



by



OPERATING INSTRUCTIONS MODEL 230

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 work place.

For instance, any user of electrical machinery, SLICE® included, must be instructed that never, under any circumstances, should a machine be left on 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:
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1.0 Product Description

The SLICE 230 is an automatic cutting machine intended to cut various materials to length within the scope of the technical data. It is for industrial use ONLY.

1.1 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

1.2 FUNCTION AND OPERATION

1. Operates like other models in the SLICE series.

1.3 PERFORMANCE SPECIFICATIONS

1. Cutting system to cut 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 $\pm .025$ "

1.4 POWER REQUIREMENTS

1. Electric 120volts at 50/60 hertz

1.5 OPERATING CONDITIONS

1. Temperature 10° to 35° C

1.6 SYSTEM SIZE

Length: 28"

Width: 18"

Overall Height: 30"



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1.7 UNIT WEIGHT

70 pounds

Aluminum & hardened tool steel construction

1.8 MAX SOUND LEVELS

74 DB

1.9 MATERIALS

The SLICE 230 will cut most materials that 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.



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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.



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3.0 The Operating Instructions

These operating instructions are valid for the SLICE 230 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 SLICE 230. 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”.



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3.1 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: SLICE 230

S/N: 20182339

115V-60HZ-2A-200W



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3.2 Personal Qualifications & Training

3.2.1 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.

3.2.2 Training

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



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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 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 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 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.



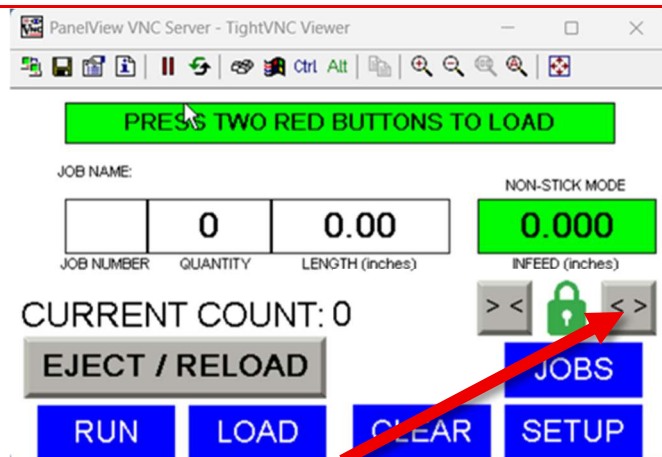
5.0 QUICK START GUIDE



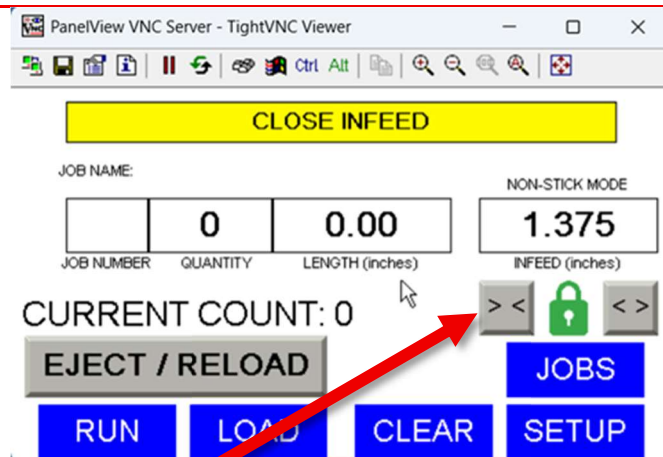
- 1. CONNECT AIR LINE TO 1/4" NPT NIPPLE. SET REGULATOR TO 80 PSI.**



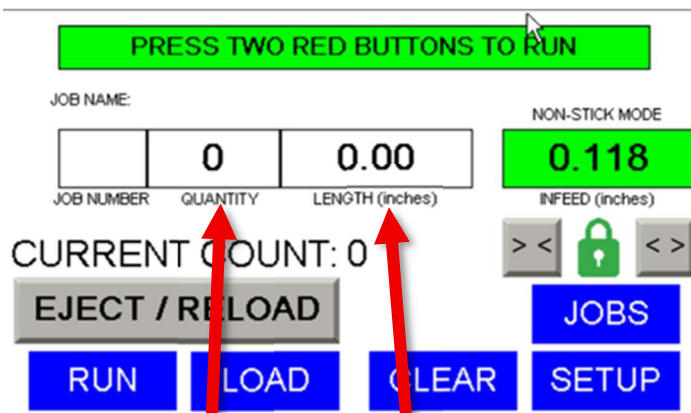
- 2. PLUG IN POWER CORD AND TURN POWER ON. DISPLAY APPEARS IN A FEW SECONDS.**



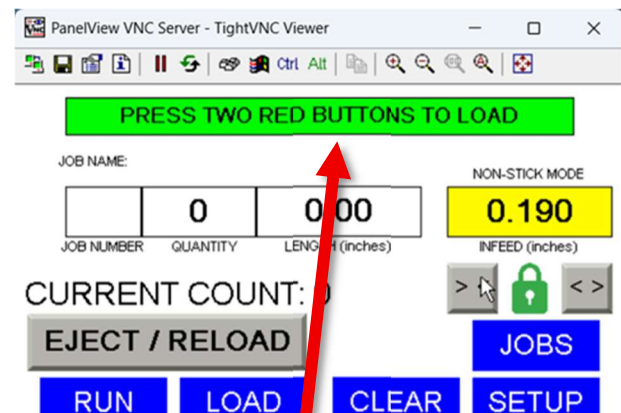
- 3. PRESS THE OPEN BUTTON TO OPEN THE INPUT WHEELS. INSERT MATERIAL.**



- 4. PRESS THE CLOSE BUTTON TO CLOSE/CLAMP THE INPUT WHEELS TO PREVENT SLIPPAGE.**



- 5. ENTER JOB QUANTITY AND PIECE LENGTH.**



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



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5.1 QUICK START GUIDE CONT

7. AGAIN, PRESS BOTH RED BUTTONS ON THE SIDE OF THE MACHINE TO NOW "RUN"	8. PRESS THE CLOSE BUTTON TO CLOSE/CLAMP THE INPUT WHEELS TO PREVENT SLIPPAGE.

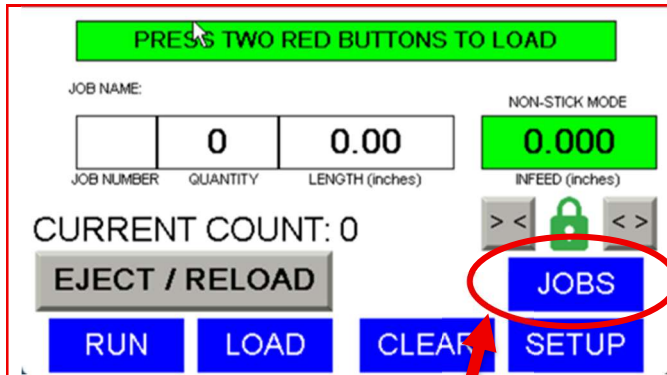


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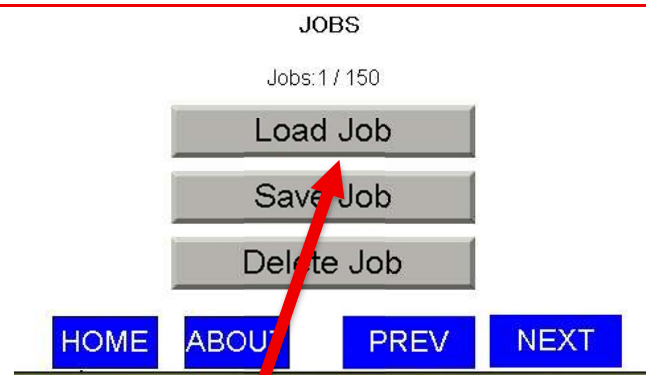


TO RUN MACHINE FROM JOBS

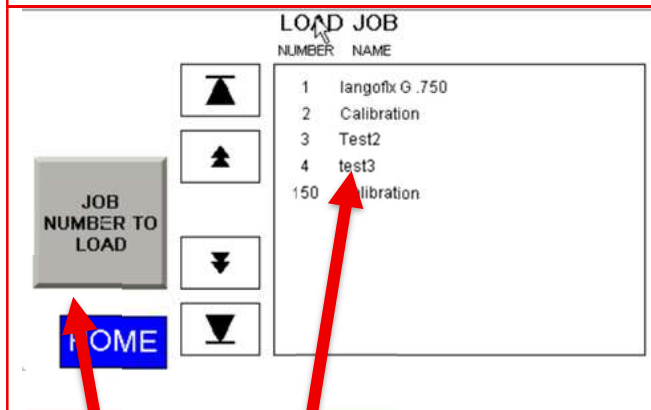
5.2 LOAD JOB



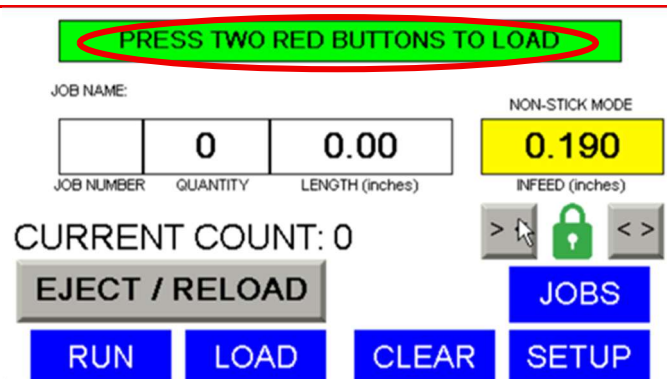
1. FROM HOME, PRESS "JOBS".



2. PRESS "LOAD JOB"



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



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



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



6. CONFIRM STATUS SHOWS "RUNNING"



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6.0 TROUBLESHOOT

- 1) **Machine will not power on / HMI does not boot:** Confirm the power cord is fully seated and the outlet is live. Check that the air supply is connected. Verify no E-STOP is engaged. If the HMI still does not boot after 30 seconds, contact AMTI Service.
- 2) **Light tower flashes or shows yellow / red:** Yellow typically indicates the machine is paused or waiting for operator input (E-STOP engaged or job not yet loaded). Red indicates a fault - check the HMI screen for a specific fault message. Press HOME on the HMI to review current status. Power cycle the machine if the fault cannot be cleared from the HMI.
- 3) **Cut quality is poor (ragged edges or inconsistent lengths):** Ensure the blade is not worn or damaged - replace if needed (see Spare Parts List). Ensure ball plungers on bottom of die assembly are set properly. Verify feed speed (SPD) is appropriate for the material. Adjust LENGTH CALIBRATION FACTOR if cut lengths are drifting. Check the blade optic sensor for debris.
- 4) **Material not feeding (infeed rollers spin but material does not advance):** Verify the INFEED (throat) setting matches the material diameter. Rigid or concentric materials need the infeed set within 0.050"-0.100" of actual diameter. Re-run INFEED CALIBRATE with no material loaded. Inspect the drive wheel and tracking wheel for wear or debris buildup.
- 5) **Machine stops mid-job or E-STOP triggers unexpectedly:** Verify air supply is stable at 80 PSI. Low air pressure can cause the cutter cylinder to time out (see CUTTER CYCLE TIMEOUT in Factory Settings). Check for material jammed in the throat or around the blade. Inspect air lines for kinks or leaks.
- 6) **Cut length is shorter or longer than expected:** Adjust the LENGTH CALIBRATION FACTOR in the FACTORY SETTINGS screen (press F4). Increase the value to lengthen cuts; decrease to shorten. Always run a one-piece sample after any change. Materials with elasticity or slippage typically need a higher calibration factor.
- 7) **Mouse is inoperable:** Make sure the USB cable internal to the 230 is connected to the USB port on the HMI (requires opening the HMI).
- 8) **Infeed roller opening does not match the INFEED dimension displayed:** Press F4 to navigate to the FACTORY SETTINGS screen. With no material loaded or in the throat, press INFEED CALIBRATE.
- 9) **Light tower does not light green:** Check that the light tower is connected to the 230. Check that the HMI-to-PLC cable is fully seated (requires opening the 230).

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



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7.0 SLICE-230 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:

- Scanning a 3-digit numeric value will cause the unit to load the settings defined in a job corresponding to the 3-digit numeric value. If the job does not exist in the unit, the scanned barcode will be ignored.
- Individual setting values corresponding 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.

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



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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	Notes
QTY	Quantity	Integer	0 to 99999
LEN	Length	Real	0.0 to 3900.00
INF	Infeed	Real	-0.375 to 1.25
CRL	Crop Length	Real	0.0 to 3.0
ZLT	Zero Load Wait Time	Real	0.0 to 99.9
SPD	Speed	Real	1.0 to 35.0
STL	Stick Length	Real	1.0 to 100.0
UNT	Units	INCHES, MM	
ALN	Auto Load Next Stick	ON, OFF	
ASE	Automatic Scrap Eject	ON, OFF	
MOD	Mode	STICK, NON-STICK	
TYP	Load Type	CROP, ZERO	
ASL	Auto Start After Load	ON, OFF	
LCF	Length Calibration Factor	Real	0.0 to 999.99
MCF	Measured Length Calibration Factor	Real	0.0 to 999.99
BSD	Blade to Zero Load Sensor Distance	Real	0.0 to 99.9999
PMD	Platen Motor Power-off Delay	Real	0.0 to 99.9
IMT	Infeed Motor Timeout	Real	0.0 to 99.9
CCT	Cutter Cycle Timeout	Real	0.0 to 99.9
PID	Platform ID	Integer	1 to 99

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



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^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_OD_0A

QTY 15_OD_0A

LEN 4.00_OD_0A

SPD 25_OD_0A

MOD STICK_OD_0A

STL 22.00_OD_0A

ZLT 10_OD_0A

ALN ON_OD_0A

ASL ON_OD_0A

ASE ON_OD_0A

INF 0.000_OD_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_OD_0A

QTY 6_OD_0A

LEN 3.00_OD_0A

SPD 25_OD_0A

MOD NON-STICK_OD_0A

TYP CROP_OD_0A

CRL 1.0_OD_0A

ASL OFF_OD_0A

INF 0.000_OD_0A

^XZ



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8.0 230 SPARE PARTS LIST

PART	DESCRIPTION	PART	DESCRIPTION
ELS4706	PLC - Micro 850	MFB3332	DRIVE 2 AXLE, LEFT
ELS4707	HMI 4" Panel View Display	MFB3333	ENCODER WHEEL AXLE
ELS4655	CABLE, USB. A-B MALE	MFB3334	DRIVEN IDLER WHEEL AXLE
ELS4724	Switching Power Supplies	MFB3338	IDLER WHEEL - SS
ELS4725	PLC Serial Cable 3m/9.8ft	MFB3339	DRIVE 2 AXLE, RIGHT
ELS4727	Stepper Motor Driver (Main)	MFB4521	BLADE D2
ELS4729	Stepper Motor Driver (Throat)	MFB4577	Front Die Clamp Plate
ELS4731	Signal Tower	MFB4705	BLADE S7
GR3341	PIC G7-60 SPUR GEAR	SA1531	FAN ASSEMBLY
GR3342	PIC G7-42 SPUR GEAR	SA3331	FEED GUIDE ASSEMBLY - 141
MFB3209	IDLER GUIDE ROD	SA3345	AUXILLARY GEAR ASSY. - 141
MFB3210	IDLER MOUNT BLOCK	SA2187	SENSOR ASSEMBLY -36"
MFB4949	HORIZONTAL DRIVE SCREW	SA3811	IDLER WHEEL POLY ASSY (BACK, TOP)
MFB4603	IDLER MOUNT PLATE	SA3812	IDLER POLY DRIVE WHEEL 3 ASSY (BACK, BOTTOM)
MFB3213	IDLER SCREW PLATE	SA3813	POLY DRIVE WHEEL 2 ASSY. (FRONT, TOP)
MFB3215	IDLER WHEEL MOUNT, LEFT	SA3814	MAIN POLY DRIVE WHEEL ASSY. (MOTOR)
MFB3216	IDLER WHEEL MOUNT, RIGHT	SA4317	EMERGENCY STOP SWITCH ASSY
MFB3220	BOTTOM GUIDE ANTI ROTATE	SA4549	QUICK RELEASE PIN
MFB3221	BOTTOM GUIDE SCREW	SA4843	REGULATOR/FILTER KIT- 230
MFB3229	FLAG	SA4991	INTERFACE POWER CIRCUIT BOARD - 230
MFB3230	DIE BOTTOM	SA5001	AIR VALVE ASSY - SLICE 230
MFB3232	DIE GUIDE	SA5002	ENCODER ASSY - SLICE 230
MFB4578	DIE SUPPORT	SA5003	THROAT MOTOR SENSOR - SLICE 230
MFB3235	DIE MOUNT	SA5012	DIE ASSEMBLY
MFB3236	DIE SIDE, RIGHT	SA5016	Throat Motor Assy
MFB3237	DIE SIDE, LEFT	SUP563	SELF CLOSING CLIPS
MFB3238	TOP GUIDE COUPLING PLATE	SUP615	RUBBER FEET
MFB3242	SIDE BAR CLAMP	SUP1598	SHIELDED BEARING
MFB3244	DRIVE WHEEL SS SLICE 141	SUP1902	DOWEL PIN
MFB3245	DRIVE WHEEL, POLY FOR SLICE 141	SUP2111	INSIDE GUIDE KNOB
MFB3247	DRIVE TWO BLOCK	SUP3344	SPRING
MFB3248	DRIVE WHEEL AXLE	SUP3357	SHAFT COUPLING - INSIDE GUIDES
MFB3249	FRONT GUIDE	SUP3427	RETRACTABLE SPRING PLUNGER
MFB4850	CLEVIS	SUP3613	SPRING WASHER
MFB3254	SENSOR MOUNT	SUP3648	BALL PLUNGER
MFB3307	GEAR HOLDER, LEFT	SUP4615	AIR CYLINDER
MFB3308	GEAR HOLDER, RIGHT	SUP4965	timing gear
MFB3309	GEAR AXLE	SUP4966	Timing Belt
MFB3310	GEAR SWIVEL BAR	SW4330	MOMENTARY SWITCH
MFB3312	IDLER WHEEL, POLY-141		



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9.0 Routine Maintenance Notes For The Slice Machines

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

Note: The Preventive Maintenance Program is based solely on the extent of use of the SLICE machine. Typically, item 2 should be done on a weekly basis, however, if the 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 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 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 Die Assembly.
- 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.
- Clean machine internally

Annually:

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

As Needed:

- Check ball plunger setting on bottom of die assembly.
- Check sharpness of blade and die.
- Apply 3-in-1 type oil to cutting blade.



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10.0 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:

Telephone: 847.588.7090 **E-mail:** info@amtproducts.com

Identify yourself as a 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.

**Evolutions Hub Inc dba AMTI Products
4330 Regency Drive, Glenview Illinois 60025
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