



FAQ

Vac-U-Torq®, Neuma-Torq® & Econo-Cut® clutch/brake rotary cutters:

Q. Cannot re-set the safety guard circuit?

A. Check cutter bush safety sensors are lined-up correctly & that they are no more than 1 mm apart. Check the emergency stop buttons are correctly set.

Q. The pre-set cut length does not equal the actual cut length?

A. Adjust the scale factor in the length counter. Refer to cut length counter settings.

Q. The machine won't cut?

A. On a Neuma-Torq® & Econo-Cut® check that the incoming compressed air supply is no greater than 3 Bar. Check the cutter motor is running the correct direction. Looking from the front & top the drive belt will come towards you.

On a Vac-U-Torq® check the vacuum pump pressure is set to 0.75 Bar.

Check the clutch/brake has not gone into overload. If it has refer to the clutch/brake overload calibration procedure.

Check the condition of the clutch/brake. Is it badly worn?

Check the clutch/brake solenoid coils are free from dust. Use WD40 or similar to clean away any brake dust.

Check the resistance of the clutch/brake coils; they should be around 10 Ohms. If considerably less than 10 Ohms then they may have damaged the clutch/brake control unit (SRB 3110). Both items need replacing.

Q. Econo-Cut® with SRB 3107 controller is missing cuts every so often?

A. Check the encoder is not slipping. Check that the encoders' 24VDC supply is coming from the SRB 3107 board & not the length counter.

Q. The cutter stops cutting. It can be re-set and it carries on cutting until the next stop?

A. The clutch/brake is badly worn and is going into overload. Re-calibrate the overload board. It will come to a time when the clutch plates have completely worn-out. At that point the clutch/brake will need either replacing or refurbishing.

Q. The blade will suddenly constantly spin or will only constantly spin?

A. The brake sensor is faulty or a wire has come loose from the brake sensor. Check that the disc at the end of the cutter shaft is as far as possible in the brake sensor. There is a red LED to indicate that the brake sensor is working correctly. Check that the clutch/brake solenoid valve is clean from clutch dust as this can jam the movement.

Check that the clutch/brake is not completely worn.

For Vac-U-Torq® machines check that the vacuum pump pressure is set to 0.75 Bar. Also check that the vacuum pump vanes are in good condition.

Q. The cutter motor stops?

A. Check if you have an option called “Batch end stop” fitted? This will automatically stop the cutter when the batch quantity is reached.

Increase the “Circuit breaker overload” current setting.

Check the electrical connection to the motor and the condition of the motor.

Q. How can I tell if the clutch/brake is worn and needs replacing?

A. There are certain things to check for to see if the clutch/brake is worn:

- 1) Check the stopping position of the brake disc at the end of the cutter shaft. The notch in the disc will stop within 90° of the brake sensor on a brand-new clutch. If the stopping distance is greater than 180° then this is a clear sign of wear.
- 2) Also check that the disc is stopping in the same place. When the clutch/brake wears it will start stopping in different positions and cause inaccurate cut lengths.
- 3) On a Neuma-Torq® & Econo-Cut® check that the incoming compressed air supply is no greater than 3 Bar. The clutch/brake also requires an oil free and filtered compressed air supply.



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- 4) Clean the brake and clutch solenoid valves by spraying WD40 or similar to clean out any accumulated brake dust.
- 5) For Vac-U-Torq® machines check that the vacuum pump pressure is set to 0.75 Bar. Also check that the vacuum pump vanes are in good condition.

Q. Inaccurate cut length?

A. Check that the clutch/brake isn't worn and the stopping position of the brake disc is constant.

Check the tension of the cutter shaft drive belt; this needs to be very tight with no movement.

Check the blade datum position; it should be 180 degrees from the cutter bushes.

Check that the bush sizes are not too large as the product will be able to move. Check the condition of the blade.

On a free-standing cutter, check the encoder isn't slipping on the caterpillar belt and that the connections are good.

On a cutter/infeeder combination machine, check the condition of the caterpillar belts. Worn belts will seriously impact on a smooth product feed into the cutter.