Split-All Instruction Sheet

Installation, Set Up and Dust Collection

◆There is no assembly required. Choose a location within 8 feet of a 120volt/60hz grounded outlet. For the 230volt/50hz motor you must provide your own electrical plug or connection to the end of the power cord. The motor draws 8 amps maximum, or 4 amps with the 230volt version.

◆The extra electrical cord is for dust and chip collection while you saw the hoppers. Plug the cord into a toner vacuum and put the vacuum's power switch to the ON position. Plug the toner hose from the vacuum into the hole in the side of the splitter. With this arrangement the vacuum will collect 95% of the toner dust and plastic chips while splitting, and provide cooling airflow for the saw blade.

◆There is a microswitch under the front cover that will switch off the motor (saw blade), but will allow the vacuum to operate as normal without the saw blade turning. When you are ready to thoroughly clean the saw blade area, remove the four screws holding the front cover on the splitter. With the front cover off, turn the main power switch on, and you can use the vacuum hose to safely clean around the splitter blade.

◆The overall depth of the splitter is 19", the width is 36". Two holes are provided in the base plate for screwing the machine to your table top if you desire, but this is not necessary.

◆<u>Make sure the surface that the Split-All rests on is flat. An uneven table top can cause the saw blade to cut the hoppers crooked. Use a flat board underneath if necessary!</u>

Fixture Plates and Tooling Sets

The fixture plate locates the hopper in relationship to the saw blade. The fixture plate is also a safety guard.

Do not operate machine without guard (fixture plate) in place. Do not operate machine without a hopper in the fixture plate. Saw blade is very sharp and can cut fingers if fixture plate and hopper are absent from machine.

The fixture plates are attached to the carriage with two 1/4-20 X 1" screws. Do not over tighten these screws.

◆There are two white plastic pins in each fixture plate. These pins locate the hopper in one dimension. <u>It is normal for the cutting blade to trim the tips off these pins the first time the fixture is used</u>. Eventually the blade will cut the pins off too low to position the hopper correctly, especially the pin on the right. So you will have to tap the pin up from the bottom to restore their original height of ~3mm (1/8") when this happens. We include some extra pins in the tool box if you need them, or just ask us for some new ones.

◆The fixture plate for the EX hopper will work with or without the mag roller in place.

◆For the HP4000 and HP2100 you must remove the mag roller, but the small end plate can be left on the hopper.

◆The 5Si/8000, HP8100 and HP5000 require that the hopper be stripped down in order to split.

◆The HP8000 (the latest version of the 5Si) requires an extra cutting operation in order to be able to split it, and clip it back together again. An instruction sheet for this operation is included with the HP8000 Trimming Fixture.

◆Each tooling set includes a fixture plate, a toner hopper fixture, a foam replacement fixture and a funnel. Use the toner hopper fixture for any assembly operation before or after splitting. The foam replacement fixture is for the holding the mag section after you've separated it from the hopper. The funnel is for refilling your resealed hoppers. Each of these items is available separately as well. Call for pricing on any of these items.

Splitting Hoppers

Saw blade is very sharp!!! Avoid turning on the power except when you are actually splitting hoppers!!!

Move the carriage all the way to the right. Insert a hopper, with the mag section down, into the fixture plate. Make sure the hopper is properly seated in the fixture. Turn the power switch on. Holding onto the hopper, feed the carriage all the way to the left, then return it all the way to the right. Pull the hopper out of the fixture plate, reverse it, and repeat the procedure on the opposite side.

◆You may have to peck the hopper into the blade to get a straight clean cut, especially on the large format cartridges. Try feeding the hopper half way or a third of the way through, pull back a little to clear the chips, then feed it into the blade again to finish the cut. This pecking motion will produce a straighter cut.

◆Separate the mag section from the hopper section with a flat screwdriver or tack pulled. Some types of hoppers are harder to separate after splitting than others. This is because of pins, foams or internal welds which hold the two sections of the hopper together even with the main welds sawed away.

Using a sharp knife to separate the hopper from the mag section after splitting can lead to personal injury!!!

Avoid feeding the carriage too fast, which may cause the blade to wander off center.
Avoid feeding the hopper too slowly, which creates frictional heat, melting the plastic.
Avoid pushing down too hard on the hopper while feeding it into the saw blade, which could cause the blade to wander of center also.

The cut you are making is light and requires little force. Just let the fixture plate position the hopper and feed it through at a sensible rate. It should only require a few minutes to get the cutting process right.

Changing the Saw Blade or Belt

◆You may be able to clean a gummed up cutter blade with solvent or scraper knife. Eventually the cutter will have to be changed after splitting hundreds of hoppers. The blade is a standard metal cutting slitting saw 4”diameter with 36 teeth, 1/32” thick and 1” diameter mounting hole. Plastic Tooling has them in stock for $25 each. Eventually you may also need to replace the drive belt if the teeth get stripped off or it breaks. The belt is an industry standard# 170XL 3/8” width, and we can supply you with extra belts for $6 each.

◆Changing the blade: Remove the front cover to gain access to the cutting blade arbor. Removing the front cover will also shut the power off to the motor. Removing the front cover does not cut the power off to the vacuum. An allen wrench and a plastic block are provided for loosening the blade. Turn the screw counter clockwise to loosen. Clean the saw arbor before reinstalling cutter. The saw blade turns counter clockwise. Tighten arbor cap onto blade, but avoid excessive force. Reinstall front cover.

◆Changing the belt: Unplug the power cord. Remove the front, back and top panels. Loosen the four motor mounting bolts. There is a set screw that adjusts belt tension located under the safety switch above the blade. The slot in the partition where this switch mounts is oversized on the bottom so that the belt tensioning screw is accessible. Using a 1/8” hex wrench, turn the screw so the belt is slack. Remove the old belt and reinstall the new belt. Turn the belt tensioning screw clockwise until the belt has 1/4”(6mm) of deflection. Push down on the motor while tightening the belt to make sure no tilt develops. Tighten the motor mounting bolts while still pushing down on the motor. Bolts should be very tight, but not excessively so. After tightening, check the belt deflection again. Adjust again if needed. Reinstall the top, back and front panels.

Plastic Tooling Corporation

125 Woodwinds Industrial Court, Cary NC 27511

☎1-800-595-8334 ☎(919) 469-3332 FAX(919) 469-3475