



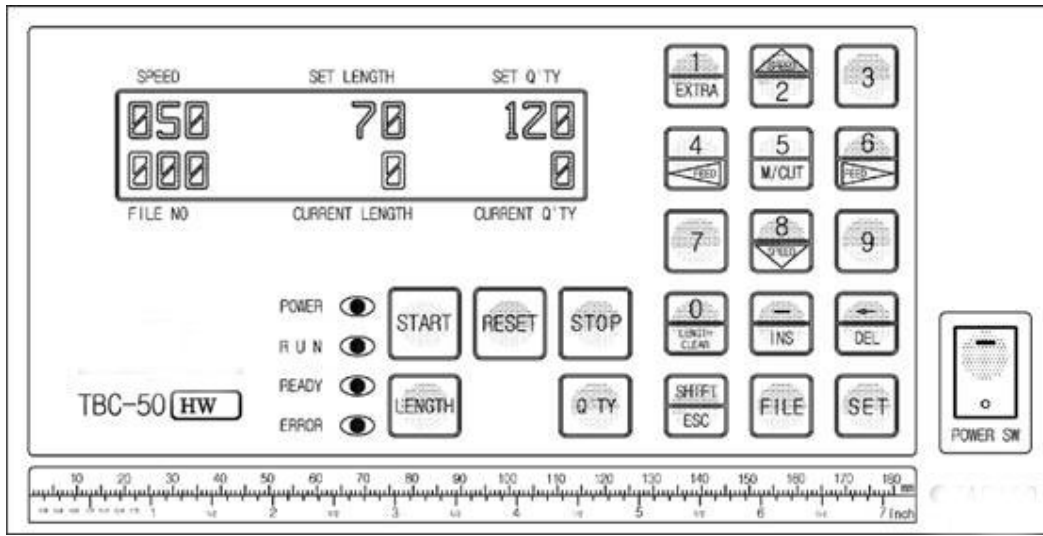
# Instruction Manual

## TBC-50HW



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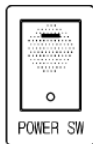
# TBC50-HW Operation



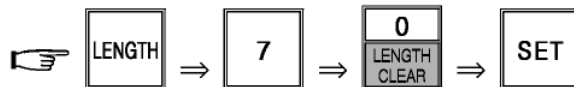
## 1. Machine Operation Example:

Running the machine to cut 120 pieces at 70mm per piece

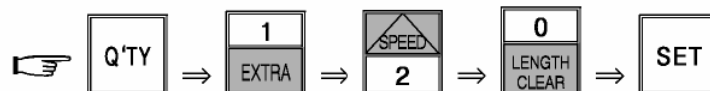
1. Turn on Power Switch



2. Set cut length by pressing the following buttons:



3. Set cut quantity by pressing the following buttons:



4. Press START button to begin operation:



# 1. Key Functions:



: Current preset length will be reset to 0.



: Current length and quantity will be reset to 0.



: Manual cut cycle

- ① To run a test cut
- ② To remove material jammed between knife blades
- ③ To align knife blades when replaced



: Cuts one additional piece



: Resets machine after ERROR (red LED) message appears



: To move roller manually for mounting material on machine or feeding it forwards or backwards



: Increase speed (Current speed appears on the top left side of display marked by a "%". Normal speed = 50%, Maximum speed = 100%.)



: Decrease speed (Current speed appears on the top left side of display marked by a "%". Normal speed = 50%, Minimum speed = 0%.)

\*Speed Up and Speed Down functions are available at any time (while in operation or while stopped). Preset specifications will be maintained through pressing reset button, or powering on and off.



: To correct wrong data

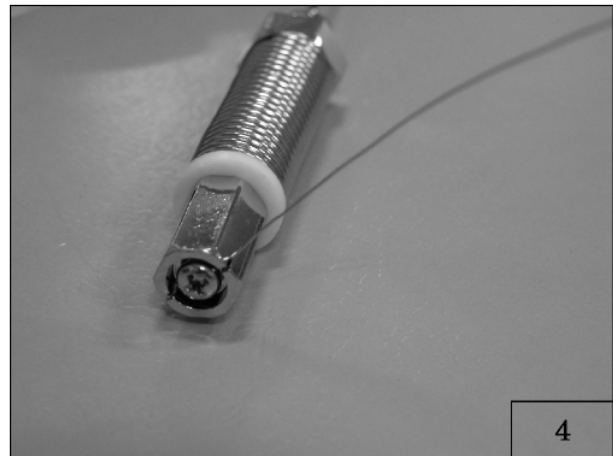
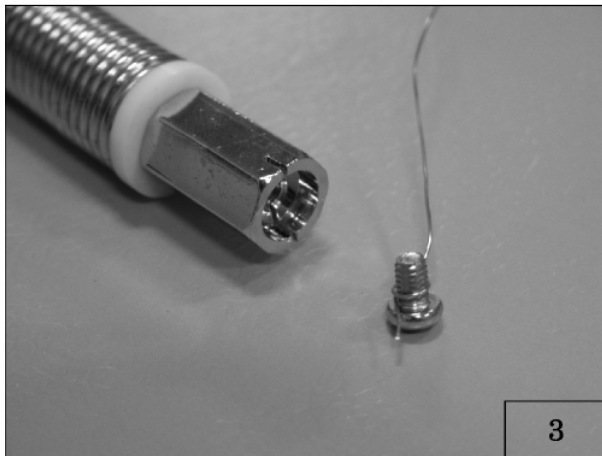
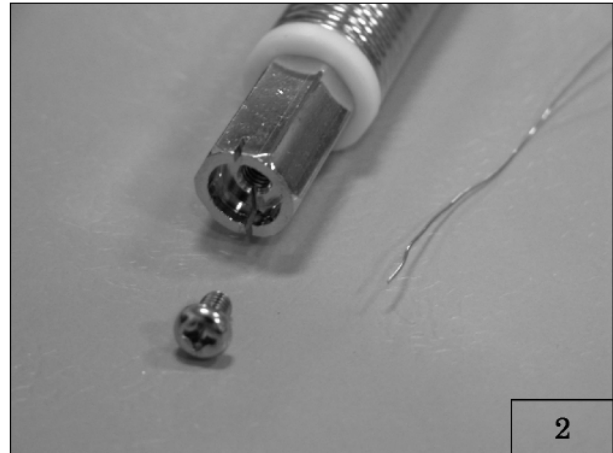
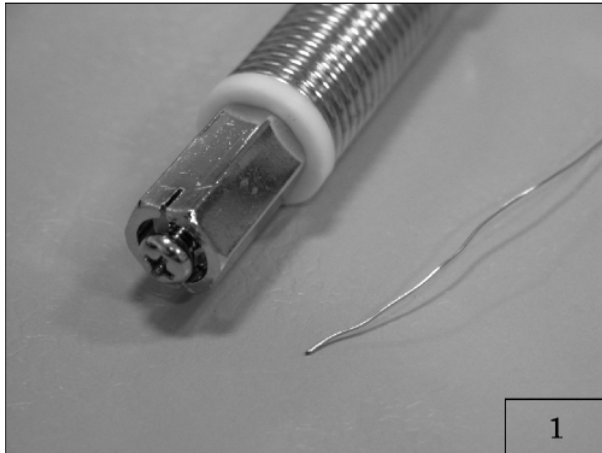
### 3. Specification

Model Name	Main Cutting Materials	Cutting Knife	Power Supply	Max. Cutting Width	Range of Cutting Length	Cutting Q'ty/min. (Length: 100mm)	Machine Size (Net Weight)	Packing Size (Gross weight)
TBC-50HW (expander sleeve cutter)	expander sleeve	Hot wire	AC110/220V 50/60Hz	70mm	15mm~ 99,999mm	25 cuts	820×370×380 (21.3kgs)	540×470×430 (26kgs)

### 4. Caution for use

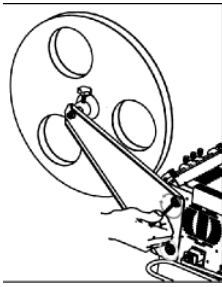
- Before use, please confirm the voltage and make ground(earth) connection.
- Do not access hands or any object close to the working How wire. (for safety)

#### **EXCHANGE OF HOT WIRE**



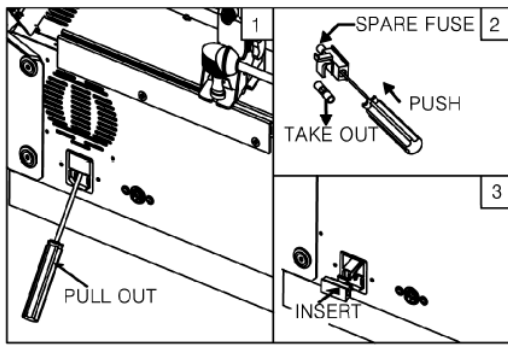
**Mount of roll**

**Fix the roll triangle by 4mm-wrench.**



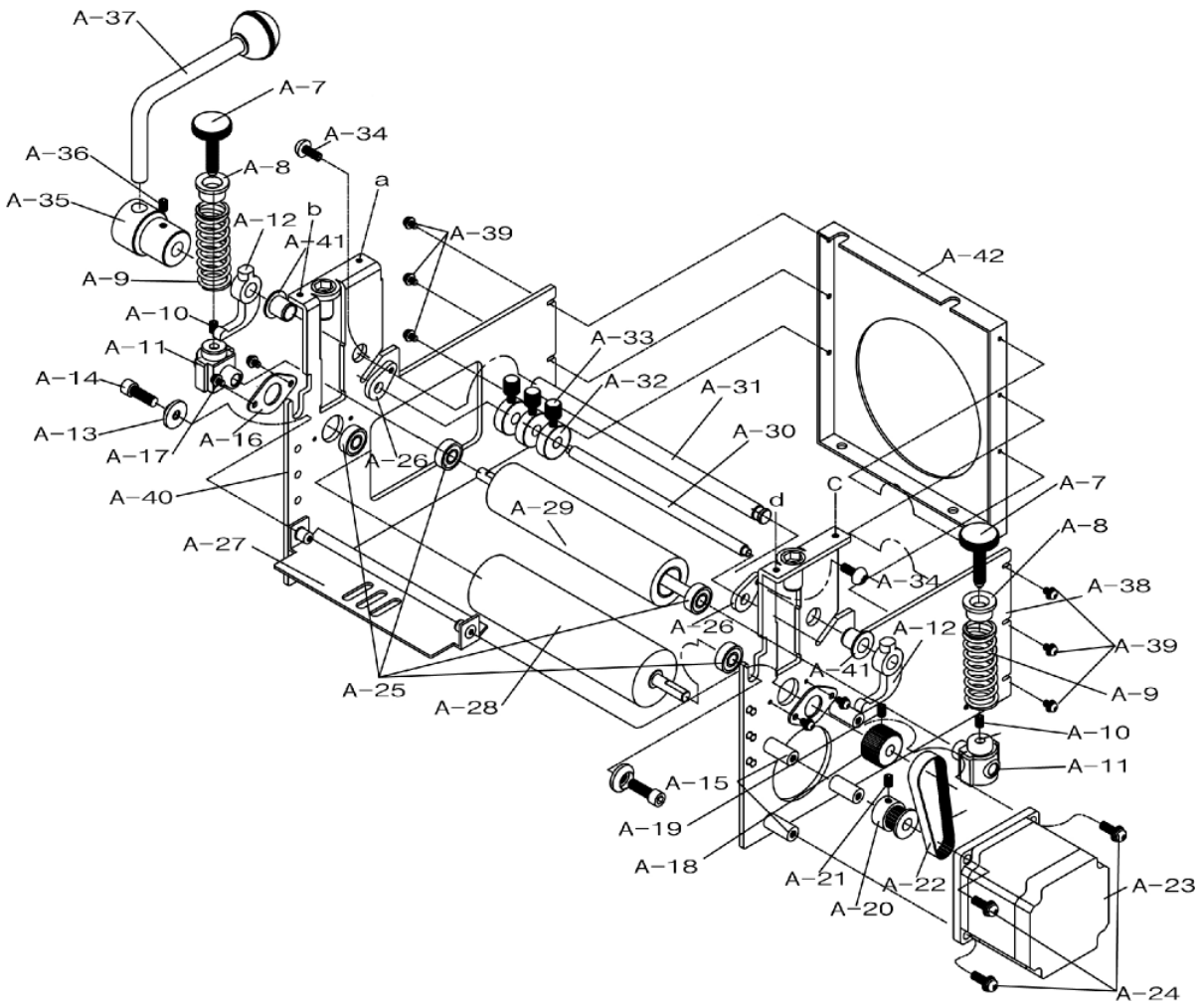
**Exchange of fuse**

**Take off the power plug and exchange as picture.**



- Please contact following address for further information.

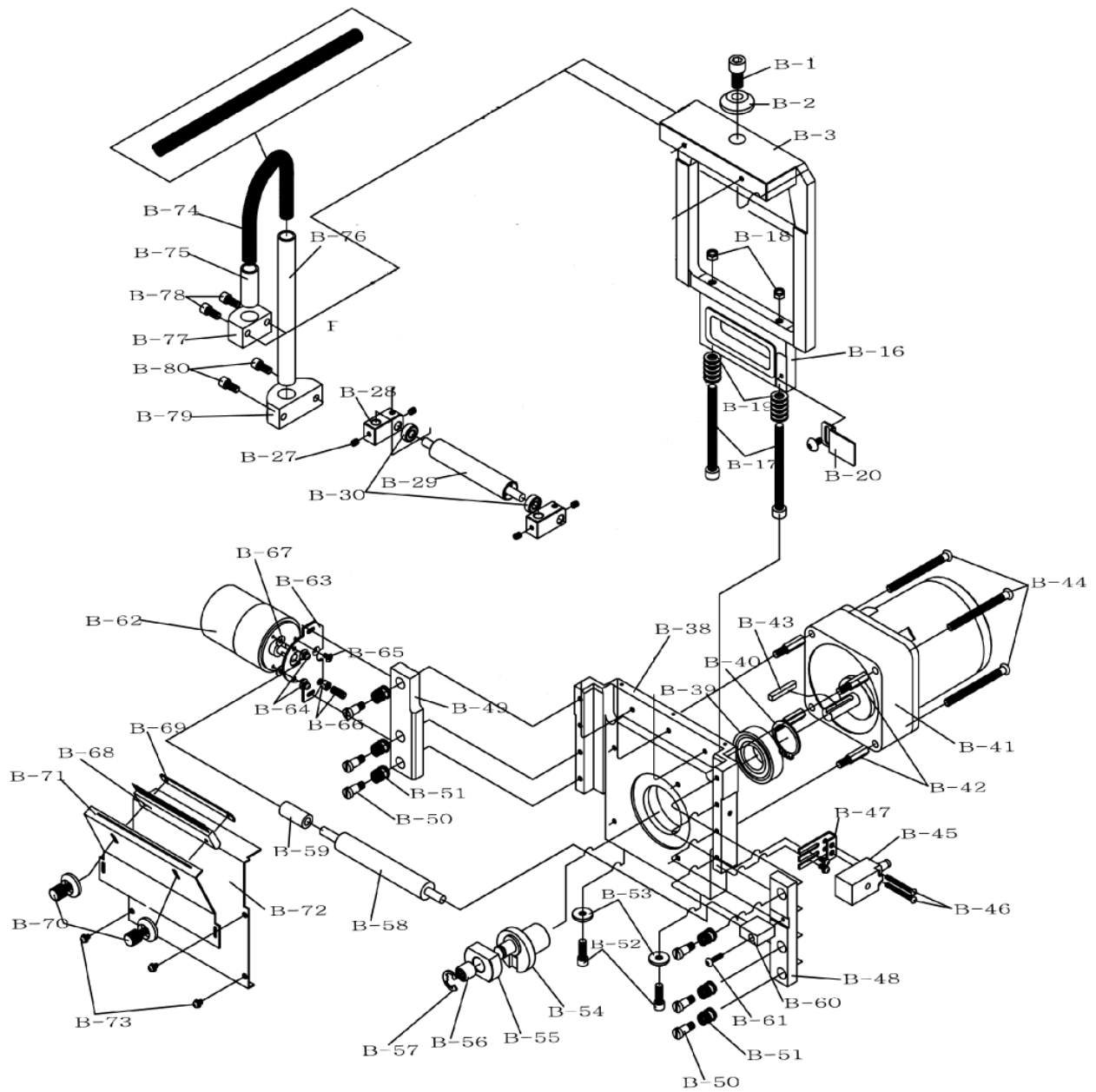
Part Drawing A of TBC-50H (Feeding part)



Part List A of TBC-50H (Feeding part)

Part No.	Description	Part No.	Description
A-1	-	A-23	Stepping Motor
A-2	-	A-24	Clamping Bolt(M4×13L)
A-3	-	A-25	Ball Bearing(#696)
A-4	-	A-26	Guide-clamping Bracket
A-5	-	A-27	Stopper
A-6	-	A-28	Lower Roller
A-7	Pressure-control Bolt	A-29	Upper Roller
A-8	Pressure-control Spring Cover	A-30	Front-guide Pin
A-9	Pressure-control Spring	A-31	Lever Shaft
A-10	Detent Screw(M4×6L)	A-32	Guide Ring
A-11	Slide Block of Upper Roller	A-33	Knob Bolt of Guide Ring
A-12	Slide Lever	A-34	Round Screw(M4×5L)
A-13	Clamping Washer	A-35	Lever Bracket
A-14	Wrench Bolt(M4×14L)	A-36	Clamping Bolt(M5×5L)
A-15	Tie Bar of Stepping Motor	A-37	Lever
A-16	Bearing Cover	A-38	Right Roller Bracket
A-17	Clamping Bolt(M3×5L)	A-39	Clamping Bolt(M3×5L)
A-18	Feed-timing Gear(MXL30T)	A-40	Left Roller Bracket
A-19	Detent Screw(M4×6L)	A-41	Oilless
A-20	Drive-timing Gear(MXL20T)	A-42	Space Plate of Roller Bracket
A-21	Detent Screw(M3×6L)		
A-22	Timing Belt(MXL75)		

Part Drawing B of TBC-50H (Cutting part)

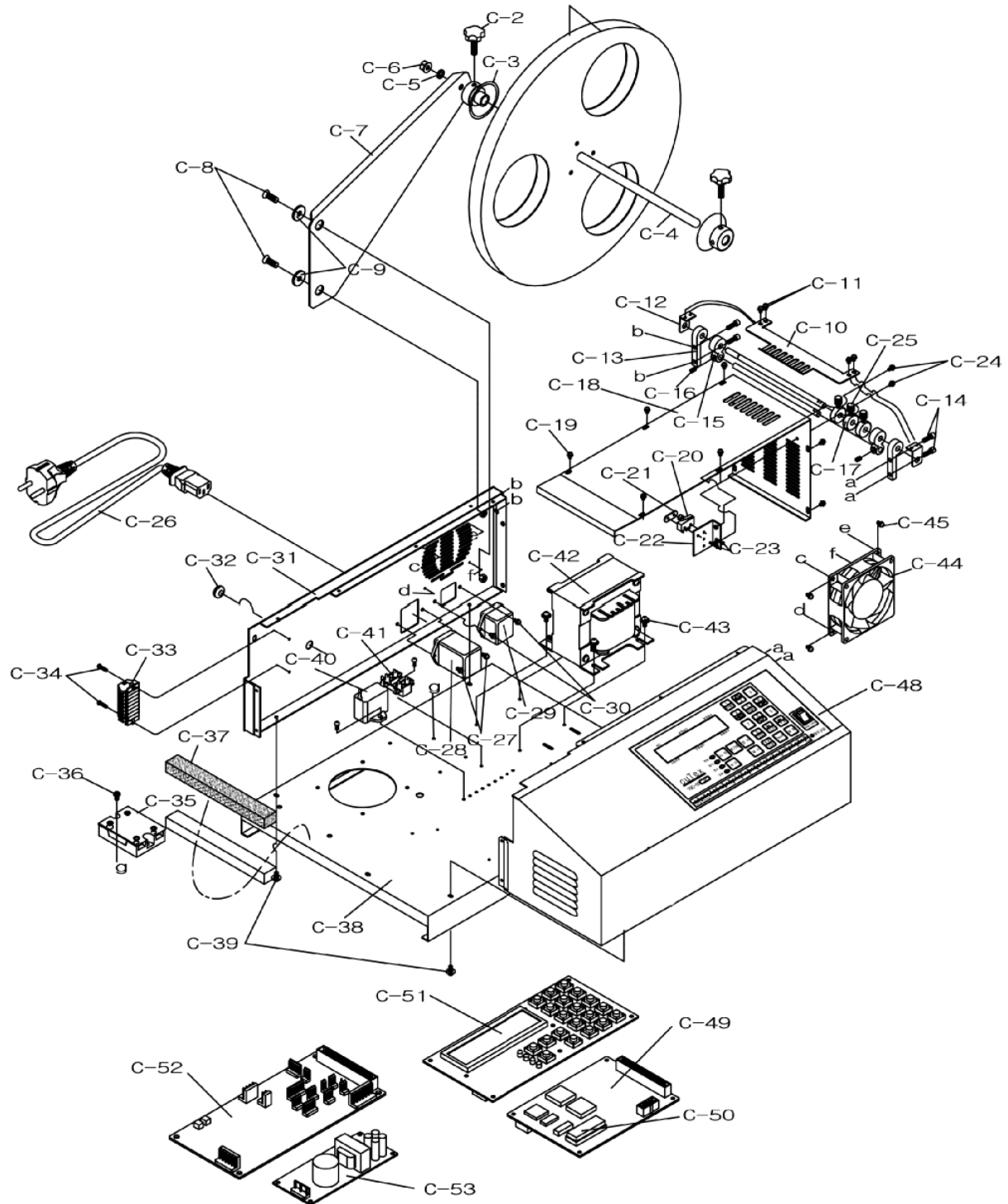




Part List B of TBC-50H (Cutting part)

Part No.	Description	Part No.	Description
B-1	Clamping Bolt(M8×15L)	B-38	Lower Knife Case
B-2	Neck Washer of Hot-knife Bracket	B-39	Ball Bearing(#6004)
B-3	Upper Knife Case	B-40	Snap Ring
B-4	-	B-41	Motor+Reduction Gear
B-5	-	B-42	Motor Supporter
B-6	-	B-43	Motor Key
B-7	-	B-44	Clamping Bolt(M5×42L)
B-7b	-	B-45	Counting Sensor
B-8	-	B-46	Clamping Bolt(M3×18L)
B-9	-	B-47	Clamping Bracket
B-10	-	B-48	Right Pressure Plate
B-11	Pressing Plate Cover	B-49	Left Pressure Plate
B-12	Clamping Bolt(M4×6L)	B-50	Clamping Bolt of Pressure Plate
B-13	Front Cover	B-51	Pressure Spring
B-14	Clamping Bolt(M3×5L)	B-52	Wrench Bolt(M5×15L)
B-15	Slide Ram	B-53	Neck Washer
B-16	Clamping Bolt(M6×80L)	B-54	Crank Bundle
B-17	Check Nut(M6)	B-55	Cam
B-18	Flat-head Washer Spring	B-56	Niddle Bearing
B-19	Counting-sensor Bracket	B-57	E-Ring
B-20	-	B-58	Front Feeding Roller
B-21	-	B-59	Front Feeding Sub-roller
B-22	-	B-60	Roller Shaft Bracket
B-23	-	B-61	Clamping Bolt(M3×12L)
B-24	-	B-62	DC Motor
B-25	-	B-63	DC Motor Bracket
B-26	Detent Screw(M4×6L)	B-64	Clamping Bolt(M3×4L)
B-27	Roller-clamping Bracket	B-65	Flat-head Bolt(M3×4L)
B-28	Pressing Roller	B-66	Vertical Control Nut
B-29	Roller Shaft	B-67	Flat Washer
B-30	Ball Bearing(#686)	B-68	Heater Wiring Spring
B-31	-	B-69	Heater Wiring Pipe(1)
B-32	-	B-70	Heater Wiring Pipe(2)
B-33	-	B-71	Upper Pipe Bracket
B-34	-	B-72	Wrench Bolt(M4×15L)
B-35	-	B-73	Lower Pipe Bracket
B-36	-	B-74	Wrench Bolt(M4×15L)
B-37	-		

Part Drawing C of TBC-50H (Other parts)



Part List C of TBC-50H (Other parts)

Part No.	Description	Part No.	Description
C-1	Roll-hanger Wheel	C-28	AC Connector(IN-PUT)
C-2	Clamping Bolt of Holder	C-29	AC Connector(OUT-PUT)
C-3	Holder	C-30	Clamping Bolt(M3×5L)
C-4	Roll-hanger Shaft	C-31	Left Cover
C-5	Roll-hanger Shaft Washer	C-32	Rubber Bushing
C-6	Check Nut(M6)	C-33	Separated Terminal
C-7	Roll Hanger	C-34	Clamping Bolt(M3×6L)
C-8	Flat-head Bolt(M6×16L)	C-35	SSR(Solid State Relay)
C-9	Neck Washer of Roll-hanger	C-36	Clamping Bolt(M4×8L)
C-10	Existence Detector	C-37	Sponge
C-11	Clamping Bolt(M3×5L)	C-38	Base
C-12	Clamping Bolt	C-39	Clamping Bolt(M4×8L)
C-13	Rear Guide-pin Bracket	C-40	Condenser
C-14	Wrench Bolt(M4×15L)	C-41	Terminal
C-15	Rear Tension-guide Block	C-42	Transformer
C-16	Detent Screw(M4×6L)	C-43	Clamping Bolt(M4)
C-17	Guide Ring	C-44	Cooling Fan(Large)
C-18	Upper Guide Plate	C-45	Clamping Bolt(M3×6L)
C-19	Clamping Bolt(M3×5L)	C-46	-
C-20	Micro Limit Switch	C-47	-
C-21	Plate Nut	C-48	Control Cover
C-22	Limit Switch Bracket	C-49	Control Circuit Board(MB)
C-23	Clamping Bolt(M2×10L)	C-50	ROM
C-24	Clamping Bolt(M3×5L)	C-51	Operation Circuit Board(OP)
C-25	Knob Bolt	C-52	Drive Circuit Board(DR)
C-26	Power Cord	C-53	SMPS(Power Supply,SP)
C-27	Clamping Bolt(M3×5L)		

## Trouble-shooting of TBC-50 series

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