



 A Maxcess
International
Company

Class II Edge-Trim High-Speed

Operation and Maintenance

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CAUTION

- Wear eye protection when using tools or compressed air.
- Wear stainless steel protective gloves when handling blades.



TIDLAND CUSTOMER SERVICE

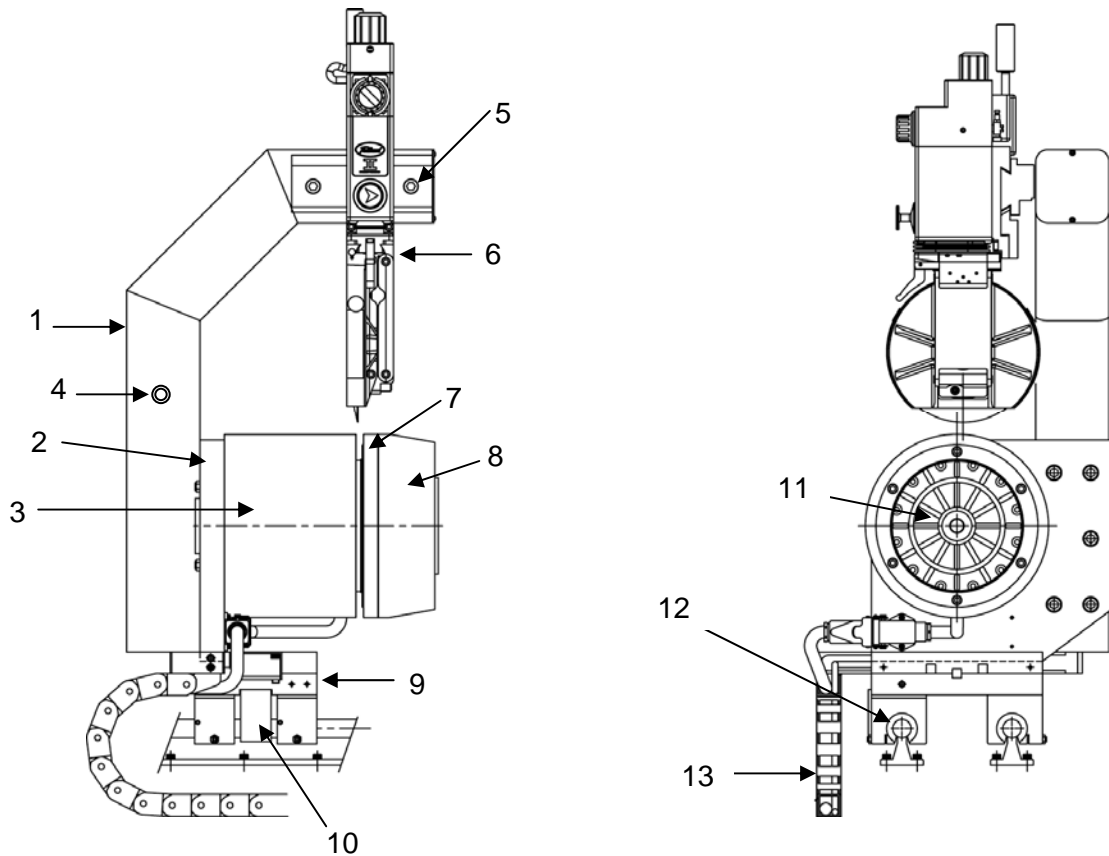
1-800-426-1000

www.tidland.com

RECOMMENDED TOOLS

- Clean non-lubricated air supply: 80-120 psig (5.4-8.2 bar) for proper operation.

NOMENCLATURE



1. C-Frame
2. Motor Mount
3. Trim Support
4. Brake Release Button
5. Guide Bar
6. Knifeholder
7. Anvil Ring
8. Nose Cone
9. Carriage
10. Brake
11. Anvil Motor
12. Bearing
13. Cable Management

OPERATION

Refer to the Tidland Knifeholder Technical Manual for correct operation and setup of the knifeholder.

Knifeholder blade cartridge must be retracted before positioning the Edge-Trim unit.

To position the Edge-Trim unit

1. Press and hold the Brake Release Button located on the C-Frame.
2. The brake is released.
3. Slide the Edge-Trim unit along the linear rails to the new position.
4. Release the Brake Release Button. The brakes are engaged and the Edge-Trim unit locks in position.
5. Using a measurement device, ensure the Edge-Trim unit is in the correct location.
6. To engage the knifeholder for slitting, see your knifeholder technical manual.

MAINTENANCE

Remove and Replace Anvil Rings



HAND HAZARD

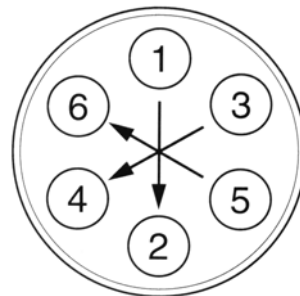
Knife blades and anvil rings are sharp.
Wear protective gloves when working with knife blades and anvil rings.
Tidland recommends stainless steel gloves.

1. Stop the anvil motors.
2. Remove power to the anvil motors.
3. Complete your company lock-out procedures to lock out system power.
4. Remove the six (6) socket head cap screws that hold the anvil ring and nose cone to the motor flange or blade adapter flange.
5. Remove the anvil ring and nose cone from the motor or blade adapter flange register.
6. Replace the anvil ring and nose cone making sure that the sharpened anvil ring edge is toward the slitting side of the knife blade.

Note: The anvil ring should slide easily onto the motor register when held square with the register.

7. Replace the six (6) socket head cap screws that hold the anvil ring and nose cone to the motor or blade adapter flange.
8. Tighten the cap screws using the procedure illustrated below as a guide.
9. Adjust the knifeholder and knife blade according to the knifeholder setup procedure. See your technical manual.

Bolt Torque Specifications		
Bolt Size	in-lb	N-m
M6	45	5
M8	80	9

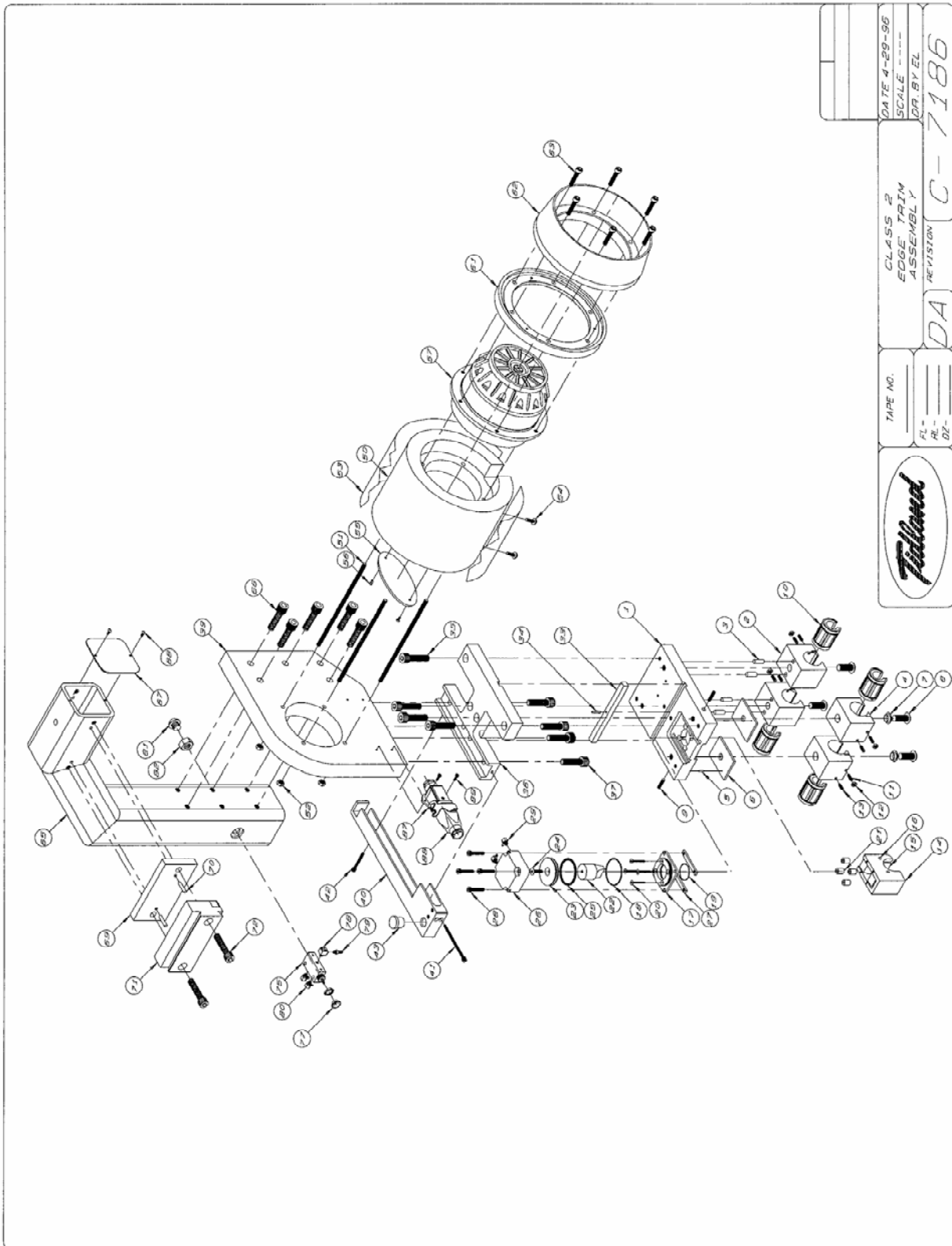


To keep the rotating assembly balanced and to prevent vibration, all cap screws must be of equal weight. (Use the same brand and size for all six.)

SPARE PARTS

Description	Part Number
Linear Open Bearing	133133
O-Ring #2-030	130472
O-Ring #2-022	130187
O-Ring #2-222	132246
4-Way Control Valve.....	132238
Push Button	250256
Air Fitting, Adjustable Elbow	250425
1/8" ID Tubing to 1/8 NPT Adapter Fitting	132366
Tubing, Red 5/64" ID	250038
Tubing, Red 1/8" ID	132940
Tubing, Blue 1/8" ID.....	128898
Motor AC	Call with your System Serial Number
Gear Reducer	Call with your System Serial Number
Anvil Ring	131393
 Tidland Performance Series Knifeholder with Manual Mount	
Control Body, Knifeholder	
Automatic	530527
Manual	535761
Swing Cartridge, Knifeholder	
Automatic	524508
Manual	569393
with 360° Blade Guard.....	548274
Manual Mount Assembly	531760
Cant Key	Call
Cant Key O-Ring	578331
Knife Blade	128401
Cartridge Hose Assembly (Manual Swing Cartridge only).....	561043
Bench Clamp Fixture	130788
Safety Glover.....	132084

PARTS DRAWING



PARTS LIST

Item	Description	Part No.
1	Carriage Plate	133281
2	Bearing Housing, Fixed	133131
3	Dowel Pin 1/4 dia x 1"	132929
4	Bearing Housing, Floating	133132
5	Roll Pin 3/32 dia x 3/8"	133137
6	Bearing Plate	133027
7	Screw Bushing	132050
8	Btn Hd Cap Scr M10 x 25 mm	132251
9	Socket Set Scr Brass Tip M6 x 12 mm	132930
10	Linear Open Bearing	133133
11	Soc Set Scr Cone Point M5 x 20 mm	132931
12	Soc Set Scr Half Dog Point M5 x 10 mm	131239
13	Hex Jam Nut M5	131600
14	Air Brake Body	131191
15	Air Brake Shoe	131188
16	Dowel Pin 3/16 dia x 1-1/4"	132932
17	Air Brake Gland	131449
18	O-Ring	130472
19	O-Ring	130187
20	Flat Hd Cap Scr M4 x 30 mm	132254
21	Brake Mount Spacer	132154
22	Air Brake Piston Rod	131319
23	Air Brake Piston	131318
24	Flat Hd Cap Scr M6 x 16 mm	132255
25	O-Ring	132246
26	Air Brake Cap	131317
27	Brake Mount Bar	132153
28	Soc Hd Cap Scr M5 x 25 mm	127638
29	Fitting, Adjustable Elbow	250425
30-32	Not used	–
33	Carriage Plate Key	133283
34	Roll Pin 1/8 dia x 5/8"	609148
35	Soc Hd Cap Scr M8 x 30 mm	132264
36	Carriage Plate Adapter	133284
37	Soc Hd Cap Scr M8 x 20 mm	132263
38	Not used	–
39	Motor Mount Plate	615166
40	Side Cover	133286
41	Soc Hd Cap Scr M4 x 65 mm	call
42	Soc Hd Cap Scr M4 x 30 mm	call
43-49	Not used	–
50	Trim Support Drum	615168

PARTS LIST

Item	Description	Part No.
51	Soc Hd Cap Scr M6 x 130 mm	call
52	Not used	–
53*	Trim Shoe	682445
54*	Btn Hd Cap Scr M6 x 10 mm	call
56	Not used	–
57	AC Motor	call
58-60	Not used	–
61	Anvil Ring	131393
62	Nose Cone	133353
63	Soc Hd Cap Scr M6 x 30 mm	call
64	Not used	–
65	Gooseneck	611524
66	Soc Hd Cap Scr M10 x 35 mm	call
67	Gooseneck Cover	133406
68	Btn Hd Cap Scr M3 x 6 mm	call
69	Spacer for "B" Web Path (where applicable)	133348
70	Roll Pin 3/16 dia x 3/4" (1-1/4" with item 69)	call
71	Guide Bar	613978
72	Soc Hd Cap Scr 3/8-16UNC x 1-3/4"	call
73-74	Not used	–
75	Control Valve, 4-Way	132238
77	Manual Push Button	250256
78	Fitting, "L" Type – 90°	128899
79	Fitting, Hose	132239
80	Fitting, Adjustable Elbow	250425
81-83	Not used	–
84	Knifeholder	call
85-86	Not used	–
86-87	Housing Mount & Cable Connect	132807 132808
88	Cover & Cable Plug	132805 132806
89	Soc Hd Cap Scr M3 x 10 mm	250235
90	Quick Disconnect Coupling	130236
91	Quick Disconnect Plug	250693
92	Tubing Clamp	132428
*	Option to replace Trimshoe and Btn Hd Cap Scr (Items 53, 54)	
	Right Hand Platen	615163
	Left Hand Platen	615164
	Low Soc Hd Cap Scr M6 x 12 mm	605250



Tidland Corporation
2305 SE 8th Avenue
Camas, WA 98607 USA
Phone: 1-800-426-1000
1-360-834-2345
Fax: 1-360-834-5865
E-mail: tidland@tidland.com
Web: www.tidland.com

Maxcess Europe
Fifestrasse 1, D-65779
Kelkheim/Ts., Germany
Phone: (49) 6195-7002-433
Fax: (49) 6195-7002-933
E-mail: info@maxcess.de

Maxcess Asia
300 Orchard Road No. 15-05
Orchard Towers
Singapore 238875
Phone: (65) 6834-1998
Fax: (65) 6835-4818
E-mail: info@maxcess.de

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