

cuTex®

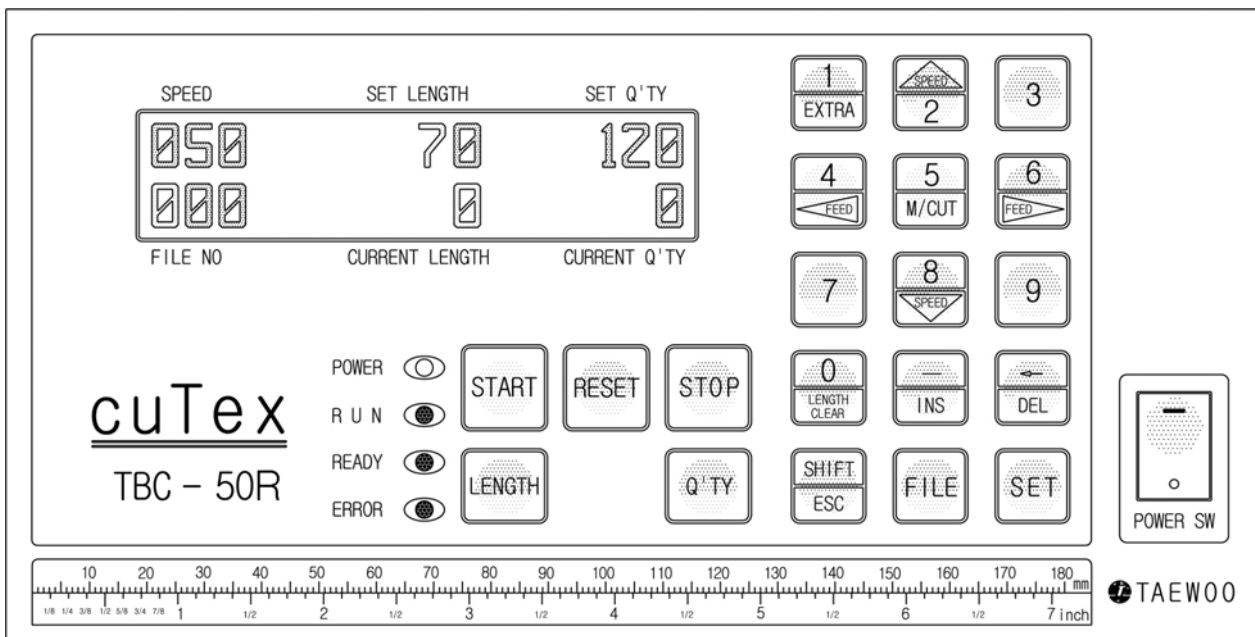
AUTOMATIC VELCRO TAPE CUTTER

TBC-50R



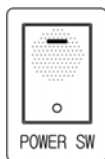
 TAEWOO CO., LTD

How to operate TBC-50R



1. An example (Cutting length : 70mm, Cutting quantity : 120 pcs)

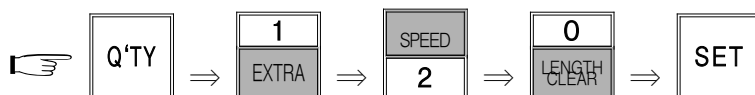
▷ Turn on the POWER SW.



▷ Set cutting length 70mm. (Press the following buttons in order.)



▷ Set cutting quantity 120 pcs.



▷ Press START button.



2. Key functions



: Current length on display will be back to "0" at a stop.



: All of current length and current q'ty on display will be back to "0".



: Moving knife only.

- ① to cut the material for test.
- ② to take out the material jammed between knife blades.
- ③ for balancing of knife blades in exchange.



: Cutting additional one.



: Restoring to normal condition in ERROR(red LED) and inputting parameter or program.



: to move the roller manually for mounting the material on the machine or for feeding it forwards or backwards.



— Speed up (The current speed appears on the left-upside of LCD display with "%". Normal speed : 50%, Maximum speed : 100%)



— Speed up (The current speed appears on the left-upside of LCD display with "%". Normal speed : 50%, Maximum speed : 0%)

* Speed up & down is possible in any time(operation or stop) and set-speed will not be changed even though you press RESET button or power off & on.



: to insert new program between programs inputted already in time of program-input.



: to delete the wrong program in time of program-input. (All things of the STEP will be deleted.)



: Function for label cutting

3. Specification

Model Name	Main Cutting Materials	Cutting Knife	Power Supply	Max. Cutting Width	Range of Cutting Length	Cutting Q'ty/min. (Length: 50mm)	Machine Size (Net Weight)	Packing Size (Gross weight)
TBC-50R (VELCRO® round cutter)	Exclusive for VELCRO®	Cold	AC110/220V 50/60Hz	12.5mm ~ 55mm	5mm ~ 300M	70 ~ 90 cuts	800×320×380 (20.4kgs)	540×430×340 (24kgs)

4. Caution for use

- Before use, please confirm the voltage and make ground(earth) connection.
- Do not access hands or any object close to the working knife. (for safety)
- When the knife blade becomes dull, please use it after grinding with the grinding machine.
(Please do not let the unskilled person grind manually or install the knife blade.)
- Please contact following address for further information.

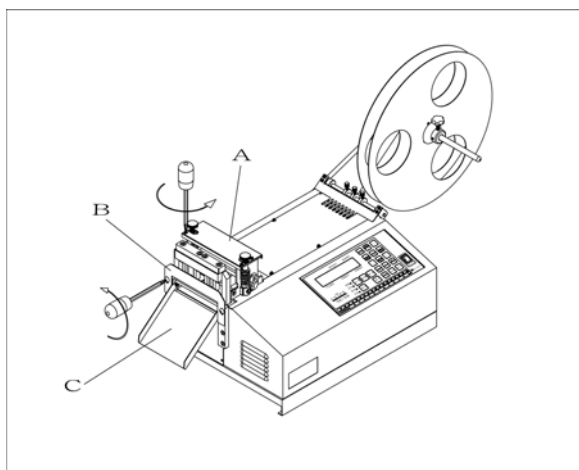
EXCHANGE OF KNIFE

Be careful when you exchange knives of TBC-50R against for a damage of blade !

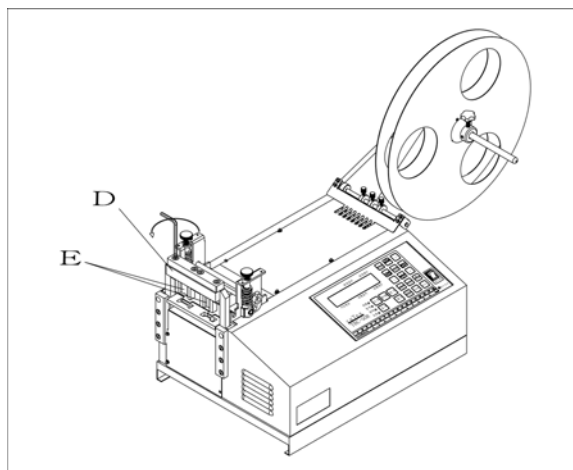
<Separation of Punch>

(a) By a cross(+) screw driver, take off A, B, C from the machine.

(b) By 5mm-wrench, take off punch E from the upper knife case D.



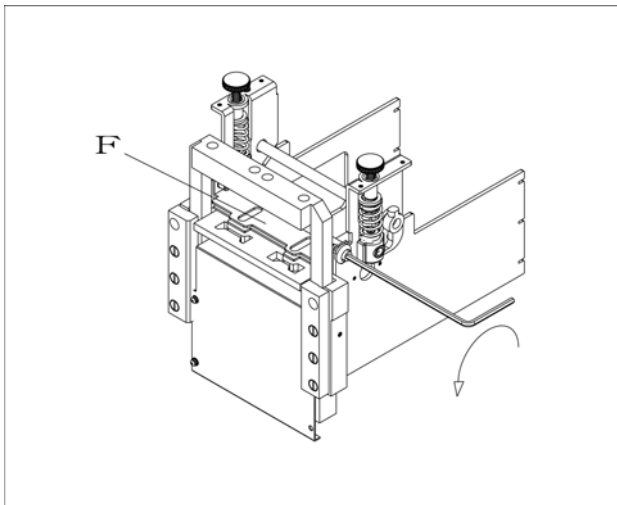
(a)



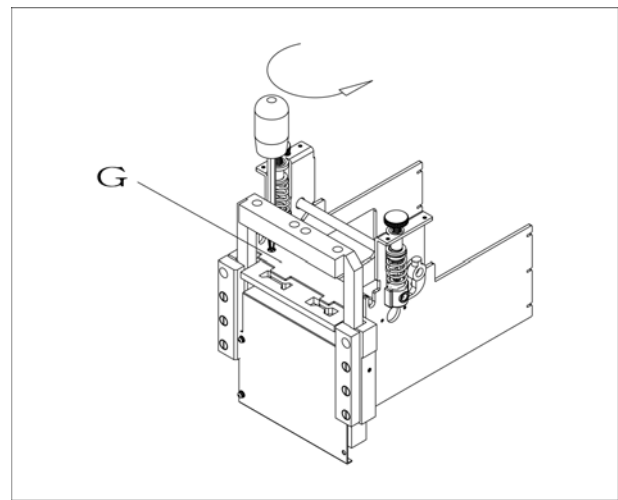
(b)

(c) By 3mm-wrench, take off fixing stopper F from the machine.

(d) By a cross(+) screw driver, take off pressure bracket G from the machine.



(c)



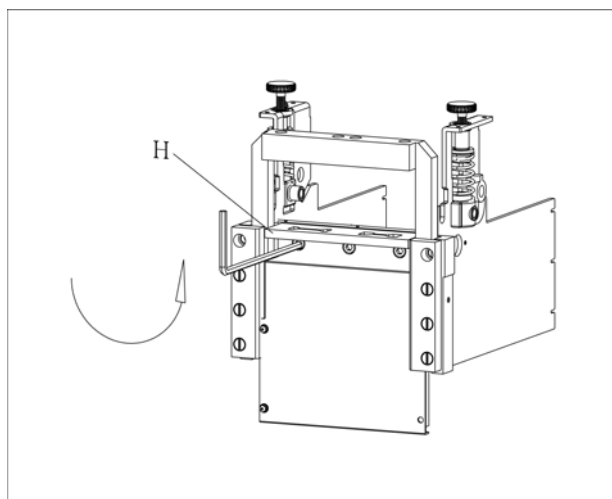
(d)

(e) By 4mm-wrench, take off punch die H from the machine.

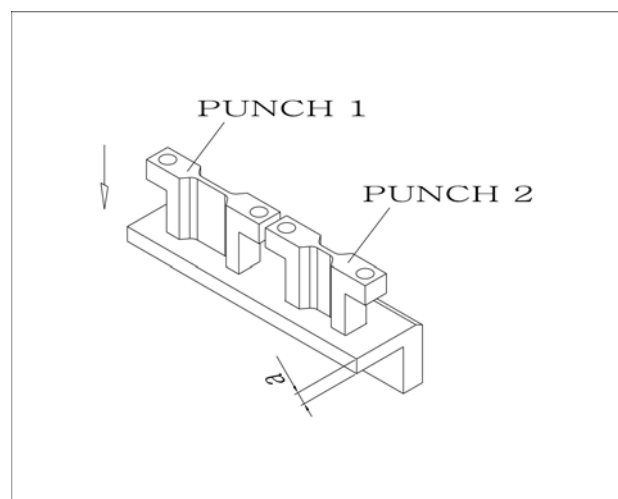
<Assembly>

(f) - Clean knife parts with clean-tissue.

- Install punch 1,2 in punch dies.(You must not install punch deeper than width of "a".)

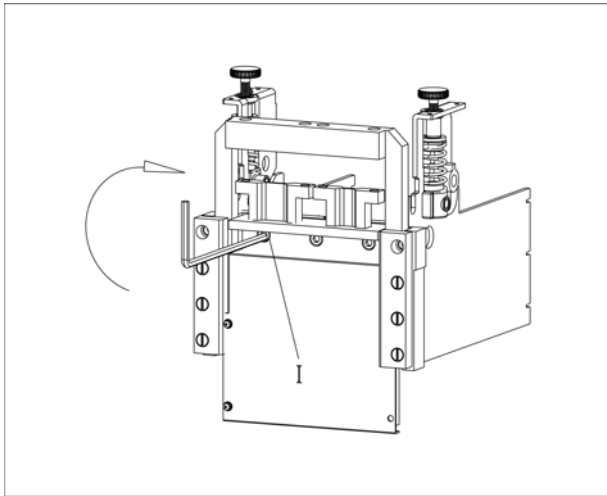


(e)

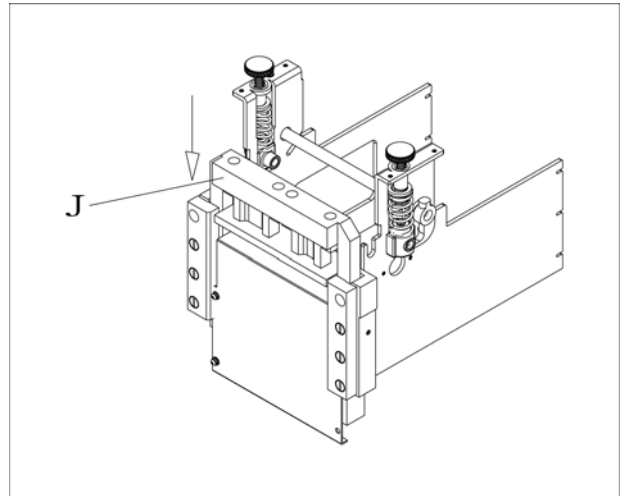


(f)

- (g) By 4mm-wrench, assemble punch set(inserted with M5-wrench bolts I) on the machine.
(This time, make punch die full-contact to lower knife case, and screw bolts by 2~3 times in turn.)
- (h) By soft touch of M/CUT button, press punches with upper knife case J little by little.

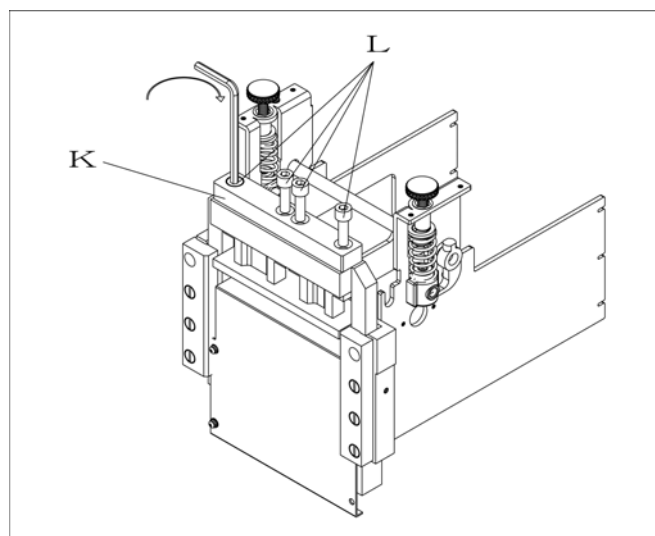


(g)



(h)

- (i) - Install punch-fix bracket K and by 5mm-wrench fit it in upper knife case.
- Release punch-die bolts I of fig. (g) a little and fasten it again. Release punch-fix bolts L a little and fasten it again.
 - After lubricating on punch, make upper knife case up & down 7~8 times by M/CUT.
 - After fastening punch-die & punch-fix bolts fully, assemble others in opposition.



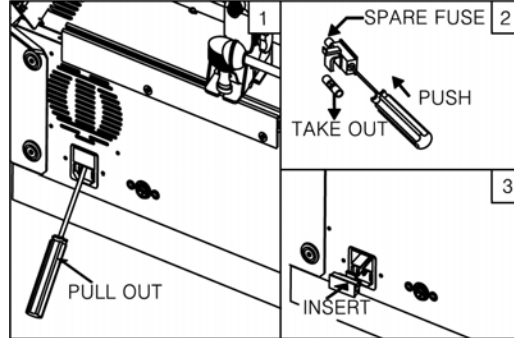
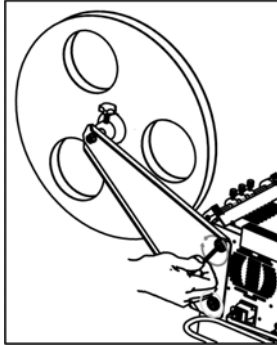
(i)

Mount of roll

Fix the roll triangle by 4mm-wrench.

Exchange of fuse

Take off the power plug and exchange as picture.



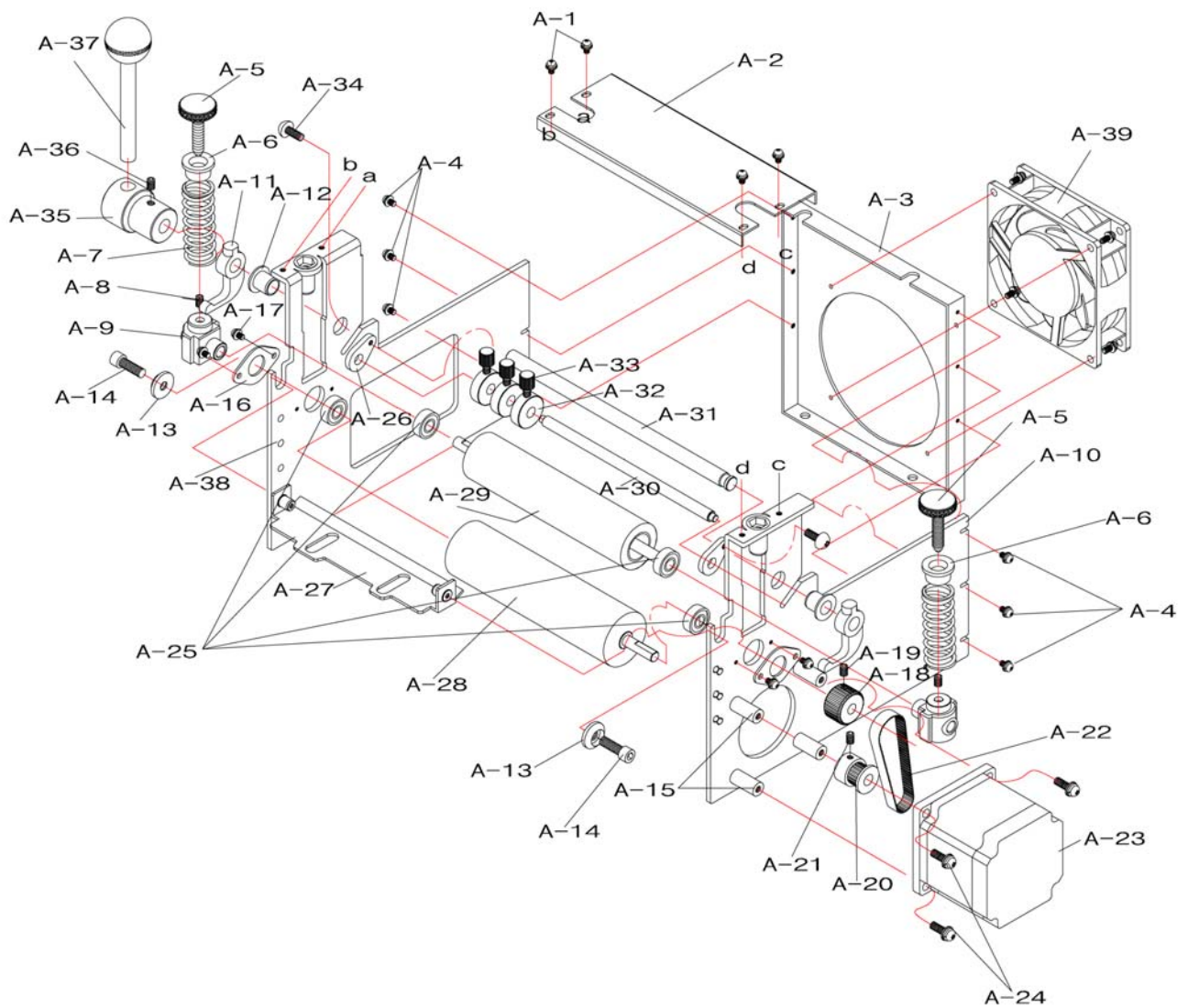
– Please contact following address for further information.



泰友精密
TAEWOO CO., LTD.

ADDRESS : A-302, 1025-1 DOGOK-RI, WABU-EUP,
NAMYANGJOO, KYONGGI-DO, KOREA
TEL +82 31 521-6904~7
FAX +82 31 521-6908
E-mail : taewoo@cutex.kr
www.cutex.kr

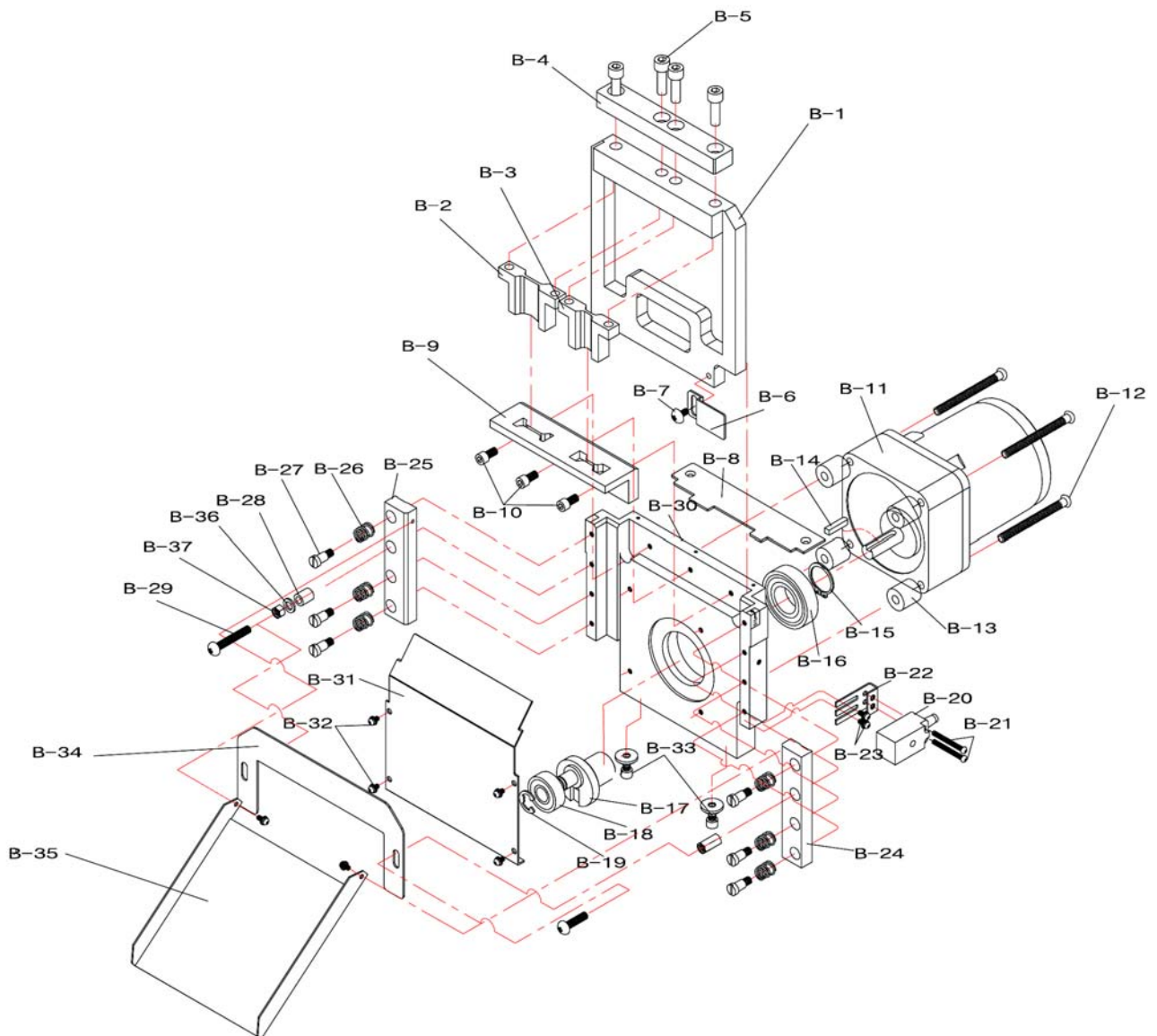
TBC-50R Part Drawing A (Feeding part)



TBC-50R Part List A (Feeding part)

Part No.	Description	Part No.	Description
A-1	Clamping Bolt(M3×6L)	A-21	Detent Screw(M3×6L)
A-2	Knife Safety Cover	A-22	Timing Belt(MXL75)
A-3	Space Plate of Roller Bracket	A-23	Stepping Motor
A-4	Clamping Bolt(M3×6L)	A-24	Clamping Bolt(M4×14L)
A-5	Pressure-control Bolt	A-25	Ball Bearing(#696)
A-6	Pressure-control Spring Cover	A-26	Guide-clamping Bracket
A-7	Pressure-control Spring	A-27	Stopper
A-8	Detent Screw(M4×6L)	A-28	Lower Roller
A-9	Slide Block of Upper Roller	A-29	Upper Roller
A-10	Right Roller Bracket	A-30	Front-guide Pin
A-11	Slide Lever	A-31	Lever Shaft
A-12	Oilless	A-32	Guide Ring
A-13	Clamping Washer	A-33	Knob Bolt of Guide Ring
A-14	Wrench Bolt(M4×12L)	A-34	Round Screw(M4×6L)
A-15	Tie Bar of Stepping Motor	A-35	Lever Bracket
A-16	Bearing Cover	A-36	Detent Screw(M5×6L)
A-17	Clamping Bolt(M3×6L)	A-37	Lever
A-18	Feed-timing Gear(MXL30T)	A-38	Left Roller Bracket
A-19	Detent Screw(M4×6L)	A-39	Cooling Fan
A-20	Drive-timing Gear(MXL20T)		

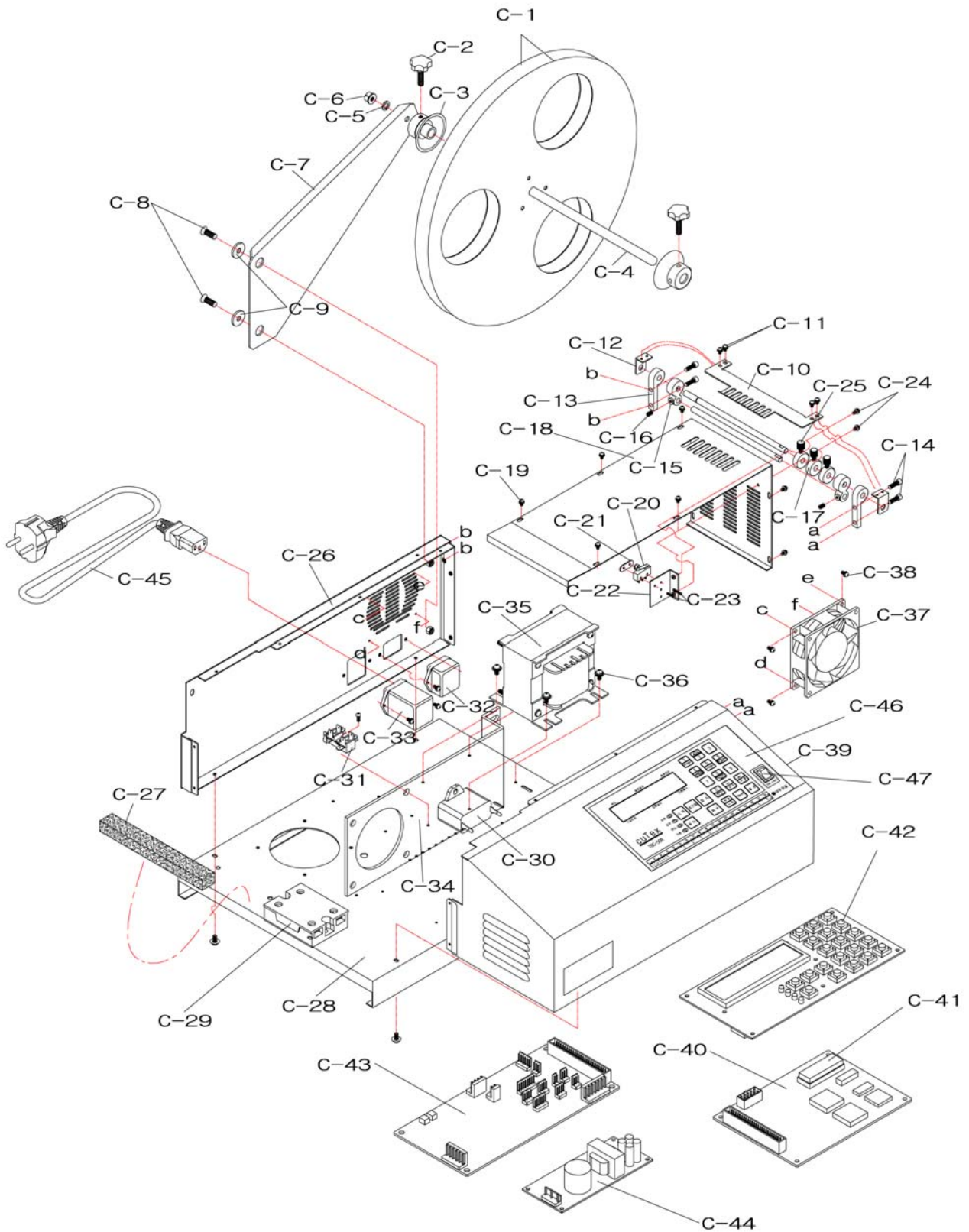
TBC-50R Part Drawing B (Cutting part)



TBC-50R Part List B (Cutting part)

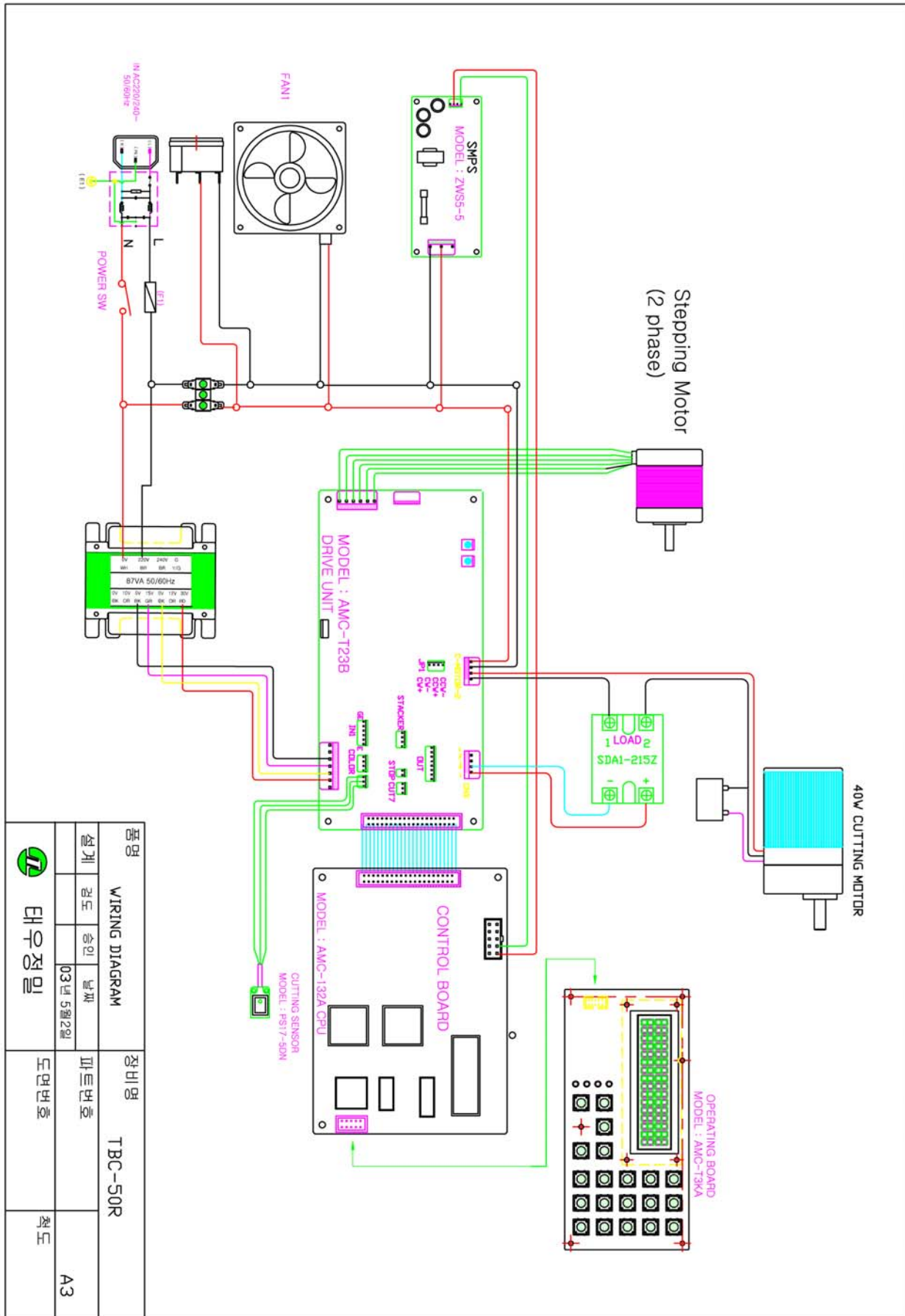
Part No.	Description	Part No.	Description
B-1	Upper Knife Case	B-21	Clamping Bolt(M3×22L)
B-2	Punch Mold 1	B-22	Clamping Bracket
B-3	Punch Mold 2	B-23	Clamping Bolt(M3×8L)
B-4	Clamping Bracket	B-24	Right Pressure Plate
B-5	Wrench Bolt(M6×30L)	B-25	Left Pressure Plate
B-6	Counting Sensor Bracket	B-26	Pressure Spring
B-7	Clamping Bolt(M4×6L)	B-27	Wrench Bolt(M5)
B-8	Pressure Bracket	B-28	Urethane Bush
B-9	Punch Dies	B-29	Tension-control Bolt
B-10	Wrench Bolt(M5×10L)	B-30	Lower Knife Case
B-11	Motor + Reduction Gear	B-31	Front Cover
B-12	Clamping Bolt(M6×80L)	B-32	Clamping Bolt(M3×6L)
B-13	Motor Supporter	B-33	Wrench Bolt(M5×10L)
B-14	Motor Key	B-34	Safety Cover
B-15	Snap Ring	B-35	Tape Guide
B-16	Ball Bearing(#6005)	B-36	Tension-control Washer
B-17	Crank Bundle	B-37	Tension-control Nut
B-18	Ball Bearing(#6000)		
B-19	E-Ring		
B-20	Counting Sensor		

TBC-50R Part Drawing C (Other parts)



TBC-50R Part List C (Other parts)

Part No.	Description	Part No.	Description
C-1	Roll-hanger Wheel	C-26	Left Cover
C-2	Clamping Bolt of Holder	C-27	Sponge
C-3	Holder	C-28	Base
C-4	Roll-hanger Shaft	C-29	SSR(Solid State Relay)
C-5	Roll-hanger Shaft Washer	C-30	Condenser
C-6	Wrench Bolt(M6×10L)	C-31	Terminal
C-7	Roll-hanger	C-32	AC Connector(OUT-PUT)
C-8	Flat-head Bolt(M6×20L)	C-33	AC Connector(IN-PUT)
C-9	Neck Washer of Roll-hanger	C-34	Radiating Plate of Step Motor
C-10	Existence Detector	C-35	Transformer
C-11	Clamping Bolt(M3×6L)	C-36	Clamping Bolt(M4×8L)
C-12	Clamping Bracket	C-37	Cooling Fan
C-13	Rear Guide-pin Bracket	C-38	Clamping Bolt(M3×8L)
C-14	Wrench Bolt(M4×12L)	C-39	Control Cover
C-15	Rear Tension-guide Block	C-40	Control Circuit Board(MB)
C-16	Detent Screw(M4×6L)	C-41	ROM
C-17	Guide Ring	C-42	Operation Circuit Board(OP)
C-18	Upper Guide Plate	C-43	Drive Circuit Board(DR)
C-19	Clamping Bolt(M3×6L)	C-44	SMPS(Power Supply)
C-20	Micro Limit Switch	C-45	Power Cord
C-21	Plate-nut	C-46	Urethane Panel
C-22	Limit Switch Bracket	C-47	Power Switch
C-23	Clamping Bolt(M3×12L)		
C-24	Clamping Bolt(M3×6L)		
C-25	Knob Bolt		



Trouble-shooting of TBC-50 series

No	Troubles		Applicable model	Causes & Measures
1	No power supply		All models	<ul style="list-style-type: none"> - Check if electric cord is connected well. - Check if the fuse blows out or not.
2	Power is on, but no work	Feeding roller doesn't work.	All models	<ul style="list-style-type: none"> - Check if there is inserted any alien substance in roller. - If current length on display is changed, exchange drive board. - If current length on display is not changed, exchange Control board(MB).
		Knife doesn't work.	All models	<ul style="list-style-type: none"> - Check if pressure plates of upper knife are too much fastened or not.
		LCD display doesn't work.	All models	<ul style="list-style-type: none"> - After opening the cover, check the connetion. (especially between Operation & MB board)
		All functions don't work	All models	<ul style="list-style-type: none"> - Check if auto-stop device lies down. If any, raise it up.
3	Material is not cut.		Hot cutter (H, LH, SH, HX)	<ul style="list-style-type: none"> - Check if temperature goes up to set-degree. - Check if knife blades are even(parallel).
4	Material is cut onesidedly.		All models	<ul style="list-style-type: none"> - Check if blades are damaged or weared. - After making both knives close each other by M/CUT button and check if they are even or not. (If they are not even, adjust them by bolts)
5	Cut-length is different from set-length.		All models	<ul style="list-style-type: none"> - Test cutting after loosening material from the reel by hand or attaching feeding device.
6	It cuts before the cutting line of labels.		Label cutter (S, SH)	<ul style="list-style-type: none"> - Move the sensor towards knife side as long as the difference by pushing.
7	It cuts after the cutting line of labels.		Label cutter (S, SH)	<ul style="list-style-type: none"> - Move the sensor towards counter-knife side as long as the difference by pushing.
8	ERROR on LCD & LED	ERROR CODE [064] >Sensor check Er	Label cutter (S, SH)	<ul style="list-style-type: none"> - Trouble in Mark sensor → · Check if the sensor is connected well or not. · Check if the sensor is adjusted well or not. (FILE NO 001) · Check if it is label problem or not.
		ERROR CODE [065] >CUT I/O Error!	All models	<ul style="list-style-type: none"> - Trouble in cutting motor or counting sensor → · Upper knife moves 1~3 sec. and ERROR on display. Check the connection of cutting sensor. If not, exchange the counting sensor. · Upper knife doesn't move and ERROR on display. Exchange the cutting motor or drive board.
		STOP INPUT !! CHECK STOP INP!	All models	<ul style="list-style-type: none"> - Auto stop device is pressed down or shortage. → raise up the device and check shortage.
		(C)ACORD CTRL-OP AMC-T3KA VER1.7D	All models	<ul style="list-style-type: none"> - Bad connected ROM → Press ROM by hand or connect it again. (If not, change MB board)
		ERROR CODE[065] >CHECK CODE[003]	All models	<ul style="list-style-type: none"> - Change of FILE 003 in program by noise or mis-operation → Initialize the controller. ※ How to Initialize(programs to be initial) : press SET+SHIFT/ESC buttons and RESET button at the same time. (Press RESET later than other two keys.)
9	Operator feels electric current in touch of machine.		All models	<ul style="list-style-type: none"> - Connect the earth cord(green) to any bolt of backside of machine.

※ A/S center : TEL +82 31 521 6904~7, FAX +82 31 521 6908