



By



OPERATING INSTRUCTIONS MODEL HOT SLICE 300

**READ CAREFULLY
BEFORE OPERATING YOUR MACHINE**

A Safety Note:

Your good manufacturing practices should ensure that a written safety program is in place, which includes the assessment of all processes that take place in house, for potential risks.

The employer response to this assessment is to establish specific instructions for the safe use of all machines, safe use of certain chemicals, etc. in your workplace.

For instance, any user of electrical machinery, HOTSLICE included, must be instructed that **never, under any circumstances**, should a machine be left powered, or with air connected, while attempting to clear a jam, if it should occur.

This written rule, along with other directives, should be translated into either a training document that is signed or work instruction that is also signed and dated by all operators and that ideally remains with the equipment as a reminder of safe operation.



Published by:
AMTI PRODUCTS

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AMTI reserves the right to make technical changes to the system described and indicated in these instructions if such changes are necessary to improve the machine.

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1.1 Product Description

The HOT SLICE 300 is an automatic cutting machine intended to cut various materials to length within the scope of the technical data. It is for industrial use.

1.2 System Description

1. Die size: 1.5" x 3" opening
2. "Stock Jam or Not Feeding" indicator
3. User-friendly HMI with PLC integration
4. Drive wheel and tracking wheel to enhance pulling action

1.3 FUNCTION AND OPERATION

1. Operates like other models in the HOT SLICE series (closest to the 230).

1.4 PERFORMANCE SPECIFICATIONS

1. Thermal cutting system to cut and cure synthetic materials within its input aperture of 1.5" height by 3" wide
2. Adjustable feed rate from 5" per second to 35" per second
3. Machine discrimination 0.5mm repeatability and accuracy is greatly dependent upon material and material feeding conditions. Best accuracy to be expected is ± 1 mm

1.5 POWER REQUIREMENTS

1. Electric 120volts at 50/60 hertz

1.6 OPERATING CONDITIONS

1. Temperature 10° to 35° C

1.7 SYSTEM SIZE

Length: 28"

Width: 18"

Overall Height: 30"

1.8 UNIT WEIGHT

70 pounds

Aluminum & hardened tool steel construction

1.9 MAX SOUND LEVELS

74 DB

1.10 MATERIALS

The HOT SLICE 300 will cut most materials that would otherwise require a heated blade and can fit within the die size of 1.5" diameter x 3" wide. Contact AMTI Customer Service regarding materials that can be processed on the unit.

2.0 Safety

Always observe the following safety rules:

1. These sets of documentation are integral parts of the machines and devices they were written for and must be heeded.
2. Always turn off power and disconnect the air lines before investigating jams or internal issues.
3. Never place fingers, hands, or tools into the machine while it is plugged in and air is connected
4. Prior to starting the machine, check to see that all safety features are attached and properly operating. The safety requirements are met only if the safety features are operating properly.
5. Machine safety is only achieved when the materials being processed (wire, tubing, etc.) are those specified in the technical data. Make sure the improper use of materials is prevented!
6. Do not cut flammable, explosive, wet, etc. materials.
7. Do not operate outside standard environment requirements and use power supply as recommended.
8. Only duly authorized and trained persons familiar with the safety features of the machine are allowed to maintain and repair the machine. The machine can be dangerous if operated improperly by untrained persons.
9. Machine safety is achieved only by operators. Persons working on the machine must always take care that no other persons are endangered by the input of a command.
10. If you have reason to believe the machine can no longer be operated safely, you must take the system out of operation and safeguard it against being unintentionally switched back on.
11. Observe the notes in these instructions as well as locally valid rules of safety and accident prevention.

3.1 The Operating Instructions

These operating instructions are valid for the HOT SLICE 300 and available in English. Other languages are available upon request.

The instructions contain complete information on the controls, handling, maintenance, and setting procedures as well as all technical data.

The operating instructions are an integral part of the HOT SLICE 300. Keep them within reach so you have access to the information you need at all times.

Pay very close attention to the safety notes and directions. If you need additional sets of documentation, please contact AMTI for more details, or visit our website at “www.amtiproducts.com”.

3.2 Machine Identification

On the back of the machine, you will find a nameplate with the following:

Information:

Company Contact
Machine Type
Machine Serial
Power Requirement



MODEL: HOT SLICE 300

S/N: 20182339

115V-60HZ-2A-200W

MADE IN USA

WWW.AMTIPRODUCTS.COM

3.3 Personal Qualifications & Training

3.3.1 Personnel Qualifications

Machine Operator:

The machine operator must be sufficiently familiar with the machine to be able to operate it, its accessories, and its peripheral devices in production on his/her own without difficulty. This requires that the operator be educated in the technology involved and be knowledgeable of the software for operating the machine.

Service Technician:

The service technician should have an extensive knowledge of the machine. Apart from machine operations, he/she must be able to locate errors and take suitable steps to remedy them. A service technician must be able to maintain the machine correctly to increase its service life and availability. His/her full familiarity of the software should enable the machine to be used to the maximum effect in production.

For this work, the service technician must have wire processing experience. He/she must also have completed training in mechanics or electronics and have a sound knowledge of the machine.

3.3.2 Training

All personnel that are using SLICE® equipment should be trained in its proper use and safety required when operating this equipment.



4.0 SET-UP

1. Take pictures of crate prior to opening.
2. Open crate and take pictures of contents.
3. Get a helper to lift 300 to a cart, make sure the exit guide is over the 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. Pins may need to be jigged 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 HOT SLICE
8. If 300 has optional bar code scanner, connect scanner cable on left side of the machine.
9. Plug mouse into USB on right side of machine. Use provided mouse pad if needed.
10. Connect air – 80 psi.
11. Install power cord and connect to power.
12. Power up 300. 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 again to toggle to the FACTORY SETTINGS screen. Defaults should be Length Calibration Factor, Measure Length Calibration Factor 100.00, Blade to Zero Load Sensor 0.4000, and Cutter Dwell .35.
16. From this screen, WITH NO MATERIAL LOADED OR IN THE THROAT, press INFEED CALIBRATE. The 300 will close the throat to zero then open it to the INFEED setting dimension on the HOME screen.
17. 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 20.0, Cutter Cycle Time Out 5.0, and Platform ID 3.
18. Press F4 or NEXT again to toggle to the FACTORY SETTINGS 3 screen. Default should be Warm Up Time 240.0, Temperature Wait Time 10.0, and Material Retract Distance 1.75.
19. Press F2 or ABOUT to toggle to VERSION INFORMATION. PLC & HMI software is production option and time specific.
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 300 QR code link on the top of the machine.



5.0 General Operational Information

1. 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 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).
2. 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.
3. The HOT 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).
4. The two red actuating buttons located on the sides of the HOT SLICE will only be functional from the HOME screen.
5. 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.
6. ALWAYS RUN A ONE PIECE 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 PIECE SAMPLE CAN THEN BE TRIMMED TO LENGTH INSTEAD OF SCRAPPED.
 - a) If length is not as expected, recalibrate per the note above. You may have to run a couple of initial articles to confirm.



6.0 TROUBLESHOOT

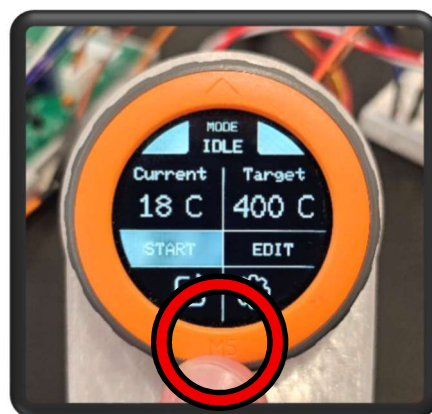
1. Light tower does not light green: Check Light tower is connected to 300. Check HMI to PLC cable is fully seated (requires opening 300).
2. Infeed roller actual opening as measured is not per the INFEED dimension as displayed: Press F4 to toggle to the FACTORY SETTINGS screen. WITH NO MATERIAL LOADED OR IN THE THROAT, press INFEED CALIBRATE.
3. Mouse is inoperable: Make sure the USB cable internal to the 300 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).



7.0 Temp Tune Dial – Main Page

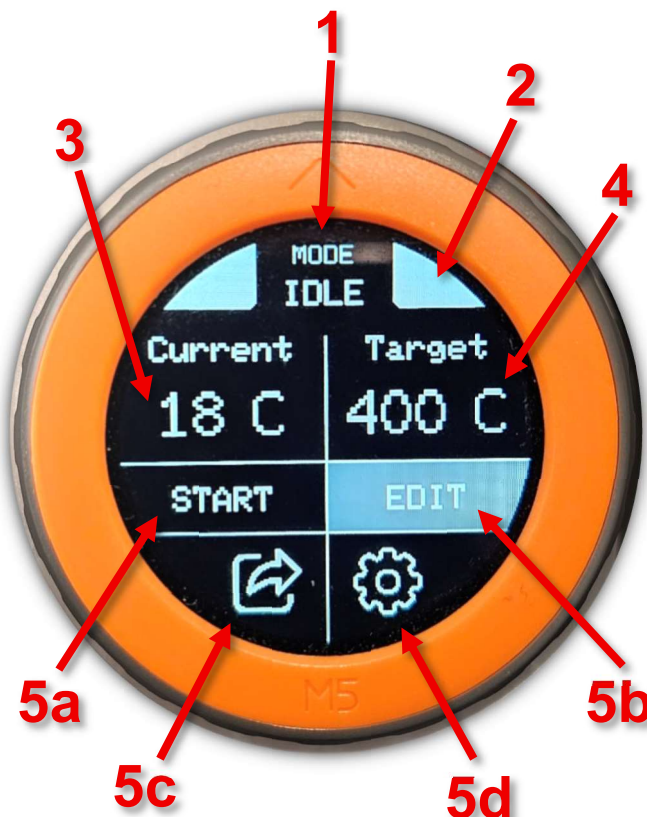
How To Control:

Use the rotating outer ring in either direction to navigate through menus and edit values. Press the bottom of the dial to select and confirm interactions with menu items.



Main Page:

1. Mode Status Indicator (IDLE / EDIT / HEAT)
2. Supporting Mode Status Indicators (WHITE-IDLE / YELLOW-EDIT / RED-HEAT)
3. Current Temperature Reading (actual reading from the integrated thermocouple)
4. Target Temperature (current set value for the desired operating temperature)
5. Main Menu Navigation
 - a. “Start”: Begin heating to target temperature (button value will become “STOP” and can be pressed again to exit heating)
 - b. “Edit”: Press to edit target temperature, rotate outer ring to increment/decrement, press dial button again to confirm new target
 - c. “Presets”: Press to enter Presets Page
 - d. “Settings”: Press to enter Settings Page

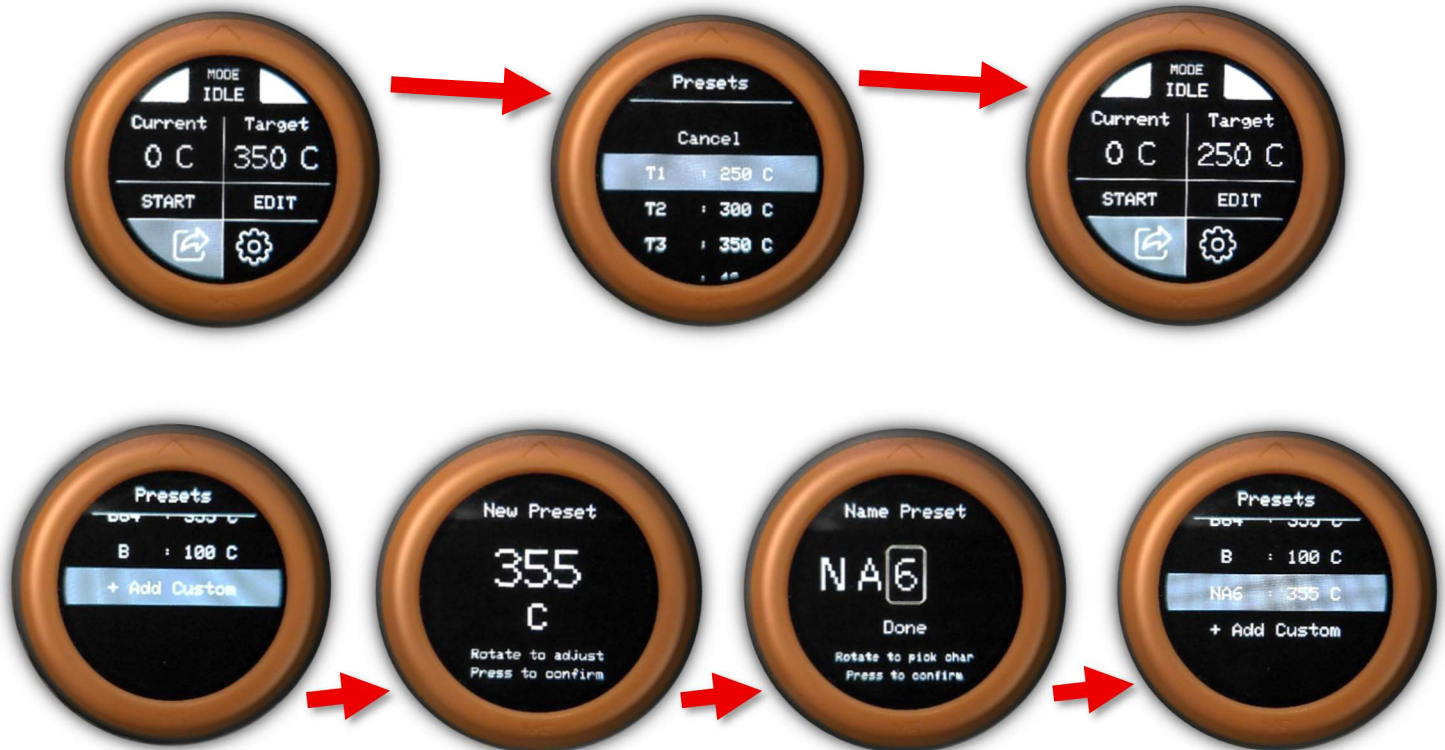




7.1 Temp Tune Dial – Presets Page

Presets Page:

1. “Cancel”: Return to Main Page
2. Select an existing preset to automatically populate the target temperature value and return to the Main page
3. “+ Add Custom”: Press to create a new custom preset
 - a. Rotate outer ring to change preset value, press to confirm
 - b. Rotate outer ring to select a character space to edit, press to confirm, use outer ring once again to select which character to fill space with, press once again to confirm
 - c. When done with editing, rotate outer ring to hover over “Done” and select to finish the creation of a new preset
4. To modify or delete existing presets, when on the Presets Page, hover over whichever preset should be modified/deleted and hold press on the dial button until the configuration menu appears. Now, press “Modify” to edit the preset, “Delete” to delete the preset, or “Cancel” to return to the Presets page without making any changes



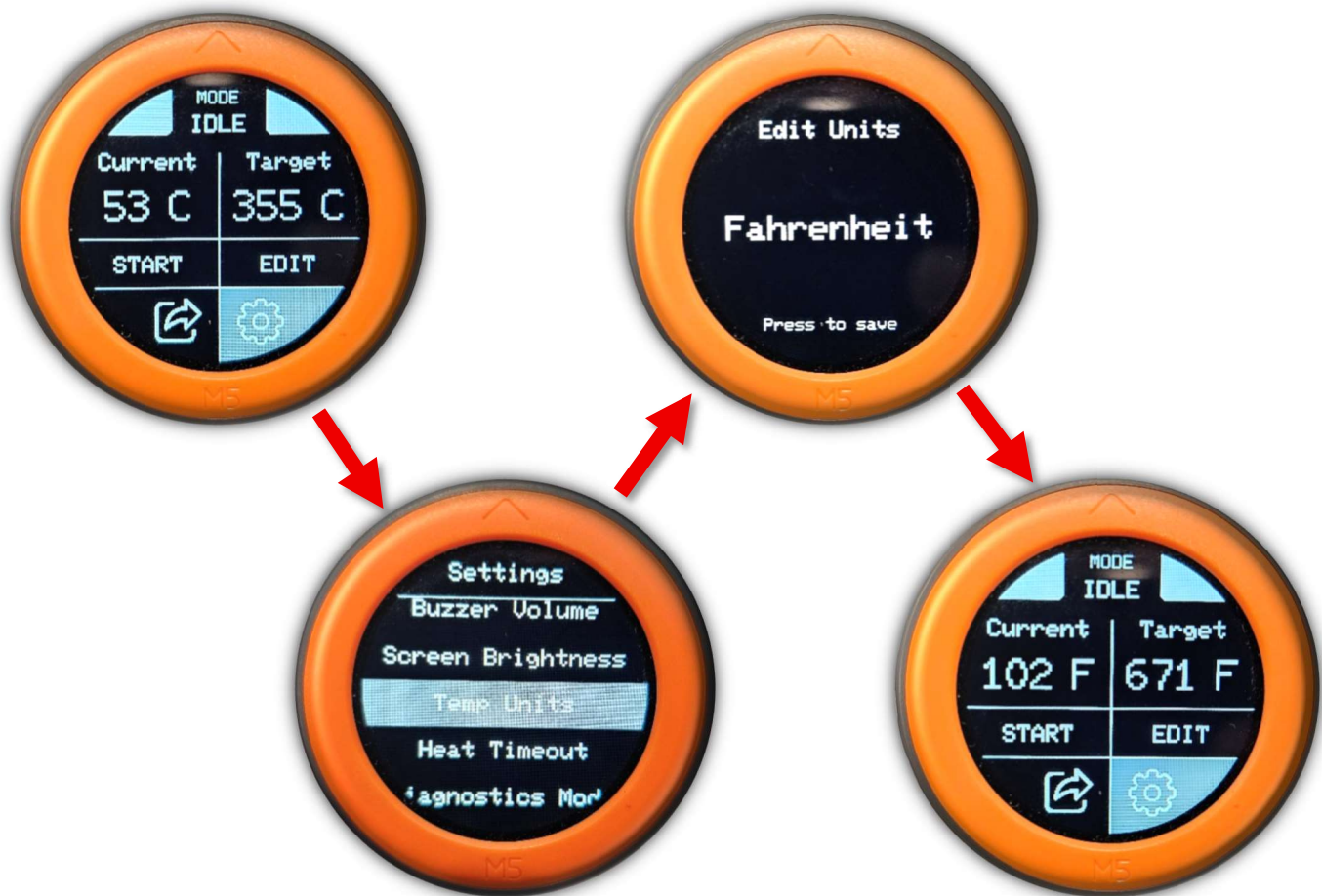


7.2 Temp Tune Dial – Settings Page

Settings Page:

1. “Buzzer Volume”: Controls volume of beeping when navigating (Quiet / Normal / Loud)
2. “Screen Brightness”: Controls brightness of display (Dim / Normal / Bright)
3. “Temp Units”: Choose between device-wide temperature units (Celsius / Fahrenheit)
4. “Heat Timeout”: Turns mode back to Idle if no jobs are started (30s / 1min / 2min / 5min)
5. “Diagnostics Mode”: Switches Main Page to diagnostics mode for developer troubleshooting
6. “Show Welcome”: Toggles on and off the Temp Tune Dial welcome screen on startup
7. “Calibrate Heater”: Automatic heater calibration (step through on screen instructions)
8. “System Info”: Provides current system information
9. “Cancel”: Return to Main Page

Example:



HOT SLICE 300



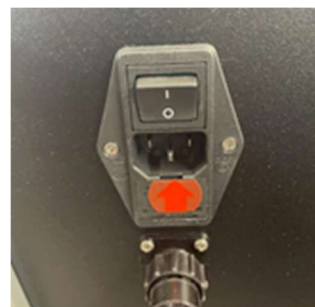
MAKE SURE TOP & BOTTOM SAFETY GUARDS ARE ATTACHED



8.0 QUICK START GUIDE



1. CONNECT AIR LINE TO 1/4" NPT NIPPLE. SET REGULATOR TO 80 PSI.



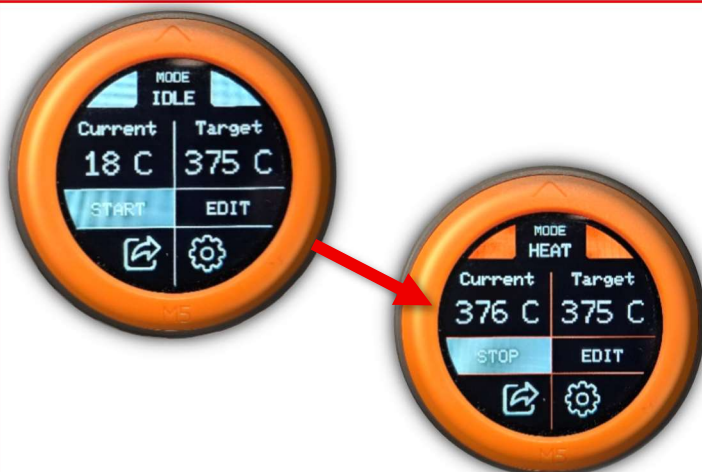
2. PLUG IN POWER CORD AND TURN POWER ON. DISPLAY APPEARS IN A FEW SECONDS.



3. ROTATE THE GRAY RING UNTIL "EDIT" IS HIGHLIGHTED. PRESS THE DIAL BUTTON TO SELECT.



4. WHEN THE RING TURNS YELLOW, ROTATE TO SET TEMPERATURE. PRESS THE DIAL BUTTON TO CONFIRM.



5. ROTATE UNTIL "START" IS HIGHLIGHTED. PRESS THE DIAL BUTTON TO SELECT.

PRESS TWO RED BUTTONS TO WARM

400 °C

JOB NAME: 0 0.00 0.000

JOB NUMBER QUANTITY LENGTH (inches) INFEEED (inches)

CURRENT COUNT: 0

EJECT / RELOAD **WARM** JOBS

LOAD CLEAR SETUP

6. PRESS "WARM" TO BEGIN THE 4-MINUTE WARM-UP.

HOT SLICE 300

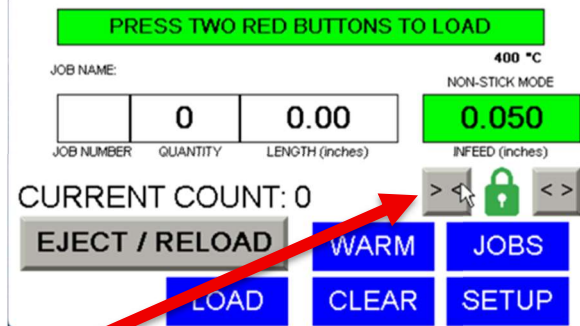
8.1 QUICK START GUIDE CONT



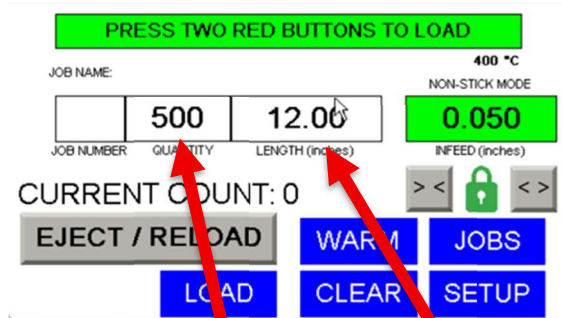
MAKE SURE TOP & BOTTOM SAFETY GUARDS ARE ATTACHED



7. ON THE HOME SCREEN, PRESS THE OPEN BUTTON TO OPEN THE INPUT WHEELS. INSERT MATERIAL.



8. PRESS THE CLOSE BUTTON TO CLOSE/CLAMP THE INPUT WHEELS TO PREVENT SLIPPAGE.



9. ENTER JOB QUANTITY AND PIECE LENGTH.



10. PRESS BOTH RED BUTTONS ON THE SIDE OF THE MACHINE TO LOAD MATERIAL AND CROP CUT



11. AGAIN, PRESS BOTH RED BUTTONS ON THE SIDE OF THE MACHINE TO NOW "RUN"



12. CONFIRM STATUS SHOWS "RUNNING"

TO RUN MACHINE FROM JOBS

8.2 LOAD JOB

PRESS TWO RED BUTTONS TO WARM

JOB NAME: [] 400 °C
NON-STICK MODE

JOB NUMBER: 0 QUANTITY: 0.00 LENGTH (inches): 0.000 INFEEED (inches): 0.000

CURRENT COUNT: 0

EJECT / RELOAD WARM JOBS
LOAD CLEAR SETUP

1. FROM HOME, PRESS "JOBS".

JOBS

Jobs: 1 / 150

Load Job
Save Job
Delete Job

HOME ABOUT PREV NEXT

2. PRESS "LOAD JOB"

LOAD JOB

NUMBER NAME

1 langoffx G .750
2 Calibration
3 Test2
test3
10 Calibration

JOB NUMBER TO LOAD

HOME

3. Remember the Job Number. Press JOB NUMBER TO LOAD NUMBER. Enter the Job Number in the Key Pad.

PRESS TWO RED BUTTONS TO LOAD

JOB NAME: Calibration TEMP °C: 400
NON-STICK MODE

JOB NUMBER: 0 QUANTITY: 0.00 LENGTH (inches): 0.000 INFEEED (inches): 0.000

CURRENT COUNT: 0

EJECT / RELOAD WARM JOBS
LOAD CLEAR SETUP

4. PRESS BOTH RED BUTTONS ON THE SIDE OF THE MACHINE TO LOAD MATERIAL AND CROP CUT

PRESS TWO RED BUTTONS TO RUN

JOB NAME: Test2 400 °C
NON-STICK MODE

JOB NUMBER: 3 QUANTITY: 10 LENGTH (inches): 12.00 INFEEED (inches): 0.000

CURRENT COUNT: 0

EJECT / RELOAD WARM JOBS
RUN LOAD CLEAR SETUP

5. PRESS BOTH RED BUTTONS ON THE SIDE OF THE MACHINE TO NOW "RUN"

RUNNING

JOB NAME: Test2 400 °C
NON-STICK MODE

JOB NUMBER: 3 QUANTITY: 10 LENGTH (inches): 12.00 INFEEED (inches): 0.000

CURRENT COUNT: 1

EJECT / RELOAD PAUSE JOBS
RUN LOAD CLEAR SETUP

6. CONFIRM STATUS SHOWS "RUNNING"

9.0 Contact Info

SLICE® was specifically designed for easy set-up and use. However, if you experience any difficulties with your machine that you cannot resolve using the information we have provided you with, please contact us for assistance. If you have any suggestions for improvement or ease of operation, please contact our Service Department with your comments/suggestions.

How To Reach Our Service Department:

E-mail: info@amtproducts.com **Telephone:** 847.588.7080

Identify yourself as a HOT SLICE customer who needs to talk about a problem, and you will be placed in contact with either an applications engineer or a service technician.

Important Information: Save the original packaging materials.

10.0 Routine Maintenance Notes For The Slice Machines

Important! Be Sure To Turn Off And Unplug Machine Along With Disconnecting The Air Line From The Hot Slice Unit Before Performing Any Maintenance or Inspections!

Note: The Preventive Maintenance Program is based solely on the extent of use of the HOT SLICE machine. Typically, item 2 should be done on a weekly basis, however, if the HOT SLICE machine is being used extensively then you may want to initiate a Daily Maintenance Program.

1. Make certain that the venting holes located on the side of the machine are not blocked when the machine is in use.
2. Periodically, you may need to remove material fragments from the inside the machine. First and always, unplug machine and disconnect airline from the HOT SLICE unit. Remove front panel and use air gun or soft, clean brush to gently brush any fragments that may have accumulated over time. Reassemble front panel and only then plug the HOT SLICE unit back in and connect the air line.
3. Additional Maintenance Procedures would include the following and should be done periodically depending on the extent of use.

Weekly:

- Check to make sure no material is stuck in Blade and plunger.
- Check blade Optic Sensor making sure it is free from debris.
- Check to make sure all connections are intact.

Monthly:

- Check Flag and Sensor alignment, adjust accordingly if needed.
- Check Drive and Idler wheels for damage, clean or replace as needed.

Annually:

- Apply grease to gearbox on left side of cutter housing assembly.

As Needed:

- Check heating blade, plunger.

11.0 HOT SLICE 300 SCANNER APPLICATION NOTE

The barcode scanner option allows the operator to easily configure the unit by scanning one or more barcodes. Any symbology supported by the scanner may be used if the symbology selected supports the characters required.

The two types of barcodes are supported:

- **Job Loading:** Scanning a 3-digit numeric value will cause the unit to load the settings defined in a previously saved Job corresponding to the Job's 3-digit numeric value. If the Job does not exist in the unit, the scanned barcode will be ignored. Loading a saved Job will update the current job-related settings with the settings from the saved Job.
- **Current Settings:** Individual setting values correspond to the settings that may be entered using the touchscreen display (HMI) mounted on the unit. By using an appropriate barcode symbology, multiple settings may be concatenated into a single barcode. This method does not require the use of previously saved Jobs.

Table 1 - Supported Barcode Symbologies

Aztec	Code 93	GS1 Databar	Interleaved 2 of 5
Codabar	Code 128	PDF417	UPC/EAN/JAN
Code 39	Data Matrix	QR Code	

Example 1: Code 39 barcode to load Job 150:



Example 2: QR barcode to set the Quantity to 5, the Length to 24.0 and the Infeed to 1.0:



QTY 5
LEN 24.0
INF 1.0

To program a specific setting, select the appropriate 3-letter tag for the setting and follow it with the setting's new value. Multiple settings may be concatenated into a single barcode. To indicate the end of the data for a specific setting, append a carriage return <CR> and line feed <LF> character sequence immediately following the setting's new value (see examples below).

Tag	Setting	Value type	Input Range	Notes
QTY	Quantity	Integer	0 to 99999	The total number of pieces to cut
LEN	Length	Real	0.0 to 3900.00	The length of each piece to cut
INF	Infeed	Real	-0.375 to 1.25	The distance between the infeed rollers
CRL	Crop Length	Real	0.0 to 3.0	The distance moved to perform a crop cut
ZLT	Zero Load Wait Time	Real	0.0 to 99.9	The time the infeed rollers will wait for the next stick to be inserted
SPD	Speed	Real	1.0 to 35.0	The material speed
STL	Stick Length	Real	1.0 to 100.0	The material length inserted into the infeed during Stick/Multi-Stick modes
UNT	Units	INCHES, MM		Inches or Millimeters
ALN	Auto Load Next Stick	ON, OFF		Automatically load the next stick when the current stick is complete
ASE	Automatic Scrap Eject	ON, OFF		Do not require a "Two Red Button" press to eject scrap when a stick is complete
MOD	Mode	STICK, NON-STICK, MULTI-STICK		Material processing modes
TYP	Load Type	CROP, ZERO		Crop cut or zero-load when a new length of Non-Stick material is inserted
ASL	Auto Start After Load	ON, OFF		Do not require a "Two Red Button" press to start processing after a crop or zero-load is complete
LCF*	Length Calibration Factor	Real	0.0 to 999.99	The scaling factor used to determine the length of the material is moved before it is cut
MCF*	Measured Length Calibration Factor	Real	0.0 to 999.99	The scaling factor used to adjust the measured material length (currently unused)
BSD*	Blade to Zero Load Sensor Distance	Real	0.0 to 99.9999	The distance between the zero-load sensor and the cutting blade (knife)
PMD*	Platen Motor Power-off Delay	Real	0.0 to 99.9	The time the platen motor remains energized after motion is complete

IMT*	Infeed Motor Timeout	Real	0.0 to 99.9	The maximum time the Infeed motor will remain energized while calibrating the Infeed home position
CCT*	Cutter Cycle Timeout	Real	0.0 to 99.9	The maximum time the cutter actuation cylinder will remain energized while waiting for cutter motion
MSC	Multi-Stick Stick Count	Integer	1 to 10	The number of material sticks inserted into the Infeed
MIO	Multi-Stick Infeed Open	Real	-0.375 to 1.25	The distance to open the Infeed to allow loading of material sticks
LAN	Language	ENGLISH, SPANISH		English or Spanish
CDT	Cutter Dwell Time	Real	0.0 to 99.99	The time the cutter blade (knife) will remain extended during a cut operation
PRD	Printer Relative Darkness	Integer	-30 to 30	The relative darkness setting for the Barcode Label
PLT	Printer Label Title	String	25 characters max	The title of the label to be printed on the Barcode Label
PIT	Printer Include Text	YES, NO		Include human readable text for each setting on the Barcode Label
PBC	Printer Barcode Contents	MACHINE, JOB, MACHINE+JOB		Select the settings to print on the Barcode Label
NAM	Job name	String	20 characters max	A descriptive name of the current Slice 230/300 settings
TMP†	Temperature	Real	100.0 to 500.0	The cutter blade (knife) temperature setting
WUT*†	Warm Up Time	Real	0.0 to 999.9	The amount of time to wait during the warmup cycle
TWT*†	Temperature Wait Time	Real	0.0 to 99.9	The amount of time to wait for the temperature of the cutter blade (knife) to be in range
MRD*†	Material Retract Distance	Real	0.0 to 9.99	The distance to retract the material after cutting when material processing is complete or paused

Items marked * are for factory use only.

Items marked † are on Hot Slice 230/300 units only.

Items marked  are updated when a previously stored Job is loaded.

The method used to generate the barcodes will depend on the type of printer being used. Here are several examples using Zebra printers:

The text in yellow contains the command and data to create the QR code. The remaining text contains printer controls and commands to generate text to reflect the various setting values. Note the ^BQ command used the ^FH modifier to allow ASCII hex values to be inserted into the barcode's field data (_0D_0A). This provides the required <CR> and <LF> characters needed after each setting value.

```
^XA^MMT
^FO20,100^AD40,40^FD      1. RAPID STICK FEED DEMO^FS
^FO20,140^AD40,40^FDQuantity=15 Length=4.00" Infeed=0.000"^FS
^FO20,180^AD40,40^FDSpeed=25.0IPS Stick Mode Stick Length=22.00"^FS
^FO20,220^AD40,40^FDZero Load Zero Load Wait Time=10SEC^FS
^FO20,260^AD40,40^FDAuto Load Next Stick=ON^FS
^FO20,300^AD40,40^FDAuto Start After Load=ON^FS
^FO20,340^AD40,40^FDAutomatic Scrap Eject=ON^FS
^FO400,380^BQN,2,10^FH^FDA,
UNT INCHES_0D_0A
QTY 15_0D_0A
LEN 4.00_0D_0A
SPD 25_0D_0A
MOD STICK_0D_0A
STL 22.00_0D_0A
ZLT 10_0D_0A
ALN ON_0D_0A
ASL ON_0D_0A
ASE ON_0D_0A
INF 0.000_0D_0A
^XZ
```

```
^XA^MMT
^FO20,100^AD40,40^FD      2. MULTI-CUT STICK DEMO^FS
^FO20,140^AD40,40^FDQuantity=6 Length=3.00" Infeed=0.000"^FS
^FO20,180^AD40,40^FDSpeed=25.0IPS Non-Stick Mode Crop Cut Load^FS
^FO20,220^AD40,40^FDAuto Start After Load=OFF^FS
^FO400,260^BQN,2,10^FH^FDA,
UNT INCHES_0D_0A
QTY 6_0D_0A
LEN 3.00_0D_0A
SPD 25_0D_0A
MOD NON-STICK_0D_0A
TYP CROP_0D_0A
CRL 1.0_0D_0A
ASL OFF_0D_0A
INF 0.000_0D_0A
^XZ
```

12.0 Factory Reset

If the scanner is ever replaced or becomes misconfigured, the following procedure should be performed to reset the scanner and configure it for use with the Slice 230/300.

To reset the scanner to the factory settings, scan the following barcodes in sequence, making sure the scanner beeps for each scan. After scanning the sequence, cycle power on the scanner.

1. FACTORY DEFAULT THE SCANNER



3. FACTORY DEFAULT THE SCANNER



2. SET SCANNER BAUD RATE TO 38400:



4. CYCLE SCANNER POWER AND
VERIFY PROPER OPERATION

13.0 SPARE PARTS LIST

ELS4655	CABLE, USB. A-B MALE	SA1531	FAN ASSEMBLY
ELS4706	PLC - Micro 850	SA2187	SENSOR ASSEMBLY -36"
ELS4707	HMI 4" Panel View Display	SA3331	FEED GUIDE ASSEMBLY
ELS4724	Switching Power Supplies	SA3345	AUXILLARY GEAR ASSY.
ELS4725	PLC Serial Cable 3m/9.8ft	SA4317	EMERGENCY STOP SWITCH ASSY
ELS4727	Stepper Motor Driver (Main)	SA4549	QUICK RELEASE PIN
ELS4729	Stepper Motor Driver (Throat)	SA4843	REGULATOR/FILTER KIT
ELS4731	Signal Tower	SA4991	INTERFACE POWER CIRCUIT BOARD
GR3341	PIC G7-60 SPUR GEAR	SA5001	AIR VALVE ASSY - SLICE
GR3342	PIC G7-42 SPUR GEAR	SA5002	ENCODER ASSY - SLICE
MFB3229	FLAG	SA5003	THROAT MOTOR SENSOR - SLICE
MFB3232	DIE GUIDE	SA5016	Throat Motor Assy
MFB3236	DIE SIDE, RIGHT	SA5202	Blade/Thermocouple ASSY
MFB3237	DIE SIDE, LEFT	SUP563	SELF CLOSING CLIPS
MFB3244	DRIVE WHEEL SS SLICE	SUP615	RUBBER FEET
MFB3245	DRIVE WHEEL, POLY FOR SLICE	SUP1598	SHIELDED BEARING
MFB3248	DRIVE WHEEL AXLE	SUP3344	SPRING
MFB3254	SENSOR MOUNT	SUP3427	RETRACTABLE SPRING PLUNGER
MFB3307	GEAR HOLDER, LEFT	SUP3602	AIR CYLINDER
MFB3308	GEAR HOLDER, RIGHT	SUP3648	BALL PLUNGER
MFB3309	GEAR AXLE	SUP4965	timing gear
MFB3310	GEAR SWIVEL BAR	SUP4966	Timing Belt
MFB3312	IDLER WHEEL, POLY	SW4330	MOMENTARY SWITCH
MFB3332	DRIVE 2 AXLE, LEFT		
MFB3333	ENCODER WHEEL AXLE		
MFB3334	DRIVEN IDLER WHEEL AXLE		
MFB3339	DRIVE 2 AXLE, RIGHT		
MFB4578	DIE SUPPORT		
MFB5200	Plunger HOT SLICE		

