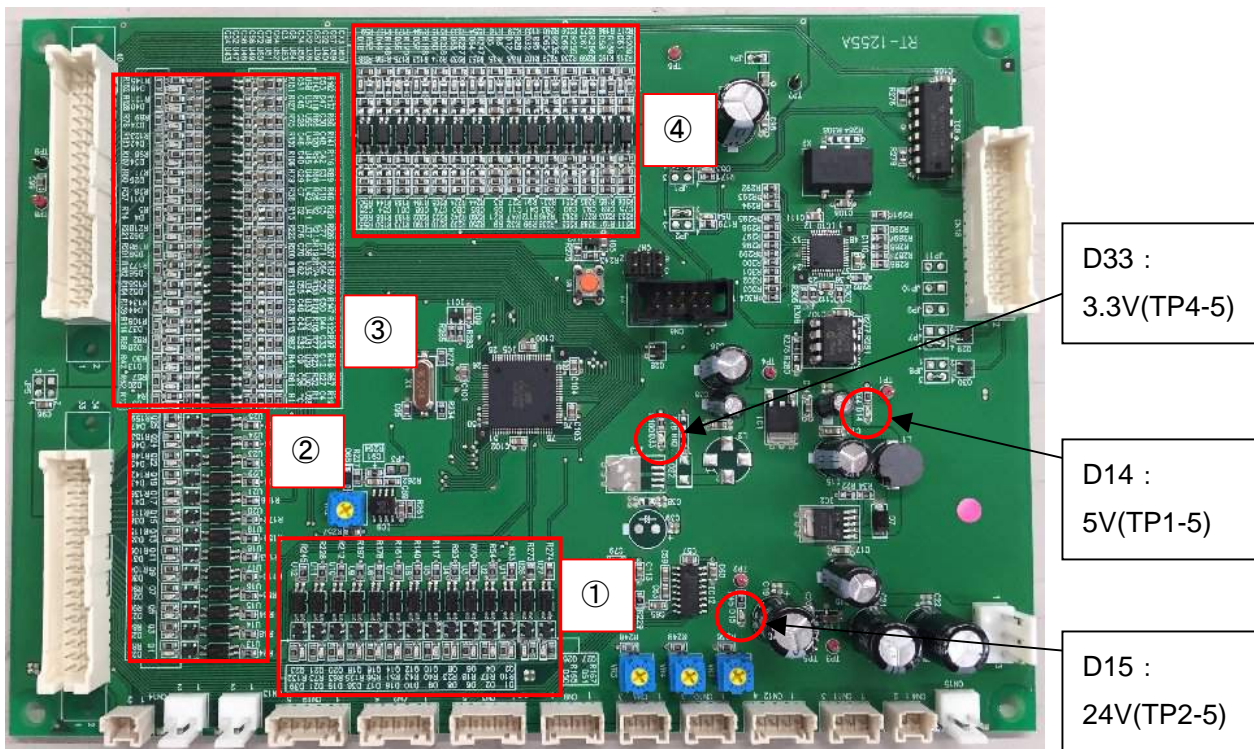
② I / O BOARD



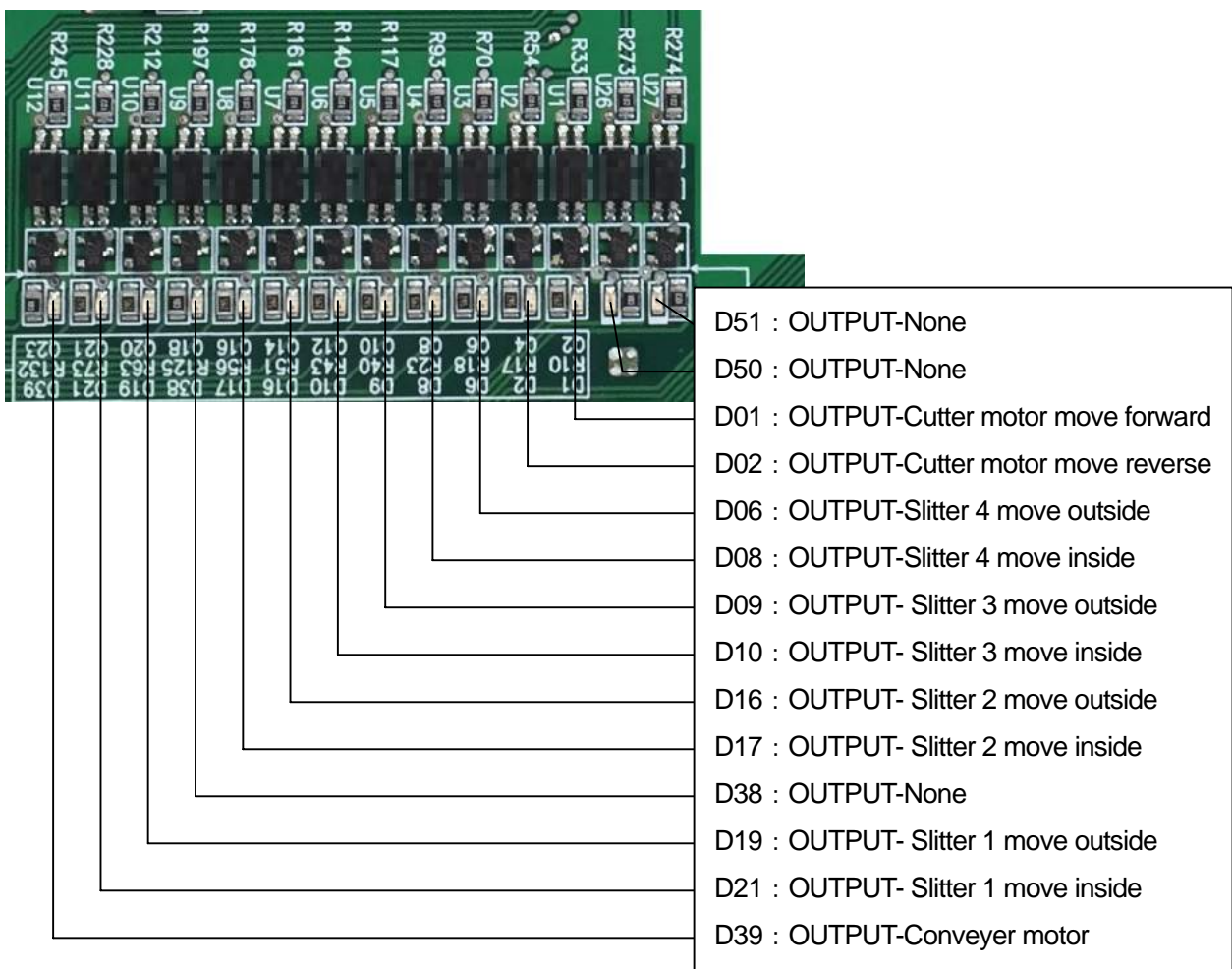
③ Wiring Details



8- (3) Input/Output LED Details



①LED on Lower Side



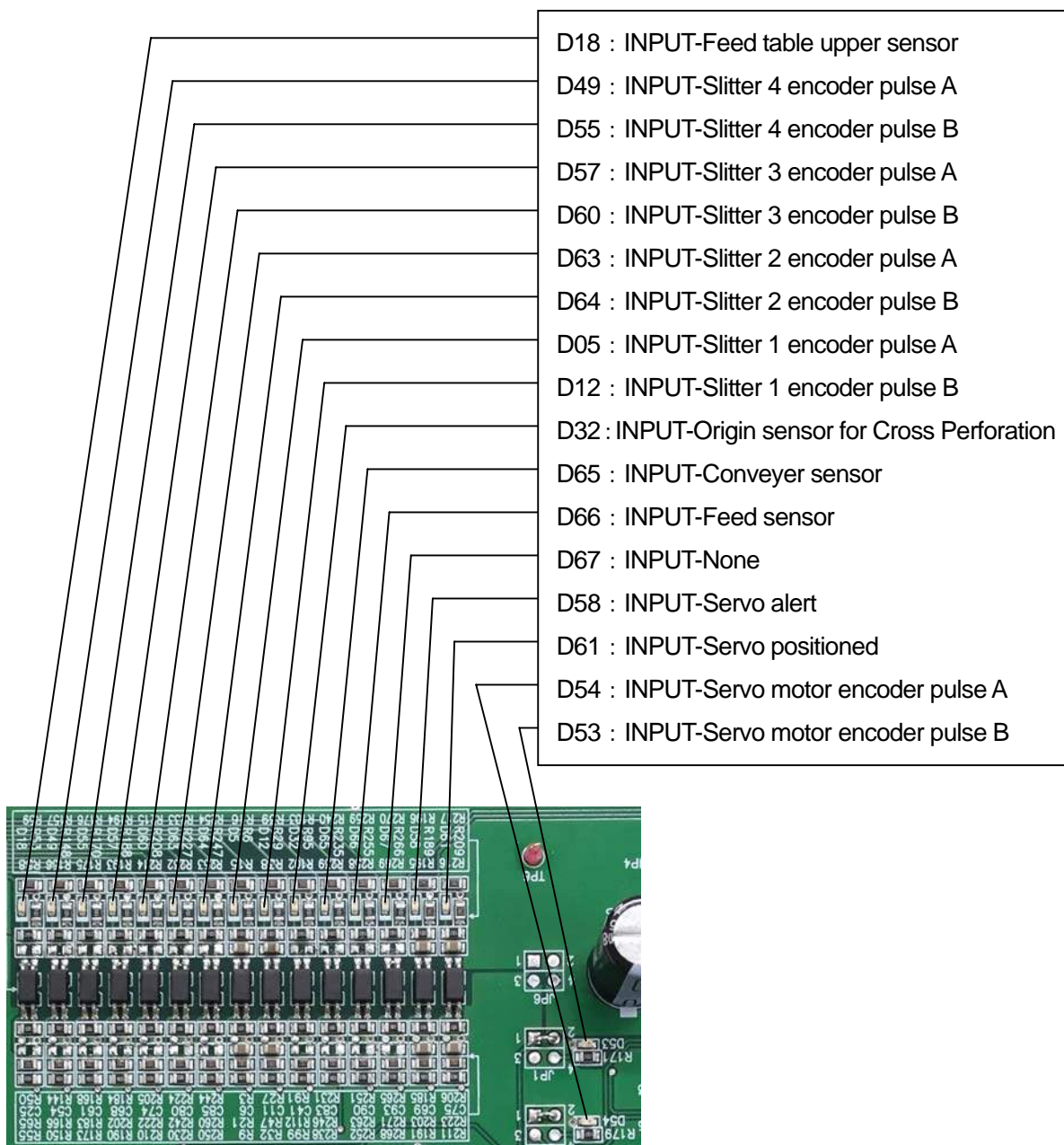
②LED on Left Lower Side

D47 : OUTPUT-Jump-perforation 1	
D46 : OUTPUT-Jump-perforation 2	
D45 : OUTPUT-None	
D43 : OUTPUT-Side Blow fan motor	
D41 : OUTPUT-Ionizer	
D36 : OUTPUT-Fed table move down	
D35 : OUTPUT-Fed table move up	
D31 : OUTPUT-Blow fan motor	
D30 : OUTPUT-Fed belt move forward	
D29 : OUTPUT-Fed belt move reverse	
D27 : OUTPUT-Vacuum fan motor	
D25 : OUTPUT-Crease motor move reverse	
D23 : OUTPUT-Crease motor move forward	

③LED on Left Upper Side

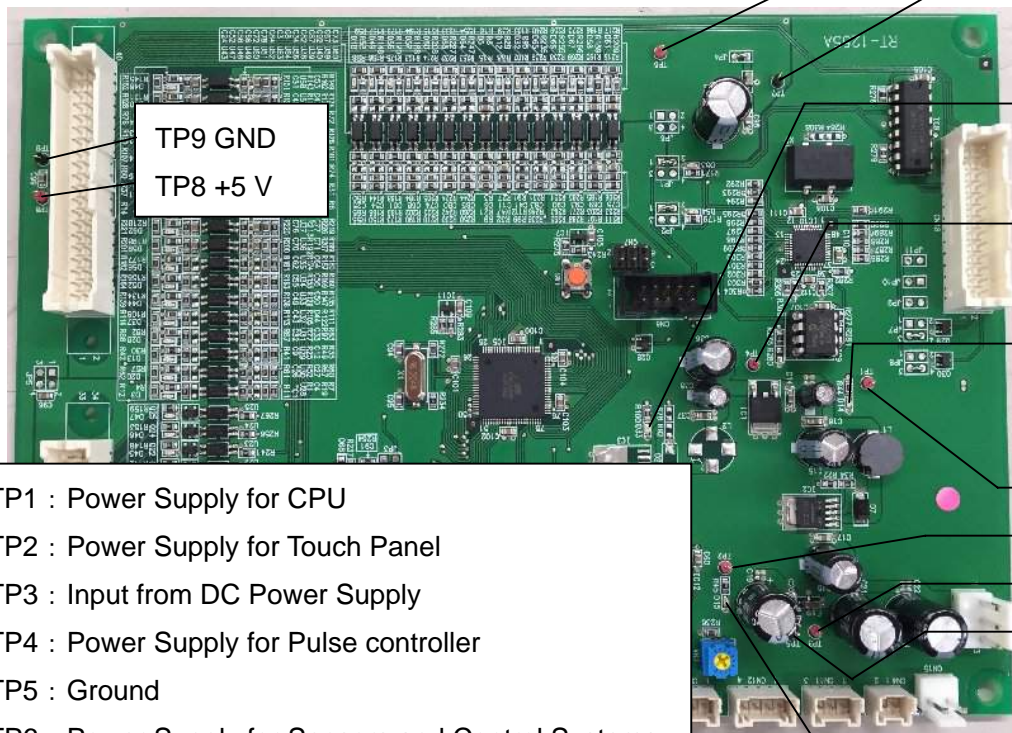
[illegible]

④LED on Upper Side



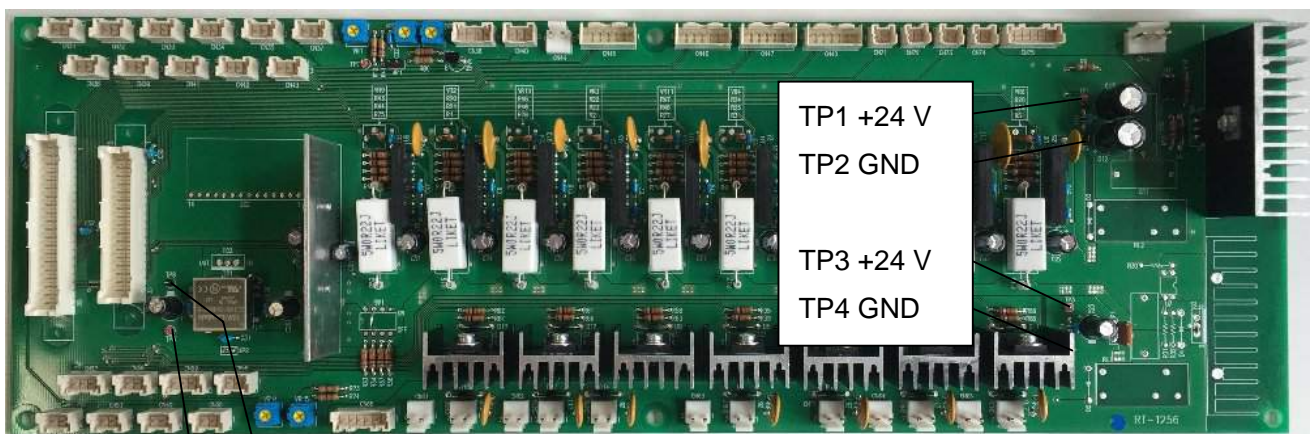
8- (4) Tap Voltage Details

CPU BOARD



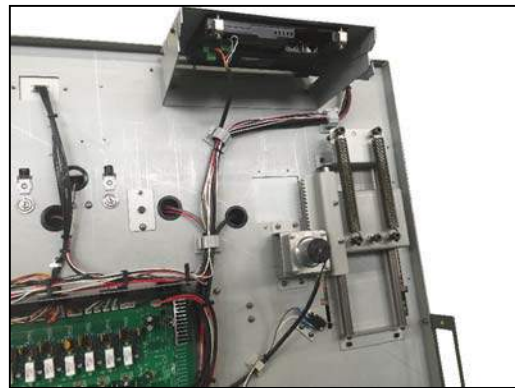
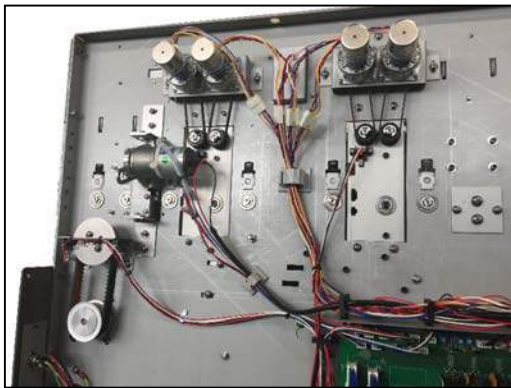
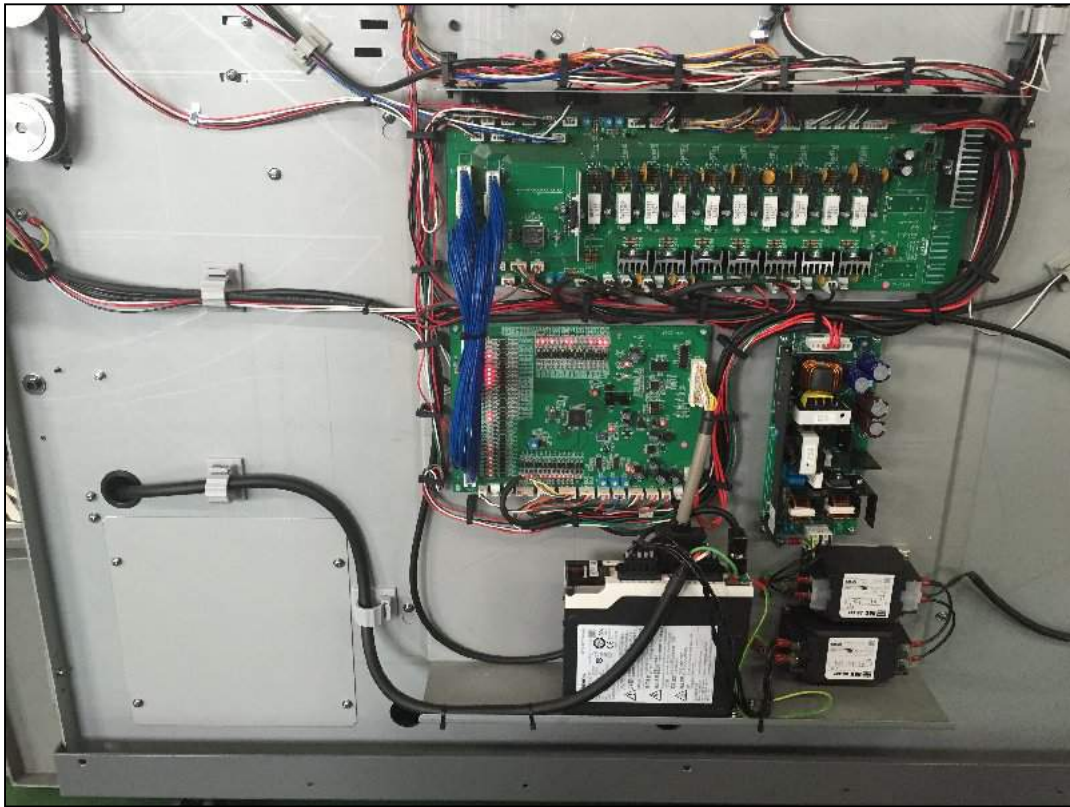
TP1 : Power Supply for CPU
 TP2 : Power Supply for Touch Panel
 TP3 : Input from DC Power Supply
 TP4 : Power Supply for Pulse controller
 TP5 : Ground
 TP6 : Power Supply for Sensors and Control Systems
 TP7 : Ground
 TP8 : Power Supply for Slitter encoders
 TP9 : Ground

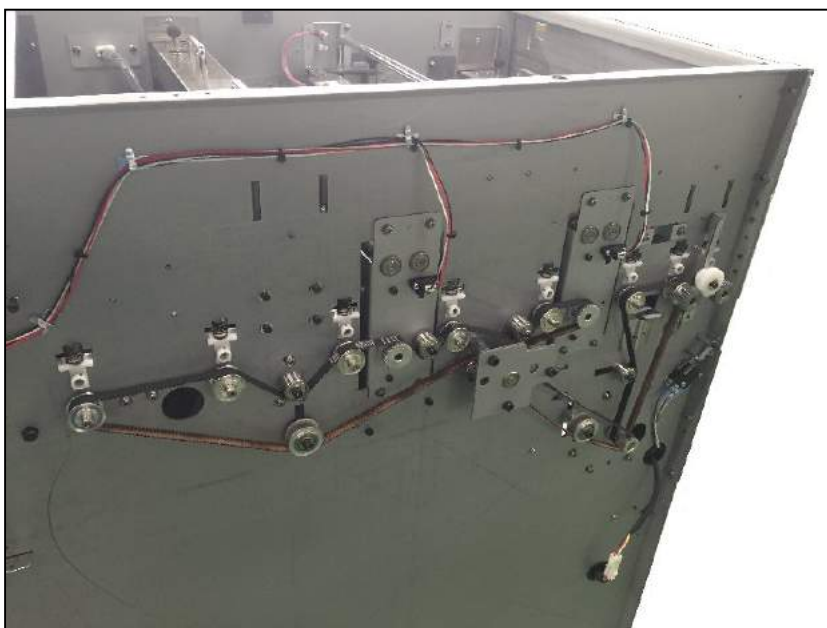
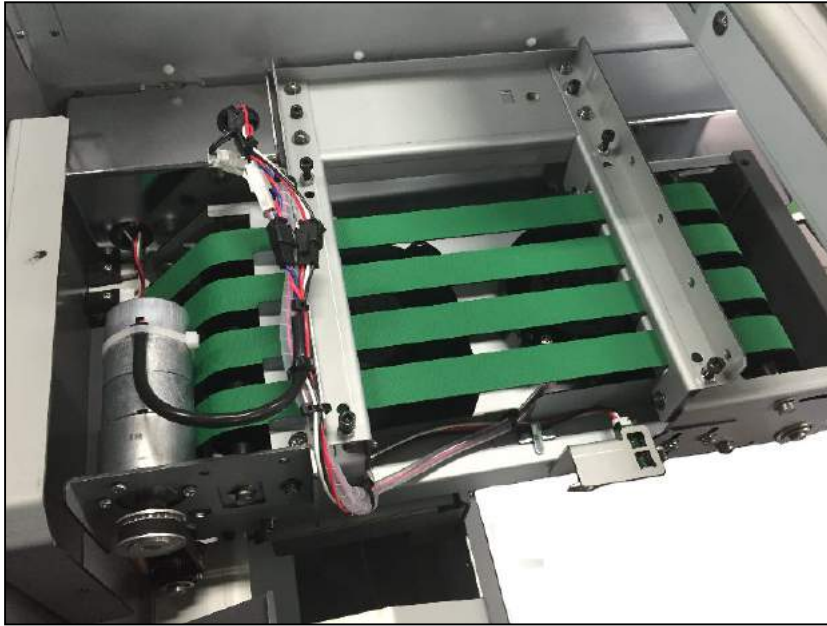
I/O BOARD



TP1 : Power Supply for Motors
 TP2 : Ground
 TP3 : Power Supply for Sensors and Control Systems
 TP4 : Ground
 TP5 : Power Supply for Slitter encoders
 TP6 : Ground

8- (5) Wiring Details





8- (6) Servo motor driver setting

- ① No need for setting after shipment as it will be set prior to shipment.
- ② However, special software is required to change the factory settings.
- ③ The software is available for download from the manufacturer's website, which is accessible via the following link. Download the Setup support software (PANATERM V5.0) along with the operating manual for the setup support software. Also download the "WHEN in trouble" manual.

http://industrial.panasonic.com/ww/e/25000/fa_pro_acs_e/fa_pro_acs_e/a5.html

The latest version of the software as of August 2011 is version 5.0.

- ④ Install the software according to the downloaded operating manual.
- ⑤ Connect the USB cable (A → mini B) to the connector X1 for the driver to also install the USB driver. For installation, refer to the downloaded operating manual.

A5 series

	Operating Manual (Overall)	[PDF: 10,457KB]	2011.4.18 UP
	Before Using the Products	[PDF: 1,601KB]	2011.4.18 UP
	Preparation	[PDF: 3,012KB]	2011.4.18 UP
	Connection	[PDF: 659KB]	2011.4.18 UP
	Setup	[PDF: 723KB]	2011.4.18 UP
	Adjustment	[PDF: 431KB]	2011.4.18 UP
	When in Trouble	[PDF: 319KB]	2011.4.18 UP
	Supplement	[PDF: 4,389KB]	2011.4.18 UP
	Operating Manual (Basic) A-frame to F-frame	[PDF: 2,577KB]	(2009.11) 2009.10.31 UP
	Operating Manual (Basic) G-frame and H-frame	[PDF: 2,077KB]	(2011.4) 2011.4.19 UP

A5N series

	Reference Specifications	[PDF: 3,255KB]	2011.6.17 UP
	Technical Reference - Functional Descriptions -	[PDF: 1,499KB]	2011.6.17 UP
	RTEX Partners Area		

▶ Setup Support Software (for MINAS A5-Family)

Download

+ 32bit version(Windows XP/Vista/7)
PANATERM Ver.5.0 (full service including NET Framework) [301MB] (for MINAS A5-Family) 2011.8.9 UP
PANATERM Ver.5.0 [69.7MB] (for MINAS A5-Family) 2011.8.9 UP
 * You need to download and install .NET Framework 3.5 SP1 separately.
 If version up, download this one because .NET Framework remains in PC.

+ 64bit version(Windows7)
PANATERM Ver.5.0 [70.0MB] (for MINAS A5-Family) 2011.8.9 UP

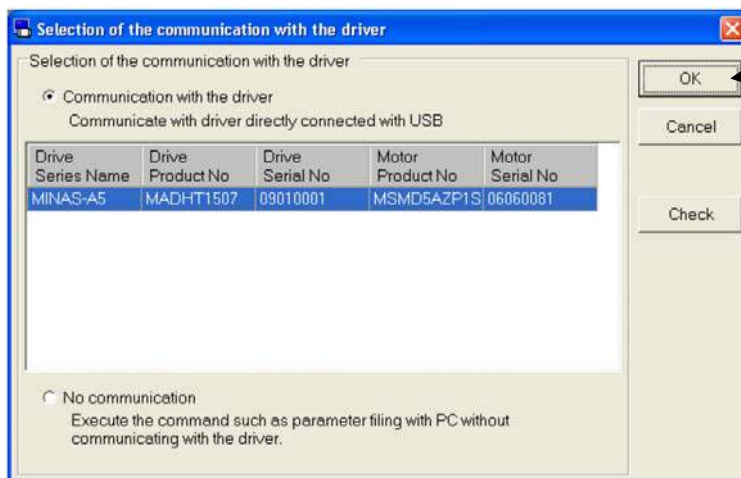
Note:
 If version up, it is necessary to uninstall the old PANATERM before installing new one. Even though 32bit PANATERM is uninstalled, .NET Framework is left in PC.

Operating Manual

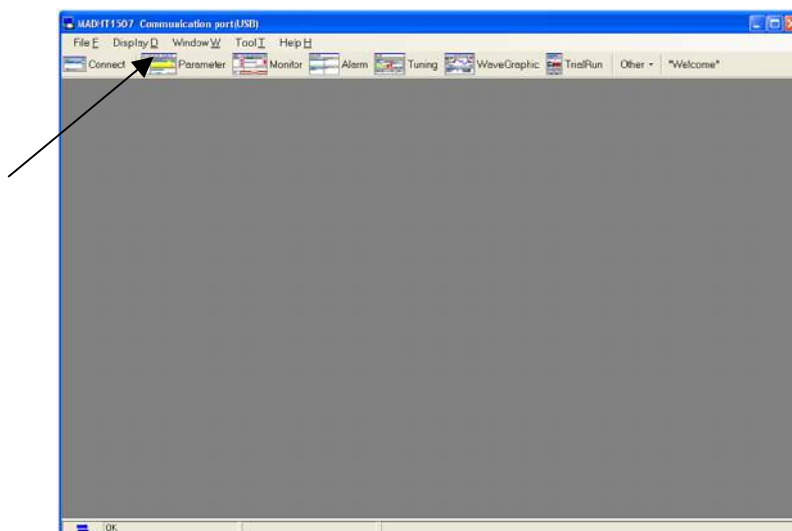
Operating Manual [2.34MB] 2011.8.9 UP

⑥ Start "PANATERM".

⑦ Click "OK".



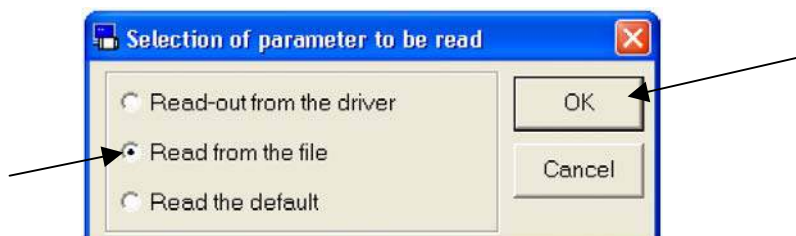
⑧ Click "PARAMETER" of the tool bar on the main screen.



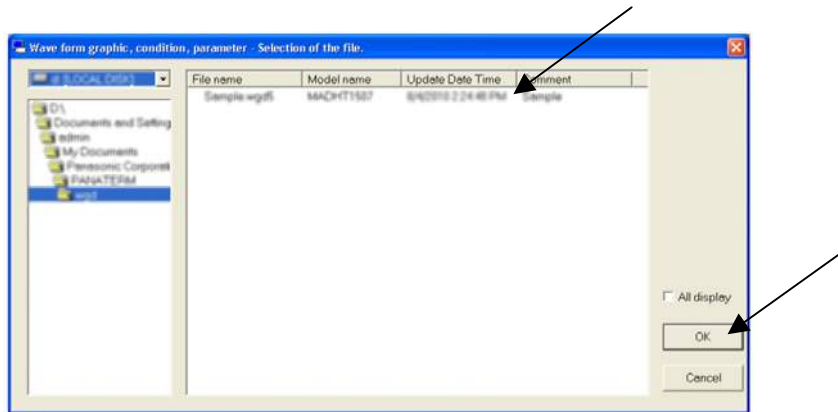
⑨ Selection of parameter to be read window is displayed.

⑩ Click "Read from the file".

⑪ Click "OK".

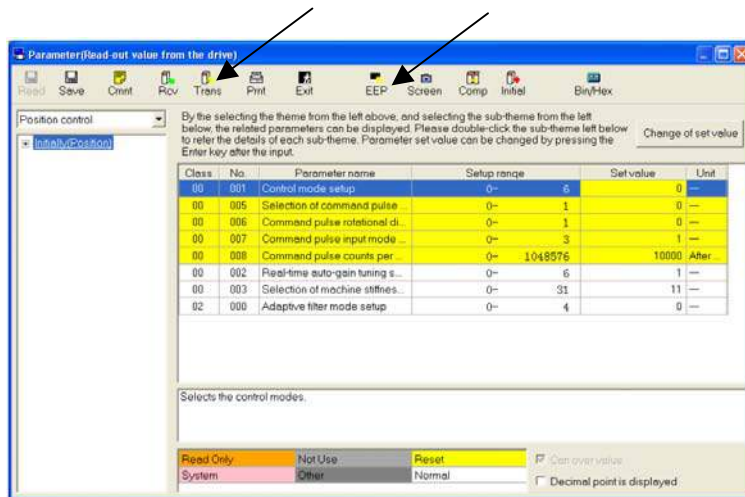


- ⑫ Of the data we provided, select a data file with a file extension of “.prm5,” and click “OK”.



- ⑬ Click “Trans”.

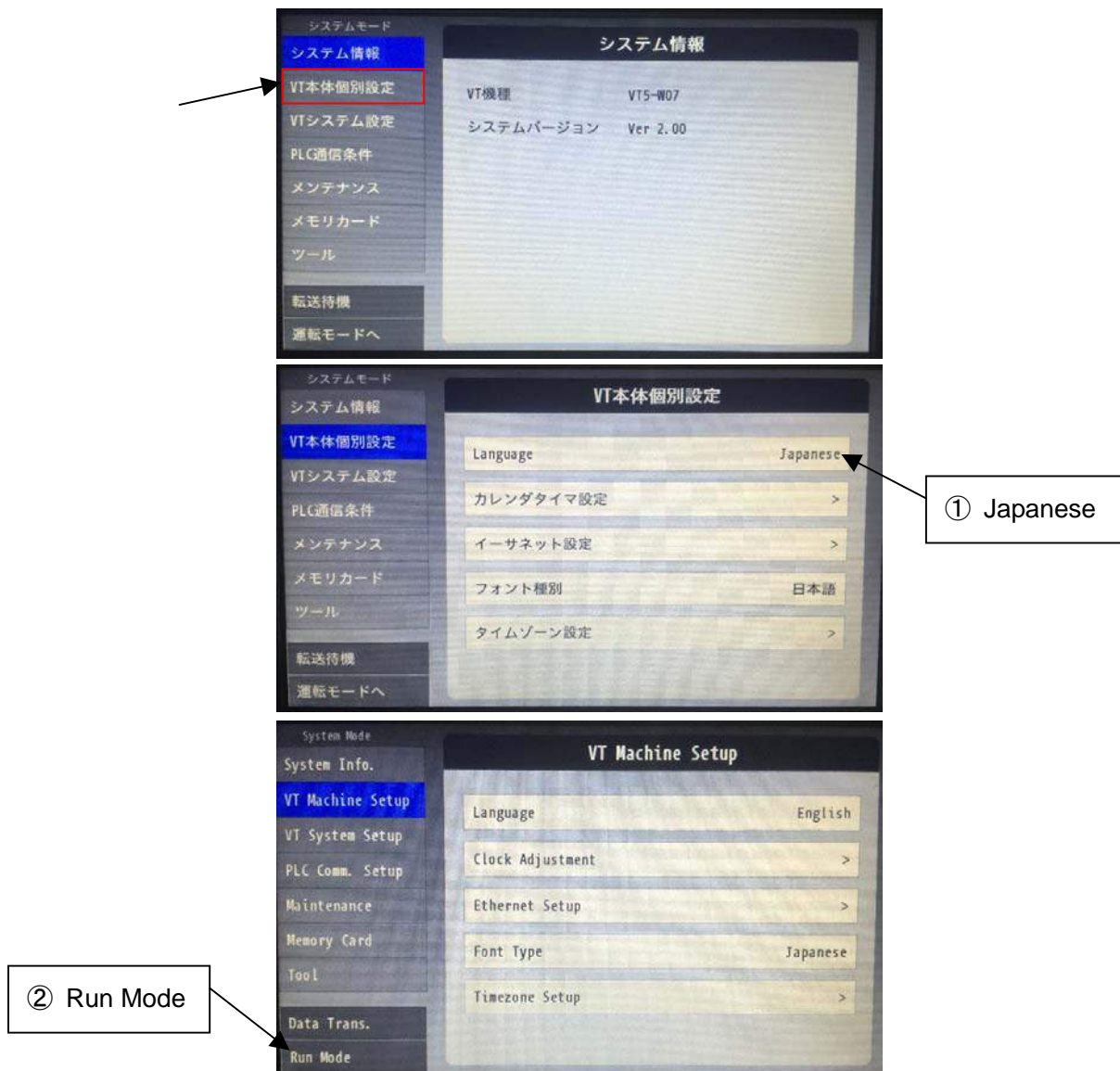
- ⑭ Click “EEP” after the transmission is completed to complete the entire process.



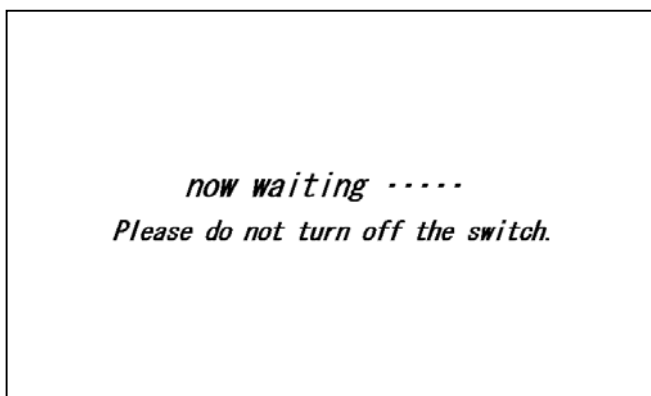
8- (7) Initial Setting of Touch Panel

(No setting is necessary after shipment, as it will be set prior to shipment)

- ① Turn on the power supply while pressing the top right corner of the touch panel. The following screen will appear when successful.



- ② After seeing that words on the screen, turn off the machine and turn it on again.



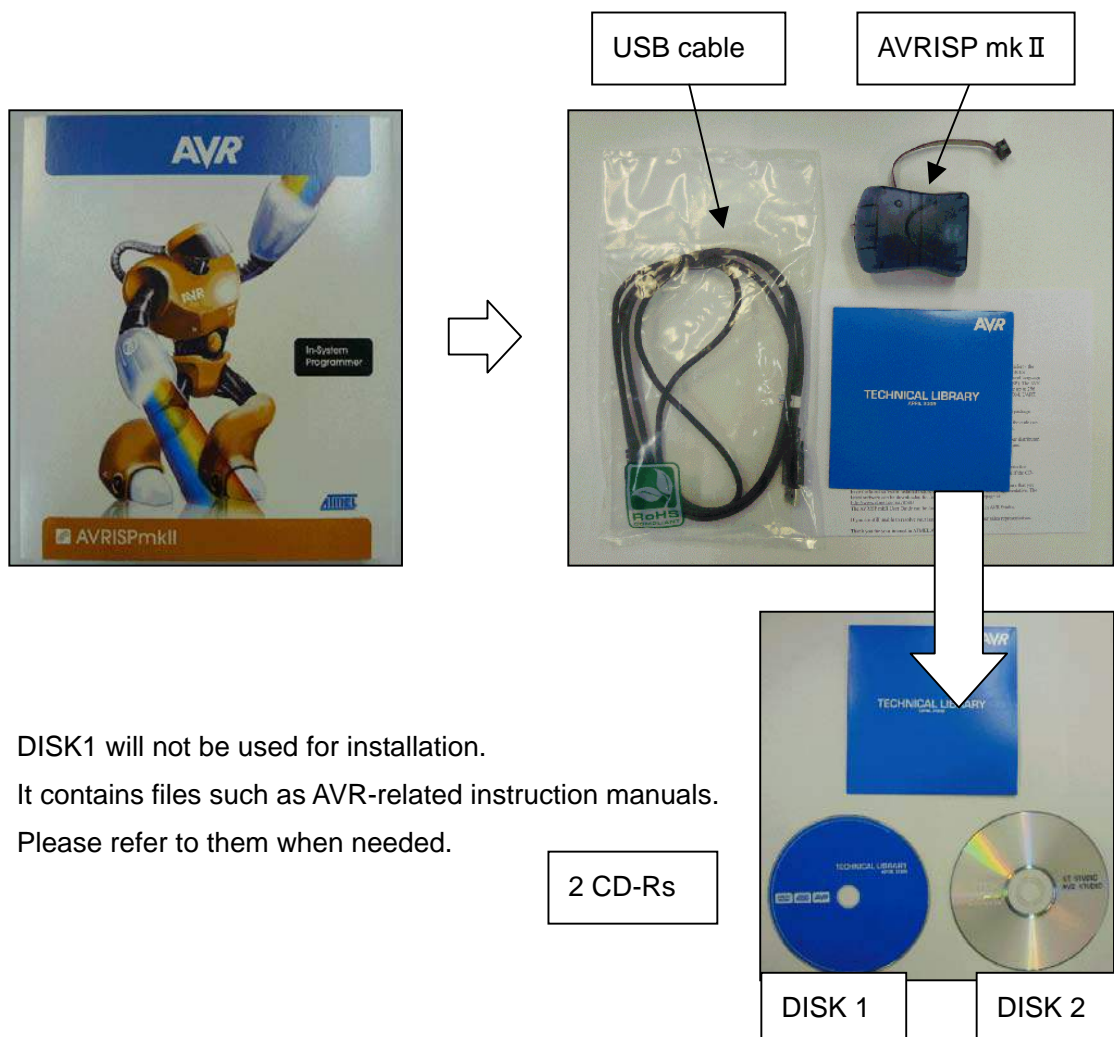
9. Program update

9- (1) Software install

(a) Requirements

	VT Transfer Tool		AVR STUDIO
	for AeroCut One	for AeroCut Prime	
Supported OS	Windows XP/VISTA/7/8		Windows XP/XP/VISTA/7
CPU	Pentium 800 MHz processor or equivalent		Pentium 200 MHz processor or equivalent
Memory	256 MB or more		256 MB or more
Hard disk space	50 MB or more	300 MB or more	100 MB or more
Display	1024 × 768 screen 16 bit high color or better		1024 × 768 screen (minimum 800 × 600 screen)
Interface	USB port		USB port

(b) Confirmation of Accessories

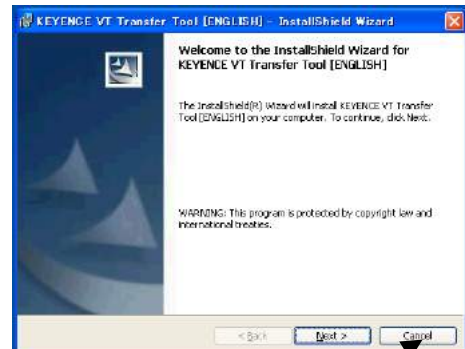
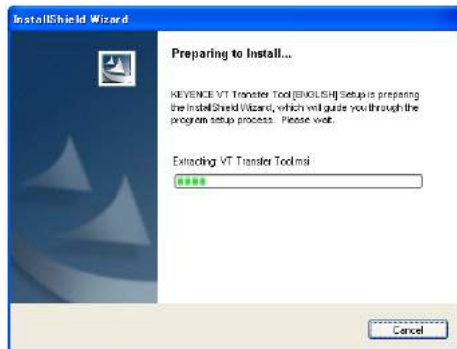


(c) How to install VT Transfer Tool for AeroCut One/Velocity

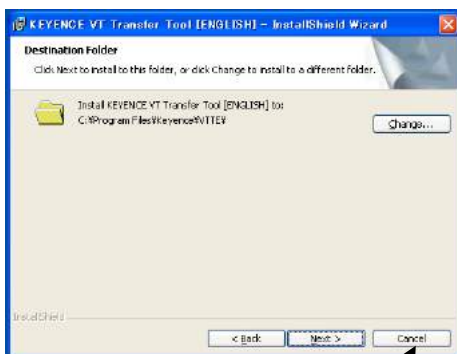
Insert DISK2 in the CD/DVD drive and install it according to the following procedure.

(The procedure below is for WINDOWS XP)

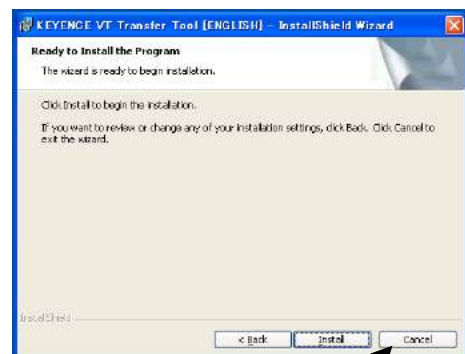
Double click on “VTTransferTool¥ One¥VTTEHp4?? .exe” of the CD/DVD.



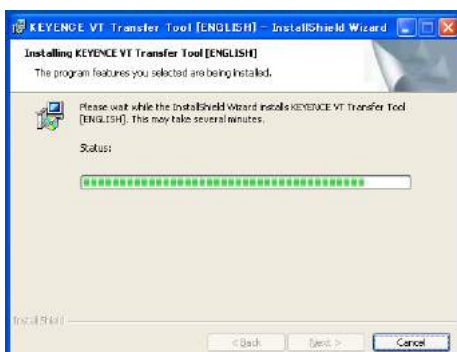
① Next



② Next



③ Install



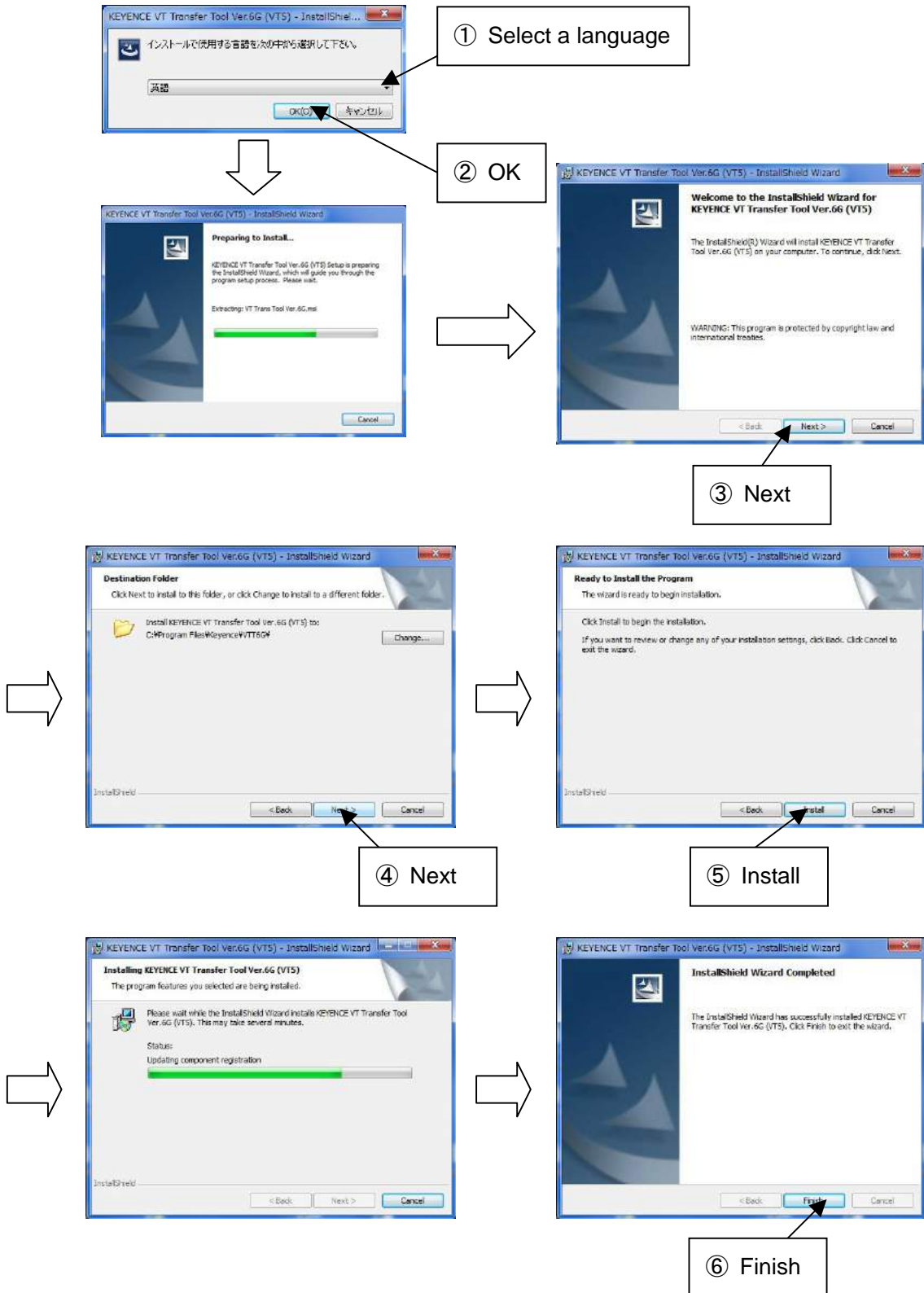
④ Finish

(d) How to install VT Transfer Tool for AeroCut Prime

Insert DISK2 in the CD/DVD drive and install it according to the following procedure.

(The procedure below is for WINDOWS 7)

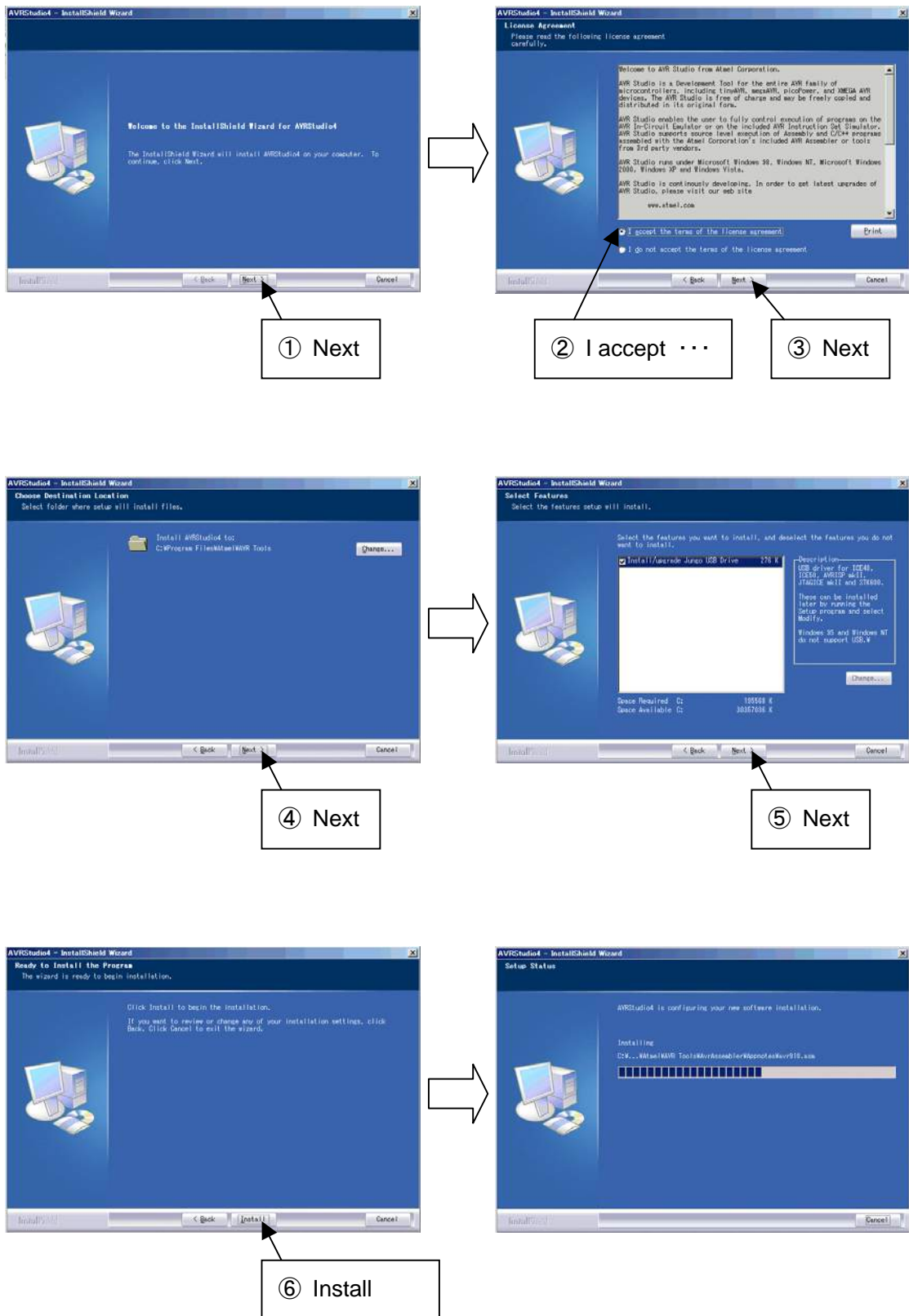
Double click on “VTTransferTool¥Prime¥VTTGHP6???.exe” of the CD/DVD.

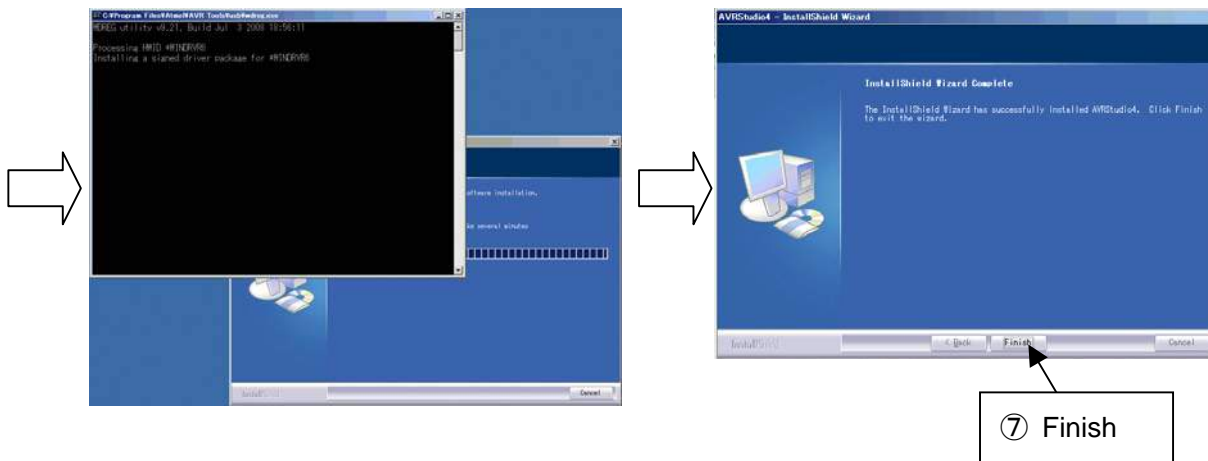


(e) How to install AVR STUDIO

(The procedure below is for WINDOWS XP)

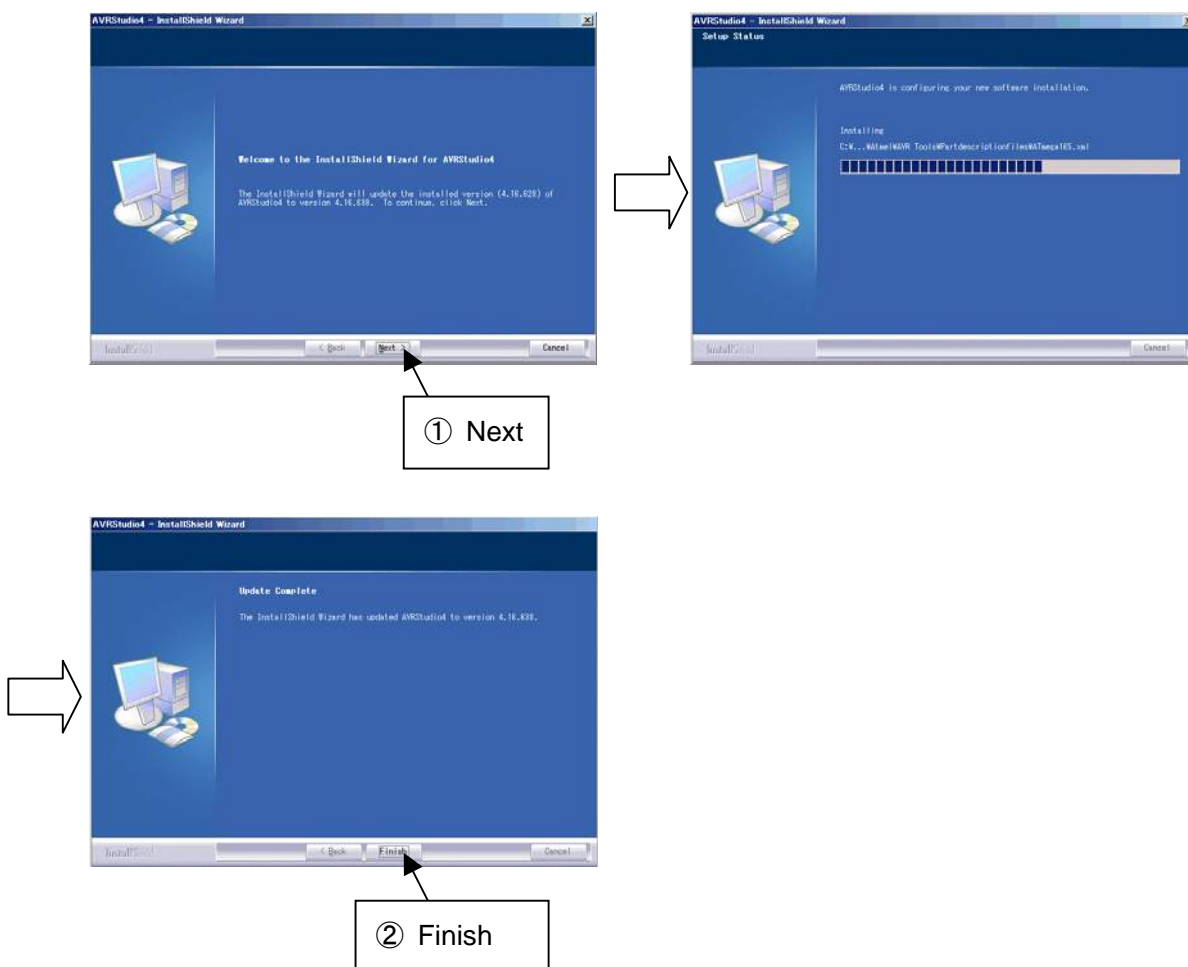
Double click on “AVR_TOOL¥ AvrStudio4Setup.exe” of the CD/DVD.





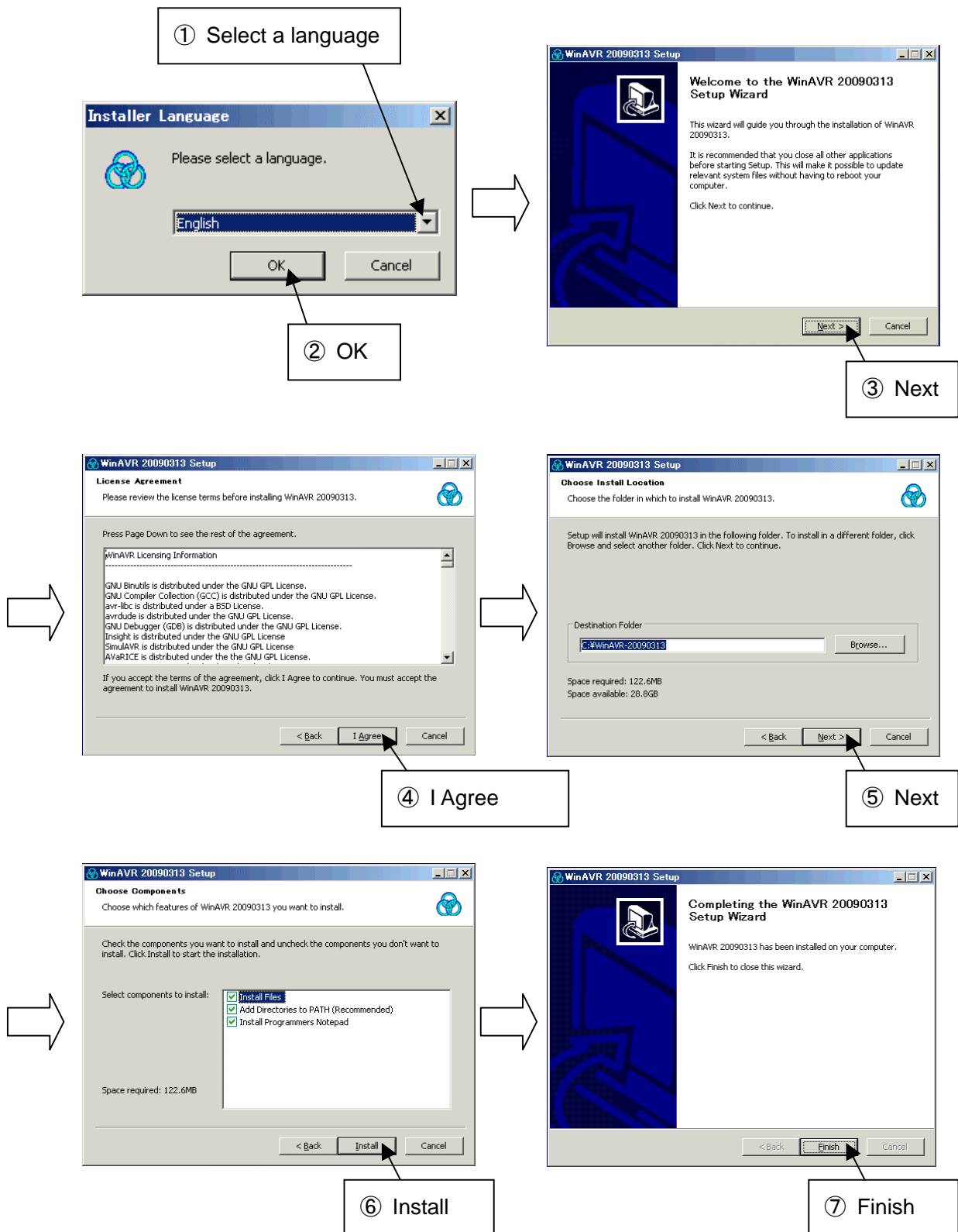
Next is the update of AVR STUDIO.

Double click on “AVR_TOOL¥ AVRStudio4.18SP3.exe” of the CD/DVD.



Next is the installation of WINAVR.

Double click on “AVR_TOOLS WinAVR-20100110-install -install.exe” of the CD/DVD.



⑧ × (Close the Window)



9- (2) Touch panel

(a) Connecting to a computer/VT Transfer Tool operation

If any changes are made to the touch panel content, we will send the data to you most likely by e-mail.

For Prime :

The data format will look like "AeroCut_prime_100.mu2" with a file extension of ".mu2".

For One/Velocity :

The data format will look like "AeroCut_one_100.ms3" with a file extension of ".ms3".

The figure "100" refers to a version, which means Version 1.00.

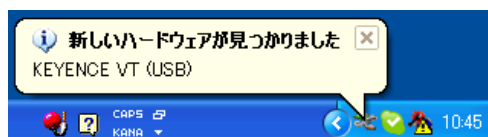
Save this data in a folder of your choice in your computer and upgrade the version as follows:

- ① Remove the unit cover, and connect the USB cable provided with the unit to the back of the touch panel as shown below. (The procedure below is for WINDOWS XP).

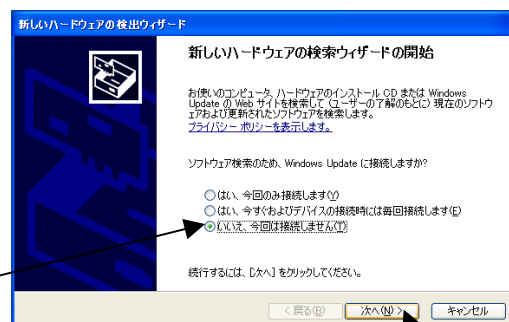


USB cable

- ② Turn on the power supply. If the installation of the USB driver is necessary at this point, install the driver using DISK2, which contains the driver in the USB folder.

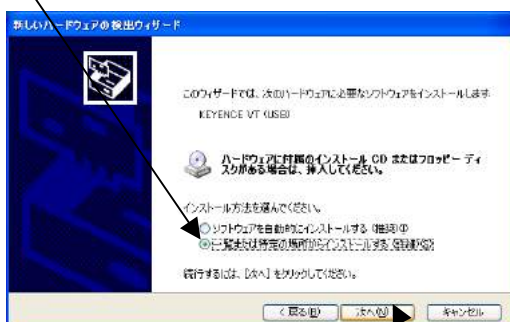


① Select the one at the bottom

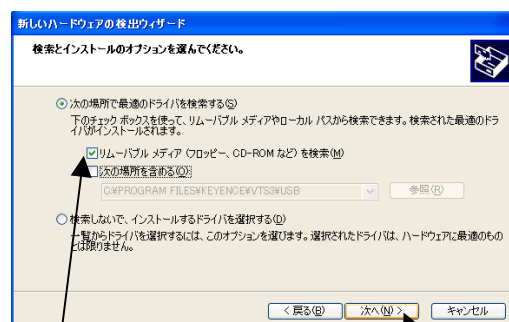


② Next

③ Select the one at the bottom

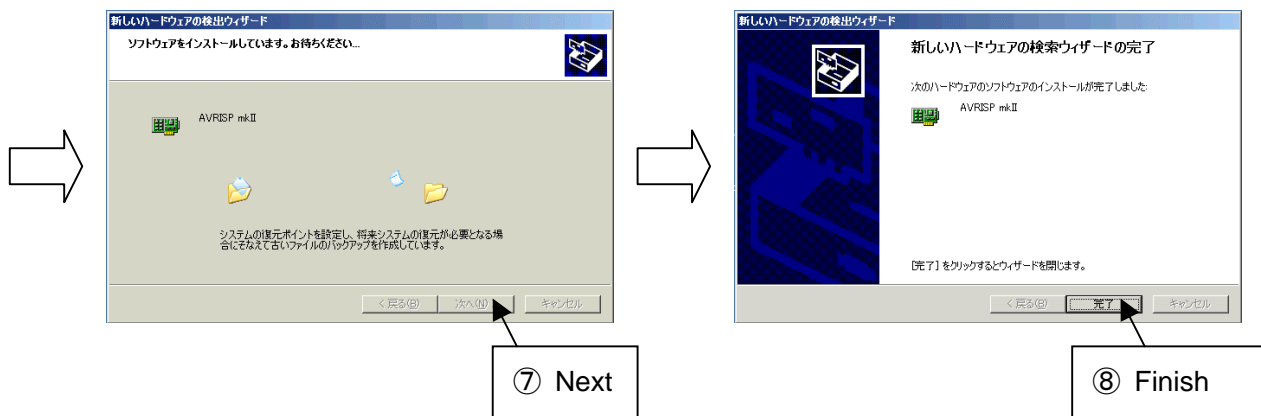



④ Next



⑤ Select the one at the top

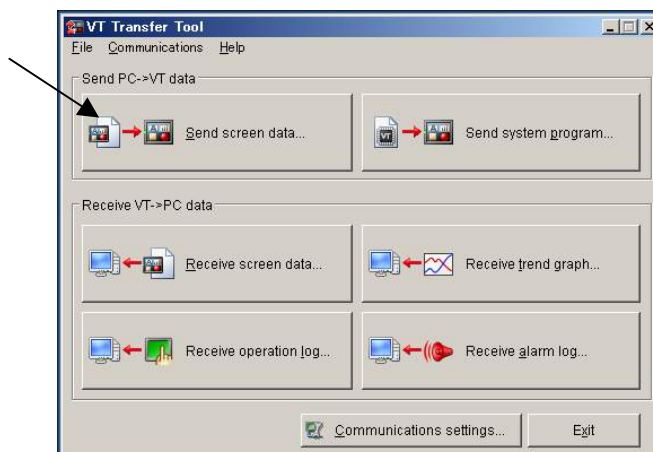
⑥ Next



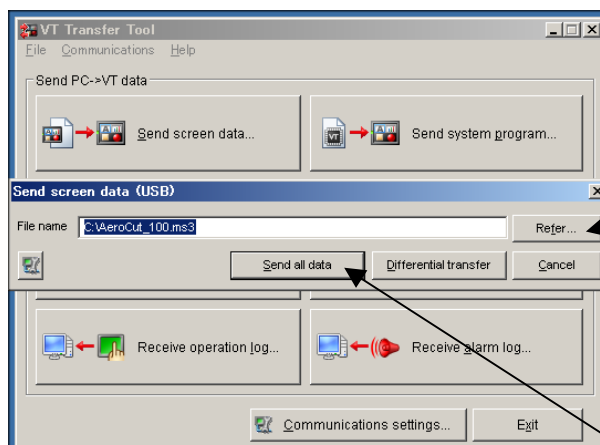
- ③ Start up the computer and double click on  (For AeroCut One/Velocity).

Start up the computer and double click on  (For AeroCut Prime).

- ④ Click on Send screen data.



- ⑤ Select the folder in which you saved our screen data, select a file with a file extension of ms3, and click on Send all data.



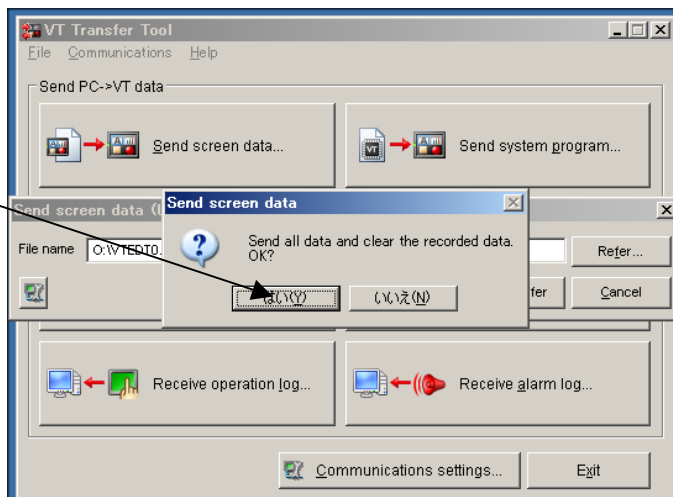
For One/Velocity :

Select where you saved the
“.ms3” file sent from us.

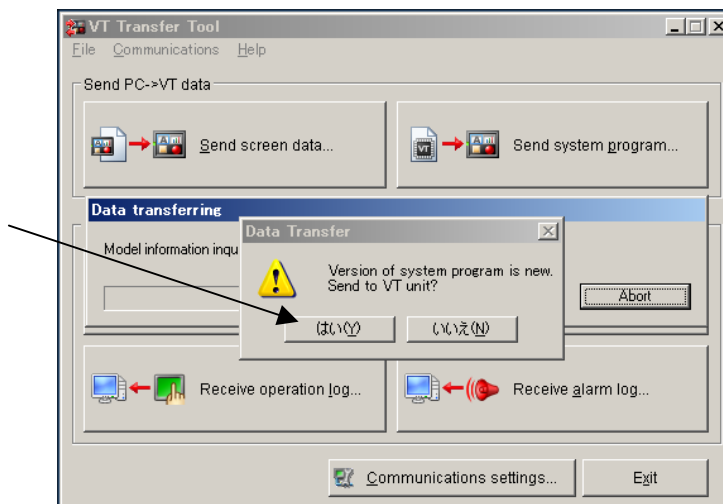
For Prime :

Select where you saved the
“.mu2” file sent from us.

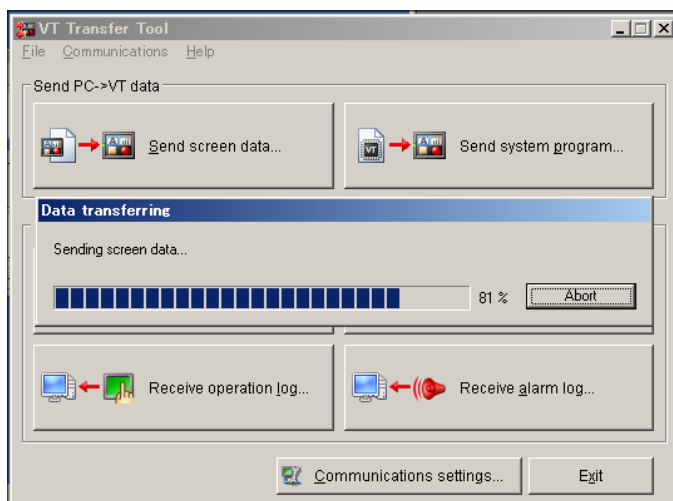
- ⑥ Click on “Yes.”



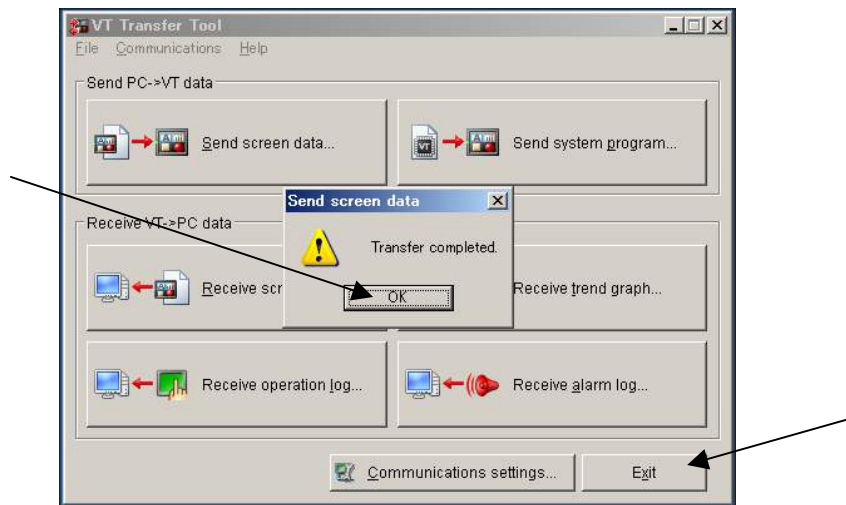
- ⑦ Click YES if a question, “Version of system program is new. Send to VT unit?” is asked. If the question is not asked, you do not need to do anything.



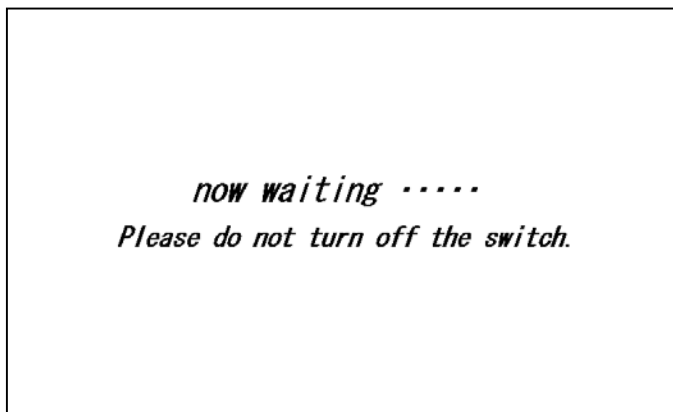
- ⑧ The touch panel will make a peep sound when the transmission has completed.



- ⑨ Click OK and finish by pressing Exit.



- ⑩ After your installing updated software, the direction you can see the below will remain on the touch panel. After seeing that words on the screen, turn off the machine and turn it on again.



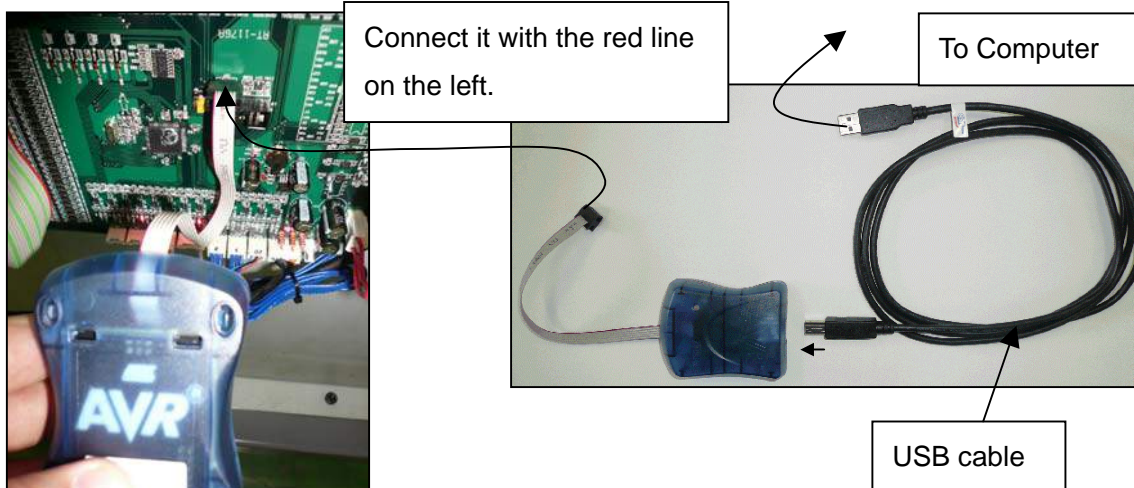
9- (3) CPU board

(a) AVRISP mk II connection and AVR STUDIO operation

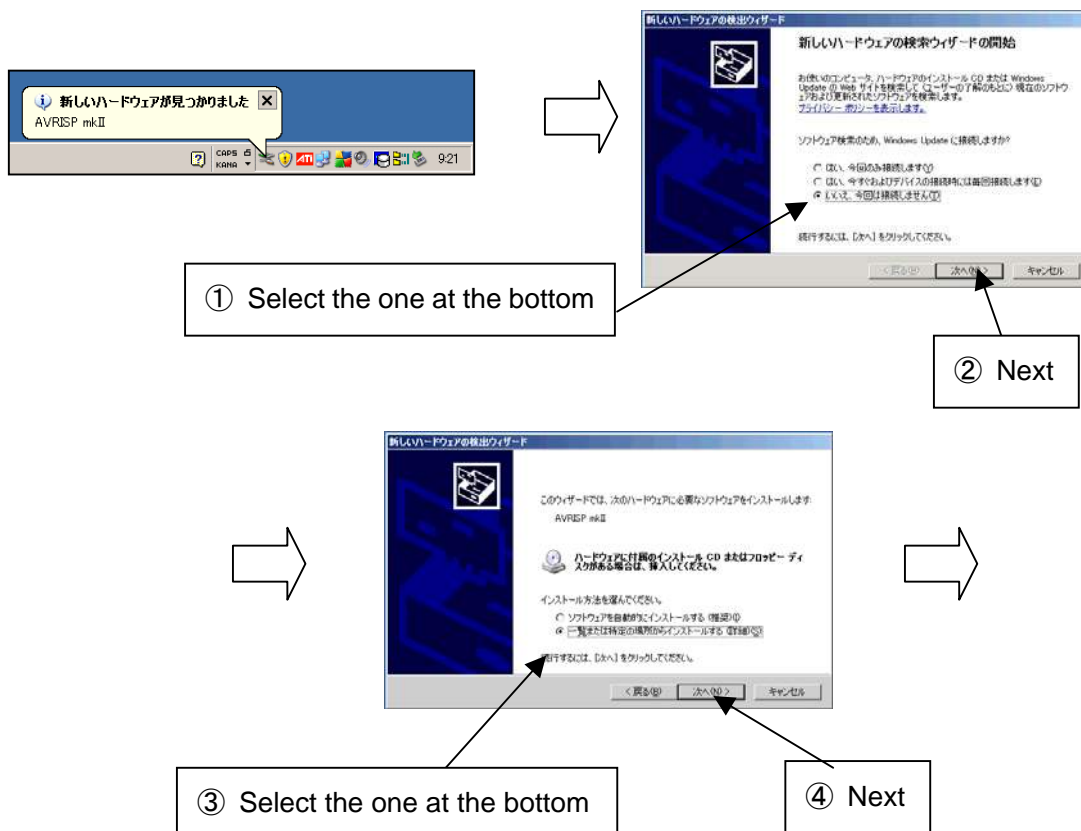
If any changes are made to the program content, we will send the data to you most likely by e-mail.

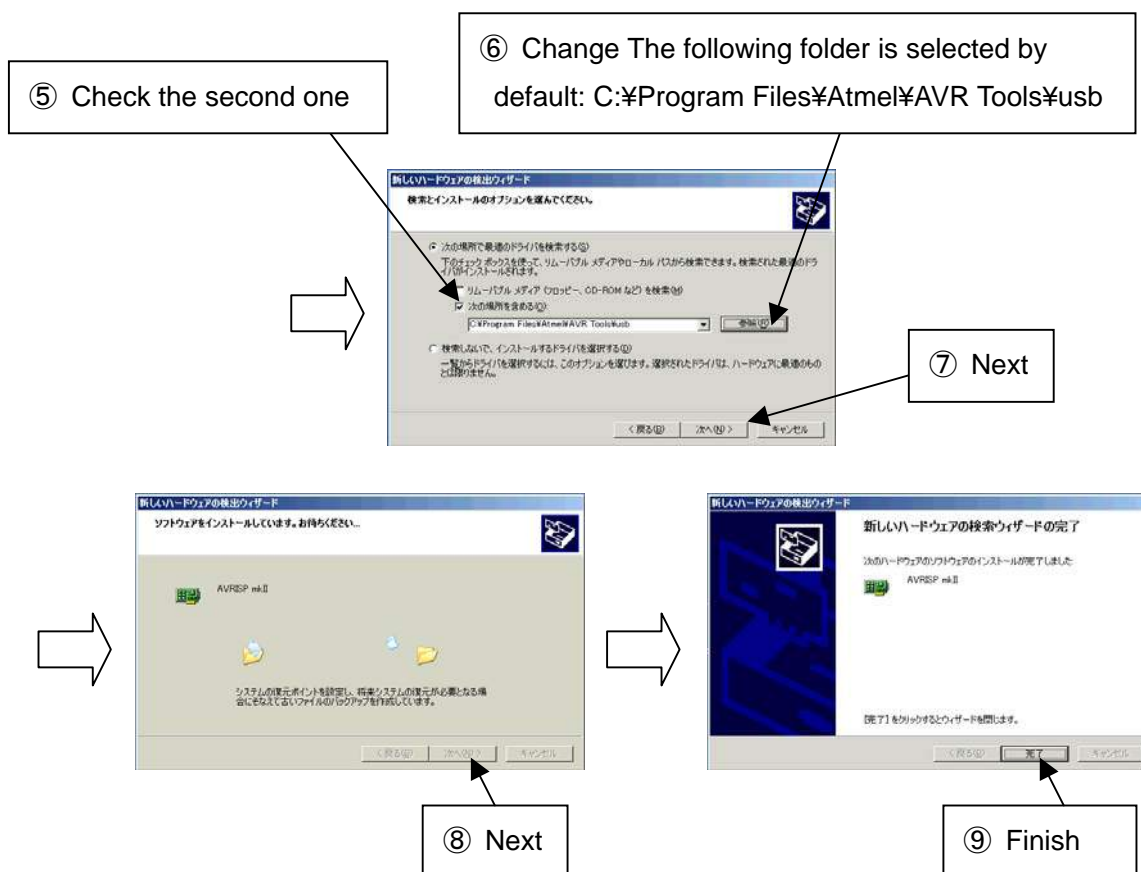
The data format will look like "AeroCut_prime_100.hex" or "AeroCut_one_100.hex" with a file extension of ".hex." The figure "100" refers to a version, which means Version 1.00. Save this data in a folder of your choice in your computer and upgrade the version as follows:

- ① Remove the cover at the bottom of the front of the unit. Connect AVRISP mk II provided with the unit to CN7 of the CPU Board, and connect the USB cable to the computer.

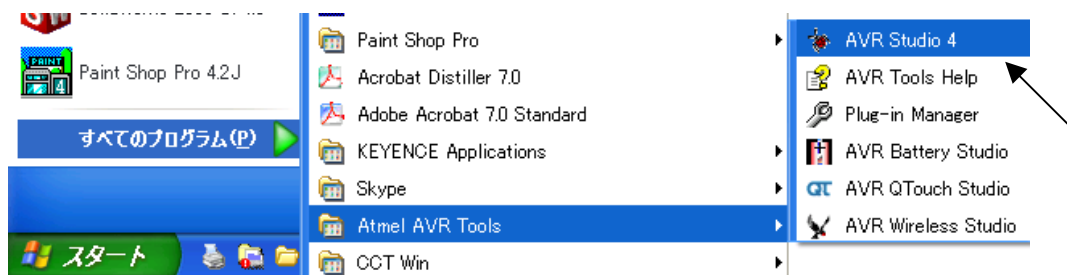


- ② If the installation of the USB driver is necessary at this point, install the driver following the procedure below (The procedure below is for WINDOWS XP).

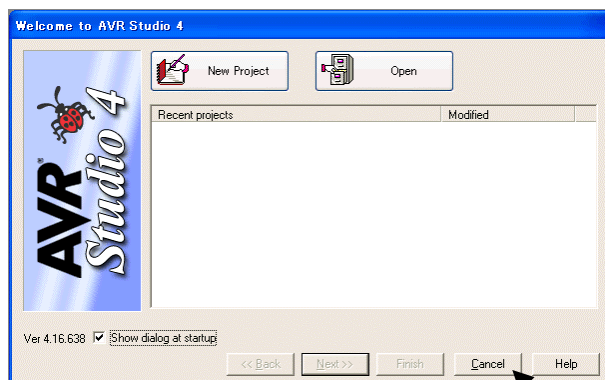




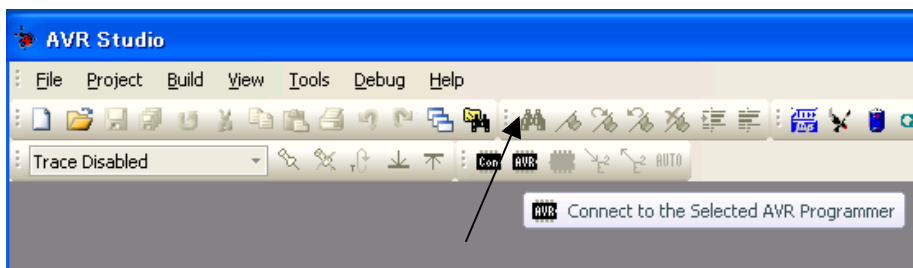
- ③ Start up the computer and double click on Start ⇒ Program ⇒ Atmel AVR Tools ⇒ AVR Studio 4.



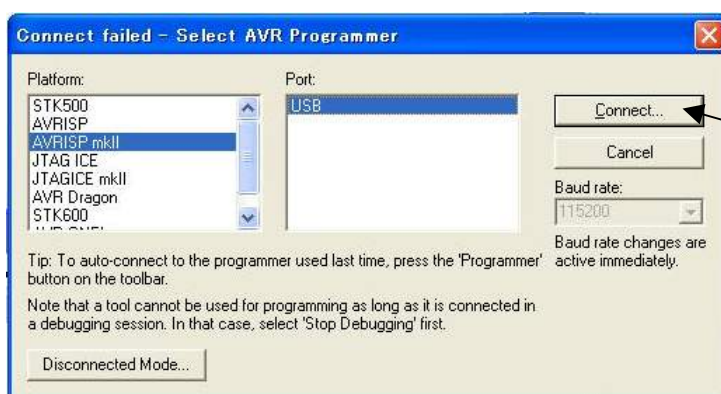
- ④ Click on Cancel.



- ⑤ Click on AVR (Connect to the Selected AVR Programmer).



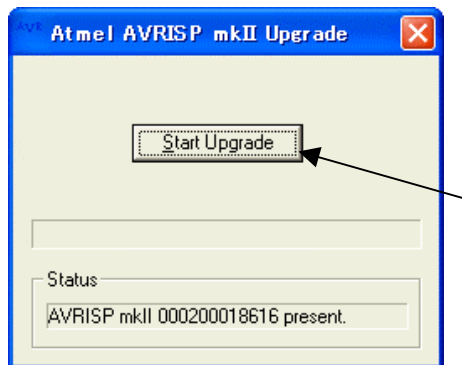
- ⑥ Select AVRISP mk II for Platform, Select USB for Port, click on Connect.



- ⑦ If the following warning appears on the screen, AVRISP mk II firmware upgrade is necessary. Click on OK. If the warning does not appear on the screen, skip to ⑩.



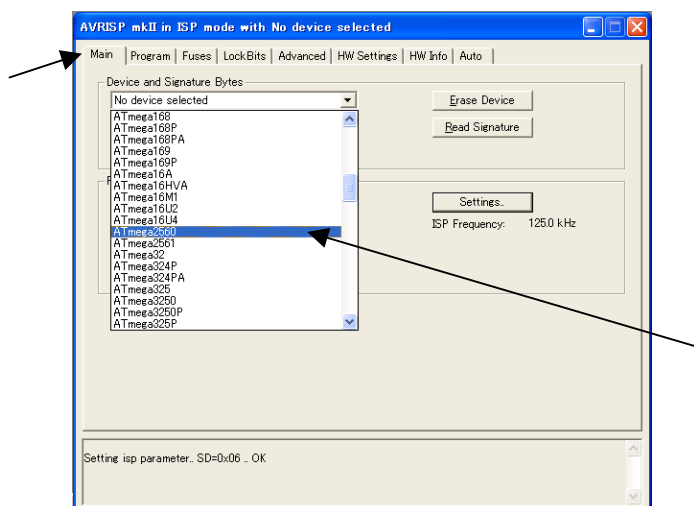
- ⑧ Click on Start Upgrade.



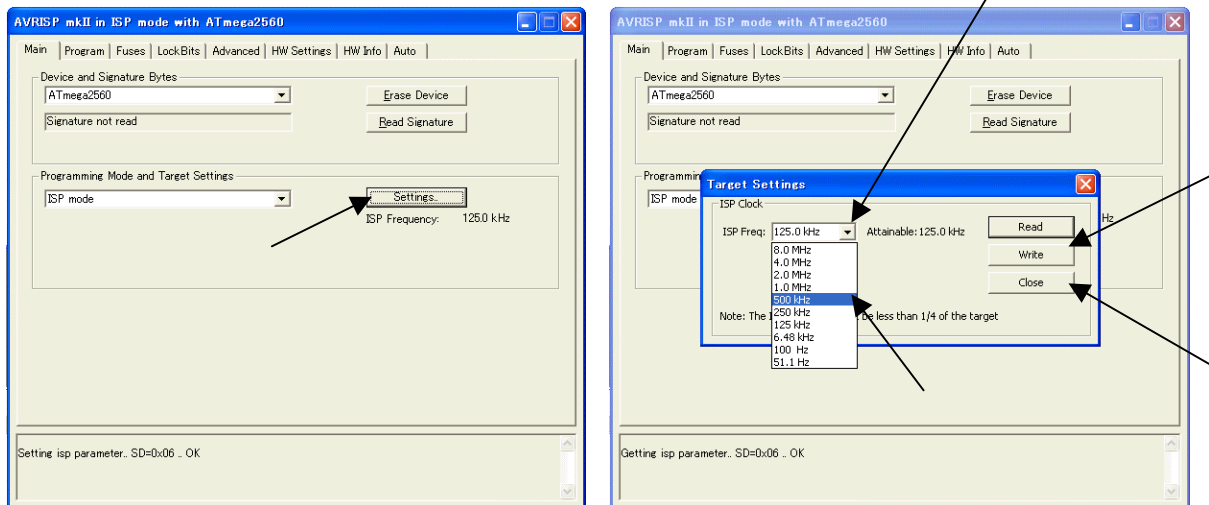
- ⑨ Disconnect the USB cable of AVRISP mk II and connect it again. After that, click on OK. If AVR STUDIO has shut down, return to ③ and conduct the operation again.



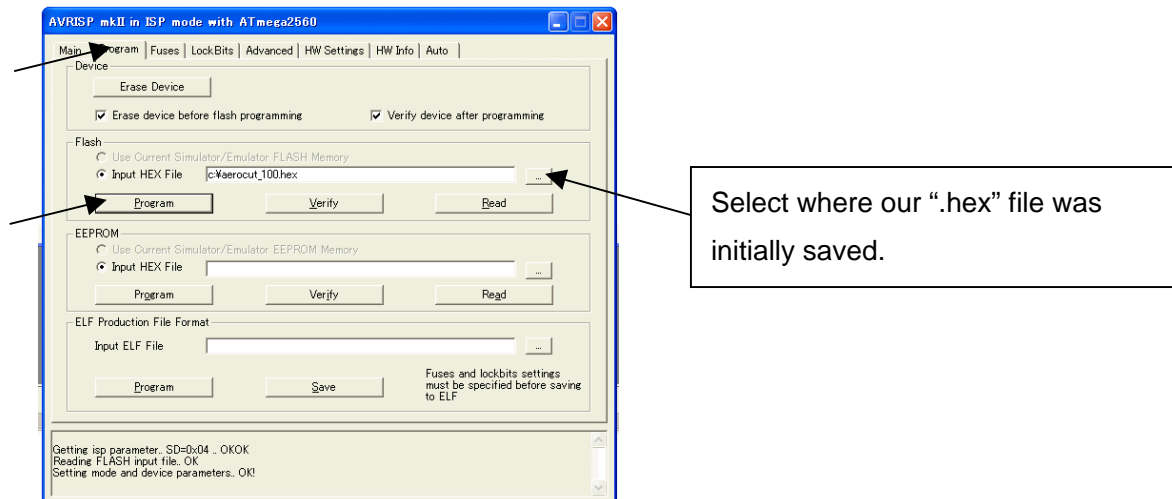
- ⑩ Click on Main tab, select the Atmega2560 for Device and Signature Bytes.



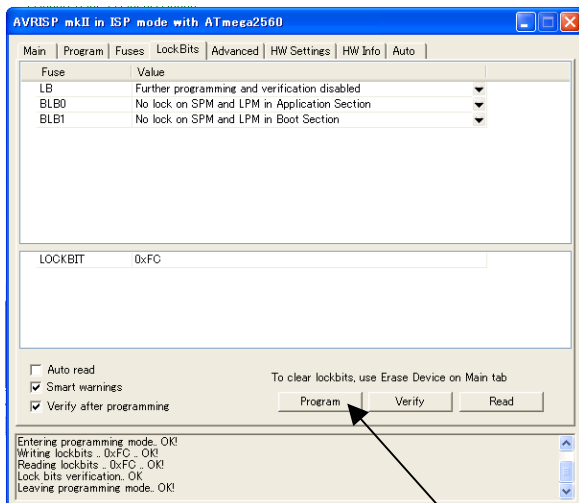
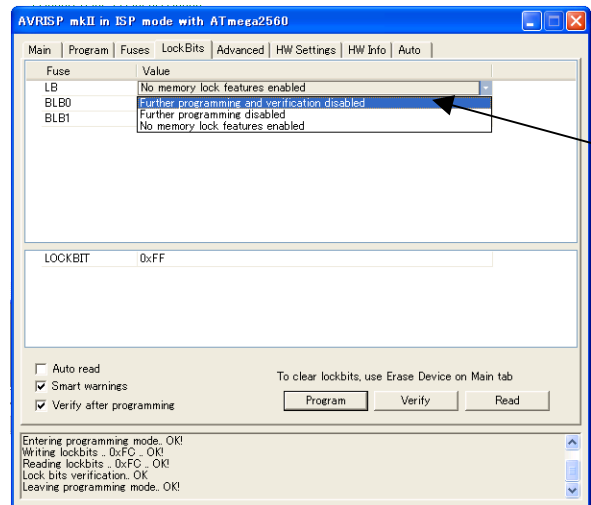
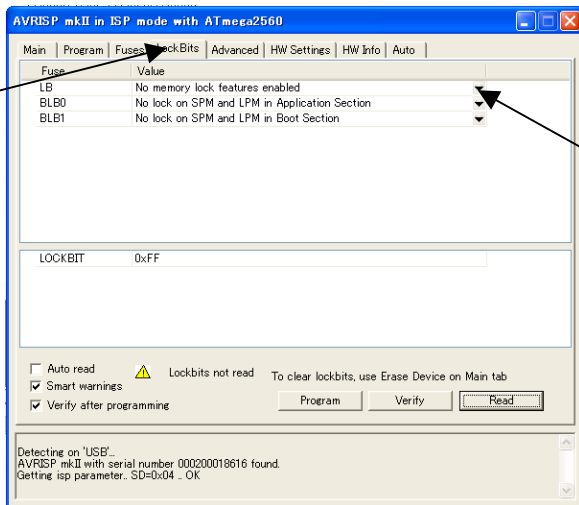
- ⑪ Click on Main tab and on Settings. Select 500 kHz for ISP Freq, click on Write, and click on Close.



- ⑫ After clicking on Program tab, select the folder where the file was initially saved as the save location. By clicking on Program, the transmission of the program will start. (About 30 sec.)



- ⑬ Click the LockBits tab, and click ▼ next to “No memory lock features enabled,” then, select
 “Further programming and verification disabled.” Click “program”.



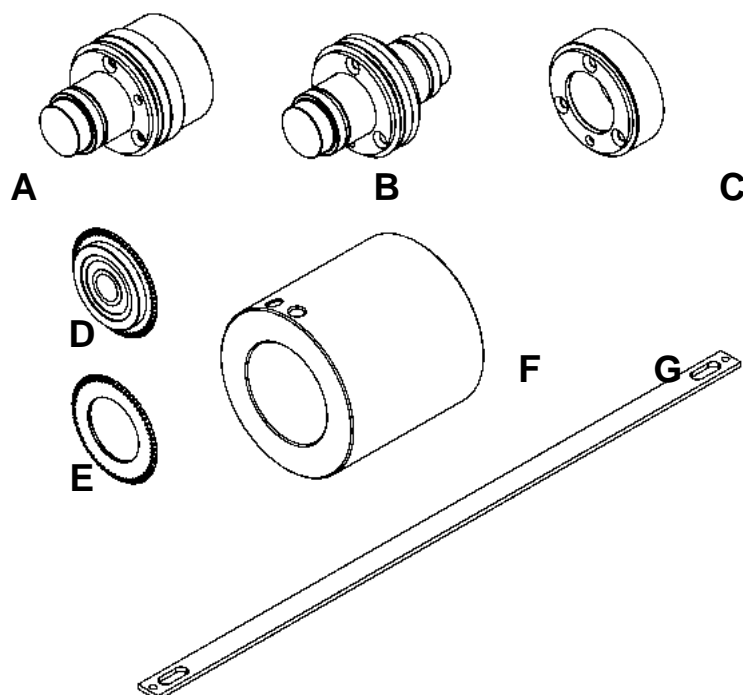
- ⑭ The process is completed when the transmission of the program has finished.
- ⑮ From the next time onward, proceed in the order of ③,④,⑤,⑩,⑫, and ⑬.

10. Cleaning & greasing

- Clean Rollers and Sensors properly.
 - Rollers ahead and behind of Guillotine may affect accuracy if they are dirty.
 - Stop sensor mirror may cause inoperativeness if it is dirty.














11. Recommended replacement parts








No.	Parts name	Parts No.	Qty	Remarks
A	Slitter blade (Margin, upper)	7703-0270+	2	
B	Slitter blade (Gutter, upper)	7726-8271	2	
C	Slitter blade (Lower)	51-596+	6	
D	Perforator blade	61-061+	-	For X-perfo. & Y-jump perfo.
E	Perforator blade	61-061	-	For Y-perfo.
F	Blade receiver	7711-0410	-	For Y-jump perfo. & Y-perfo.
G	Blade receiver	7703-0531	1	For X-perfo.
	Guillotine	61-045	1	
	Timing belt (Roller)	82-546	1	S3M 1146
	Timing belt (Roller)	82-548	1	S3M 552
	Timing belt (Roller)	82-547	1	S3M 528
	Timing belt (Main motor)	82-562	1	S3M 285
	Timing belt	82-545	1	S3M 1014 For X perforator
	Timing belt (Crease)	82-549	1	S5M 340
	Timing belt (Slitter)	82-557	4	S3M 216
	Feed belt	80-718	4	L750






12. Troubleshooting





1	<p>This occurs when the Safety cover or Stacker panel is opened.</p> <p>If the screen below remains after close the both cover.</p> 	<ul style="list-style-type: none"> Cover Sensor either A or B, or both may be out of order.  3- (6) INPUT DATA CHECK Screen The angle of the shield plate may be wrong.  3- (6) INPUT DATA CHECK Screen I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
2	<p>This occurs when the unit was started with paper still remaining inside the unit.</p> <p>If the screen below remains after paper removal.</p>  	<ul style="list-style-type: none"> Clean the reflector under the Stop Sensor.  10.Cleaning & greasing Either Origin Sensor, C/M Sensor, or Stop Sensor may be out of order.  3- (6) INPUT DATA CHECK Screen CPU Board may be out of order. Wire breakage or connection failure may have occurred.
3	<p>This occurs when the paper did not pass through Origin Sensor at time of paper feeding.</p> <p>If this occurs frequently (except when there is no paper on Feed Table)</p> 	<p>When Feed Belt and Carrying Roller are both rotating:</p> <ul style="list-style-type: none"> Paper guides (Small) hold the sheets too tightly on the Feed table. Paper tip could remain inside of the machine. Clean feed belts. Vacuum motor may be out of order. Origin Sensor may be out of order.  3- (6) INPUT DATA CHECK Screen I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.


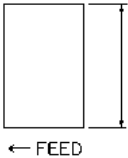




3		<p>When Feed Belt is not rotating:</p> <ul style="list-style-type: none"> • Feed Motor may be out of order. • I/O Board may be out of order. • CPU Board may be out of order. • Wire breakage or connection failure may have occurred. <p>When Carrying roller is not rotating:</p> <ul style="list-style-type: none"> • Servo Motor and/or Driver may be out of order. • CPU Board may be out of order. • Wire breakage or connection failure may have occurred.
4	<p>This occurs when the paper did not pass between Origin Sensor and Stop Sensor within a designated period of time.</p> <p>If this frequently occurs,</p> 	<p>When Feed Roller is rotating:</p> <ul style="list-style-type: none"> • Paper tip could remain inside of the machine. • Origin Sensor may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen • Stop Sensor may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen • Slipping is caused by powdered paper at Feed Roller. • Paper warpage may have occurred. • Slitter may be out of order. • CPU Board may be out of order. • Wire breakage or connection failure may have occurred. <p>When Carrying roller is not rotating:</p> <ul style="list-style-type: none"> • Servo Motor and/or Driver may be out of order. • CPU Board may be out of order. • Wire breakage or connection failure may have occurred.


5	<p>This occurs when Feed Table is overloaded.</p> <p>If this occurs frequently,</p>  <p>The screen is red with the text "OVERLOADED !!", "CHECK PAPER FEED TABLE !!", and a "RETURN" button.</p>	<ul style="list-style-type: none"> Feed Motor may be out of order. Switch (TBL UP/LMT SW or TBL LW/LMT SW) may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen Screws of the coupling may be loose. I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
6	<p>This occurs when Cutter or Crease are overloaded.</p> <p>If this occurs frequently,</p>  <p>The screen is red with the text "OVERLOADED !!", "CHECK KNIFE or CREASER UNIT !!", and buttons "RETURN", "<", and ">".</p>	<p>When Cutter is overloaded:</p> <ul style="list-style-type: none"> Paper tip could remain inside of the machine. Paper double feeding. Paper thickness is out of specification. Cutter blade may be blunt. Cutter Motor may be out of order. Switch (CUTTER UP/LMT SW) may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred. <p>When Crease is overloaded:</p> <ul style="list-style-type: none"> Paper tip could remain inside of the machine. Paper double feeding. Paper thickness is out of specification. Crease depth adjustment may be set incorrectly. Crease Motor may be out of order. Sensor (CRSR UP/SENS) may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.

7	<p>This occurs when Slitter Unit is overloaded.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> Paper tip could remain inside of the machine. Slitter Movement Screws or shaft may be out of order. Tension of Timing Belt may need to be adjusted. Screws of Timing Pulley need to be checked for their tightness. Sensor (SLTR1-4 HM POS) may be out of order. <p>☞ 3- (6) INPUT DATA CHECK Screen</p> <ul style="list-style-type: none"> Origin Sensor's location may be set incorrectly. Slitter Motor may be out of order. I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
8	<p>This occurs when Cut Mark could not be detected.</p> 	<ul style="list-style-type: none"> Cut Mark printing density needs to be checked. Cut Mark Sensor needs to be re-adjusted. <p>☞ 6- (2) Cut mark sensor</p> <ul style="list-style-type: none"> Cut Mark Sensor may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
9	<p>Two or more sheets are fed at one time.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> Fan out the paper sufficiently and jog the paper to make the each of the sheets separately. Adjust the volume of Blower FAN and Vacuum Fan. <p>☞ 3- (3) SPEED Screen</p> <ul style="list-style-type: none"> Blow motor may be out of order. <p>Note: Activate double-feed detection mode.</p> <p>☞ OPERATION MANUAL 「5.1 Adjustments on the paper feed section」</p>

10	<p>This occurs when a servo error is detected.</p> 	<ul style="list-style-type: none"> COVER SENS A, B may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen Servo Motor Driver may be out of order. Servo Motor may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
11	<p>This occurs at times of communication errors.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> Touch Panel may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
12	<p>This occurs at times that machine is operated when Cutter is not on top dead center.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> Switch (CUTTER UP/LMT SW) may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
13	<p>This occurs at times that machine is operated when Cutter is not on bottom dead center.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> Sensor (CRSR UP/SENS) may be out of order. ☞ 3- (6) INPUT DATA CHECK Screen I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.
14	<p>This occurs when the harness of X-perfo is disconnected.</p> <p>If it occurs although the harness are not disconnected,</p> 	<ul style="list-style-type: none"> Check signals of a harness. ☞ 3- (6) INPUT DATA CHECK Screen I/O Board may be out of order. CPU Board may be out of order. Wire breakage or connection failure may have occurred.

15	<p>This occurs when X-perfo detects overload or X-perfo moves beyond its moving range caused by losing steps and its location.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> ▪ Paper tip could remain inside of the machine. ▪ Malfunction of X-Perfo. ▪ I/O Board may be out of order. ▪ CPU Board may be out of order. ▪ Wire breakage or connection failure may have occurred.
16	<p>This occurs when X-perfo moves beyond initial position by losing steps and its position</p> 	<ul style="list-style-type: none"> ▪ Paper tip could remain inside of the machine. ▪ Malfunction of the origin sensor of X-perfo. ☞ 3- (6) INPUT DATA CHECK Screen ▪ Malfunction of X-Perfo. ▪ I/O Board may be out of order. ▪ CPU Board may be out of order. ▪ Wire breakage or connection failure may have occurred.
17	<p>This occurs when barcode cannot be read.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> ▪ Check if barcode is printed clearly and is clean. ▪ Check if the position of barcode is correct. ▪ Tipping the Barcode scanner unit can improve accuracy of reading. ▪ Malfunction of Barcode scanner ▪ CPU Board may be out of order. ▪ Wire breakage or connection failure may have occurred.
18	<p>This occurs when the format of the Barcode is incorrect.</p> <p>If this occurs frequently,</p> 	<ul style="list-style-type: none"> ▪ Check if name of the machine (Prime or One and machine number (0 – 9) is correct. ▪ Check if the setting of the Plug-in is correct.
19	<p>The dimensions of finished card are different from the measurements you have input.</p>	<ul style="list-style-type: none"> ▪ Make it correct at ADJUST Screen. ☞ OPERATION MANUAL 「5.5.2 If the cut measurement does not match the input value」

20	<p>The lengths of finished cards are unequal.</p> 	<ul style="list-style-type: none"> • Clean Carrying rollers. • Clean Sensors. • Cutter blades could have got damaged and got partly dull. Replace the cutter unit.
21	<p>The widths of finished cards are unequal.</p> 	<ul style="list-style-type: none"> • Clean Carrying rollers. • Slitter blade could have got damaged and got partly dull. • CPU Board may be out of order. • Servo Motor Driver may be out of order. • Servo Motor may be out of order.
22	<p>Two or more sheets are fed at one time. If this occurs frequently,</p>	<ul style="list-style-type: none"> • Fan out the paper sufficiently and jog the paper to make the each of the sheets separately. • Adjust the volume of Blower FAN and Vacuum FAN. <p> 3- (3) SPEED Screen</p> <ul style="list-style-type: none"> • Blow motor may be out of order. <p>Note: Activate double-feed detection mode.</p> <p> OPERATION MANUAL 「5.1 Adjustments on the paper feed section」</p>
23	<p>A sheet stops after moving slightly (with noise)</p>	<ul style="list-style-type: none"> • Thick paper cannot be fed at higher speed and a sheet stop being fed with noise. <p>Please slow down the speed.</p>
24	<p>Paper jam occurs frequently.</p>	<ul style="list-style-type: none"> • Paper curl too much to be conveyed smoothly. • The dimensions of the paper are different from the measurements you input into the machine. • Paper tip could remain inside of the machine. <p>(Origin sensor, Slitter, Cutter, Creaser, Perforator)</p>
25	<p>Paper remains at a Crease blade.</p>	<ul style="list-style-type: none"> • Make Crease depth smaller. <p> OPERATION MANUAL 「5.4 Creaser adjustment」</p>
26	<p>The movement of slitter block is not smooth.</p>	<p>Please adjust slitter head.</p> <p> Page. 36</p>

27	It sounds strange while slitter block is moving.	Please adjust slitter head.  Page. 36
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