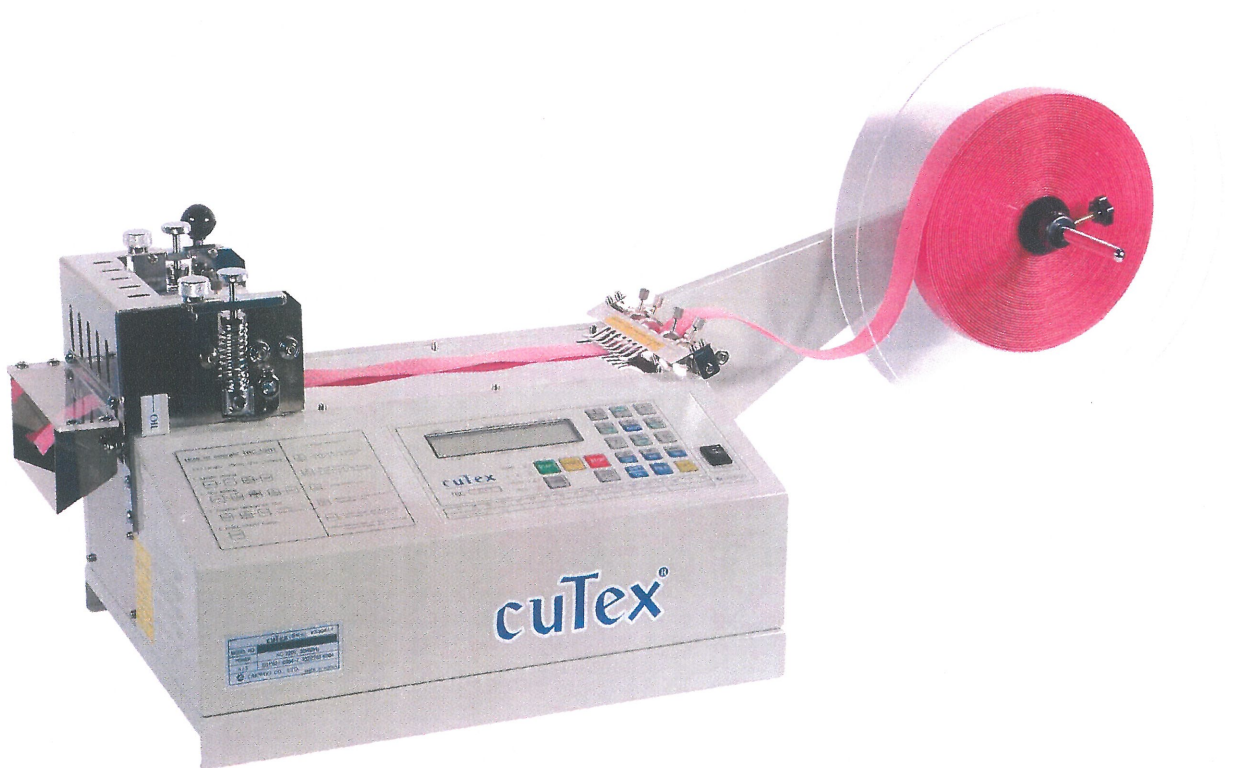


cuTex®

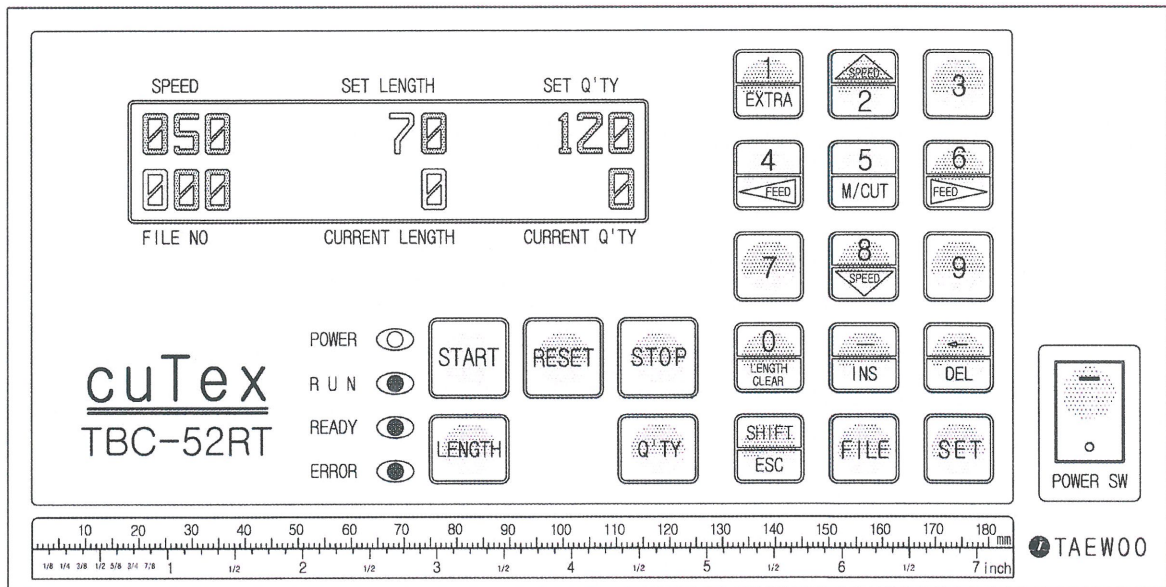
# AUTOMATIC VELCRO TAPE CUTTER

## TBC-52RT



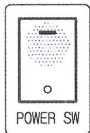
 TAEWOO CO., LTD.

## How to operate TBC-52RT

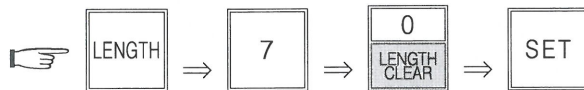


1. An example (Cutting length : 70mm, Cutting quantity : 120 pcs)

▷ Turn on the POWER SW.

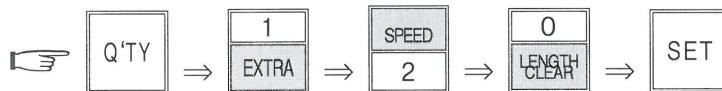


▷ Set cutting length 70mm. (Press the following buttons in order.)



※ Button "0" has a double fuctions of "0" and eraising current length.

▷ Set cutting quantity 120 pcs.



▷ Press START button.



▷ Set function.(Straight cutting : "1", Round cutting : "0")



## 2. Key functions



: Current length on display will be back to "0" at a stop.



: All of current length and current q'ty on display will be back to "0".



: Moving knife only.

- ① to cut the material for test.
- ② to take out the material jammed between knife blades.
- ③ for balancing of knife blades in exchange.



: Cutting additional one.



: Restoring to normal condition in ERROR(red LED) and inputting parameter or program.



: to move the roller manually for mounting the material on the machine or for feeding it forwards or backwards.



— Speed up (The current speed appears on the left-upside of LCD display with "%". Normal speed : 50%, Maximum speed : 100%)



— Speed up (The current speed appears on the left-upside of LCD display with "%". Normal speed : 50%, Maximum speed : 0%)

\* Speed up & down is possible in any time(operation or stop) and set-speed will not be changed even though you press RESET button or power off & on.



: to insert new program between programs inputted already in time of program-input.



: to delete the wrong program in time of program-input. (All things of the STEP will be deleted.)



: Function for label cutting

### 3. Specification

Model Name	Main Cutting Materials	Cutting Knife	Power Supply	Max. Cutting Width	Range of Cutting Length	Cutting Q'ty/min. (Length: 50mm)	Machine Size (Net Weight)	Packing Size (Gross weight)
TBC-52RT (VELCRO® straight/round cutter)	Exclusive for VELCRO®	Cold	AC110 /220V 50/60Hz	12.5mm~55mm	5mm~300M	70~90 cuts	800×320×380 (20.4kgs)	540×430×340 (27.2kgs)

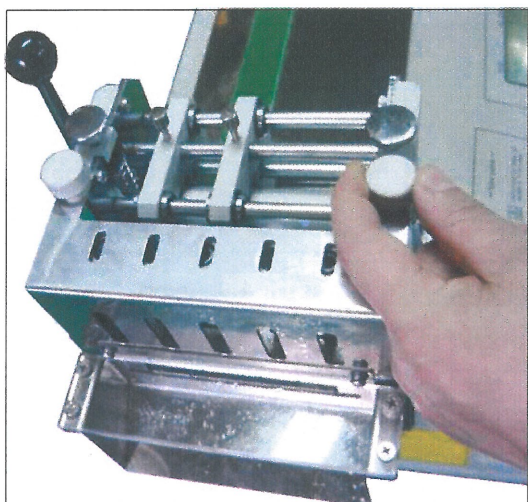
### 4. Caution for use

- Before use, please confirm the voltage and make ground(earth) connection.
- Do not access hands or any object close to the working knife. (for safety)
- When the knife blade becomes dull, please use it after grinding with the grinding machine. (Please do not let the unskilled person grind manually or install the knife blade.)
- Please contact following address for further information.

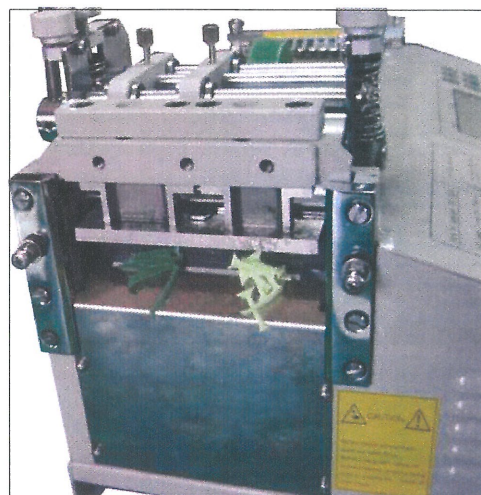


## How to install straight or round mold

1. Please remove safety cover by releasing bolts.
2. Please insert punch molds to punch die, by pressing manual cutting button.

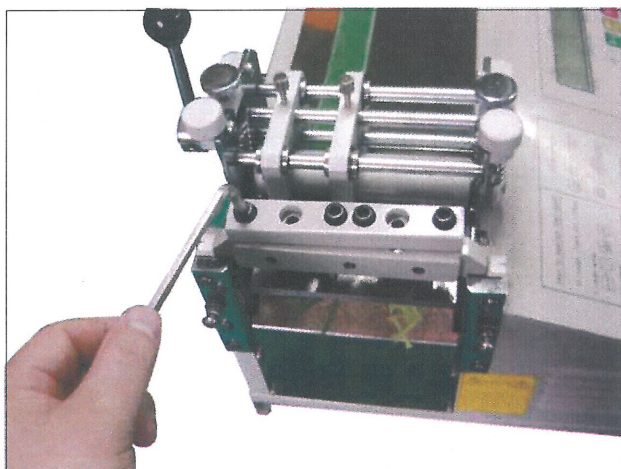


1

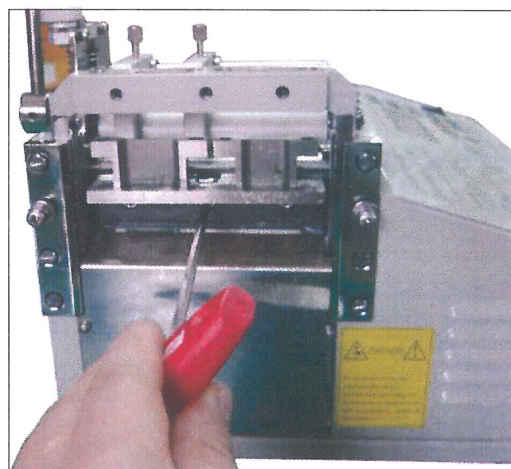


2

3. Please release wrench bolt by using 5mm wrench, referring to below image. (Picture 3)  
By this step, you can take off punch molds from upper knife case.
4. By pressing manual cutting button, raise upper knife case up.
5. Referring to picture 4,5, by using 4mm wrench, you can remove punch molds and punch die set.



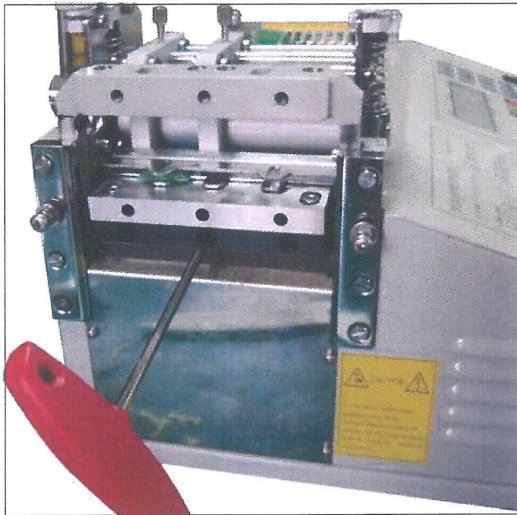
3



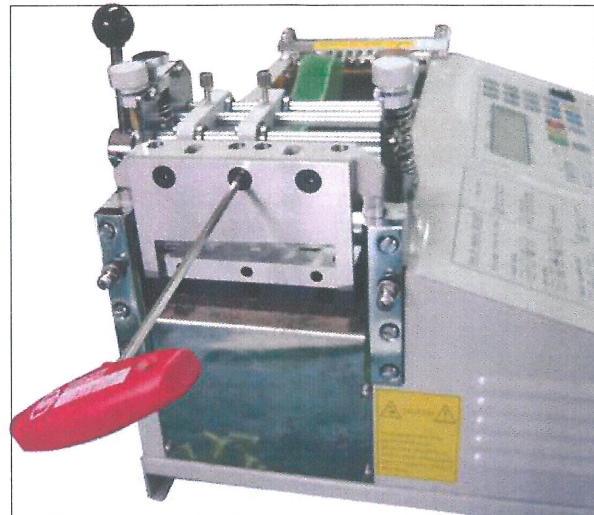
4, 5

6. After taking off punch die and punch molds set, please install lower knife of straight mold to machine.
7. Please install straight upper knife, by using 4mm wrench, referring to picture 7.



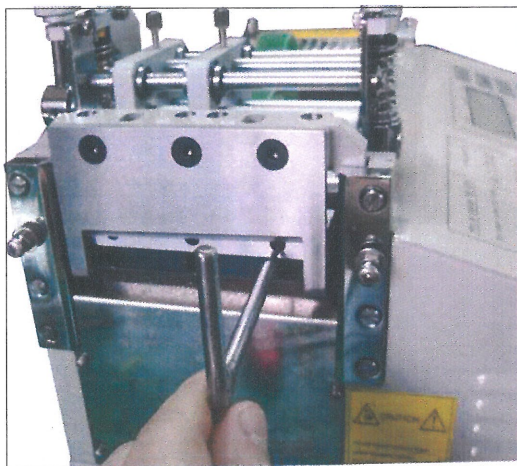


6

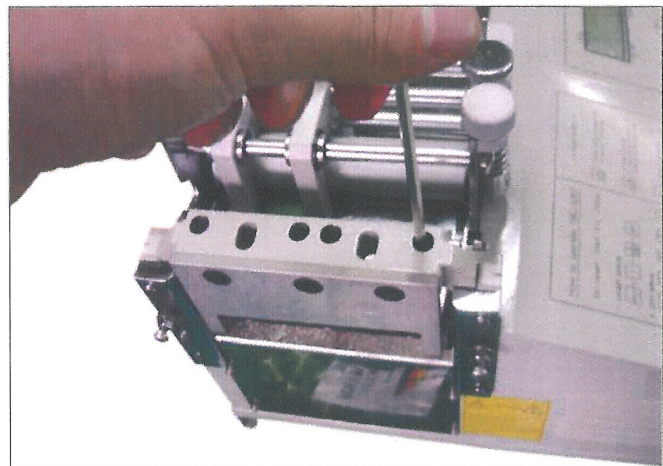


7

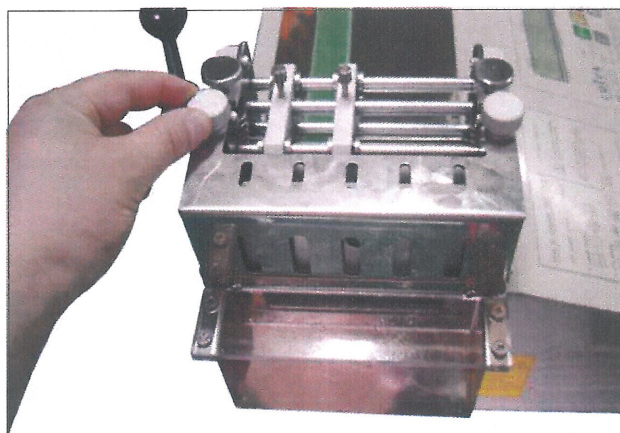
8. If there is a gab between upper and lower knife, please adjust it by using 2.5mm wrench. If you turn right, lower blade will come close to upper knife. A gab between upper and lower knife causes bad cutting.
9. After adjusting upper and lower knife, please fix lower knife by using 4mm wrench.
  - ※ Please do step 8 and 9 one time, if you did it, you don't need to do 8 and 9 step, whenever you exchange straight and round knife mold.
10. After fixing knife, please install safety cover.



8



9



10

### How to maintain knife mold.

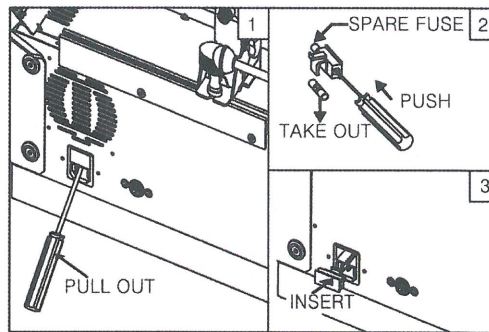
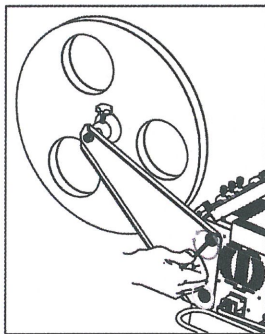
1. First of all, you should install knife mold properly.  
If you do not install properly, during working, there will be noisy & it will be worn out easily.
2. At least once a day, you should oil punch and die.
3. If there are two punches, and if you do not use one side, please remove unused side.
4. When you do not use knife mold for a long time, please oil and wrap it up in a plastic bag to keep from rusting.

### Mount of roll

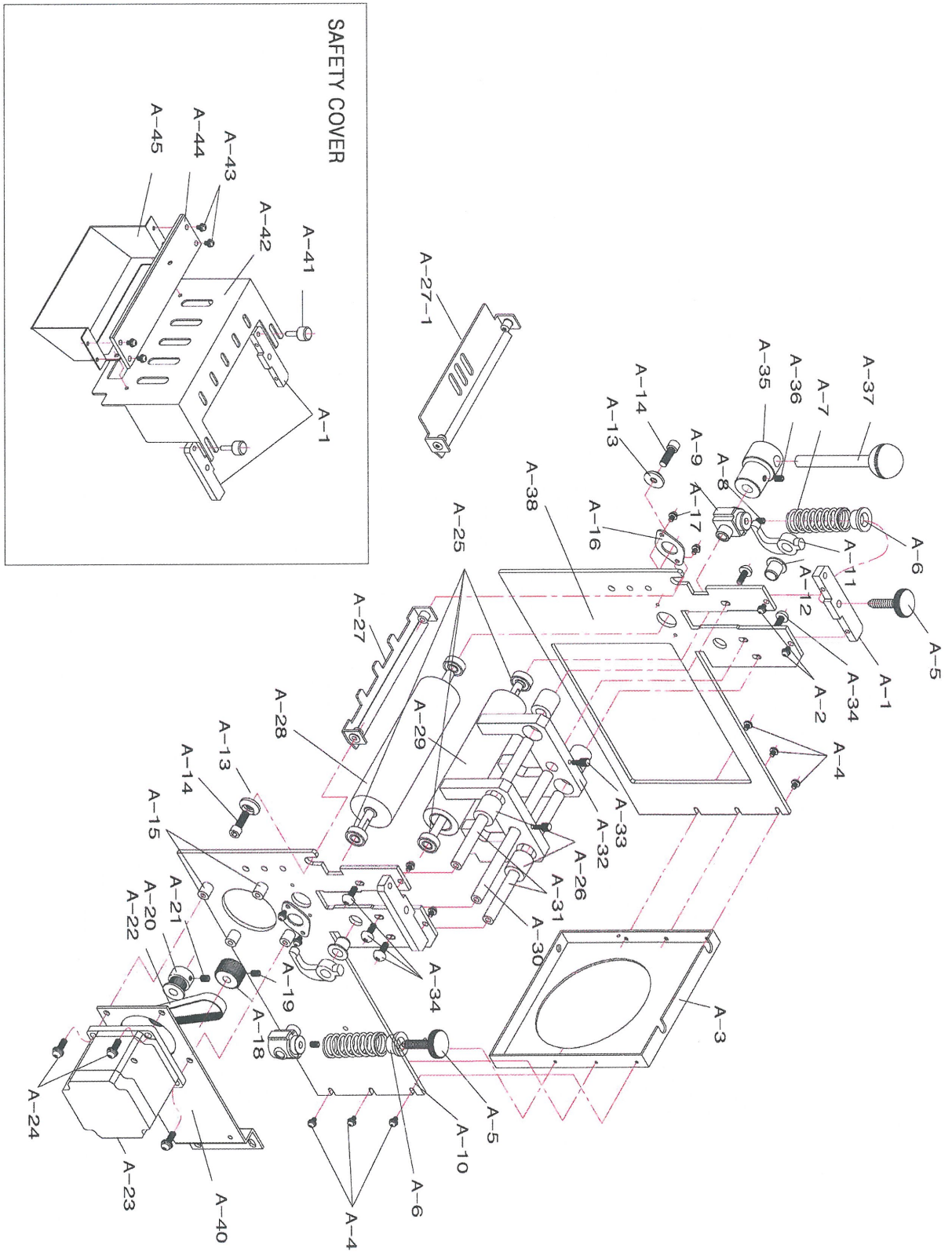
Fix the roll triangle by 4mm-wrench.

### Exchange of fuse

Take off the power plug and exchange as picture.



TBC-52RT Part Drawing A (Feeding part)

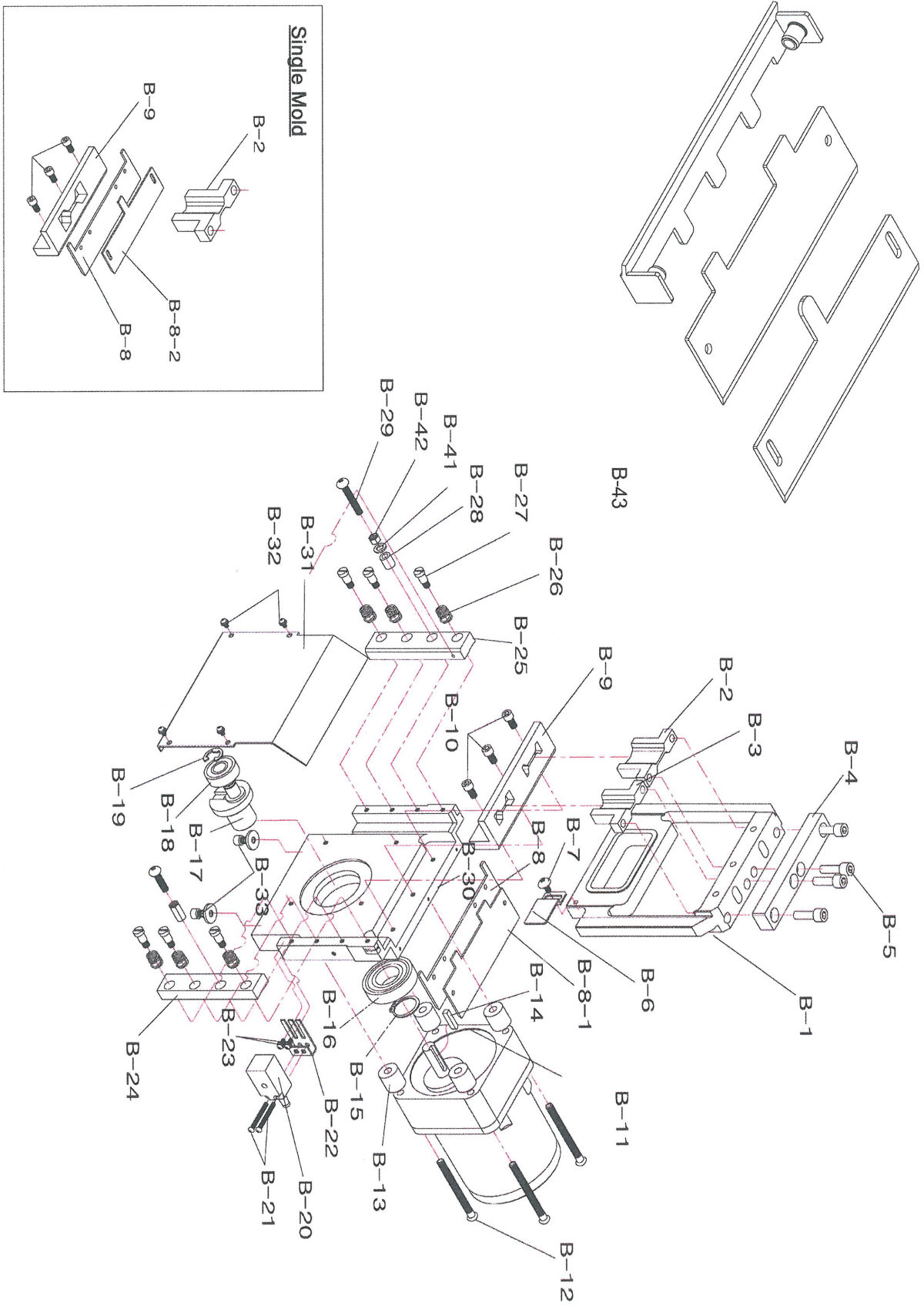




### TBC-52RT Part List A (Feeding part)

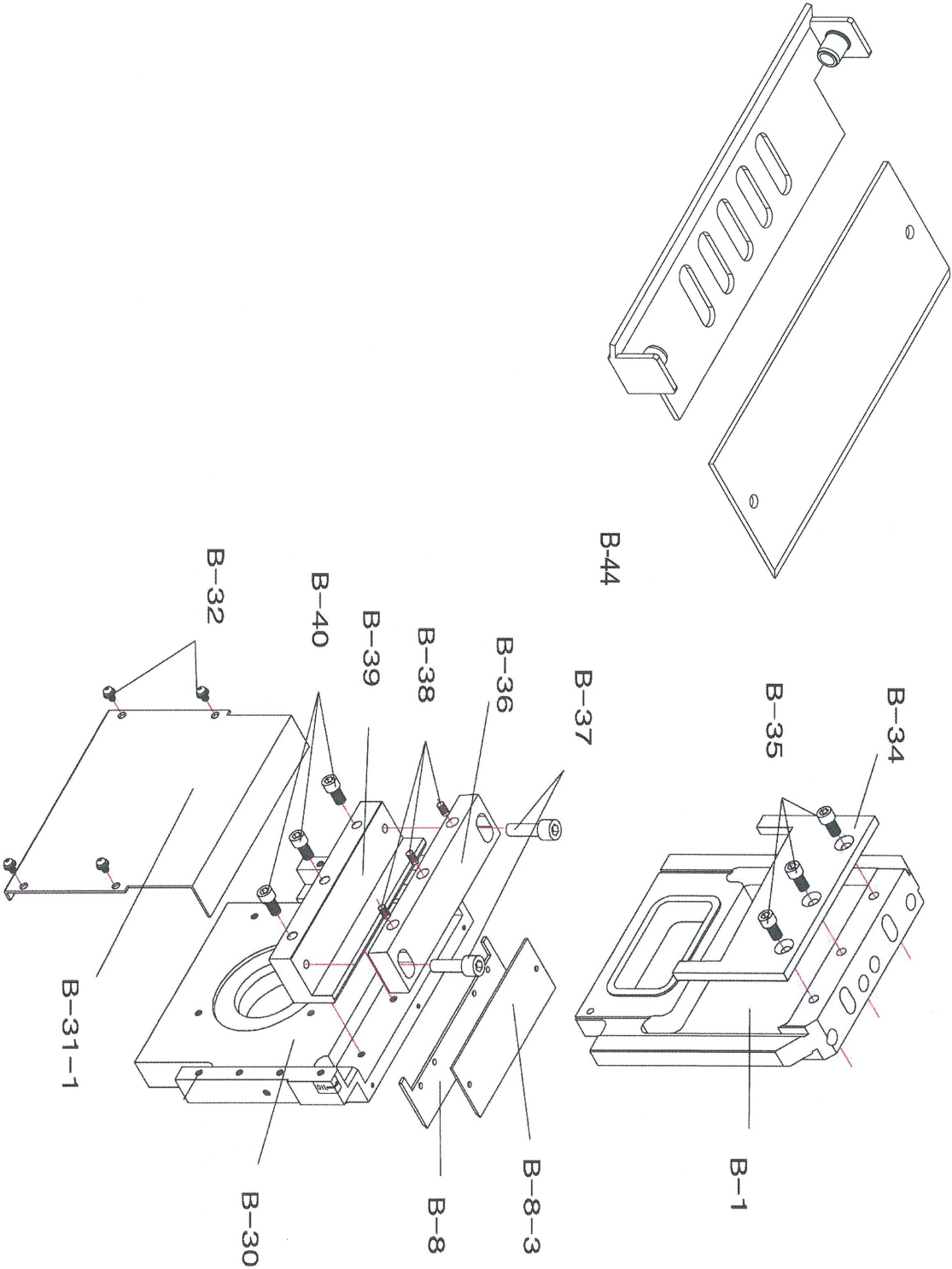
Part No.	Description	Part No.	Description
A-1	Upper Cover Bracket	A-25	Ball Bearing(#696)
A-2	Clamping Bolt(M4×8L)	A-26	LM Bearing
A-3	Space Plate of Roller Bracket	A-27	Clamping Stopper (For round mold)
A-4	Clamping Bolt(M3×10L)	A-27-1	Clamping Stopper (For straight mold)
A-5	Pressure-control Bolt	A-28	Lower Roller
A-6	Pressure-control Spring Cover	A-29	Upper Roller
A-7	Pressure-control Spring	A-30	Front-guide Pin
A-8	Detent Screw(M4×6L)	A-31	Lever Shaft
A-9	Slide Block of Upper Roller	A-32	Guide
A-10	Right Roller Bracket	A-33	Knob Bolt of Guide Control
A-11	Slide Lever	A-34	Wrench Bolt (M4×10L)
A-12	Oilless	A-35	Lever Bracket
A-13	Stopper Clamping Washer	A-36	Detent Screw(M5×6L)
A-14	Stopper Clamping Bolt	A-37	Lever
A-15	Tie Bar of Stepping Motor	A-38	Left Roller Bracket
A-16	Bearing Cover	A-40	Radiate Heat Plate of Stepping Motor
A-17	Clamping Bolt (M3×6L)	A-41	Safety Cover Control Bolt
A-18	Feed-timing Gear (MXL30T)	A-42	Upper Cover
A-19	Detent Screw(M4×6L)	A-43	Clamping Bolt (M4×6L)
A-20	Drive-timing Gear (MXL20T)	A-44	Acrylic Plate
A-21	Detent Screw (M3×6L)	A-45	Safety Cover
A-22	Timing Belt (MXL75)		
A-23	Stepping Motor		
A-24	Clamping Bolt (M4×12L)		

TBC-52RT Part Drawing B (Cutting part)-Round mold





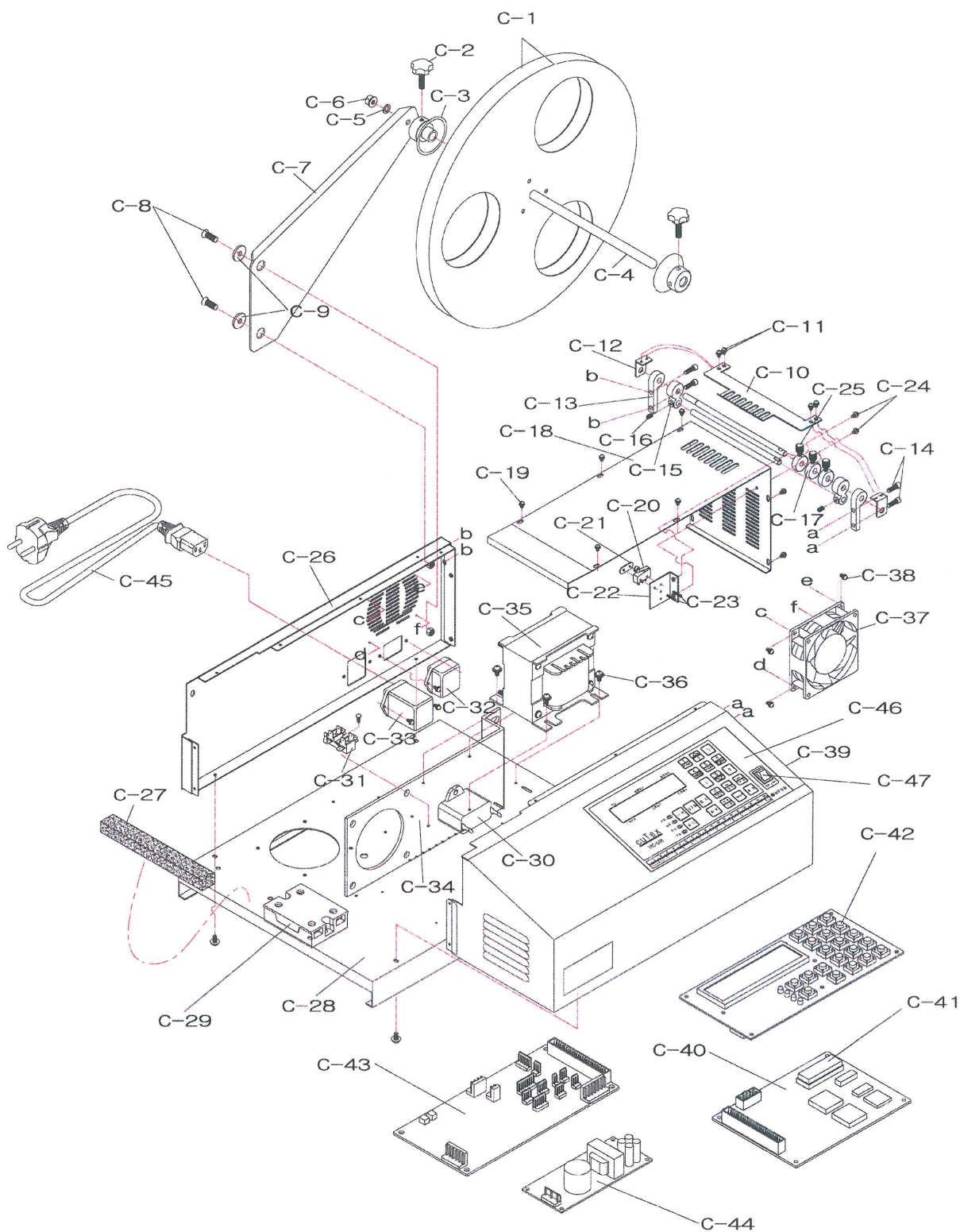
TBC-52RT Part Drawing B (Cutting part)-Straight mold



## TBC-52RT Part List B (Cutting part)

Part No.	Description	Part No.	Description
B-1	Upper Knife Case	B-22	Counting Sensor Bracket
B-2	Punch Mold 1	B-23	Clamping Bolt(M3×8L)
B-3	Punch Mold 2	B-24	Right Pressure Plate
B-4	Clamping Bracket	B-25	Left Pressure Plate
B-5	Wrench Bolt(M6×30L)	B-26	Pressure Spring
B-6	Counting Sensor Bracket	B-27	Clamping Bolt(M5)
B-7	Clamping Bolt(M4×6L)	B-28	Urethane Bush
B-8	Space Plate of Roller Bracket	B-29	Tension-control Bolt((M3×30L)
B-8-1	Pressure Bracket(double mold)	B-30	Lower Knife Case
B-8-2	Pressure Bracket(single mold)	B-31	Front Cover(For round mold)
B-8-3	Pressure Bracket(straight)	B-31-1	Front Cover(For straight mold)
B-9	Punch Dies	B-32	Clamping Bolt(M3×6L)
B-10	Wrench Bolt(M5×10L)	B-33	Wrench Bolt(M5×16L)
B-11	Motor+Reduction Gear	B-34	Upper Knife
B-12	Clamping Bolt(M6×110L)	B-35	Clamping Bolt
B-13	Motor Supporter	B-36	Lower Knife
B-14	Motor Key	B-37	Wrench Bolt(M5×12L)
B-15	Snap Ring(M25)	B-38	Clamping Bolt(M5×10L)
B-16	Ball Bearing(#6006)	B-39	Lower Knife Bracket
B-17	Crank Bundle	B-40	Wrench Bolt(M5×12L)
B-18	Ball Bearing(#6000)	B-41	Tension-control Washer
B-19	E-Ring	B-42	Tension-control Nut(M5)
B-20	Counting Sensor	B-43	
B-21	Clamping Bolt(M3×22L)	B-44	

TBC-52RT Part Drawing C (Other parts)



## TBC-52RT Part List C (Other parts)

Part No.	Description	Part No.	Description
C-1	Roll-hanger Wheel	C-26	Left Cover
C-2	Clamping Bolt of Holder	C-27	Sponge
C-3	Holder	C-28	Base
C-4	Roll-hanger Shaft	C-29	SSR(Solid State Relay)
C-5	Roll-hanger Shaft Washer	C-30	Condenser
C-6	Wrench Bolt(M6×10L)	C-31	Terminal
C-7	Roll-hanger	C-32	AC Connector(OUT-PUT)
C-8	Flat-head Bolt(M6×20L)	C-33	AC Connector(IN-PUT)
C-9	Neck Washer of Roll-hanger	C-34	Radiating Plate of Step Motor
C-10	Existence Detector	C-35	Transformer
C-11	Clamping Bolt(M3×6L)	C-36	Clamping Bolt(M4×8L)
C-12	Clamping Bracket	C-37	Cooling Fan
C-13	Rear Guide-pin Bracket	C-38	Clamping Bolt(M3×8L)
C-14	Wrench Bolt(M4×12L)	C-39	Control Cover
C-15	Rear Tension-guide Block	C-40	Control Circuit Board(MB)
C-16	Detent Screw(M4×6L)	C-41	ROM
C-17	Guide Ring	C-42	Operation Circuit Board(OP)
C-18	Upper Guide Plate	C-43	Drive Circuit Board(DR)
C-19	Clamping Bolt(M3×6L)	C-44	SMPS(Power Supply)
C-20	Micro Limit Switch	C-45	Power Cord
C-21	Plate-nut	C-46	Urethane Panel
C-22	Limit Switch Bracket	C-47	Power Switch
C-23	Clamping Bolt(M3×12L)		
C-24	Clamping Bolt(M3×6L)		
C-25	Knob Bolt		

## Trouble-shooting of TBC-50 series

No	Troubles		Applicable model	Causes & Measures
1	No power supply		All models	<ul style="list-style-type: none"> <li>- Check if electric cord is connected well.</li> <li>- Check if the fuse blows out or not.</li> </ul>
2	Power is on, but no work	Feeding roller doesn't work.	All models	<ul style="list-style-type: none"> <li>- Check if there is inserted any alien substance in roller.</li> <li>- If current length on display is changed, exchange drive board.</li> <li>- If current length on display is not changed, exchange Control board(MB).</li> </ul>
		Knife doesn't work.	All models	<ul style="list-style-type: none"> <li>- Check if pressure plates of upper knife are too much fastened or not.</li> </ul>
		LCD display doesn't work.	All models	<ul style="list-style-type: none"> <li>- After opening the cover, check the connection. (especially between Operation &amp; MB board)</li> </ul>
		All functions don't work	All models	<ul style="list-style-type: none"> <li>- Check if auto-stop device lies down. If any, raise it up.</li> </ul>
3	Material is not cut.		Hot cutter (H, LH, SH, HX)	<ul style="list-style-type: none"> <li>- Check if temperature goes up to set-degree.</li> <li>- Check if knife blades are even(parallel).</li> </ul>
4	Material is cut onesidedly.		All models	<ul style="list-style-type: none"> <li>- Check if blades are damaged or weared.</li> <li>- After making both knives close each other by M/CUT button and check if they are even or not. (If they are not even, adjust them by bolts)</li> </ul>
5	Cut-length is different from set-length.		All models	<ul style="list-style-type: none"> <li>- Test cutting after loosening material from the reel by hand or attaching feeding device.</li> </ul>
6	It cuts before the cutting line of labels.		Label cutter (S, SH)	<ul style="list-style-type: none"> <li>- Move the sensor towards knife side as long as the difference by pushing.</li> </ul>
7	It cuts after the cutting line of labels.		Label cutter (S, SH)	<ul style="list-style-type: none"> <li>- Move the sensor towards counter-knife side as long as the difference by pushing.</li> </ul>
8	ERROR on LCD & LED	ERROR CODE [064] >Sensor check Er	Label cutter (S, SH)	<ul style="list-style-type: none"> <li>- Trouble in Mark sensor →</li> <li>· Check if the sensor is connected well or not.</li> <li>· Check if the sensor is adjusted well or not. (FILE NO 001)</li> <li>· Check if it is label problem or not.</li> </ul>
		ERROR CODE [065] >CUT I/O Error!	All models	<ul style="list-style-type: none"> <li>- Trouble in cutting motor or cutting sensor →</li> <li>· Upper knife moves 1~3 sec. and ERROR on display. Check the connection of cutting sensor. If not, exchange the cutting sensor.</li> <li>· Upper knife doesn't move and ERROR on display. Exchange the cutting motor or drive board.</li> </ul>
		STOP INPUT !! CHECK STOP INP!	All models	<ul style="list-style-type: none"> <li>- Auto stop device is pressed down or shortage. → raise up the device and check shortage.</li> </ul>
		(C)ACORD CTRL-OP AMC-T3KA VER1.7D	All models	<ul style="list-style-type: none"> <li>- Bad connected ROM → Press ROM by hand or connect it again. (If not, change MB board)</li> </ul>
		ERROR CODE[065] >CHECK CODE[003]	All models	<ul style="list-style-type: none"> <li>- Change of FILE 003 in program by noise or mis-operation → Initialize the controller.</li> <li>※ <b>How to Initialize</b>(programs to be initial) : press <b>SET+SHIFT/ESC</b> buttons and <b>RESET</b> button at the same time. (Press <b>RESET</b> later than other two keys.)</li> </ul>
9	Operator feels electric current in touch of machine.		All models	<ul style="list-style-type: none"> <li>- Connect the earth cord(green) to any bolt of backside of machine.</li> </ul>

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Please do not disassemble / modify machine or its part without any permission.  
If you disassemble / modify machine or its part, you cannot receive warranty/after-sales service.