

Blade is Cupping / Rounding Off Leading Edge of Board or Not Completing Vertical Cut Through Board

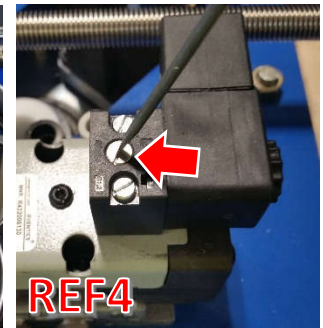
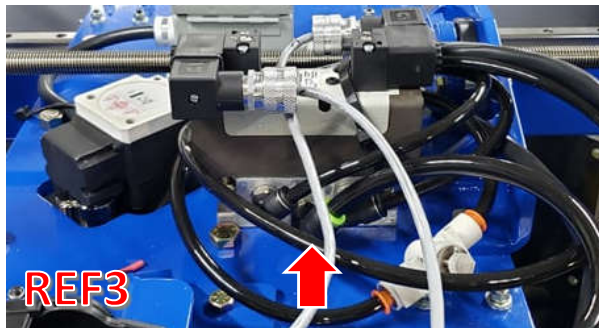
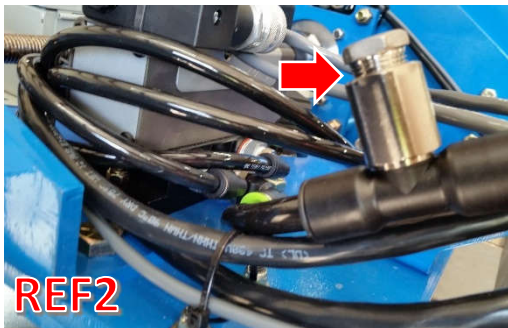
Possible Problem 1: If you are experiencing cupping or incomplete cuts specifically in colder weather you may need increase your drop/raise time. This can also be a symptom of a worn cylinder. Worn cylinders can be temporarily corrected by increasing the drop/raise time for more life out of your cylinder.

Not Cutting Through: Increase drop time 100-200 MS (*Perfect Condition #350MS*)

Cupping Top of Board: Increase raise time 100-200 MS (*Perfect Condition #350MS*)

Possible Problem 2: Flow control (white and orange tee like fitting) may be too restrictive. Confirm it is open enough to allow movement, but limit slamming (REF1).

Possible Problem 3: Ceram valve may be sticking. Add a few drops of air tool oil to the tee valve (REF2) If no tee is present, oil can be added directly at center air fitting (REF3) Manually cycle the valve (with power off) to get the oil worked through (REF4)



Possible Problem 4: Carriage air cylinder seals are failing.

With cylinder in up position, remove top air hose, listen for air leaking at the cylinder port (REF5) if a leak is heard here, the cylinder needs rebuild or replaced. Rebuilding cylinder requires 1 SMC rebuild kit. Check part number on cylinder.

Cylinders ending in A get kit #PC-0012-1

Cylinders ending in Z get kit #PC-0012-2

Replacement cylinder for single carriage style: PC-0012M

Replacement cylinder for double carriage style: PC-0012L

If no leak is heard at cylinder, listen at hose for ceram valve leak. If ceram is leaking, it needs to be cleaned or replaced. No rebuild kit available.

