



CS-9018 Cutter Stacker Operator's Guide





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SATO

10350-A Nations Ford Road

Charlotte, NC 28273

Phone: 704-644-1650

www.satoamerica.com

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Printed in the United States of America.

Revision History

Initial release	October 1, 2003	rev. -00
Revision	February 12, 2007	rev. -01

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1. BASICS

1.1. SAFETY INSTRUCTIONS

Safety Instructions for Transport and Set-Up

The following instructions and warnings are applied to the packing to ensure appropriate and safe transport.



Upright position only!



Protect from humidity and outdoor weather!



Fragile! – Handle with care!

These instructions and warnings must also be observed for transport within the user's premises.

For transport to other premises or for return shipment, the machines must be packed and provided with the same markings.

Meanings of Symbols

The following symbols and designations are used in the Guide to identify instructions of particular importance:



Remove power from the machine by unplugging the main power cord.



Instructions designed to prevent injury or extensive equipment damage.



An electrical shock hazard exists.



General instructions and special information how to use the machine most efficiently.



Instructions to use extreme caution to prevent bodily injury.

Meanings of Signal Words



WARNING: INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF IGNORED, COULD RESULT IN SERIOUS PERSONAL INJURY.



CAUTION: INDICATES A HAZARDOUS SITUATION WHICH, IF IGNORED, COULD RESULT IN A MODERATE PERSONAL INJURY, OR COULD CAUSE MACHINE DAMAGE.



NOTE: Emphasizes essential information.

Retain the product's safety and operating instructions for future reference. Follow all operating and usage instructions. Observe all warnings on the product and in the operating instructions.

To reduce the risk of fire, bodily injuries, and damage to the equipment, observe the following precautions:

Damage Requiring Service

Unplug the product from the electrical outlet and call the authorized service provider under the following conditions:

- The power cord, extension cord, or plug is damaged.
- Liquid has been spilled or an object has fallen into the product.
- The product has been exposed to water.
- The product has been dropped or damaged in any way.
- There are noticeable signs of overheating.
- The product does not operate normally when you follow the operating instruction.

Servicing

Except as explained elsewhere in the documentation, do not service this product yourself. Opening or removing enclosures may expose you to electrical shock or injury. Service needed on components inside these compartments should be done by an authorized service provider using the manufacturer's spare parts.

Installation and Mounting

The installation of the Product should follow the manufacturer's instructions.

Ventilation

Openings in the product are provided for ventilation and should never be blocked or covered since these ensure reliable operation of the product and protect it from overheating.

Water and Moisture

Do not use the product in a damp or wet location.

Grounded (Earthed) Products

This product is equipped with a three-wire electrical grounding-type plug that has a third pin for grounding.

For safety reasons this plug will only fit into a grounded electrical outlet.

Do not remove the ground pin or defeat this safety feature by trying to insert it into a non-grounded outlet.

Power Sources

The product should be operated only from the type of power source indicated on the product's electrical rating label.

Accessibility

Be sure that the power outlet you plug the power cord into is easily accessible and located as close to the equipment operator as possible. When you need to disconnect power to the equipment, be sure to unplug the power cord from the electrical outlet.

Safety Covers and Enclosures

To prevent access to areas containing hazardous energy levels and mechanical parts in movements, this product has enclosures and safety covers.

The closure of the covers is detected by switches. All the mechanical parts in movement are automatically blocked when the protective cover is opened by the operator.

The enclosures are locked with screws. For this product, observe the following precautions:

Do not remove enclosure covers or attempt to defeat the safety switches.

Repair should be performed by individuals who are qualified in servicing paper processing and finishing equipment and trained to deal with products capable of producing hazardous energy levels and mechanism in movement.

Installation Requirements

This product operates safely when used for its intended purpose within its electrical ratings and product usage instructions.

Replacements Parts

When replacement parts are required, be sure the service provider uses replacement parts specified by the manufacturer.

1.2. INTRODUCTION

The Model CS-9018 Cutter Stacker is a self-contained device designed to slit, cut and sequentially stack tickets. Throughput speed is variable and application dependent.

The tickets that feed into the CS-9018 are pre-printed on continuous forms, generally with 3 to 17 tickets running horizontally across the width of the form. The cutter stacker will slit and cut tickets precisely, to any length and width in the specified range.

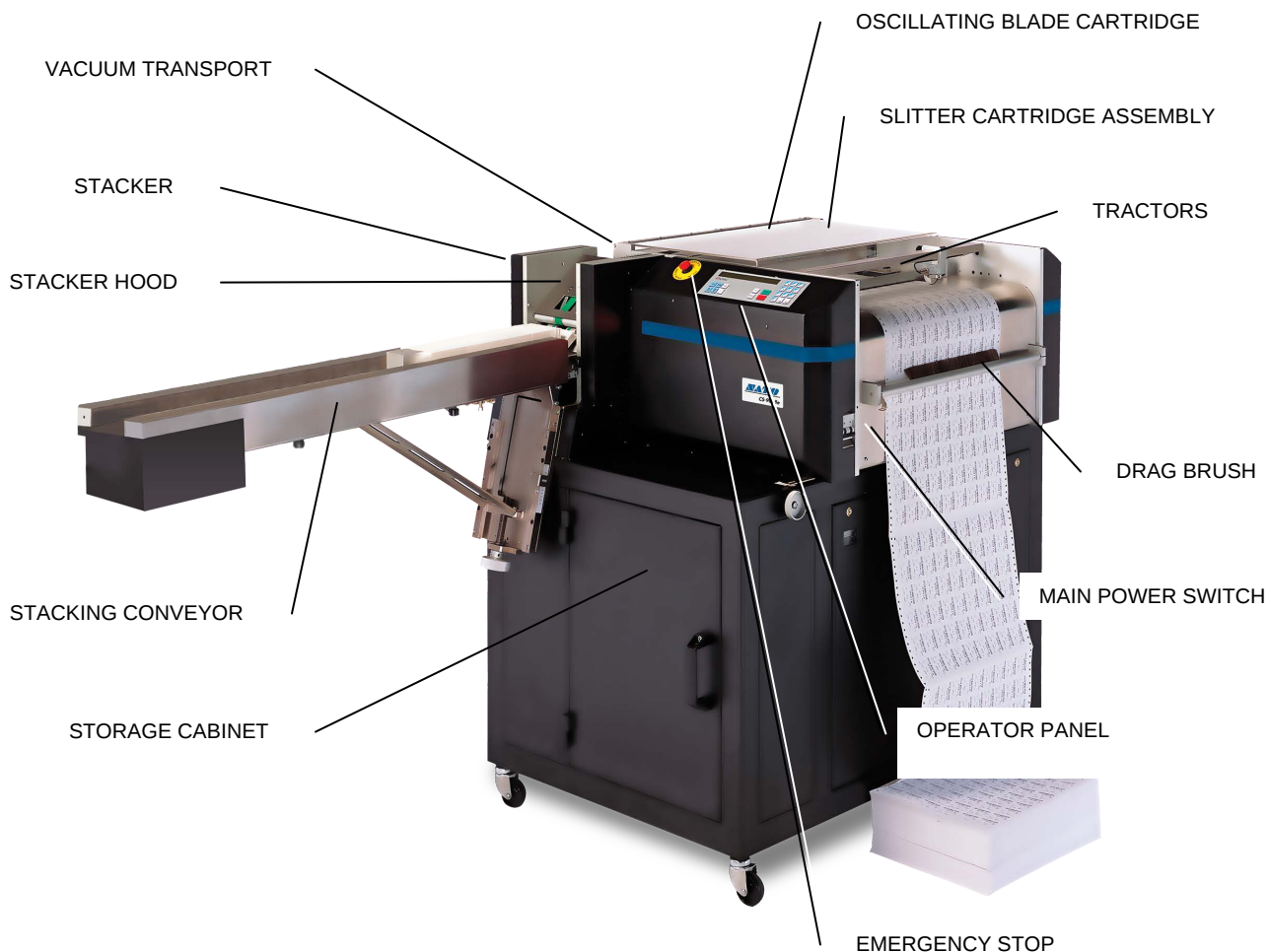
The stacker can hold up to 38" of tickets, or approximately 3500 tickets, dependent on application, ticket thickness and operator's preferences without unloading. Tickets can be unloaded easily during operation, without shutting down the unit or interrupting the cutting cycle.

1.3. OVERVIEW

The preprinted tickets feed up under the drag brush and protective cover, and onto the tractors. They are slit vertically by the slitter assembly, and then cut by the oscillating knife. Once cut, the tickets fall onto a vacuum transport where a vacuum belt holds them in place and moves them toward the stacker. As the tickets pass under the stacker hood they are put in order sequentially, as printed left-to-right across the forms, then placed on the stacking conveyor.

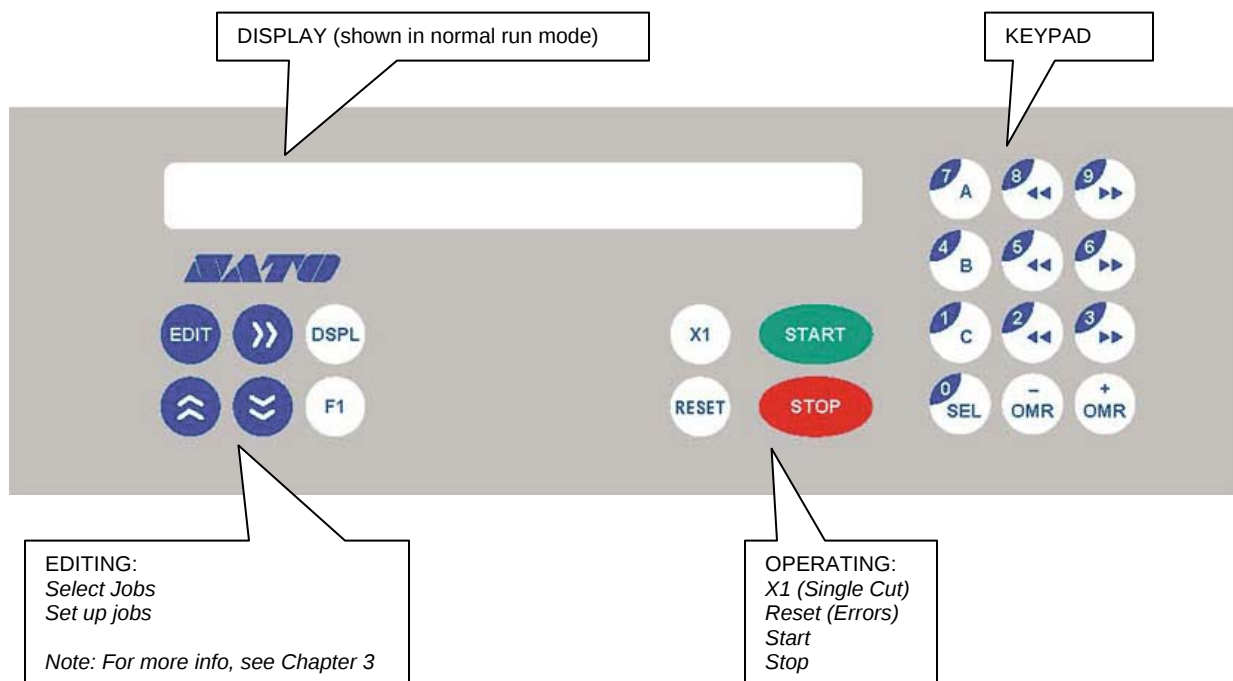
Assuming the forms were printed on a SATO laser printer, special separator tickets will be easily visible between batches, simplifying the job of separating the batches when you remove the tickets from the stacker.

The CS-9018 has a storage cabinet on the operator's side which contains the vacuum filter and will also accommodate storage of sundries. The main power switch is located on the front of the CS-9018 adjacent to the brush. The emergency stop switch is located adjacent to the operator panel.



1.3.1. Operator Panel

The keyboard is located on the left side of the ticket cutter and is divided into four parts:



1.3.1.1. Editing Section

This section is used to select or set up jobs. For more information on how to use, see Chapter 2 for selecting jobs and Chapter 3 for setting up jobs.

1.3.1.2. Operating Section

Pressing **X1** starts all motors and will align the forms with the oscillating knife when forms are first loaded. After the vacuum is ready (approximately 5 seconds) and the forms

have been aligned, pressing **X1** cuts a single row of tickets.

Pressing **START** will also align the forms with the oscillating knife when forms are first loaded. After the vacuum is ready (approximately 5 seconds) and the forms have been aligned, pressing **START** a second time starts the continuous processing of tickets.

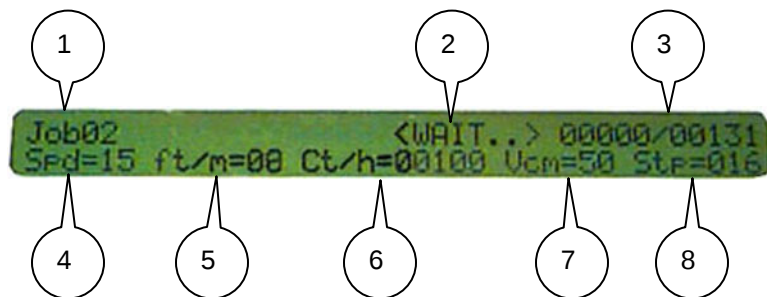
1.3.1.3. Keypad Section

The keypad is used in connection with the EDITING section for the set up of new applications and the modification of the existing ones.

It is also used to adjust the cutting registration, cutter speed, vacuum, and exit conveyor spacing.

Note: For more info, see Chapter 2 – “Changing Settings While Running”

1.3.1.4. Display Section

**NORMAL RUN SCREEN**

1. Job02 is the current job selected (see Chapter 2.11).
2. <WAIT> is displayed when  is pressed and until the vacuum reaches run levels.
3. 00000/00131– The right # "00131" is the preset group size and the left number "00000", currently starting, is the group count (see Chapter 3.3.7).
4. Spd=## is the current setting for the tractor feed speed (see Chapter 3.3.2). When the "=" sign is flashing, a password has been entered successfully (see chapter 2.11.1).
5. ft/m is the rate in feet per minute the forms are being processed.
6. Ct/h is the number of cuts per hour the oscillating blade is making.
7. Vcm is the current setting for the intensity of the vacuum to the vacuum transport (see Chapter 3.3.8).
8. Stp is the current setting for the speed of the stacking conveyor (see Chapter 3.3.9).



NOTE: For more information on job settings refer to Chapter 3 of this Guide.

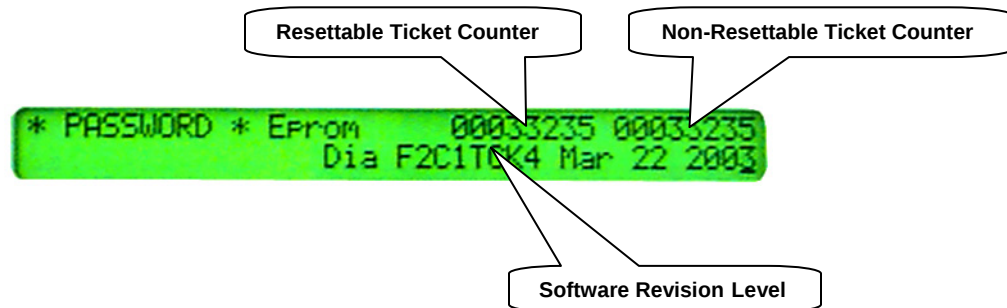
**EXAMPLE OF AN ERROR SCREEN**

NOTE: The meanings of all error screens are listed in Chapter 4.2.2.

1.3.1.5. Password Screen

The number in the upper right portion of the screen is the ticket counter. This is non-resettable unless the RAM is drained. The number next to it is a resettable counter. This counter is reset by pressing and holding RESET while pressing "1" and then "2".

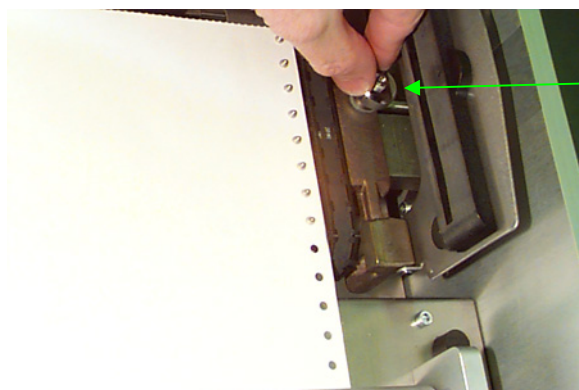
Counts displayed are the number of cuts, not tickets.



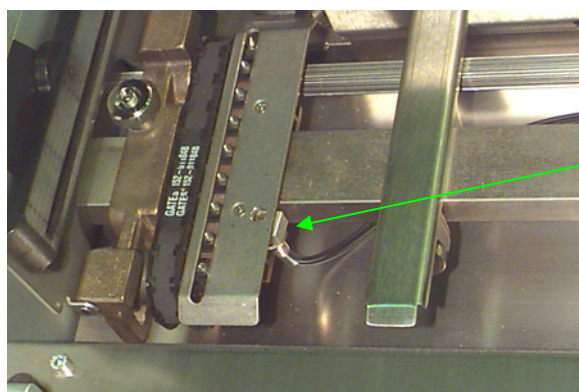
1.3.2. Paper Feeding Group

The position of the left and right tractors can be adjusted to match the form width. Generally the left tractor remains in one position and the right tractor is adjusted to match the form width. Moving both tractors left/right slightly, however, will allow for the fine registration of the forms with the slit knives.

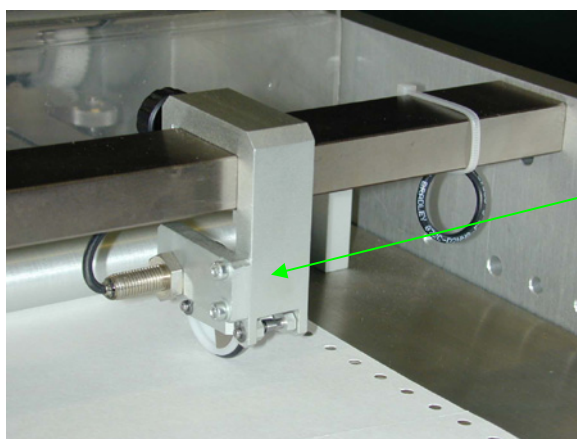
On the left tractor there is an optical sensor that detects both the leading edge of the form. This is used to set the top of the form each time the form is loaded, power is cycled, or a new job is recalled. The cutter jam sensor detects jams and end of form.



LOOSEN KNOB TO ADJUST TRACTOR



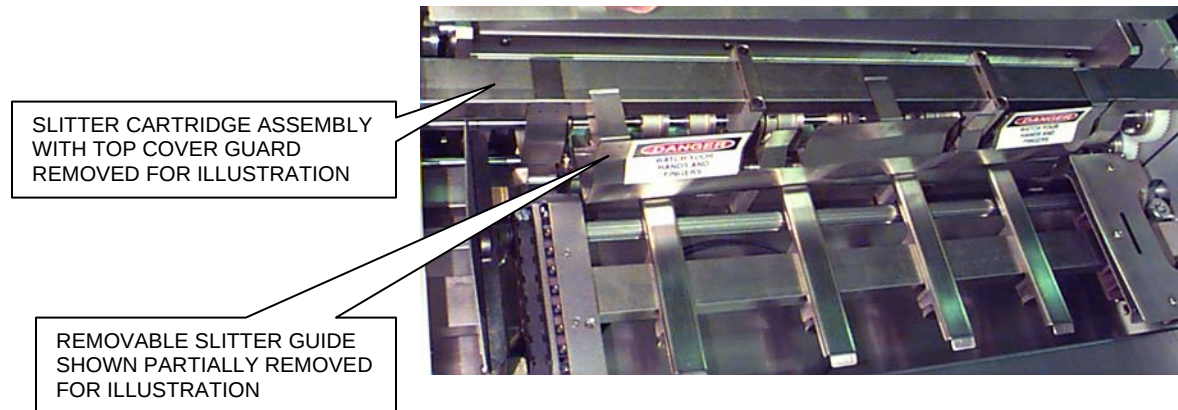
FORM LOAD SENSOR



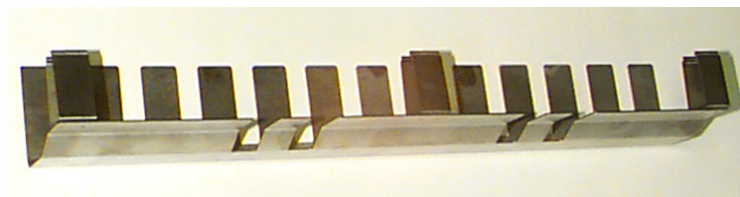
CUTTER JAM SENSOR

1.3.3. Slitter Cartridge Assembly (Ticket Width)

The slitter cartridge assembly, located just after the tractors and before the oscillating blade, is responsible for slitting the tickets to their proper width. When you align your forms, make sure the slitter knives are centered on the tickets. This ensures you have selected the correct slitter assembly for the application. The left tractor should always stay in its factory set position. Adjust the right tractor to compensate for form width changes.



WARNING! USE EXTREME CAUTION IN THIS AREA! THE SLITTERS ARE EXTREMELY SHARP.



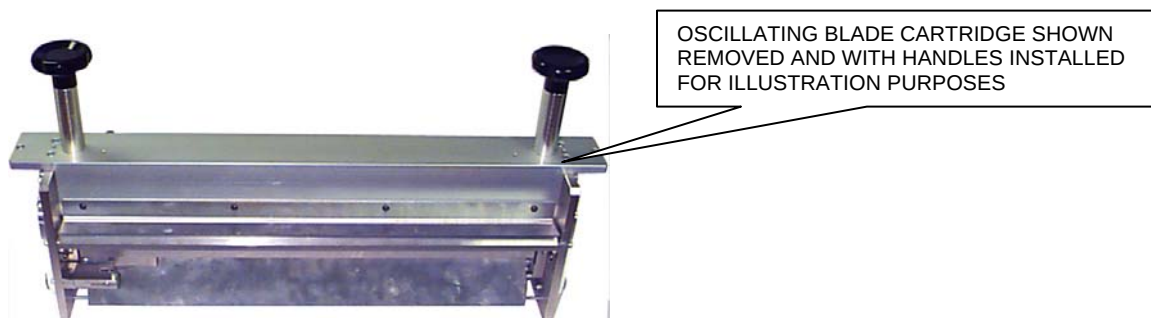
SLITTING GUIDE REMOVED

Each assembly is factory set for a specific number of tickets and a specific ticket width. Each assembly comes with slitting guides designed for a specific application. The slitter cartridge can be removed by the user for configuration changes or maintenance. Often, you will have more than one slitter assembly at a site. Chapter 2.11.2.3 describes how to change the slitter assembly.

1.3.4. Oscillating Blade Cartridge

The oscillating blade cartridge is responsible for the cross cutting of the form (i.e. the ticket length). The length of the ticket is adjusted through the keyboard during setup; see Chapter 3.3.5, "Cut Length". There are no mechanical adjustments required for this assembly.

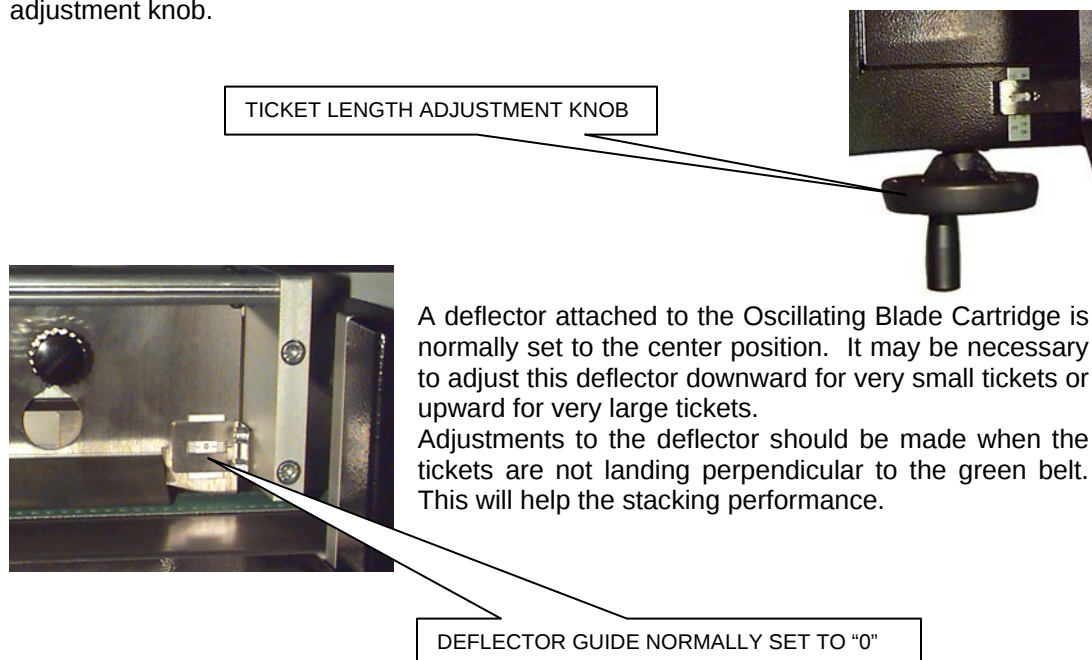
Occasionally it may be necessary to remove the blade cartridge to help clear forms from that area or to perform maintenance on the cartridge. Refer to Chapter 4.1.1 for more information.



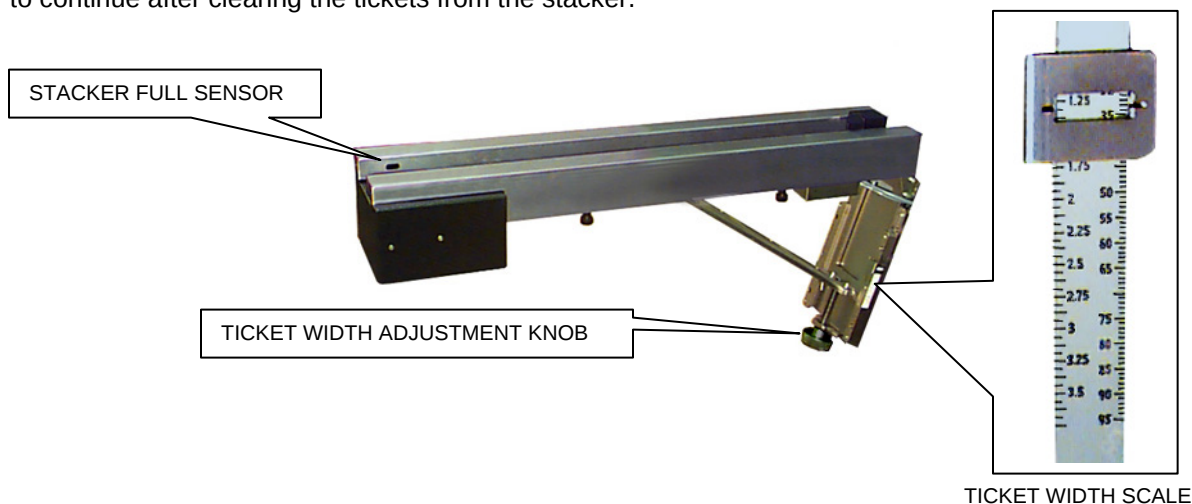
1.3.5. Transport and Stacker

After the tickets are slit and cut they are deflected onto the vacuum transport assembly that moves the tickets toward the stacker, while holding them securely to the belt.

The cut tickets should be centered on the vacuum belt by adjusting the ticket length adjustment knob.



A stacking conveyor carries the tickets away and will stop when the stack reaches a stacker full sensor at the output end. It is necessary to press the RESET and START key to continue after clearing the tickets from the stacker.



When setting up a new job, the ticket width adjustment knob, located under the stacker, must be adjusted for the width of the new ticket. It may be necessary to fine tune this after the tickets have begun processing.

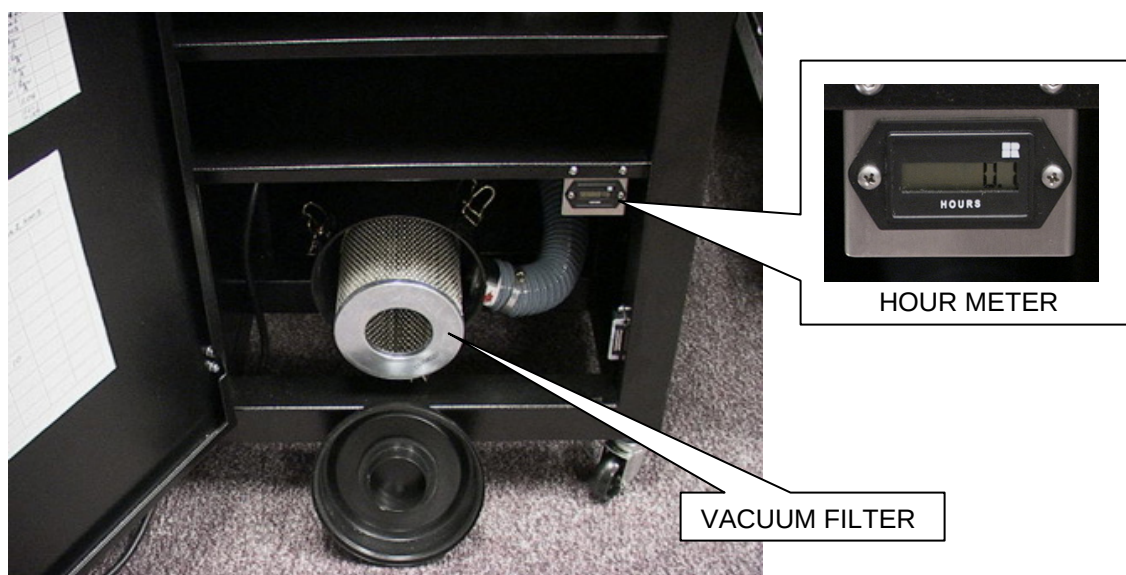
Press the  key a number of times until the stack reaches the black stacker belt.

1.3.6. Vacuum

The vacuum is located in the main cabinet under the form feed/slitter area. Vacuum pressure can be adjusted through the keyboard and programmed through the setup feature. Chapter 3.3.8 "Vacuum" explains how to do this.

The vacuum filter can be accessed through the side cabinet door on the operator side and should be changed periodically. Chapter 5 "Caring for the CS-9018" explains how and when to do this.

An hour meter is also located here. This meter runs whenever any of the motors are running.



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2. USING THE CS-9018

This chapter describes how to start and stop the CS-9018, how to load paper, and how to run a job. This Chapter assumes the jobs have been setup already. For information on how to setup a job, refer to Chapter 3 “Job Setup”

Read the “Changing Jobs” section shown later in this chapter first if the CS-9018 hasn't been setup to run the current job.

2.1. LOADING PAPER

- Open the clear protective top cover.



- Open the tractor covers.



- Release the drag brush by pressing down on the drag brush release lever.



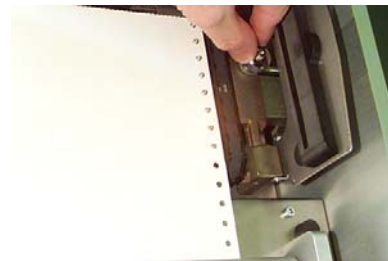
- Pass the paper under the brush.



- Load forms on the left tractor and close the tractor cover.



- Loosen the right tractor knob and adjust the right tractor position so the form paper holes are centered on the sprockets.

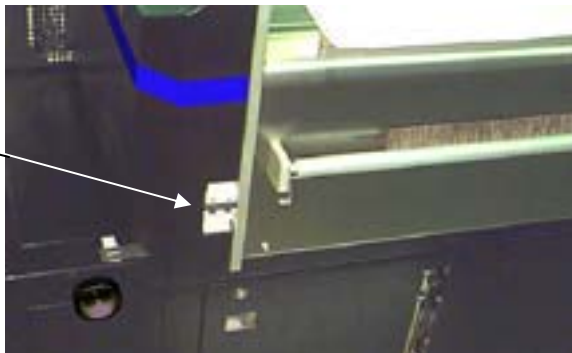


- Lock the knob. Avoid having the paper too tight / loose between the tractors.
- Close the tractor covers.
- Close the drag brush, by lifting up on the drag brush release lever.
- Close the plexiglas top cover.

2.2. STARTING AND STOPPING THE UNIT

- Switch the main power switch ON to power up the CS-9018.

MAIN POWER SWITCH

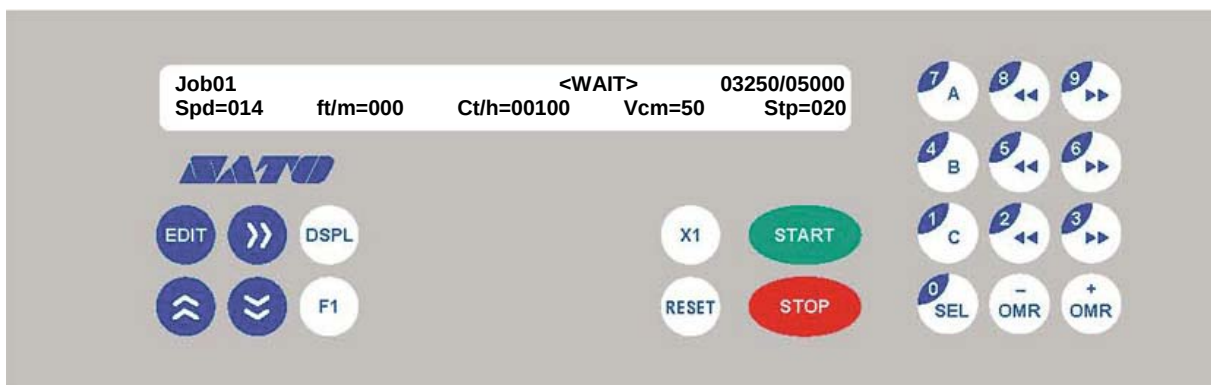


- Press  to start the motors. "<WAIT>" will be displayed on the display for approximately 5 seconds until the vacuum running level is reached. Ticket processing can not begin until this occurs.
- Press  again.



Note: The form will reverse direction to find the leading edge of the sheet and then advance to the edge of the oscillating knife blade. This sets the top of form

- Press  for a single row of tickets. Repeat a few times until proper stacking is ensured.
- Press  again for continuous run mode.
- Press  to interrupt a job.
- Press  again to stop the motors.



2.3. EMPTYING THE STACKER



NOTE: When the stacker is full, the CS-9018 will stop automatically, "Stacker Full" is displayed.

STACKER FULL
EMPTY STACKER and CONTINUE A025

2.4. RESTARTING AFTER "STACKER FULL" IS DISPLAYED

- Clear tickets from the stacking conveyor.
- Move the tag weight back to the stacker.
- Press  and  to resume.

2.5. RESTARTING AFTER "GROUP SIZE HAS BEEN MET

CS-9018 automatically stops after a pre-defined group size has been met. The counter on the display will display #####/XXXXX, where # = the number of tickets processed and X = the preset group size.

- Press  to continue.

To change this setting, refer to "Preset tickets qty per group" located in Section 3.

NUMBER OF TICKETS PROCESSED
(EXAMPLE SHOWN IS AT THE START OF A GROUP)

PRESET GROUP SIZE

Job23 3INCH 00000/07850
Spd 15 ft/m=03 Ct/h=00400 Ucm=50 StP=015

COUNT SHOWN TOWARDS THE END OF THE GROUP CYCLE.

Job23 3INCH <WAIT..> 07826/07850
Spd 15 ft/m=19 Ct/h=14100 Ucm=50 StP=015

2.6. EMERGENCY STOP

The CS-9018 will stop automatically if you raise the stacker hood or the main cover, or if you press down on the red emergency stop button.

Examples:



2.6.1. To recover after lifting a cover

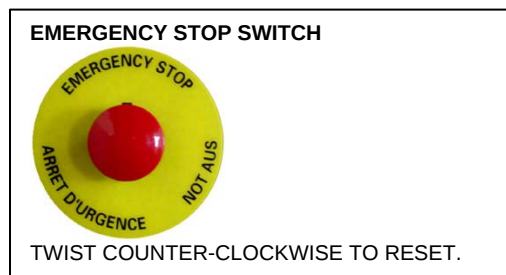


NOTE: The CS-9018 should **not** be stopped by lifting a cover except in an emergency. Lifting a cover will require the reloading of forms.

- Close the cover.
- Press  and refer to Chapter 2.1 for further instructions.

2.6.2. To recover from an emergency stop

- Reset the emergency stop switch by twisting counter-clockwise.
- Press  and refer to Chapter 2.1 for further instructions. Top of form will have to be reset after an emergency stop.



2.7. RESTARTING AFTER A “NO USE” SHUT DOWN

The CS-9018 is equipped with a time-lapse monitor and will shut down when not being used. If one minute passes without the knife operating, the vacuum and motors will shut down. If a time-out occurs and you want to start a job:

- Press  to restart the motors.
- Press  or  again to resume processing.

2.8. END OF FORMS

At the end of the forms, the cutter stops and “END of FORMS” is displayed on the screen.

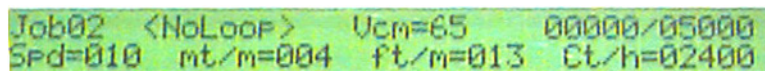


END of FORMS A016
LOAD FORMS and CONTINUE

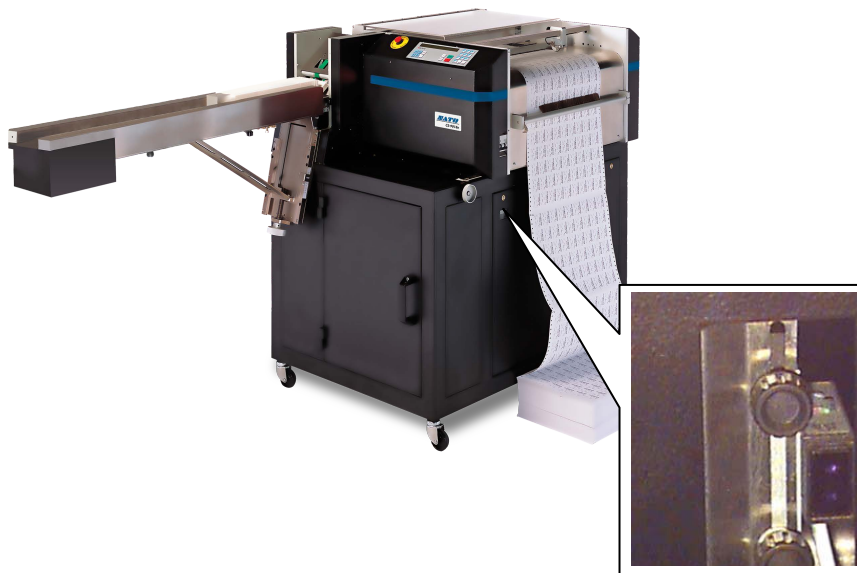
2.9. IF YOUR UNIT HAS LOOP CONTROL

Loop Control is an option that is used to coordinate the flow of forms from a form feeding device, such as a printer, to the CS-9018. Without this device, matching the speeds of the two machines would be nearly impossible. There are no physical connections between the two machines with this option.

When the paper clears the optional loop control sensor (located in the slot on the front of the CS-9018) the CS-9018 will pause and <NoLoop> will be displayed beside the Job Number on the display. When the machine feeding the forms catches up, the CS-9018 will automatically start processing again.



Job02 <NoLoop> Vcm=65 00000/05000
Spd=010 mt/m=004 ft/m=013 Ct/h=02400



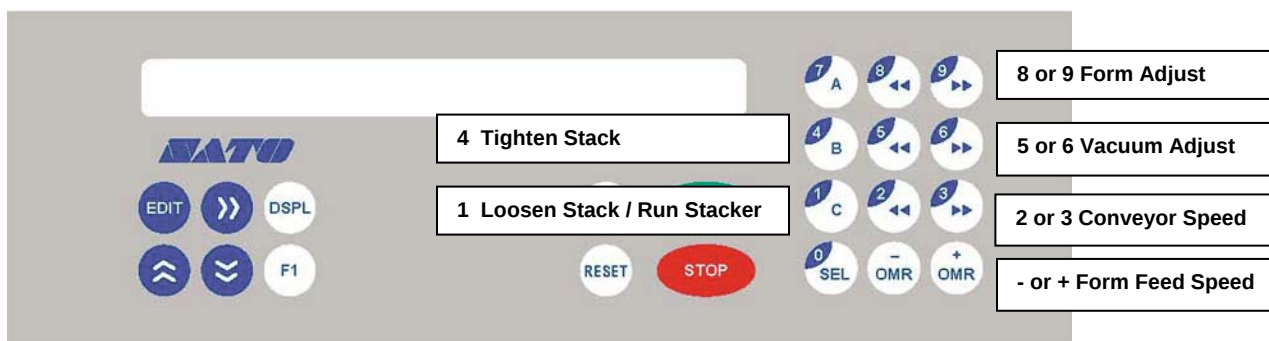
Loop Control Sensor

2.10. CHANGING SETTINGS WHILE RUNNING

It is possible to make certain fine tuning performance adjustments while the tickets are being processed. Among these are adjustments to the cut registration, vacuum pressure, stacking conveyor speed, form feed speed, tighten stack, and loosen stack. The figure below shows the appropriate keys to press for each adjustment. Adjustments should always be made in small increments.



NOTE: You must be in password mode to make these changes. The “=” sign between “Spd” and the speed value on the run screen flashes when you are in password mode. (see Chapter 3.1 for entering password)



NOTE: These setting changes will be temporary and will not be changed in the job setup! Refer to Chapter 3 for information on how to lock in changes.

2.10.1. Cut Registration (8 and 9)

Use to fine adjust the oscillating blade cross cut to the perf line.

- Pressing the 8 key while the CS-9018 is running causes the form to advance forward 1/192"
- Pressing 9 causes the form to retract 1/192".



NOTE: If this must be adjusted every time forms are loaded, contact your service representative to make an adjustment within machine setup parameters.

2.10.2. Vacuum Adjustment (5 and 6)

This setting is used to adjust the vacuum level while running which affects ticket orientation on the vacuum transport belt and stacking performance.

- Press the 5 key to decrease vacuum.
- Press the 6 key to increase vacuum.



To make this adjustment permanent for this job, refer to Chapter 3.3.8 "Vacuum".

2.10.3. Stacking Conveyor Speed Adjustment (2 and 3)

Use to adjust the tightness of the ticket stack while running. Look for the tightest stack possible without jamming.

- Press the 2 key to tighten the ticket stack.
- Press the 3 key to loosen the ticket stack.



NOTE: To make this adjustment permanent for this job, refer to Chapter 3.3.9 "Stacker Belt Step".

2.10.4. Tractor Speed Adjustment (- and +)

Maximize throughput performance by adjusting the tractor speed to match the application or operator handling speed. If your unit has the loop control option, this setting would be used to match the CS-9018 speed to the printer speed.

- Press the – key to decrease the tractor speed.
- Press the + key to increase the Tractor speed.



To make this adjustment permanent for this job, refer to Chapter 3.3.2 "Tractor Speed".

2.10.5. Tighten / Loosen Stack or Run Stacking Conveyor (1 and 4)

- Press the 4 key to create a tighter stack, press and hold to continuously jog
- Press the 1 key to loosen the stack, press and hold to continuously jog/run



NOTE: This change is temporary. To permanently change the stacking conveyor speed use the 2 and 3 keys to find the correct speed and then change the job setting in "EDIT" mode, see Chapter 3.3.9 "Stacker Belt Step".

2.10.6. Cycle Oscillating Blade (7)

This is only used when there are no forms in the machine. It is used by service technicians to test the Oscillating Blade Motor circuit.

- Press the 7 key to cycle the oscillating blade once.
- Other motors can be tested without running forms in a similar manner:
 1. Tractor Motor – 8 and 9
 2. Stacking Conveyor Motor – 1 and 4

2.11. CHANGING JOBS

2.11.1. To select a different job

- Press and hold , the current job number will appear "Job Num: 01"



```
<Edit Job.> 01
>>Job Num.: 01
```

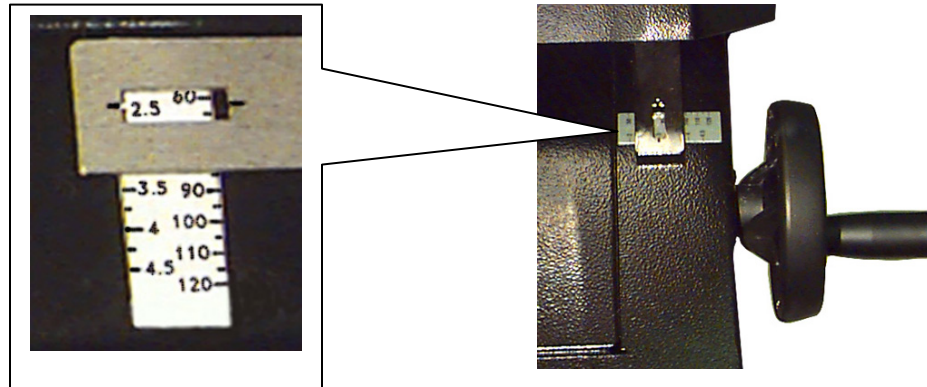
- Release the  key.
- Press  to scroll through and select one of the available jobs (See Chapter 3 "Job Setup" for instructions on how to set up a new job).
- Press  again to set the job. VERY IMPORTANT!

2.11.2. To set the CS-9018 up for a different job

After selecting a different job you must make a few adjustments to the CS-9018.

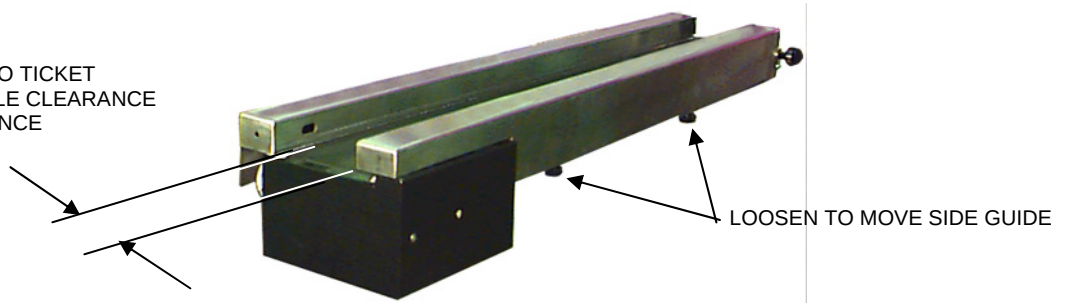
2.11.2.1. Adjusting for ticket length

- Turn the ticket length adjustment knob until the correct length appears in the window.

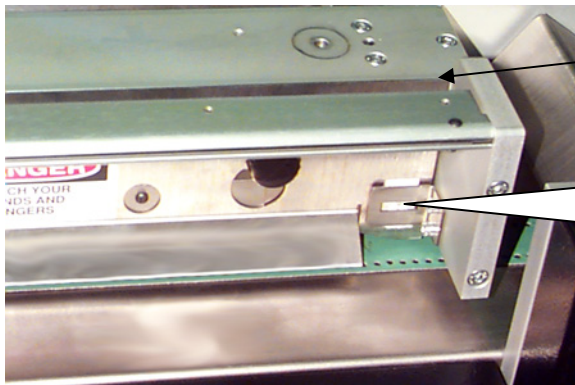


- Loosen the exit conveyor side rail adjustment knobs and adjust the side rails.

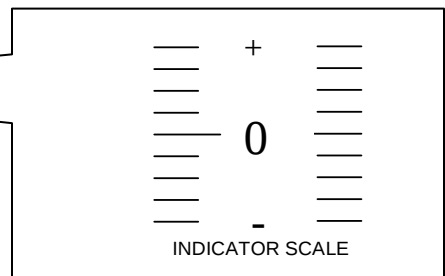
SET SIDE GUIDES TO TICKET LENGTH PLUS AMPLE CLEARANCE TO YOUR PREFERENCE



- Adjust the rear deflector plate, if necessary. The top of the rear deflector plate is normally set flush with the top plate of the oscillating blade cartridge assembly as shown below. For longer, wider tickets it may be necessary to raise the guide 2 or 3 marks on the indicator scale. For shorter tickets it may be necessary to lower the guide 1 or 2 marks.



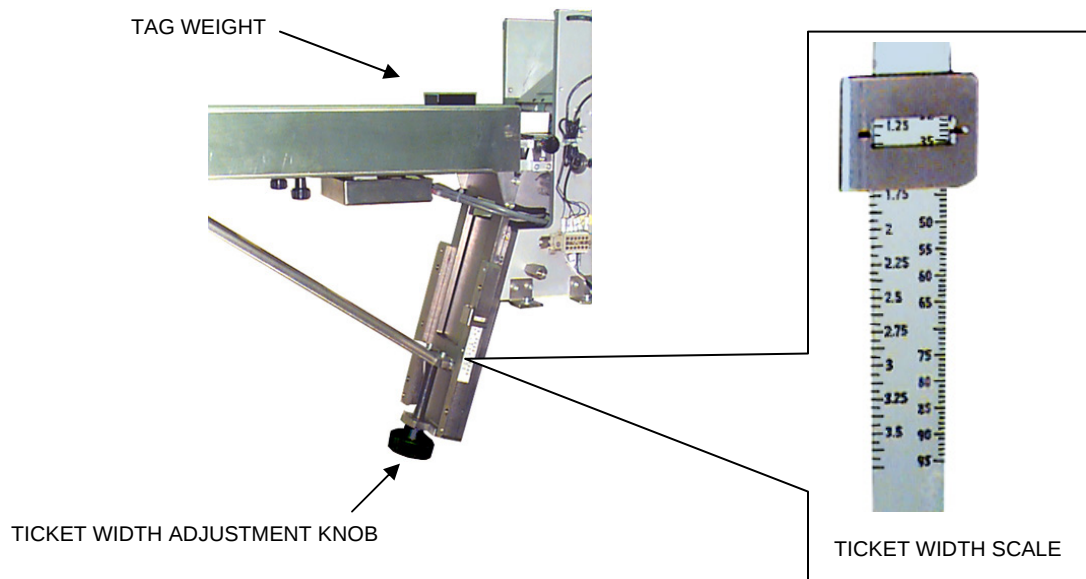
TOP OF REAR DEFLECTOR PLATE IS NORMALLY SET FLUSH WITH THE TOP PLATE OF THE OSCILLATING BLADE CARTRIDGE ASSEMBLY



2.11.2.2. Adjusting for ticket width

Ticket width is determined by the spacing of the slitter knives on the slitter knife cartridge. These are factory preset and should not be changed. Changing to a different ticket width requires changing the entire slitter cartridge assembly first. The stacking conveyor must also be repositioned to accept the new ticket width.

- Change the slitter cartridge assembly (refer to section 2.11.2.3)
- Turn the ticket width adjustment knob until the correct width of the ticket appears in the window.



NOTE: The vertical position of the stacker should be set so that there is approximately 1/16" (1.6 mm) between the top of the tickets and the roller that runs across the left edge of the hood (next to the stacker tray).



Follow the steps below to make a fine adjustment, if necessary:

- Make sure the tag weight is in place next to the tickets.
- Start the CS-9018 and while tickets are being processed, fine adjust the stacking conveyor height upward until the ticket stacking is optimal.

2.11.2.3. Changing the Slitter Cartridge

**WARNING!**

REMOVE POWER FROM THIS MACHINE BEFORE PROCEEDING!
UNPLUG THE MAIN POWER CORD.

If the job requires a different width ticket from the previous job, the correct slitter cartridge and slitter cartridge guides must be installed.

- Remove power from the CS-9018.
- Open the top plexiglas cover.
- Remove the existing forms, if applicable.



DANGER: SLITTER KNIVES ARE EXTREMELY SHARP, SEVERE CUTS TO YOUR FINGERS COULD OCCUR!

- Remove the guard over the slitter cartridge.

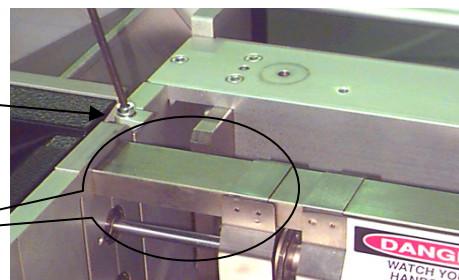


- Loosen the two securing screws (counter-clockwise) far enough to rotate the slitter cartridge locks 90°.

SLITTER CARTRIDGE LOCK



LIFT HERE ON EACH END
TO AVOID CONTACT
WITH SHARP KNIVES!



- Lift the slitter cartridge out by placing your hands at the outer ends of the slitter cartridge being very careful not to contact the slitter knives.
- Install the correct slitter cartridge in the reverse order being very careful not to contact the slitter knives.
- Secure the slitter cartridge locks.
- Replace the guards.

2.11.2.4. Reloading the paper

Refer to section 2.1 "Loading Paper" and section 2.2 "Starting and Stopping the Unit".

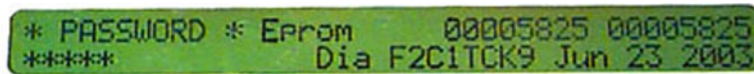
3. JOB SETUP

This chapter describes how to set up a new job and how to edit a current job on the CS-9018.

Before proceeding, make sure you have the proper slitter cartridge assembly and have made the necessary adjustments for the job. Refer to section 2.11.2.3 “Changing the Slitter Cartridge” for instructions on how to change this assembly, if necessary.

Chapter 6.2 contains a Job Setup Sheet that can be photocopied and used to document all of your job settings. This will be a useful tool in the event of a loss of machine memory.

3.1. ENTERING THE OPERATOR SETUP SCREENS



- Press the  key.
- Enter Password 12345 for Operator Mode.
- Press  again to set the password.
- Press and hold , the current job number will appear:

<Edit Job.> 01 (JOB NAME)
>>Job Num.: 01

- Release the  key.
- Press  to scroll through the available jobs.

3.2. EDIT A CURRENT JOB

With the exception of Job 90, which is reserved for service tests, any job can be edited.



- Continue to scroll  until the job to be changed is displayed.
- Scroll through the menu for that job by pressing the  key until the setting to be changed is displayed.



Note: Scroll in reverse by pressing the  key.

For information on how to change settings see Chapter 3.3 “PROGRAM A NEW JOB”.

3.3. PROGRAM A NEW JOB

- Enter the operator setup screens (see Chapter 3.1 "Entering the Operator Setup Screens").
- Enter the next available job number. Job numbers should be entered in order (i.e. 01, 02, 03) as they will appear in the order you enter them. Job numbers can't be removed although their settings may be changed. Up to 99 jobs may be entered.
- Press the  key.

 Note: Enter "0"s to clear a setting for any screen.

3.3.1. Description



Enter a description for a job by scrolling through the numeric keypad to select the desired character (see chart below) and pressing the  key. Job descriptions may have up to 10 characters.

0	—	*	%	
1	.	/	,	
2	A	B	C	
3	D	E	F	
4	G	H	I	
5	J	K	L	
6	M	N	O	
7	P	Q	R	S
8	T	U	V	
9	W	X	Y	Z

- Press the  key to go to the next parameter.

3.3.2. Tractor Speed (2...15)



- Using the numeric keypad, enter a setting for the speed of the paper entering the CS-9018.
- A speed of 8 is a good starting point. Increase the speed from there. Your actual setting will be dependent on the materials and application.
- Press the  key to go to the next parameter.

3.3.3. Strip delay, 1=5msec

```
<Edit Job.> 01
Strip delay, 1=5msec :
```

Recommended starting point: 25

This is used only when removing the perf between forms. It provides a small amount of time for the chips to fall after being cut by the oscillating blade and before the next row of tickets are advanced to the oscillating knife. Without this delay the chips will be carried to the stacker and will be mixed in with the tickets.

This delay will only function when a cut length of less than ½ inch (00+48 on the display) is programmed. Generally a chip width of 1/8" will give the best results.

- Press the  key to go to the next parameter.

3.3.4. Paper load offset

```
<Edit Job.> 01
Paper load offset :
```

Use this setting when using the chip removal feature. When paper is first loaded it will advance past the oscillating knife ½ the length off the chip being removed. The knife will then make its first cut (1/2 of the normal chip length).

- Set to one half of the chip dimension (cut length of the chip divided by 2)

Example:

If you plan to remove 1/8" on either side of the perf or ¼" total, the "Cut Length" for the chip should be set to "00+24" and the "Paper load offset" should be set to 1/8" or "00+12". See the example following "Cut Length".



Note: All lengths are set in 96ths of an inch. Example:

1/8"	=	00+12
1/4"	=	00+24
1/2"	=	00+48
1 1/2"	=	01+48

- Press the  key to go to the next step.

3.3.5. Cut Length 01, "+/96: 03+24



Refer to the "INCHES FRACTION CONVERSION TABLE" at the end of this section.

- Enter ticket length in inches, see Chapter 3.5 "TAG LENGTH REFERENCE TABLE" and 3.6 "INCHES FRACTION CONVERSION TABLE".
- Press "+", enter fractional remainder in 1/96" e.g. 3.25" is "03" "+" "24".
- Forms must be removed and reloaded after a new setting is selected.

- Press the  key to go to the next step.

3.3.6. Cut Length 02, "+/96: 03+24



If only one length ticket is required Cut Length 02 should be ignored. If it is desirable to remove the perforation between forms (chip removal) then it will be necessary to program additional Cut Lengths. The Cut Length for the chip removal must be the last length programmed. An additional Cut Length must be programmed for each ticket between the perforations.

Example:

You have a 10" form and wish to have 1/8" removed on either side of the perforation. All tickets are to be 3-1/4" (due to the perf removal). The first three cut lengths would be programmed "03+24"

Cut Length 04 (the chip) would be 1/4 of 96 or 24. Program this in the format "00+24"
Remember, all measurements are in 96 = 1".

Program in the following:

Cut Length 01 03+24
Cut Length 02 03+24
Cut Length 03 03+24
Cut Length 04 00+24

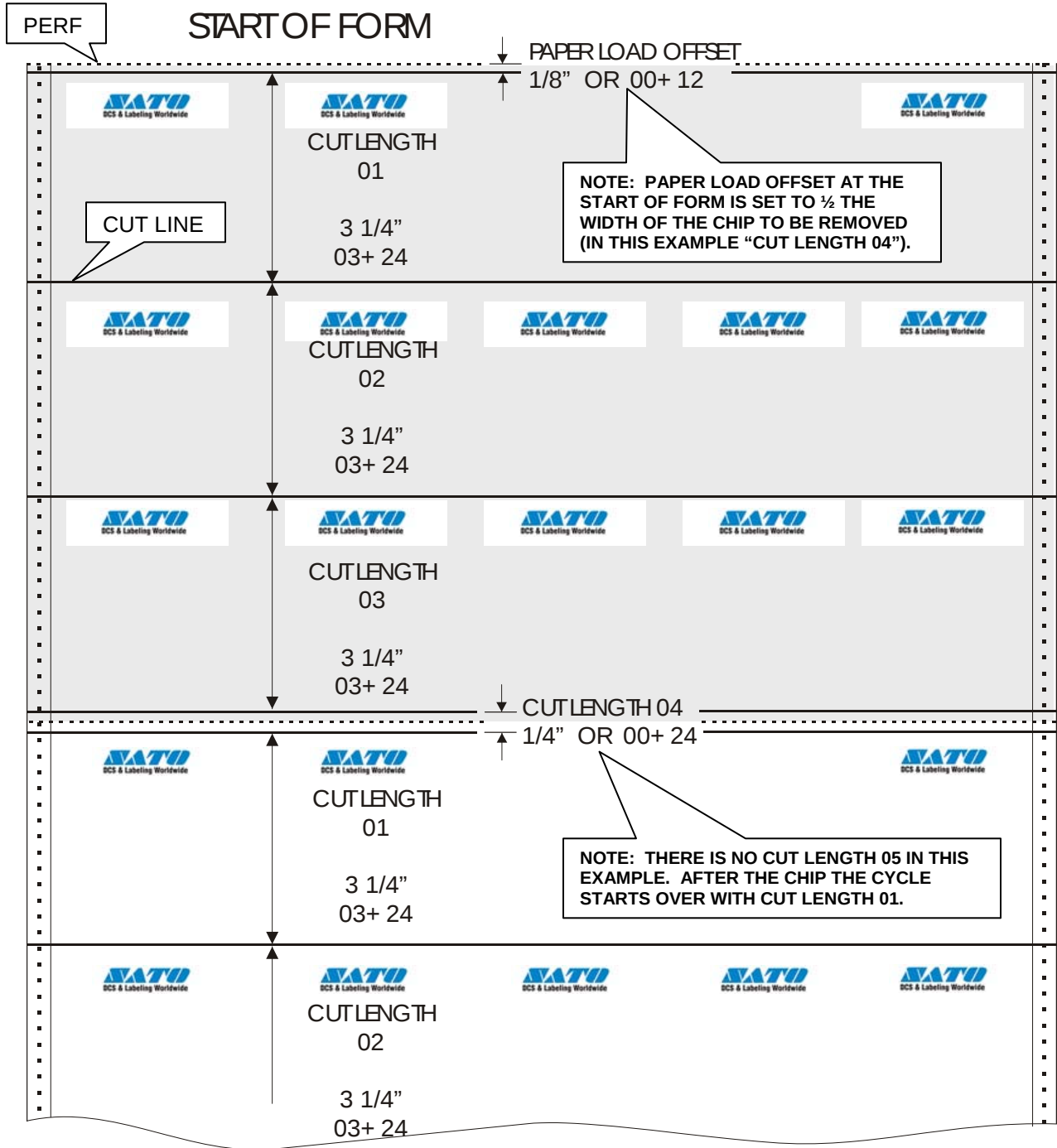


NOTE: If used, chip removal length must always be the last cut length programmed. See the example on the next page. See also, Chapter 3.3.3 "Strip delay" and 3.3.4 "Paper load offset".

- Press the  key to go to the next step.

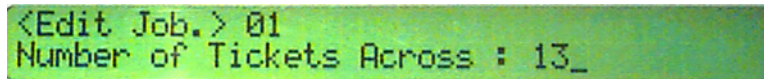
3.3.6.1. Example Of Cut Length and Paper Load Offset Setup:

The following is an example of a typical setup when the chip (the perf and a small amount of form on either side of the perf) is to be removed. If chip removal is not desired it is only necessary to program in "CUT LENGTH 01" for the length of the ticket.



3.3.7. Number of Tickets Across: 13

This is the number of tickets (or columns) cut which is determined by the number of slitter knife sets minus one.



- Enter number of tickets per cut or number of knife sets minus 1.
- Press the  key to go to the next step.

3.3.8. Preset tickets qty per group: 5000

This feature will stop the processing of tickets once a predefined number of tickets has been reached. Entering a multiple of number of tickets across works best.



- Enter the desired number of tickets to run before shutdown, group size.
- Press the  key to go to the next step.

3.3.9. Vacuum (20..90): 55



- Adjusts the force of the vacuum, inverter display on front panel window displays the Hz the vacuum is running at, vacuum runs 3000 rpm at 50Hz. Adjust down for lighter paper and up for heavier paper based on tracking and jamming on green vacuum belt.

Example:

Length	Vacuum Setting
2"	85
3"	60
3.5"	50
4"	40
4.5"	30

- Press the  key to go to the next step.

3.3.10. Stacker Belt Step, 2=1mil"

```
<Edit Job.> 01
Stacker Belt Steps, 2=1mil" : 20
```

This setting will change how tightly the tickets are stacked together on the exit conveyor. A tighter stack will mean more tickets stacked; however, stacking too tightly will cause a jam. Ideally the stack should have a very slight amount of play in it. The stack is too tight if it is lifting as shown in the photo below.



- Start with the settings provided in the following chart and, while running, fine tune from there by pressing "2" to create a tighter stack or "3" to loosen the stack.
- Once you have determined the ideal conveyor speed (displayed as Stp=###), enter that setting in the "Stacker Belt Step" screen.

```
Job01 00000/05000
Spd=15 ft/m=00 Ct/h=00100 Vcm=60 StP=020
```

# of tickets per cut	Initial Setting
7	15
9	17
13	19
17	24



Note: These are initial guideline settings. Your actual settings will be dependent on the materials and applications.

3.3.11. Saving the Job Settings

- Press  or  to save the job and leave set up.

3.4. CANCEL A PASSWORD

Entering the password "000" or cycling the main power switch will cancel any password.

3.5. TAG LENGTH REFERENCE TABLE

Use the table below as a reference when determining the Tag Length for tickets:

Ticket Lengths (inches) fractional	Ticket Lengths (inches) decimal	Setting
2	2.000	02+00
2-1/16	2.063	02+06
2-1/8	2.125	02+12
2-3/16	2.188	02+18
2-1/4	2.250	02+24
2-5/16	2.313	02+30
2-3/8	2.375	02+36
2-7/16	2.438	02+42
2-1/2	2.500	02+48
2-9/16	2.563	02+54
2-5/8	2.625	02+60
2-11/16	2.688	02+66
2-3/4	2.750	02+72
2-13/16	2.813	02+78
2-7/8	2.875	02+84
2-15/16	2.938	02+90
3	3.000	03+00
3-1/16	3.063	03+06
3-1/8	3.125	03+12
3-3/16	3.188	03+18
3-1/4	3.250	03+24
3-5/16	3.313	03+30
3-3/8	3.375	03+36
3-7/16	3.438	03+42
3-1/2	3.500	03+48
3-9/16	3.563	03+54
3-5/8	3.625	03+60
3-11/16	3.688	03+66
3-3/4	3.750	03+72
3-13/16	3.813	03+78
3-7/8	3.875	03+84
3-15/16	3.938	03+90
4	4.000	04+00
4-1/16	4.063	04+06
4-1/8	4.125	04+12
4-3/16	4.188	04+18
4-1/4	4.250	04+24
4-5/16	4.313	04+30
4-3/8	4.375	04+36
4-7/16	4.438	04+42
4-1/2	4.500	04+48

3.6. INCHES FRACTION CONVERSION TABLE

INCHES		DATA IN 1/96"
1/12		+08
1/6 or 2/12	EQUIVALENT TO	+16
1/4 or 3/12		+24
1/3 or 2/6 or 4/12	EQUIVALENT TO	+32
5/12		+40
1/2 or 2/4 or 3/6 or 6/12	EQUIVALENT TO	+48
7/12		+56
2/3 or 4/6 or 8/12	EQUIVALENT TO	+64
3/4 or 9/12		+72
5/6 or 10/12	EQUIVALENT TO	+80
11/12		+88
1 or 6/6 or 12/12	EQUIVALENT TO	01+00
1/16		+06
1/8 or 2/16	EQUIVALENT TO	+12
3/16		+18
1/4 or 2/8 or 4/16	EQUIVALENT TO	+24
5/16		+30
3/8 or 6/16	EQUIVALENT TO	+36
7/16		+42
1/2 or 2/4 or 4/8 or 8/16	EQUIVALENT TO	+48
9/16		+54
5/8 or 10/16	EQUIVALENT TO	+60
11/16		+66
3/4 or 6/8 or 12/16	EQUIVALENT TO	+72
13/16		+78
7/8 or 14/16	EQUIVALENT TO	+84
15/16		+90
1" or 8/8 or 16/16	EQUIVALENT TO	01+00

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4. TROUBLESHOOTING

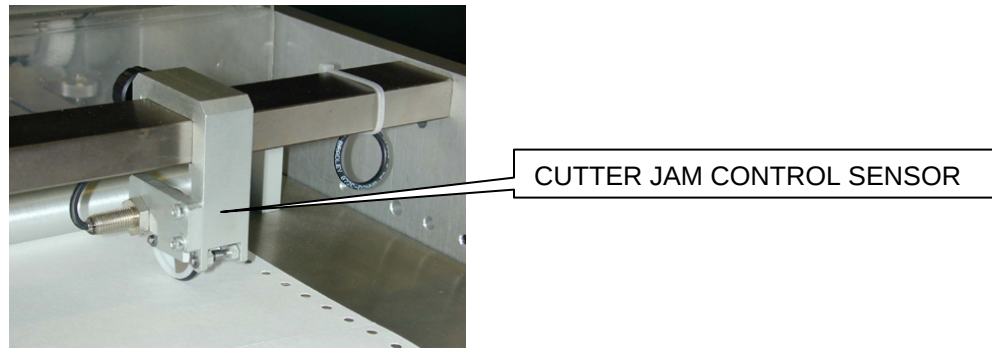
4.1. CLEARING A JAM

When the CS-9018 is not set up correctly, tickets will commonly jam at one of two places; the slitter cartridge assembly/oscillating blade area and the stacker hood area.

4.1.1. Tickets will jam at the slitter cartridge assembly if:

- The forms feeding into the CS-9018 are not aligned properly.
- The forms contain vertical perforations that are not aligned correctly.
- The forms have too much slack between the tractors, causing the forms to buckle.
- The edge of stock is torn.

When tickets jam at the slitter assembly, the motors remain on, but the feeding action stops. This is detected by the cutter jam control sensor.



To correct the jam:

- Press .
- Raise the clear protective cover over the slitter. The motors will power down.
- Remove the edge trim from the rear of the machine
- Open the tractor covers and pull out the stock, making sure you clear all the paper under the slitter wheels.

If forms are stuck under the slitter wheels:

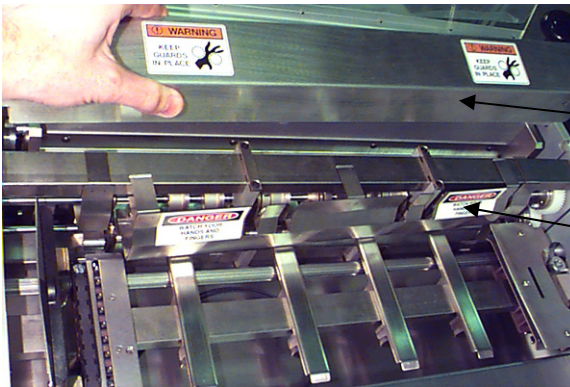
**WARNING!**

REMOVE POWER FROM THIS MACHINE BEFORE PROCEEDING!
UNPLUG THE MAIN POWER CORD.

**WARNING - HAND HAZARD EXISTS!**

USE EXTREME CAUTION WHEN WORKING AROUND KNIVES. USE THE PROVIDED HEMOSTATS TO REMOVE FORMS FROM THE SLITTER AREA.

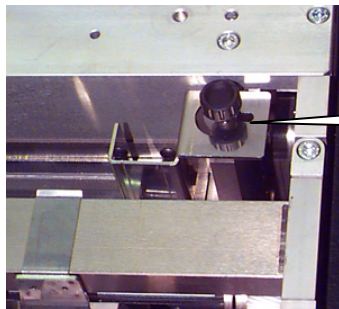
- Remove the slitter cartridge protective cover.
- If necessary, remove the slitter cartridge upper guide.



SLITTER CARTRIDGE PROTECTIVE COVER

SLITTER CARTRIDGE UPPER GUIDE

- Remove the guide between the slitter and the oscillating blade cartridges by loosening the two securing knobs, sliding the guide to the left, and lifting it up and out.





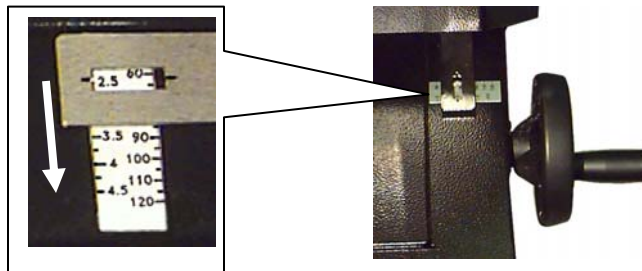
CAUTION: USE OF METAL OBJECTS MAY DULL OR DAMAGE THE SLITTER KNIVES!

- Very carefully clear tickets from the slitters using hemostats.
- Clear away any cut tickets that have piled up on the vacuum transport belt.
- Replace the infeed guide and protective cover.

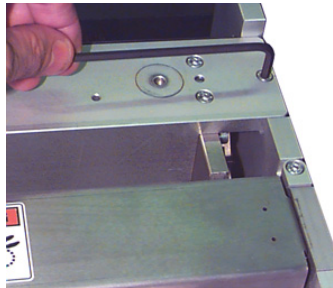
It may be necessary to remove the oscillating blade cartridge to clear a jam.

To remove:

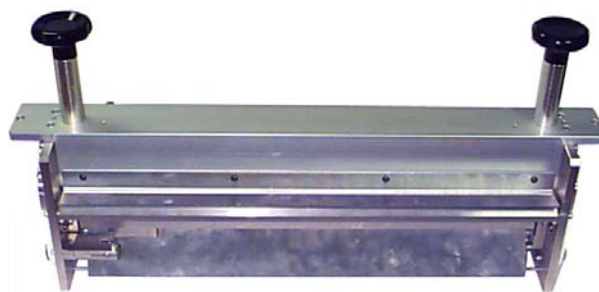
1. Adjust the ticket length to 4.5" by turning the knob on the front of the CS-9018. If this is not done, you will not be able to remove the blade cartridge.



2. Remove the two securing screws by turning counter-clockwise, one on each end of the cartridge.



3. Install the blade cartridge removal handles.



WARNING! USE PROPER LIFTING TECHNIQUES WHEN LIFTING THE BLADE CARTRIDGE. THIS CARTRIDGE WEIGHS 34 POUNDS.

4. Lift the blade cartridge upward.

To Re-install the Oscillating Blade Cartridge:



CAUTION! TO PREVENT DAMAGE TO THE OSCILLATING BLADE CARTRIDGE, USE GREAT CARE WHEN RE-INSTALLING. DO NOT FORCE THE CARTRIDGE INTO PLACE. SET IT GENTLY INTO POSITION.

1. Place the blade cartridge back in the CS-9018. Ensure it is setting flat in the side frame cut outs (the top of the cartridge should be flush with the top of the side frame on both sides).
2. Remove the blade cartridge removal handles
3. Re-install the two securing screws.
4. Adjust the ticket length to the correct length.

4.1.2. Tickets will jam at the hood if:

- The ticket length adjustment is not set properly.
- The stacker height is not adjusted properly.
- The tickets are not centered across the vacuum belt when they feed into the hood.
- The rear deflector plate is not set correctly.
- The vacuum level is not set correctly.
- The vacuum transport belt is not tracking properly.

When tickets jam in the hood, the stacker sensor will detect the problem and stop the motors. An error message "**STACKER JAM**" will alert you to the problem.

To correct the jam:

- Raise the hood and remove any tickets that are jammed under the hood, and all that remain on the vacuum transport belt.
- Press  to clear the error.
- Close the hood tightly.

Check to make sure:

- There is no obvious obstruction along the paper path.
- The paper feeding into the CS-9018 is aligned properly.
- The vertical perforations are aligned correctly and are cutting on the perf.
- The paper is taut between the two tractors.
- The edge of the stock is not wrinkled, torn, or otherwise damaged.
- The stacker and transport are aligned correctly.
- The stacker height is adjusted so that there is approximately 1/16" (1.6 mm) between the top of the tickets and the roller running across the hood assembly.
- The tickets are centered across the vacuum belt when they feed into the hood.
- The vacuum level is set correctly.

- Press  twice to restart processing.

If the blockage recurs, contact your Supervisor or Service Engineer.

4.1.3. Restarting after you have cleared the jam

- Reload the paper stock, making sure you start at a clean edge (at a fanfold perforation, for example).
- Align the forms, referring to Chapter 2.1 for instructions.



NOTE: Pressing  will cause the unit to complete the current cycle before shutting down. Similarly, a stacker jam or stacker-full condition will allow the unit to complete the current cycle. When the cutter stacker completes its cycle before shutdown, there is no need to reset to top-of-form.



NOTE: If you open a cover, however, causing an immediate shutdown, you will have to align the top-of-form before restarting the job.

4.2. WHEN ERROR OR INFORMATION MESSAGES ARE DISPLAYED

When error messages or information are displayed, detect the error code in the upper line of the display and perform the initial action for that error as listed in the "ERROR CODES" chart located in this section. To reset the error press RESET.
If the problem persists, contact your service center.

4.2.1. Operator Troubleshooting Guide

PROBLEM:	POSSIBLE CAUSE	SOLUTION
Machine ON with blank display or display off.	1. Is machine plugged in?	1. Plug the CS-9018 in.
Tickets are not cut on the perf.	1. Parameter is set incorrectly. 2. Job is set up incorrectly.	1. Press 8 or 9 to adjust cut to perf while running. This is a temporary fix and must be repeated each time the forms are loaded. Have technician check the parameter setting. 2. Adjust cut length settings for the job being run.
Can't escape from setup mode. Bad information on display.	1. Unknown reason for lockup or bad information.	1. Power CS-9018 off and back on.
"No Loop / Not Ready" on display.	1. Check Setup.	1. Check and adjust form loop. 2. Is cutter off line and printer on line?
Cutter stops without an error message.	1. Preset group setting has been reached.	1. Press START.
Cutter stops with "<NO LOOP>" message.	1. Forms have cleared loop sensor, if installed on your CS-9018.	1. Reload forms or disable loop control.
Tickets do not stack well.	1. Forms are not being cut on the perf. 2. Tickets on the extended stacker are too loose or too tight. You should be able to easily separate the tops of the tickets and see an 1/8" to 1/4" gap. 3. The stacking conveyor infeed plate is not fully in place. 4. The vacuum transport belt holes are not aligned with the slots in the vacuum support tube.	1. Reload forms or press 8 or 9 to fine adjust. 2. Adjust stacking conveyor speed. Once a good speed has been established, enter that setting into the job setup screen. 3. Loosen the two black knobs, press the plate into position, and tighten the knobs. 4. Contact your service technician for adjustment.

4.2.2. Error Codes

CODE	ERROR MESSAGE DISPLAYED	POSSIBLE CAUSE	INITIAL ACTION
A011	STACKER JAM CLEAR JAM and CONTINUE	1. Tickets are jamming in the stacker. 2. Stacker jam sensor inop. 3. Upper stacker hood belt not turning.	1. Clear tickets from stacker. 2. Check stacker jam sensor. 3. Check upper stacker hood belt.
A016	END of FORMS LOAD FORMS and CONTINUE	1. Paper ended or tore.	1. Load paper again.
A017	JOB DETAILS NOT COMPLETE MODIFY JOB	1. Missing parameters in the application.	1. Check job parameters.
A018	JOB DETAILS MISSING DIMENSIONS MODIFY JOB	1. Details missing in the current job. 2. There are no cut lengths above ½" programmed.	1. Review job settings. 2. At least one cut length must be greater than ½".
A019	PAPER LOAD ERROR (time-out) CHECK PAPER POSITION and LOAD SENSOR	1. Paper not present on tractors.	1. Set the paper properly.
A020	OSC. BLADE PHASE ERROR CHECK OSC. BLADE and CYCLE POWER	1. Logic error.	1. Cycle power to the CS-9018.
A022	JOB NOT IN MEMORY MODIFY JOB	1. There is no job set up in the memory.	1. Enter a job.
A025	STACKER FULL EMPTY STACKER and CONTINUE	1. Stacking conveyor full. 2. Stacking conveyor full sensor inop or blocked.	1. Remove tickets from the stacking conveyor. 2. Check for obstructions.
A028	1ST CUT CANNOT BE A STRIP CUT MODIFY JOB	1. Cut lengths set up incorrectly in job setup.	1. Strip cut length must be less than .5" and be the last cut length programmed.

CODE	ERROR MESSAGE DISPLAYED	POSSIBLE CAUSE	INITIAL ACTION
A035	PAPER OUT or PAPER JAM RELOAD PAPER and RESTART	1. Paper jamming out of tractors. 2. Cutter jam control sensor not in right position. 3. Cutter jam control sensor inop.	1. Check tension of paper between tractors. 2. Correct the alignment. 3. Check for free motion of the sensor and contact with the form.
A046	STACKER COVER OPEN CLOSE and START AGAIN	1. Stacker cover open.	1. Close cover.
A048	CUTTER COVER OPEN CLOSE AND START AGAIN	1. Cutter safety cover open.	1. Close the cover.
A049	EMERGENCY STOP REMOVE FORMS and RESTART	1. Emergency stop switch pushed in.	1. Rotate the red e-stop button on the control panel.
A050	OSC. BLADE MOTOR OVERTEMPERATURE CYCLE POWER and RETRY	1. Motor overheating.	1. Check for oscillating blade binding.
A051	TRACTOR MOTOR ERROR CYCLE POWER and RETRY	1. Logic error.	1. Cycle power to the CS-9018.
A052	OSC.BLADE MOTOR ERROR CYCLE POWER and RETRY	1. Logic error.	1. Cycle power to the CS-9018.

5. CARING FOR THE CS-9018

This chapter details the routine maintenance procedures required to maintain the CS-9018 cutter stacker.

Chapter 3 discusses other procedures: specifically, those involved with normal job setup. If you require information that is not covered here, first refer to Chapter 3.



CAUTION: IF YOU ARE UNFAMILIAR WITH ANY PROCEDURES OR REQUIRE MAINTENANCE BEYOND THE SCOPE OF THESE PROCEDURES, CONTACT YOUR SUPERVISOR FOR INSTRUCTION.

5.1. ROUTINE MAINTENANCE

The CS-9018 requires a certain amount of routine maintenance to ensure a trouble-free operation.



WARNING: ALWAYS SWITCH THE MAIN POWER SWITCH OFF AND UNPLUG THE MAIN POWER TO THE CUTTER STACKER BEFORE PERFORMING ROUTINE MAINTENANCE!

Daily

- 1) Clean any paper dust from the unit using a portable vacuum cleaner. Make sure to check the hood and transport areas.
- 2) Remove the waste (pin-feed trim) from behind the unit daily or as required to keep the area clear.

Weekly

- 1) Clean the vacuum air filter
- 2) 2 drops of a lightweight machine oil placed on the tractor bearings as shown. Run machine for a couple of minutes to run in.

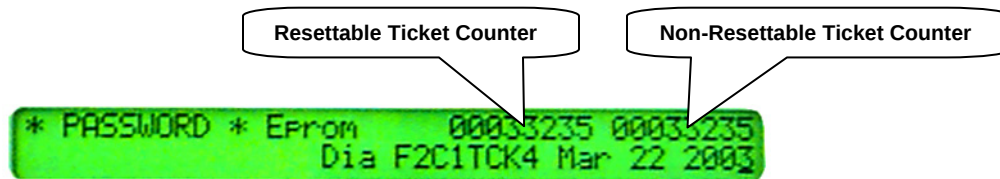


PLACE 2 DROPS OF OIL ON SHAFT AT THIS LOCATION

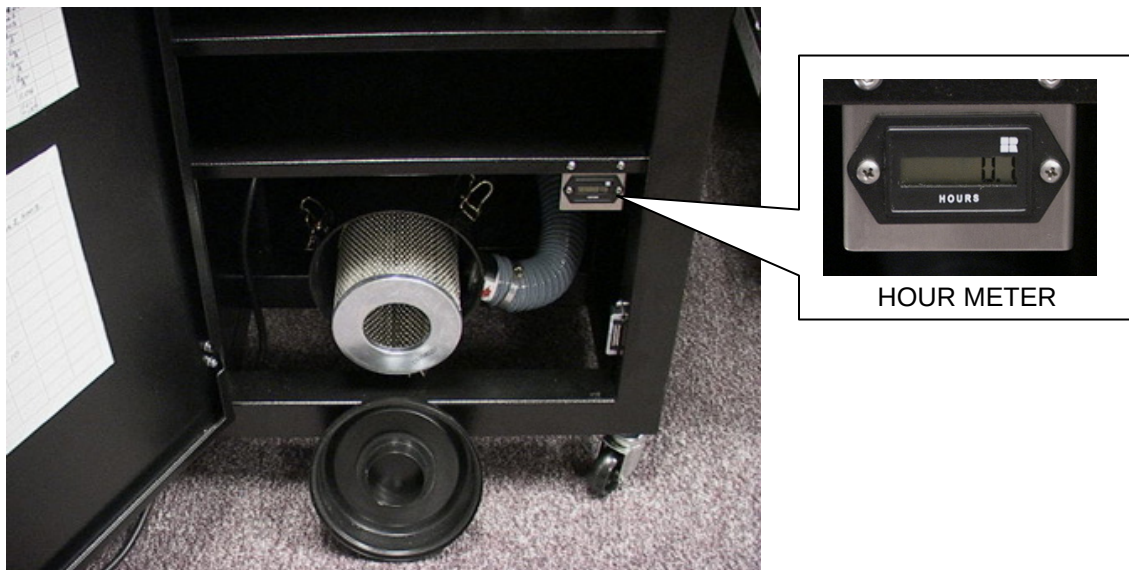
- 3) Place 1 drop of a lightweight machine oil on each end of the oscillating blade and wipe across blade. Cycle blade by hand a few times.

5.2. COUNT AND HOUR MONITORING

Total cut counts (not ticket counts) can be monitored in the password screen. The resettable counter is reset by pressing and holding RESET while pressing "1" and then "2".



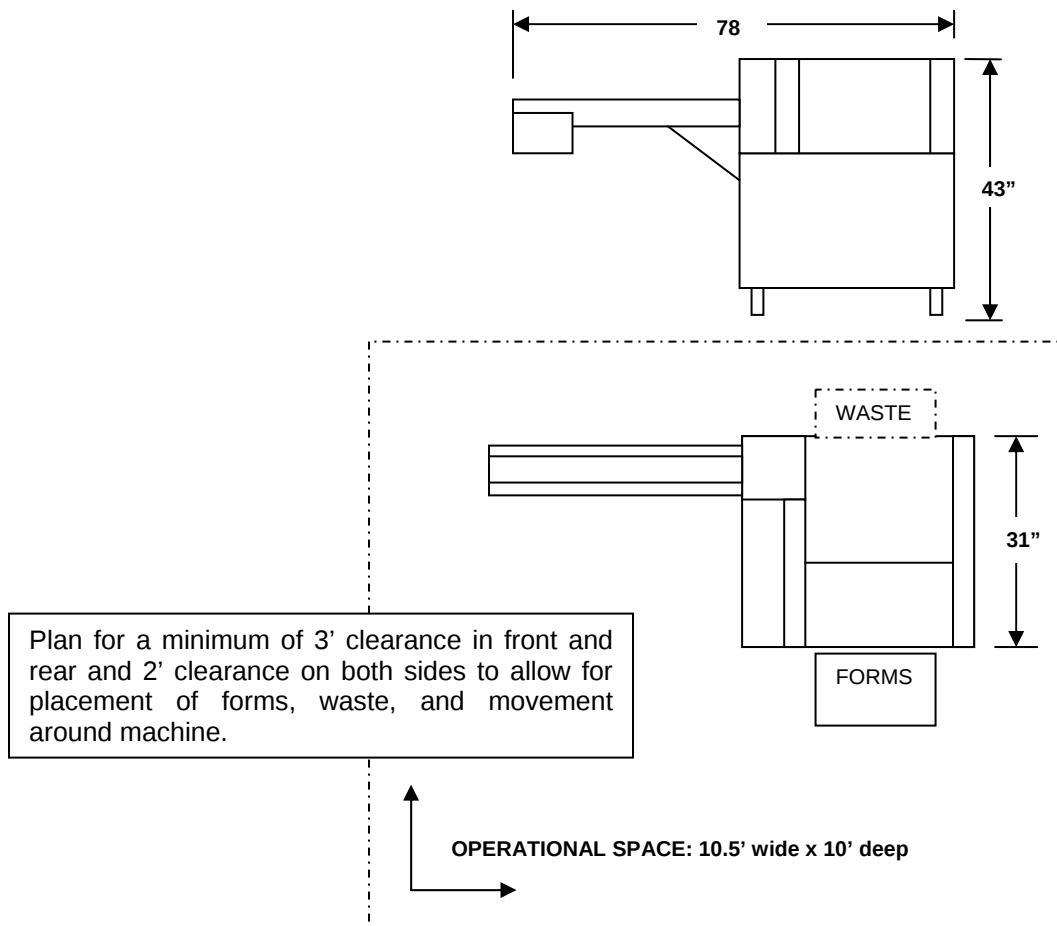
There is an hour meter mounted on the bottom shelf inside the side door that may be used to track the hours of operation. This meter operates whenever the motors operate regardless of whether tickets are processing.



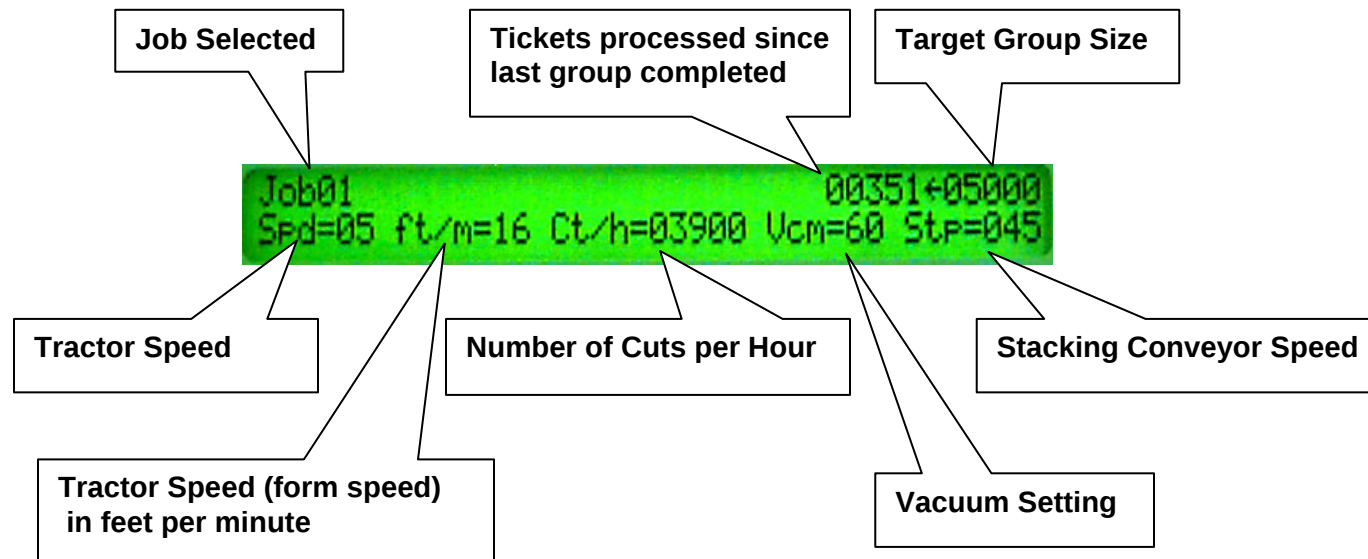
6. APPENDIX

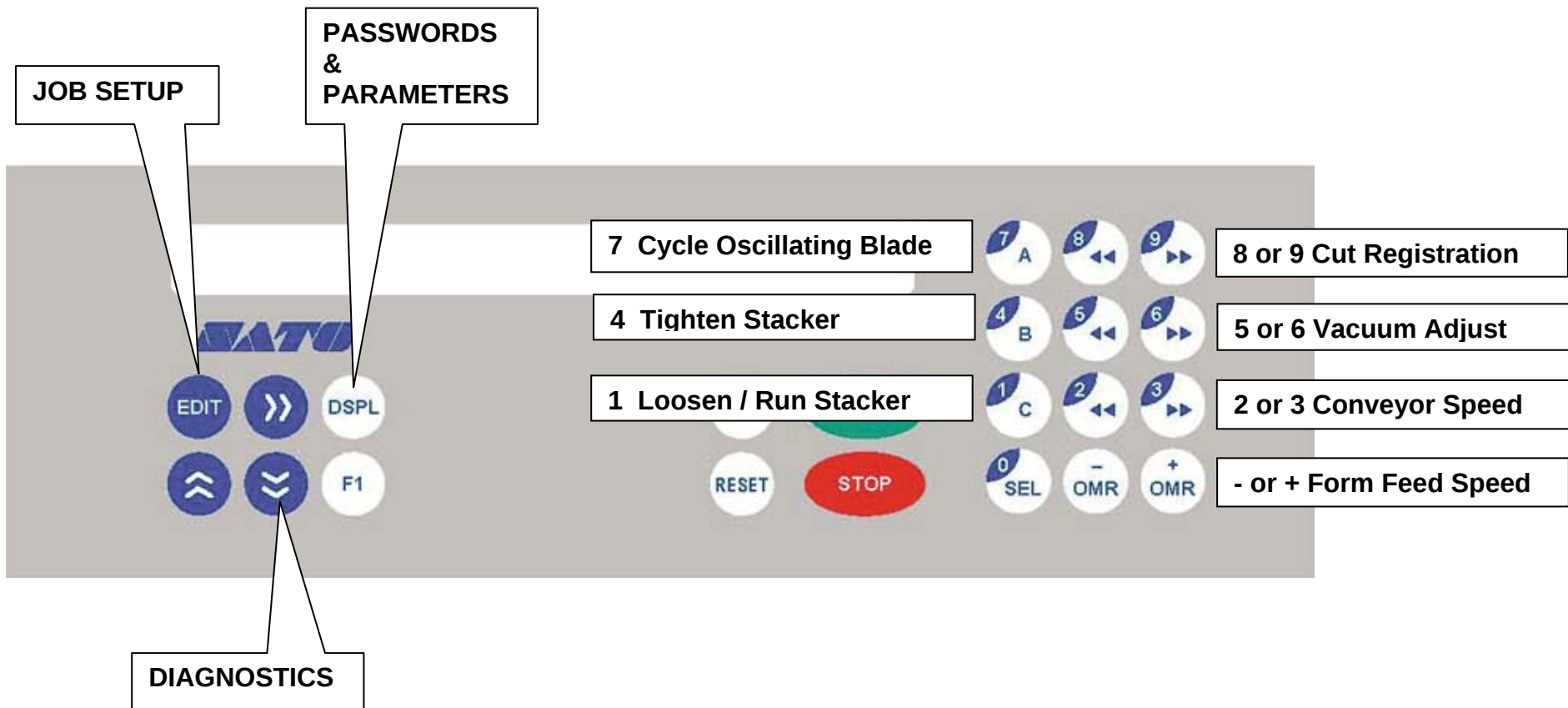
6.1. SPECIFICATIONS

Throughput	Speed is variable and application dependent.	
Stock	Material Type:	Tag stock, .009" (.229mm) min to .020" (.508mm) max
	Stock width:	6" (15.3cm) min, 18" (45.7cm) max (edge to edge)
	Ticket width:	1" (2.5cm) to 3.5" (8.9cm)
		Note: 1" (2.5cm) to 1.25" (3.2cm) is a special order
	Ticket length:	2" (5.1cm) to 4.5" (11.4cm)
	Stacker capacity:	38" (96.5cm)
Power Requirements	220 VAC, 50/60Hz single phase, 20 Amps (NEMA 6-20)	
Noise	dba	
BTU's	2000 btu	
Environment	Humidity:	35 – 70% Relative Humidity
	Temperature:	50 F(10 C) to 85 F(29 C)
Space Requirements	Height:	43" (109 cm)
	Width:	78" (198 cm)
	Depth:	31" (79 cm)
	Weight:	470 pounds (210 Kg)
	Operational Space Required:	10.5' wide x 10' deep (3.2m x 3.0m)



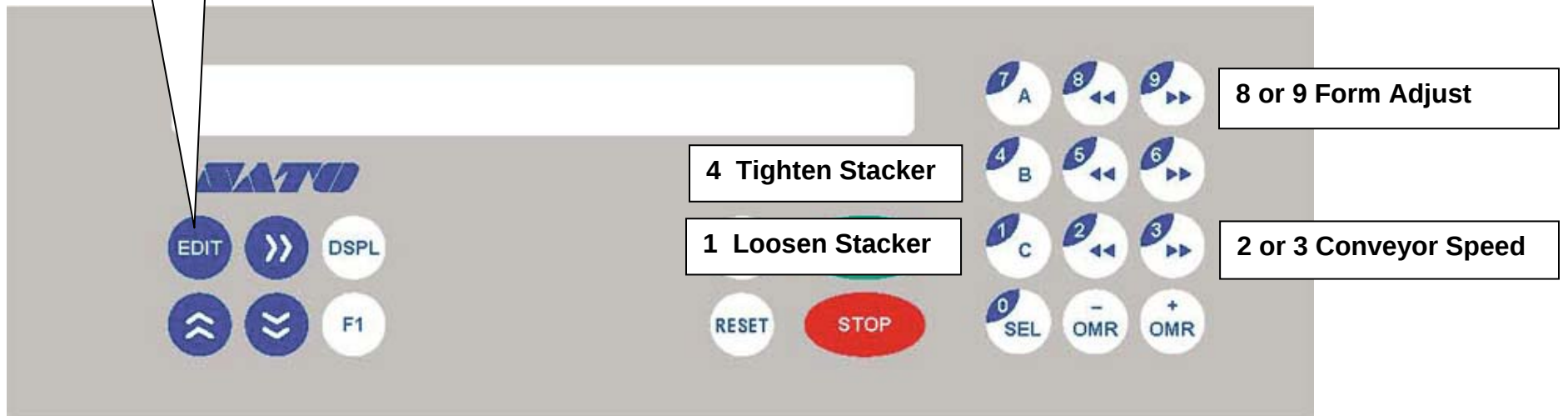
6.2. KEYBOARD OVERLAYS







Select Job



6.3. JOB SETUP SHEET

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CS-9018 Cutter Stacker Operator's Guide

Part No. 9386295-01

Ver. A February 2021



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