

TROUBLESHOOTING

CAUSE

CORRECTION

ARC CUT: SHEETS OF PAPER ARE SHORTER AT ENDS AND LONGER IN THE CENTER.

Lift is clamped only at end of paper.

Check clamp edge and apply Jayhawk's Magnetic Clamp Pad to distribute clamp pressure.

HOLLOW CUT: SHEETS OF PAPER ARE LONGER AT ENDS AND SHORTER IN THE CENTER.

Lift is clamped only at ends of paper.

Check clamp edge and apply Jayhawk's Magnetic Clamp Pad to distribute clamp pressure.

KNIFE NICKS: SMALL NICKS APPEAR IN KNIFE AFTER CYCLED.

Knife is sharpened at wrong bevel.

Increase bevel by two degrees.

Knife burned in grinding.

Sharpen knife taking off 1/16" or more to remove burned steel.

Knife set too deep into cutting stick.

Rotate or put in a fresh cutting stick and set to the proper depth.

Insufficient cutting stick.

Use a higher grade cutting stick.

Cutting recycled stock or chip board.

Increase bevel by two degrees.

KNIFE RUBBING: KNIFE FACE RUBS CLAMP CAUSING SCRATCHES ON KNIFE AND CLAMP.

Dull knife.

Sharpen knife more often or use higher grade knife.

Wrong bevel.

Decrease bevel by two degrees.

Gibbs worn on cutter.

Repair machine.

Lift is too high.

Reduce height of lift being cut.

OVERCUT: OCCURS WHEN THE LOWER SHEETS ARE LONGER THAN THE TOP SHEETS.

Dull knife.

Sharpen knife more often or use higher grade knife.

Wrong bevel.

For soft paper decrease bevel by two degrees. For hard paper increase bevel by two degrees.

Too much clamp pressure.

Reduce clamp pressure.

Back gauge not set square.

Adjust back gauge setting.

UNDERCUT: OCCURS WHEN THE LOWER SHEETS ARE SHORTER THAN THE TOP SHEETS.

Clamp pressure too low.

Increase clamp pressure.

Wrong bevel.

Decrease bevel by two degrees.

Cutting rough or uneven material.

Adjust clamp pressure.

Back gauge not set square.

Adjust back gauge setting.