



SLICE[®] 230 SET-UP & TROUBLESHOOT

MAKE SURE TOP AND BOTTOM SAFETY GUARDS ARE ATTACHED



SET-UP:

- 1) Take pictures of crate prior to opening.
- 2) Open crate and take pictures of contents.
- 3) Get a helper to lift 230 to a cart, make sure the exit guide is over an edge of the cart. The bottom of the guard is below the bottom plane of the machine.
- 4) Remove any packing tape on hardware.
- 5) Position guide arm for material use. In line for stick tubing, tilted partially back for reel or other rack fed materials. Pins may need to be jiggled around a bit to re-home. Make sure guide arm did not get too loose during shipment (should be able to reposition easily but be stable).
- 6) Make sure pushpins on guide wheels located on guide arm are seated in place.
- 7) Make sure light tower is secured and connected to SLICE
- 8) If 230 has optional bar code scanner, connect scanner cable on left side of the machine.
- 9) Plug in mouse to USB on left side of machine, use mouse pad provided on right (or left if preferred).
- 10) Connect air – 80 psi.
- 11) Install power cord and connect to power.
- 12) Power up 230. The HMI takes 5-10 seconds to boot. Home screen should be displayed.
- 13) Confirm that the green light is lit on the light tower. If not see TROUBLESHOOT
- 14) Press F4 or SETUP to toggle to the JOB SETTINGS screen. Factory default should be NON-STICK, CROP and AUTO START AFTER LOAD turned off.
- 15) Press F4 or NEXT to toggle to the ACCESSORY SETTINGS screen. Default should be Prefeeder NOT PRESENT and Coiler NOT PRESENT.
- 16) Press F4 or NEXT again to toggle to the FACTORY SETTINGS screen. Default should be Length Calibration Factor (number should match with the Calibration number on the label on the back of machine), Measure Length Calibration Factor 100.00, and Blade to Zero Load Sensor 0.4000.
- 17) From this screen, WITH NO MATERIAL LOADED OR IN THE THROAT, press INFEED CALIBRATE. The 230 will close the throat to zero then open it to the INFEED setting dimension on the HOME screen.
- 18) Press F4 or NEXT again to toggle to the FACTORY SETTINGS 2 screen. Default should be Platen Motor Power-off Delay 5.0, Infeed Motor Time Out 60.0, and Cutter Cycle Time Out 5.0.
- 19) Press F4 or NEXT again to toggle to VERSION INFORMATION. PLC & HMI software is production option and time specific. TBD
- 20) Press HOME to return to the HOME screen.
- 21) For simple QUICK START operation, follow the QUICK START guide provided with the machine (page 1). Soft copy of Quick Start Guide can be easily found by accessing the 230 QR code link on the top of the machine.
- 22) For ENHANCED STICK MODE operation, follow the QUICK START provided with the machine (page 2). Soft copy of Quick Start Guide can be easily found by accessing the 230 QR code link on the top of the machine.

NOTE: When setting the THROAT INFEED:

- a. FLAT or fully compressible material - the throat can be closed to 0.00 for operation. The rollers can open up to 0.100 beyond the INFEED setting on the HOME screen with spring compression.
- b. Concentric or rigid material - the throat should be set within .050 or .100 of the materials actual measured diameter. If motor limits (chatters) during set-up, an INFEED CALIBRATION will be needed before the next load of material. (SEE STEP 16 & 17 above).

NOTE: Pressing the red E STOP button at any time during operation will STOP and PAUSE the job that is running. When the E STOP is returned to the run position, the job can be restarted from where and when it was stopped.

NOTE: The SLICE was designed for processing a large variety of materials. It comes calibrated from the factory for a cut length of 12" using flat ribbon cable (consistent geometries with no elasticity).

NOTE: The two red actuating buttons located on the sides of the 230 will only be functional from the HOME screen.

NOTE: When cutting materials that lack concentricity or have elasticity or when cutting longer lengths of material, the LENGTH CALIBRATION FACTOR in the FACTORY SETTING screen will need to be changed to account for material stretch or slippage to achieve an accurate and consistent cut length measurement.

ALWAYS RUN A ONE PICE SAMPLE TO MEASURE AND VALIDATE CUT LENGTH WHEN SETTING UP NEW JOBS. IT IS HELPFUL TO RUN A LENGTH THAT IS LONGER THAN DESIRED IN CASE THE ACTUAL CUT LENGTH IS LESS THAN EXPECTED. THE FIRST PICE SAMPLE CAN THEN BE TRIMMED TO LENGTH INSTEAD OF SCRAPPED. If length is not as expected, recalibrate per the note above. You may have to run a couple first articles to confirm.



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TROUBLESHOOT

- 1) Light tower does not light green. Check Light tower is connected to 230. Check HMI to PLC cable is fully seated (requires opening 230).
- 2) Infeed roller actual opening as measured is not per the INFEED dimension as displayed. Press F4 to toggle to the FACTORY SETTINGS screen. WITH NO MATERIAL LOADED OR IN THE THROAT, press INFEED CALIBRATE.
- 3) Mouse is in operable. Make sure the USB cable internal to the 230 is connected to the USB port on the HMI (requires opening HMI).

For technical support in English or Spanish, please contact by email: info@amtproduct.com or phone: 847.588.7090 (From the main menu, dial 2).