

Declaration of Conformity

We,

Manufacturer:

Spartanics Ltd.
3605 Edison Place
Rolling Meadows, Illinois 60008 USA
Tel.: 847-394-5700
Fax: 847-394-0409



declare under our sole responsibility that the product,

Product: Automatic Strip Starter
Model: M73

conforms to the following standards

Safety:	EN292	Safety of Machinery (1991)
	EN60204-1	Electrical Equipment of Industrial Machines (1992)
EMC:	EN50081-1	Electromagnetic Emissions
	EN50082-2	Electromagnetic Immunity (Heavy Industrial)
	EN55011	Electromagnetic Emissions of ISM Equipment

following the provisions of

Machinery Directive (89/392/EEC)
Low Voltage Directive (73/23/EEC)
EMC Directive (92/31/EEC)

when installed in strict accordance to all relevant safety, emc, and installation instructions set forth in the accompanying documentation.

Authorized Signature:

A handwritten signature in black ink that reads 'Thomas E. Kleeman'.

Authorized Representative: Thomas Kleeman, Vice President, Engineering

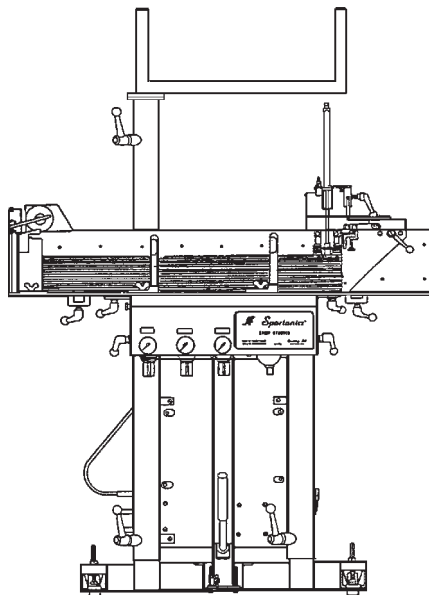
Date of Issue:

12 Nov. 2002



English

Model 73
Strip Starter
Operator Manual



SPARTANICS Model 73 Operator Manual

CE Edition

The information furnished herein is believed to be accurate and reliable. However, no responsibility is assumed by Spartanics for damages incurred directly or indirectly from errors, omissions or discrepancies between the product and this manual.

In order to show equipment detail, this manual may show equipment with guards or covers removed. In normal use, equipment must never be operated with guards or covers removed or modified, and safety mechanisms must never be defeated!

Spartanics Ltd. reserves the right to change specifications at any time without notice.

For information not contained in this manual, contact Spartanics Technical Services Department for assistance.

Spartanics is a registered trademark of Spartanics Ltd. Rolling Meadows, Illinois.

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1. Introduction

1.1. Model 73 Strip Starter

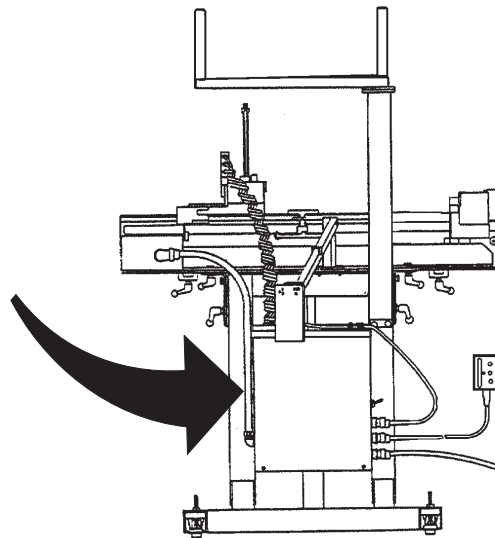
The Spartanics Model 73 Strip Starter is a device designed to be used with the Spartanics Strip Feeds. The M-73 automatically loads strips of material into a Spartanics Strip Feed. The Strip Feed then positions the material under a die for blanking or punching.

The combination of the Spartanics Strip Starter and Strip Feed;

- Improves handling for metal, plastic, paper, and other strips to be fed through a punch press.
- Improves operator efficiency by allowing simultaneous operation of several presses.
- Improves safety by hands off operation of presses.
- Improves press efficiency by operation of each press at maximum capacity.
-

1.2. System Identification

1.2.1. CE Nameplate Location



2. Spartanics

2.1. Address:

Spartanics, Ltd.
3605 Edison Place
Rolling Meadows, IL 60008
U.S.A.

2.2. Sales

Tel: 847-394-5700
Fax: 847-394-0409
sales@spartanics.com

2.3. Service

Tel: 847-394-5700
Fax: 847-394-9349
service@spartanics.com

2.4. World Wide Web

<http://www.spartanics.com>

3. General Safety

3.1. General guidelines for safety

3.1.1. General

This device conforms to established safety regulations. However, hazards are involved in the operation of this device if:

- The operation and safety guide lines in this manual are not followed.
- The device is not operated for its intended use.

3.1.2. Responsibilities

The manufacturer is responsible for delivering the device in a flawless state in terms of operation and safety regulations.

The company operating the device is responsible for;

- Ensuring that the device is used in accordance with its intended purpose;
- Training the personnel
- Providing any required protective gear
- Controlling that only authorized personnel work on the device;
- Meeting the required maintenance requirements;

The operating personnel is responsible for;

- Operating the device only when it is in a flawless state with all safety guards properly installed;
- Immediately notifying the supervisor in charge of anything affecting safety;
- Ensuring that no unauthorized persons are near the device during operation;
- The use and care of appropriate safety and protective equipment;
- Cleaning the device and the work area around the device.

3.1.3. Operator Requirements

All persons involved in the operation of this device shall;

- Be of legal age to operate this type of machinery;

- Be adequately trained and instructed in the operation of this device;
- Have read and understood all operation and safety instructions in this manual;
- Have read and understood all local and regional safety instructions governing the use of this type of machinery.

Trainees shall only work on this device when supervised by an experienced operator.

3.1.4. Malfunction Procedures

In the event of any malfunction, turn power off and contact qualified service personnel.

3.1.5. Safety Rules

- The operation of this device is subject to the local, state, federal, and international regulations regarding safety at work and accident prevention.
- Read this manual before operating this device.
- For any operation or maintenance procedures that may be required, but are not covered in this manual, contact Spartanics Technical Service Department before proceeding.
- Before device is put into operation, always check the safety equipment and protective covers.
- Unauthorized modifications and changes to the device are not authorized.
- Accessories, replacement, or spare parts produced from other manufacturers may only be used when approved by Spartanics
- Before carrying out any maintenance, repair, or modification work, lockout mains supply voltage to prevent power from inadvertently being switching on.
- Never operate this device unless it is properly grounded according to local regulations.
- Never operate this device with any of its safety guards removed or improperly installed.
- Never operate this device in an explosive atmosphere.
- Never operate this device in a wet or moist environment.

4. Special Safety Warnings

4.1. Integration Compliance



Spartanics Strip Starter Systems are designed to be integrated into Spartanics Feed Systems and an end users equipment. Continued compliance with all government regulations and codes is the responsibility of the end user management.

4.2. Guarding Warning



Attachment of Spartanics Starter and / or Feed Assemblies to the users equipment and automating material movement in no way reduces the need to adequately guard any hazardous areas. All guarding is the users responsibility.

4.3. Interface Warning



Spartanics Feed Systems provide a “request to trip” signal only. Any interfaces between the users equipment and the feed system must be done in a way that insures the integrity of all existing safety, redundancy, and shutdown features of the end users equipment.

4.4. Input Power Compliance



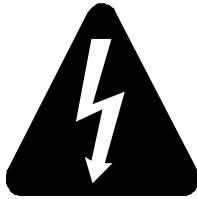
The Spartanics Starter Systems is supplied power from a Spartanics Feed System which provide a hard wired input connection in the supplied power box. An external electrical disconnect must be supplied by the end user between the feed power box and the electrical mains voltage. This is usually accomplished by connection to the users equipment electrical circuit.

4.5. Safety codes



No information supplied by Spartanics either in written or verbal form regarding safe installation or operation is intended to supersede local electrical and safety codes.

5. Specific Safety Warnings



Warning

Mains voltage is used to operate this device

Possible hazards

Death or injuries due to electrical shock

Safety measures

Covers containing electrical components, controls and distribution circuits may only be opened by authorized personnel.



Warning

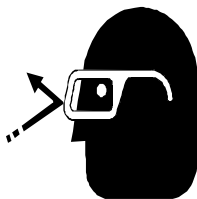
Automatic movement of the pickup head

Possible hazards

Pinch or compression injury when pickup head is in motion

Safety measures

- Do not operate device with safety guards removed.
- Do not stop movement with you hands.
- Do not operate press with any other personnel near machine.



Warning

Foreign object may be ejected from clamp or die area.

Possible hazards

Face, hand, or other injuries due to ejected objects

Safety measures

Wear safety glasses, gloves or other protective



Warning

Table can drop suddenly if height locking clamps are released when the cylinder air valve is open.

Possible hazards

Table could drop suddenly and / or rapidly causing the table to cause bodily damage.

Safety measures

Always verify that valve is closed before releasing height locking clamps.

Open valve slowly to lower table.

Always close valve and lock clamps securely when height adjustments are complete

Warning

This device uses compressed air

Possible hazards

Injury possible due to loose or broken air fittings or lines

Safety measures

Always verify that air fitting and connections are securely fastened.

Never use equipment if any fittings or lines show signs of wear or have any defects. Replace if needed.



5.1. Safety Devices

5.1.1. Protective Equipment

- Close fitting work clothing
- Safety glasses
- Gloves

6. Document Identification

6.1. Manual

Model 73
Strip Starter
Operator Manual
Part number and revision listed at bottom of each page

6.2. Execution

This manual is compiled following the provisions of the EC directive for operating instructions.

6.3. Copyright

The information contained in this manual was derived in part from proprietary and patent data of Spartanics. The express purpose of this publication is to assist users in the installation of said equipment. No part of this publication may be reproduced, stored in a retrieval system, or transmitted in any form without the prior written permission of Spartanics.

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Rolling Meadows, IL 60008
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7. Manual

7.1. Symbols



Warning

Designation of a possible hazardous situation.
If this situation is not prevented, the consequences may be;

- Unhealthy effects
- Serious injuries



Caution

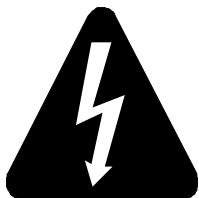
Designation of a hazardous situation.
If this situation is not prevented, the consequences may be;

- Slight or minor injuries
- Damage to the equipment.



Important

Designation of special working instructions



Dangerous voltages

Designates parts of the unit with a possible dangerous voltage



Head or body injury

Designation of a condition where device may drop or lower position which may cause injury



Compressed Air

Designation of an area where compressed air is used. Injury could result if connections are not made correctly or damaged parts are used or present.

8. Technical Data

8.1. Model

Model 73

8.2. Material

8.2.1. Material Types

metal, plastic, paper, laminate & elastomer

8.2.2. Strip Length

Minimum 12" . . . (305 mm)
Maximum 34" . . . (864 mm)

8.2.3. Strip Width

Minimum 0.75" (19 mm)
Maximum 10" . . . (254 mm)

8.2.4. Strip Thickness

Minimum 0.008" (0.2 mm)
Maximum062" . . . (1.57 mm)

8.2.5. Stack Height

Maximum 6" . . . (152 mm)

8.2.6. Stack Weight

Maximum 300 LB (133 Kg)

8.3. Hardware

8.3.1. Feed Height

Minimum 29.5" . . . (749 mm)
Maximum 44" . . . (1118 mm)

8.3.2. Feed Angle

Minimum 0 degrees
Maximum 30 degrees Tilt Back

8.3.3. Dimensions, Overall

Length 40" . . . (1016 mm)
Width 24" . . . (609 mm)
Height (Max) 55.5" . . ((1410 mm)
Height (Min) 40" . . . (1016 mm)

8.3.4. Dimensions, Mechanism

Length. 40" . . . (1016 mm)
Width 11" . . . (279 mm)
Height. 19" . . . (483 mm)

8.3.5. Dimensions, Stand

Length. 24" . . . (610 mm)
Width 27" . . . (686 mm)

8.3.6. Dimensions, Shipping

Length. 51" . . . (1295 mm)
Width 30" . . . (762 mm)
Height. 46" . . . (1168 mm)

8.3.7. Weights

Operational. 120 LB. (53 kg)
Shipping. 325 LB (148 kg.)

8.4. Requirements**8.4.1. Power Requirements**

Power. 250 VA
Volts. 120 VAC . . (supplied by feed)
Frequency 50 / 60 Hz

8.4.2. Air Requirements

Nominal 0.12 cfm @ 100 psi
(200 L / hr @ 7 bar)
Maximum . . . 0.25 cfm @ 100 psi
(400 L / hr @ 7 bar)

9. Installation

Contact Spartanics or an authorized representative for installation.

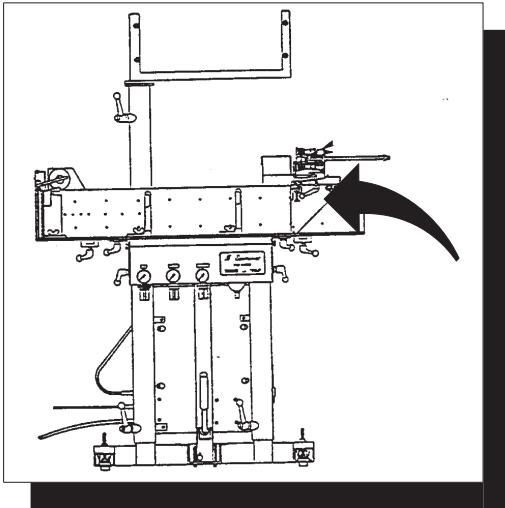


Spartanics Strip Starter Systems are designed to be integrated into Spartanics Feed Systems and an end users or Spartanics supplied equipment. Installation of this equipment can only be done by qualified personnel

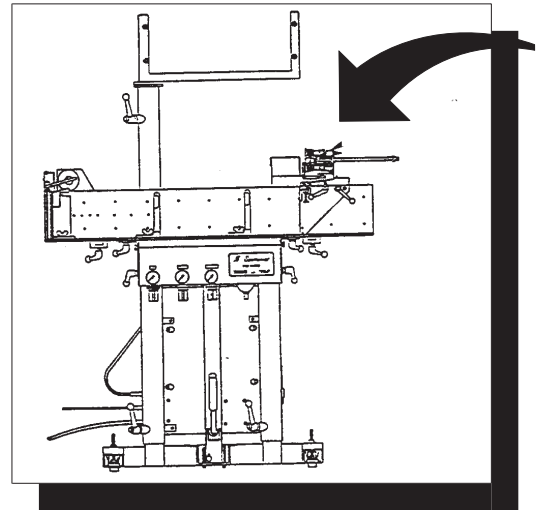
10. Setup

10.1 Pickup Head

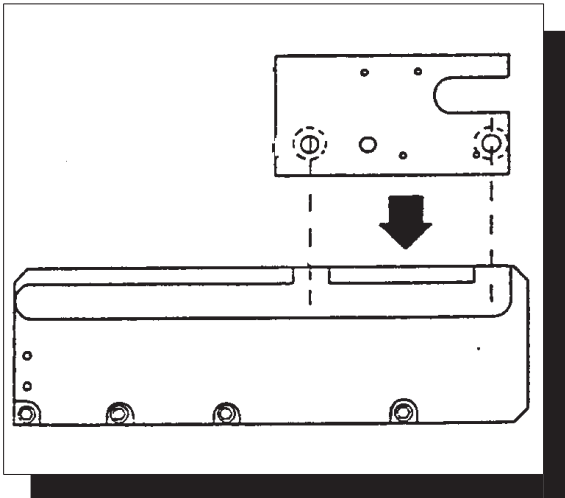
1. Loosen pickup head clamp



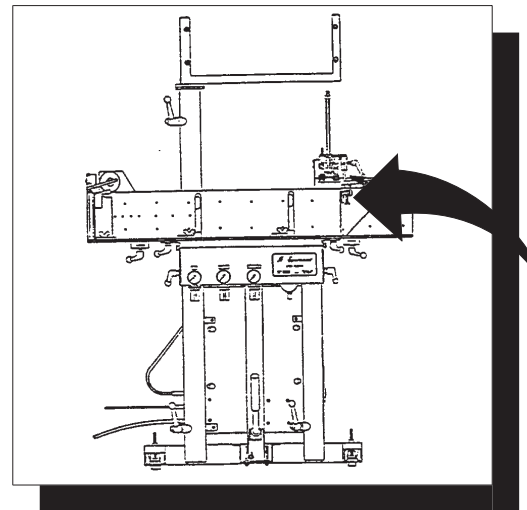
2. Remove Head



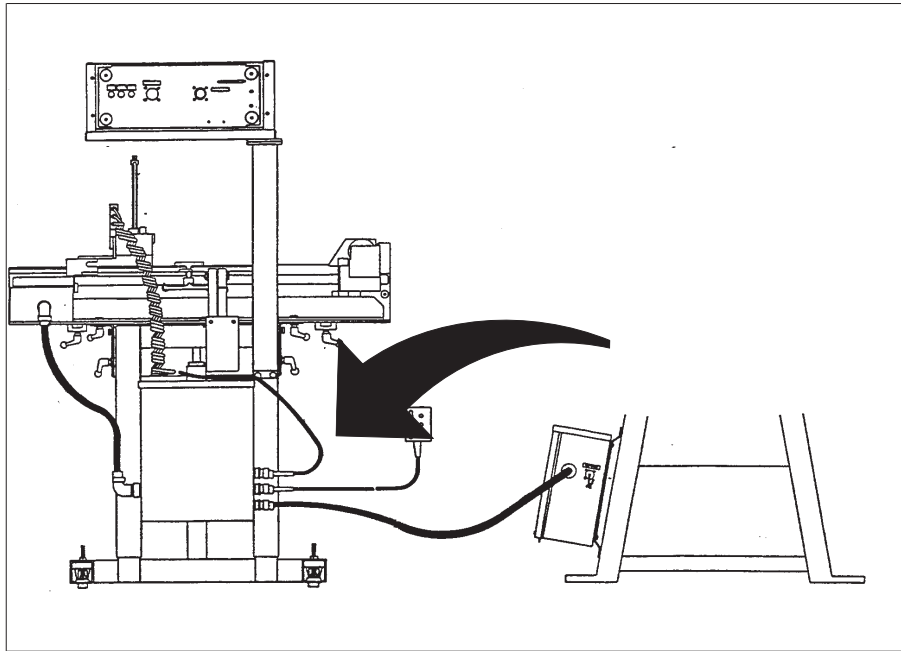
3. Slide pickup head onto mount



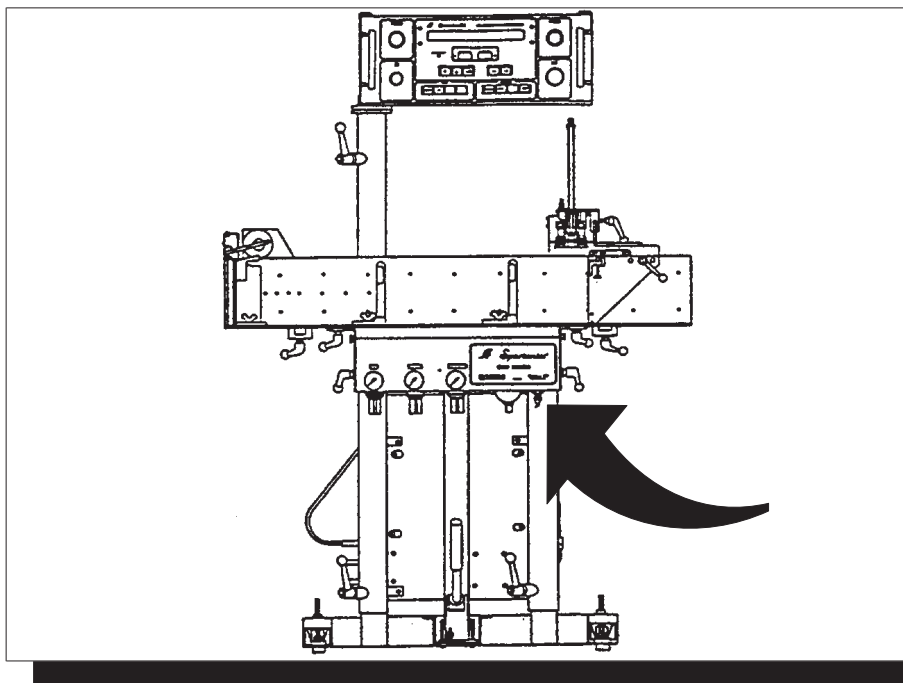
4. Tighten Clamp



5. Connect Cables

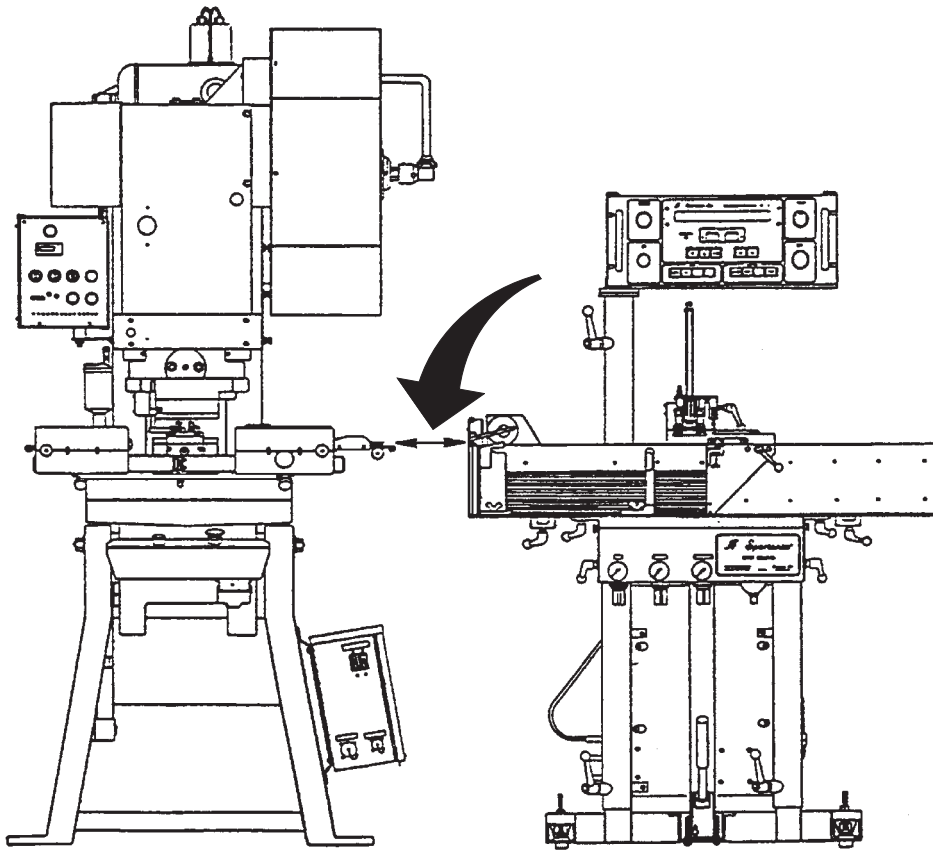


6. Connect Air line



10.2 Adjust Table to Press

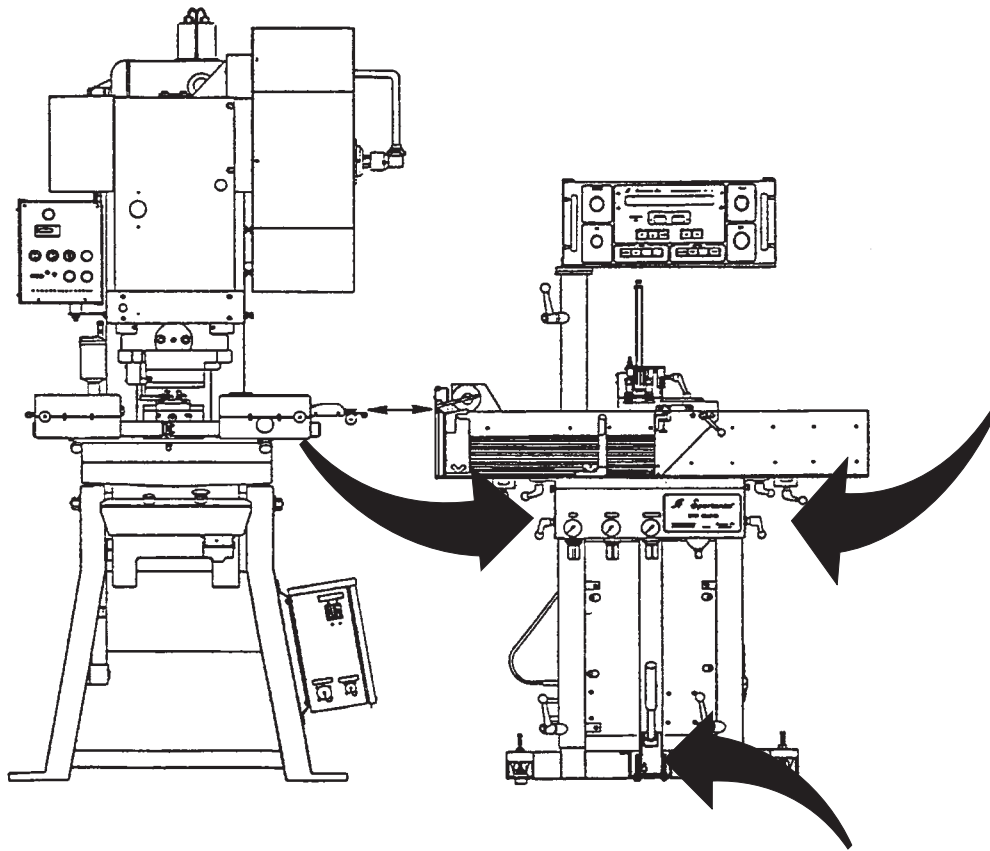
Adjust table height and tilt of Starter output to match input of Feed.



10.3. Height Adjustment

10.3.1. UP

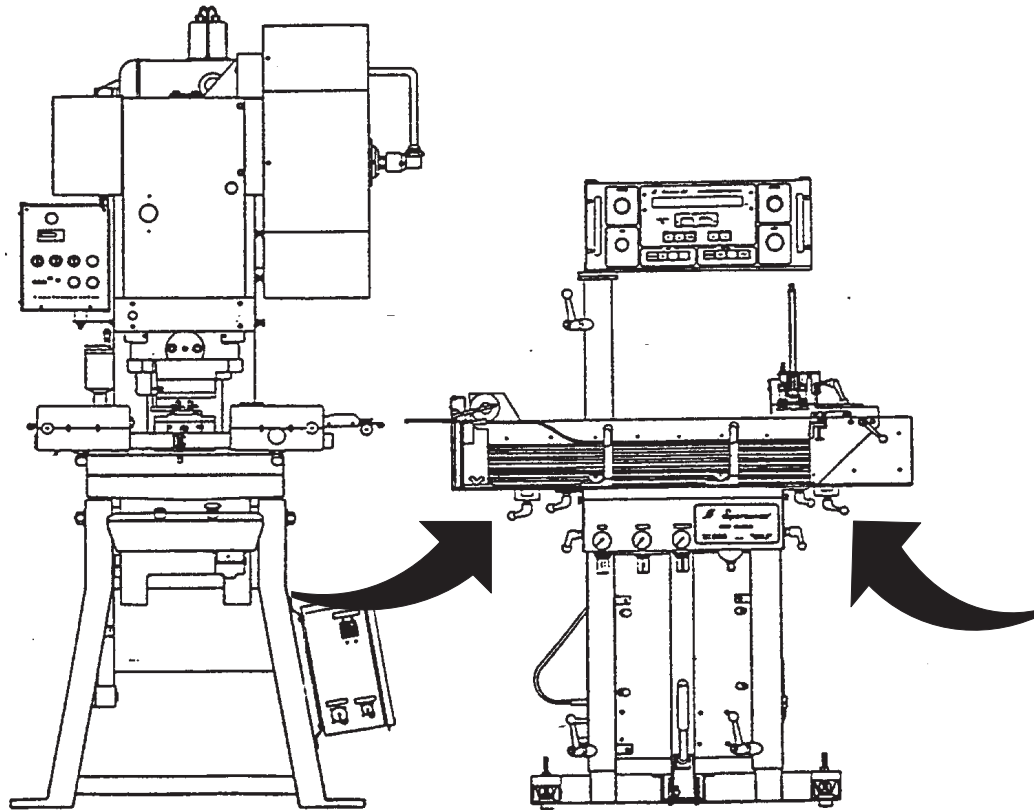
1. Loosen clamps
2. Pump air jack
3. Tighten clamps



10.3.2. DOWN

1. Loosen clamps
2. slowly release air
3. Tighten clamps.

10.4.Tilt Adjustment

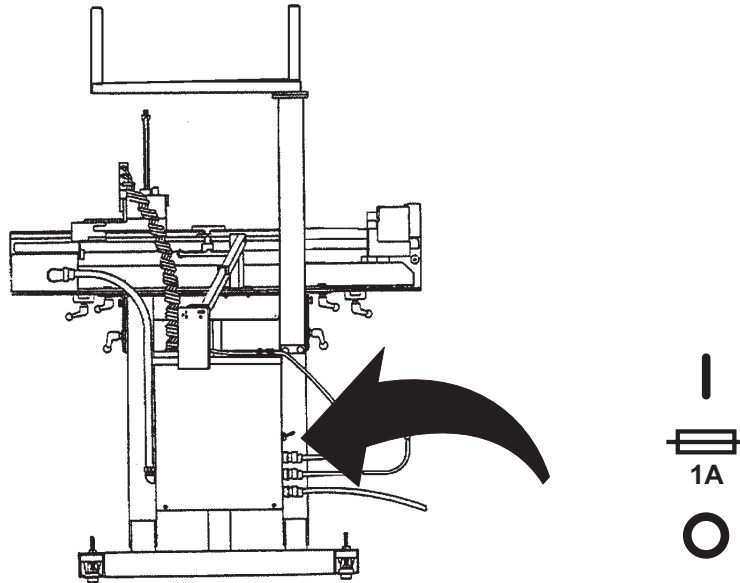


1. Loosen clamps
2. Adjust tilt to match press
3. Tighten clamps

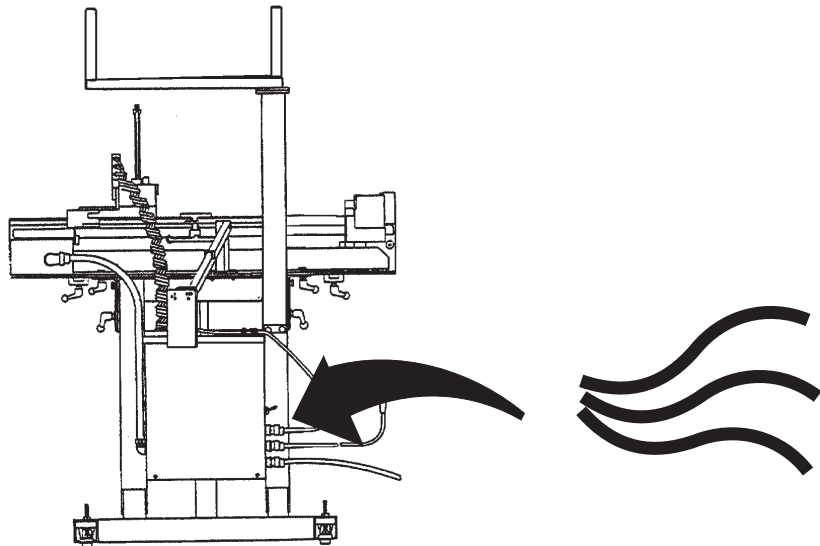
11. Controls & Icons

11.1. Electronics Enclosure (Side)

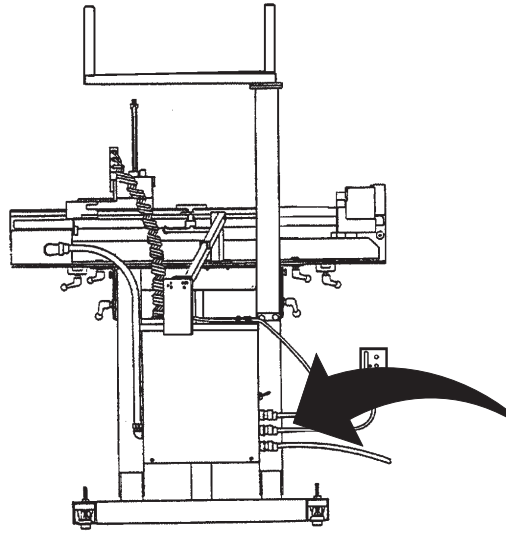
11.1.1. Power Switch (Circuit Breaker)



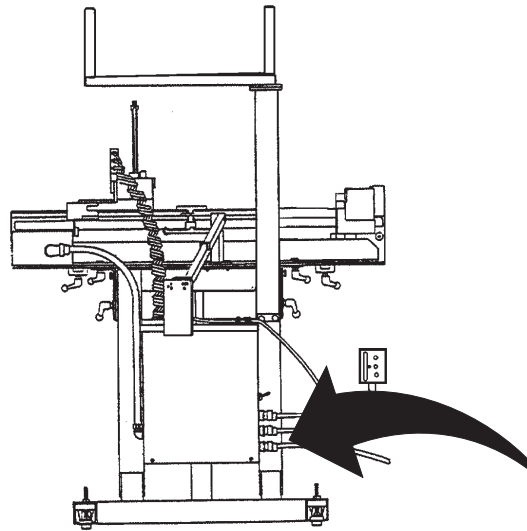
11.1.2. Air Connection



11.1.3. Remote Box Connection

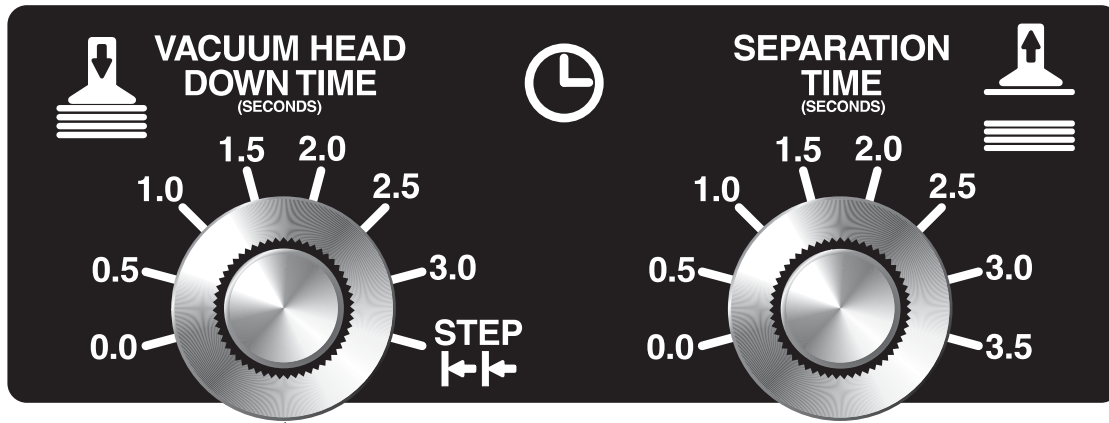


11.1.4. Power Box Connection




11.2. Electronics Enclosure (Top)

11.2.1. Vacuum Head Down Time & Step Mode

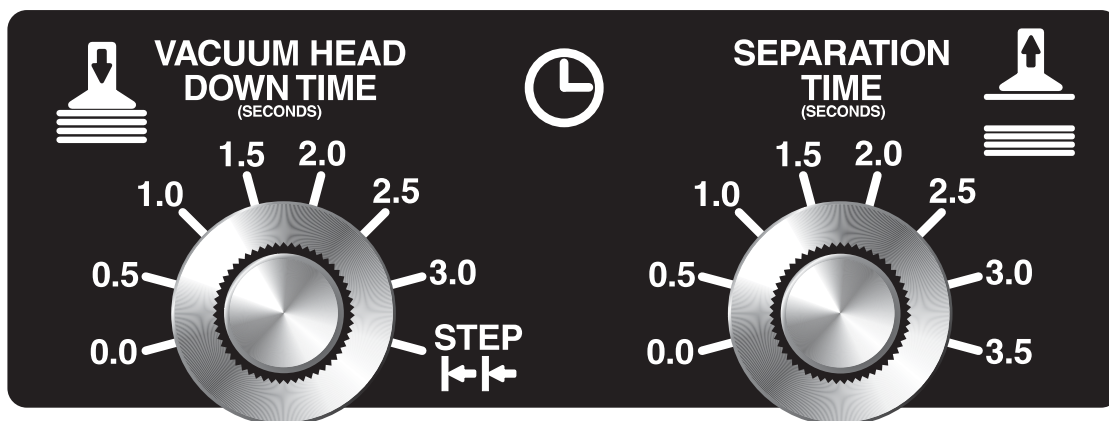


DOWN TIME: Sets the time that the vacuum head stays down on the material. (Time for a good seal)

STEP MODE: Allows single step operation through each function each time  is pressed.

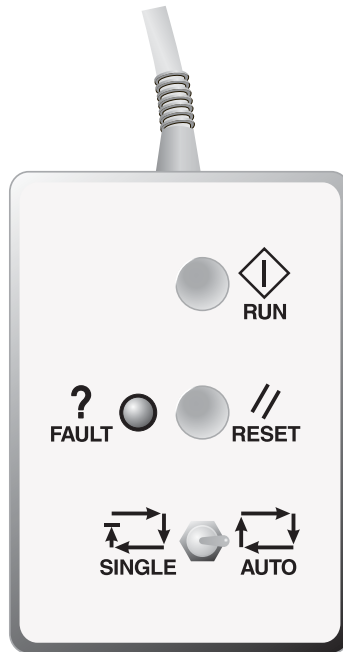
RUN

11.2.2. Separator wait time



Sets the time delay between the time the vacuum head comes up (with the material) and the time the separator runs forward into the drive wheel. (Time for the material to separate from each other.)

11.3 Remote Control Box



11.3.1. Run



Starts cycle, a sheet is picked up and feed out to the press.

11.3.2. Fault



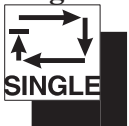
Light which indicates an error condition

11.3.3. Reset



Resets Starters mechanism's to their home positions

11.3.4. Single



When selected, Starter will load one strip when is pressed.

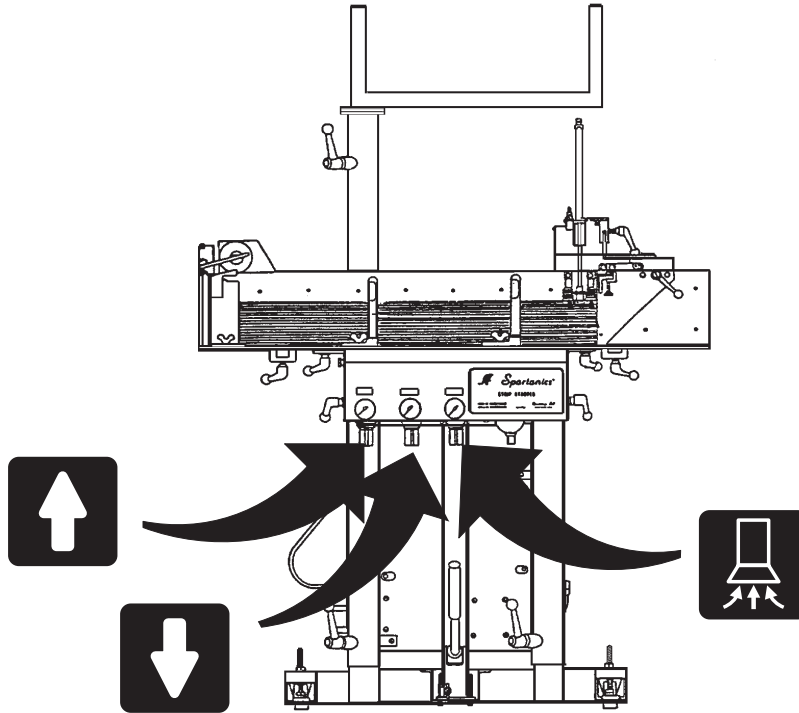


11.3.5. Auto



When selected, Starter will automatically load a strip whenever it receives a request from the Strip Feed (when "LOAD STRIP" LED on feed lights up.)

11.4. Air Control Panel



(Knobs lock in up position. Pull knobs down to adjust pressure.)

11.4.1. UP Pressure



Adjust pressure to drive pickup head up

11.4.2. Down Pressure



Adjusts pressure to drive pickup head down

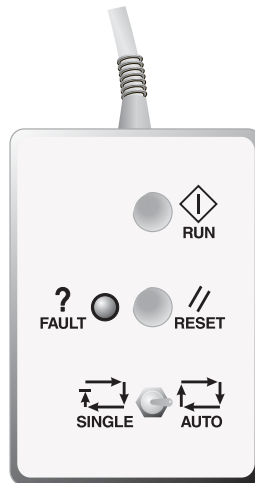
11.4.3. Vacuum Pressure



Adjusts vacuum pressure supplied to pickup suction cups.

12. Operation

12.1. Start operation with remote control

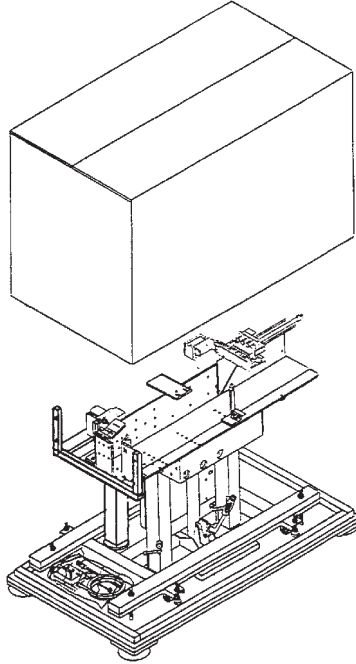


1. Verify single / auto switch set to auto.
2. Press reset
3. Press run

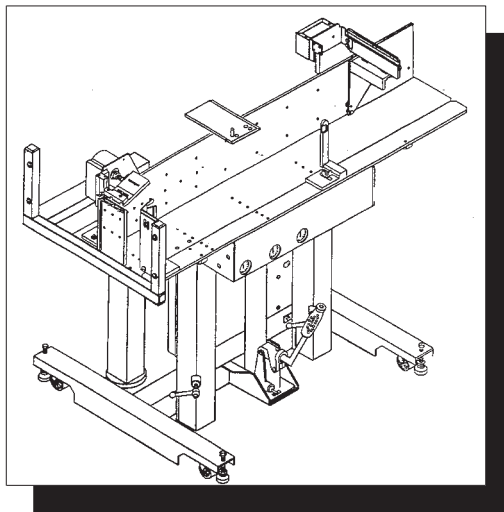
Starter will automatically load a strip whenever it receives a request from the Strip Feed (when the load strip LED on feed lights up.)

13. Optional Electronics Rack Setup

1. Uncrate unit

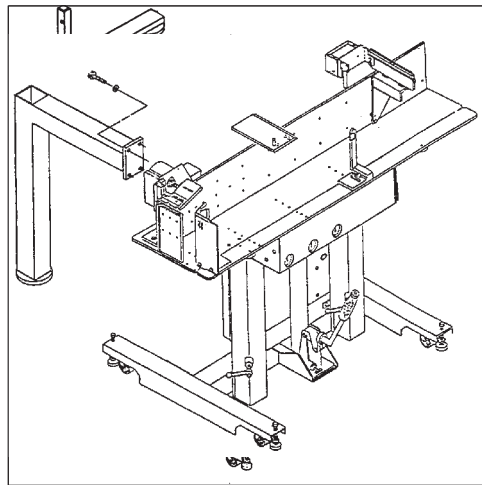


2. Starter (in transport configuration)

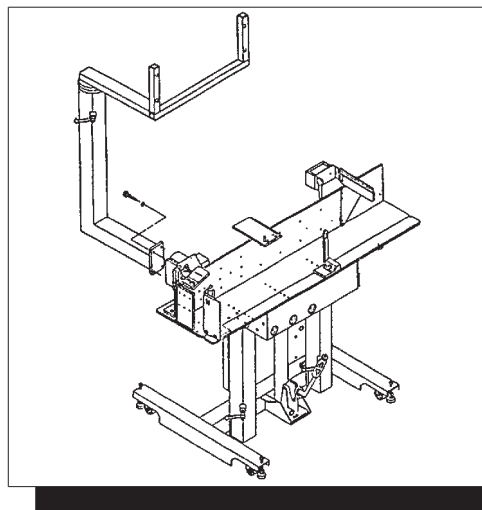


3. Remove electronics rack

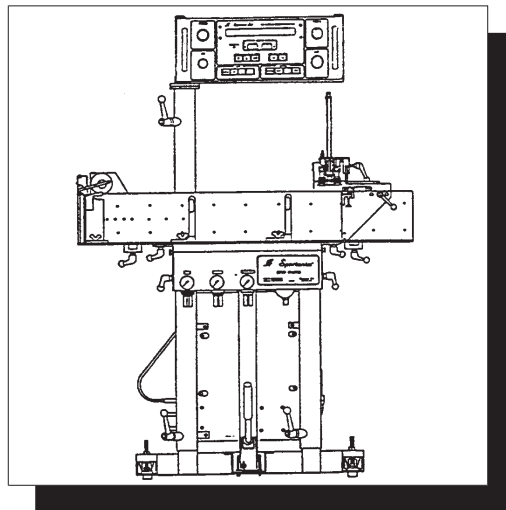
4. Remove upper frame



5. Mount upper frame and electronics rack.



6. Mount Electronics



14. Schematics

The following schematic is included in this manual

73-5001CE Schematic, Strip Starter System