

## BaumCut 31.5 Cutter Installation Instructions



Customer \_\_\_\_\_  
 Serial Number: \_\_\_\_\_  
 Date Installed: \_\_\_\_\_  
 Service Representative: \_\_\_\_\_

The following steps are very important. Be sure to read all steps completely to the end of this document before beginning.

1. **Measure with a meter, the actual incoming electrical voltage** power source that will be connected to the cutter. If the voltage is less than 215Volts you must install a buck boost transformer to boost the power to approximately 220Volts. The cutter will not perform properly below 215Volts.
2. **Measure all openings, doorways, and passageways** to install location. Be sure that the cutter can pass through. Determine if the side tables and or main table need to be removed.
3. **Inspect shipment** to purchase order to insure that all items are delivered and in proper condition. All freight damage claims must be filed immediately.
4. Insure that the correct tow motor or lifting device is available to **remove equipment from crating**. Notice the lifting instruction labels on the crating to insure that the equipment is lifted from the correct position. Do not discard crating materials until the equipment has been properly installed. Note that a lifting lug is provided at the top of the cutter for removal from skid or the forks can be placed carefully underneath.
5. **Unpack and check all accessories**. Make sure that all items are with the machine and in proper condition.
6. **Place equipment in position and level** if required using instructions in installation manual.
7. **Connect the main electrical power** to the equipment, using a certified electrician, conforming to all applicable codes. Refer to operator's manual for instructions and to the serial plate on the cutter for proper data.
8. **Turn on main power and initialize the cutter**. Perform Scan Reference Position. Do not operate in auxiliary mode. See operator's manual for details. **THIS IS A MANDATORY STEP!** See pages 2 and 3.
9. **Install knife in cutter**. Refer to operator's manual for instructions. Use the knife change tool with the protective knife guard that is provided with the machine. Use Baumfolder knives.
10. Press Cut buttons and **check for proper rotation of hydraulic pump motor**. If not correct change incoming main power wires to reverse rotation.
11. **Check accuracy of cutter** per instructions in operator's manual.
12. **Instruct operator** on operation and safety of equipment.

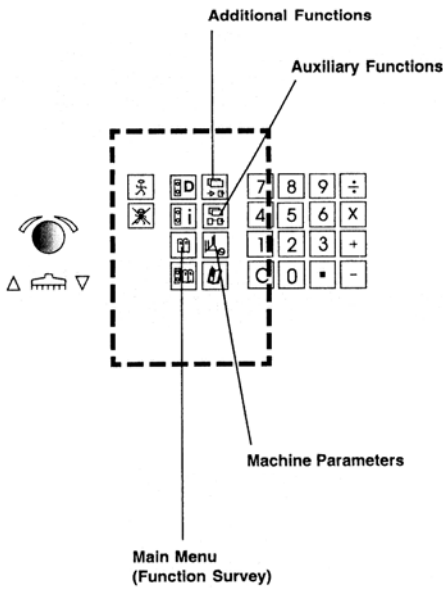
### Customer Training Checklist:

1. \_\_\_ **Explained safety procedures /labels**
2. \_\_\_ Main power switch
3. \_\_\_ Explain Program Display Screen Data
4. \_\_\_ **Manual Backgag Movement**
5. \_\_\_ Cutting Line Indicator
6. \_\_\_ Clamp pressure setting adjustment
7. \_\_\_ Cut button operation
8. \_\_\_ Safety Light Barrier
9. \_\_\_ False Clamp Plate
10. \_\_\_ Automatic Operation Programming
11. \_\_\_ Entering fractions for positions
12. \_\_\_ Deletion of wrong input
13. \_\_\_ **Sending backgag to nominal position**
14. \_\_\_ Selection of next free program
15. \_\_\_ Selecting an existing program
16. \_\_\_ Storing measurements for a program
17. \_\_\_ Setting Up a Cutting Program
18. \_\_\_ Correction of an input error
19. \_\_\_ Automatic On/Off
20. \_\_\_ Running a cutting program
21. \_\_\_ Naming a program
22. \_\_\_ Deletion of programs
23. \_\_\_ Inserting Measurements into program
24. \_\_\_ Storing measurements to printed image
25. \_\_\_ Calculator functions
26. \_\_\_ Knife Compensation
27. \_\_\_ Resting Time for Knife BDC
28. \_\_\_ Maintenance Cut Counter
29. \_\_\_ **Block Programming**
30. \_\_\_ Additional Functions
31. \_\_\_ Auxiliary Functions
32. \_\_\_ Cut and Record Program cutting
33. \_\_\_ Subtraction Repetition Cutting
34. \_\_\_ Prepressure Clamping Time
35. \_\_\_ **Knife Change**
36. \_\_\_ Cutting Stick Change
37. \_\_\_ Maintenance

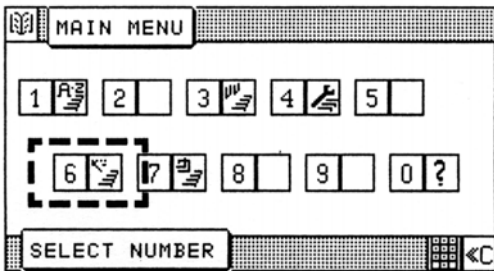
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To perform Scan Reference Position Function:

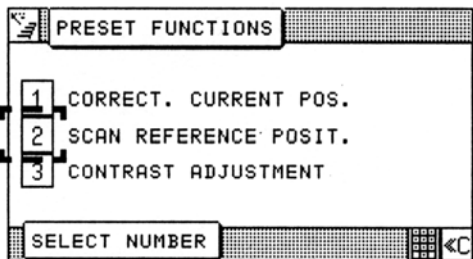
## 1. Press “Main Menu” button



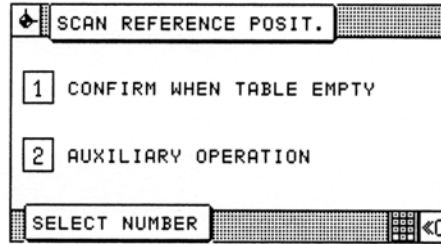
## 2. Select Item “6” on Main Menu



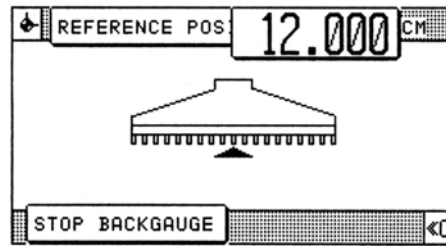
## 3. Select #2 “Scan Reference Position”



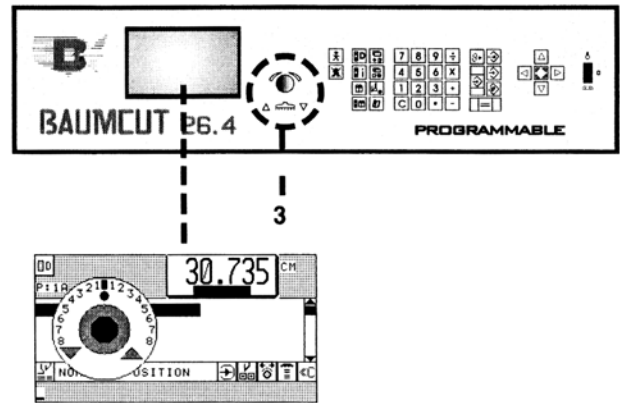
## 4. Confirm that Table is empty and press “1”



## 5. Backgauge Screen will now appear



## 6. Start backgauge by pressing in on manual positioning knob and turn the knob either direction.



The Cutter will now move the backgauge the entire length of travel and check all sensing positions.

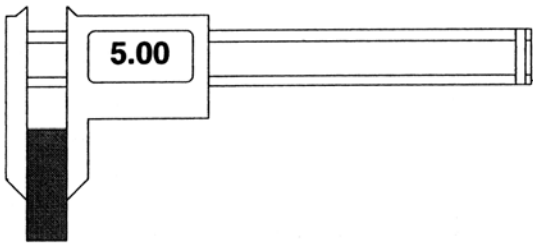
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## 7. The cutter will ask you if the current position is OK.

Place a small lift of paper at the far right and left ends of the cutter opening and cut the paper.



Using a Vernier Caliper, measure the overall length of each lift and compare your measurement to the measurement displayed on the readout.



If the measurements are the same you can confirm that the measurement is OK. If not select correct position.

Enter measured length.

Cut (2) lifts again and measure to confirm.

Note that the Scan Reference Position must be performed also when changing electrical boards and re-commissioning the cutter.

When cutting the paper at both ends and comparing the lengths of the (2) lifts you are also checking the squareness of the backgage to the knife. If the lengths are different from one side to the other, make adjustments to the backgage using the adjustment screws on the main casting.

