

TIP 0305-39

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Troubleshooting the diecutting section

Scope

Troubleshooting issues in the diecutting section.

Safety precautions

Accomplish checks with drive stopped. Use “Tag Out/Lock Out Procedures” established by the plant before your initial checks.

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
Anvil wear	• Too much penetration between die and anvil drum	• Check impression setting.
	• Anvil drum not oscillating	• Check panel light and oscillating mechanism.
	• Improper cover rotation	• See TIP 0305-35.
	• Damaged cutting rule	• Repair or replace damaged rule.
	• Improper rule height	• Correct rule height.
Registration (Not locating hand holes properly, etc.)	• Lack of pull rubber on cutting die	• Install pull rubber.
	• Worn pull rubber	• Replace pull rubber.
	• Improperly placed pull rubber	• Check location of pull rubber for proper sheet control.
	• Improper pull collar setting	• Adjust pull collars.

TIP Category: Automatically Periodically Reviewed (Ten-year review)



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Score cracking (checking found at score line)	• Ineffective or improper rubbering along scores	• Replace with firm rubber.
	• Brittle board	• Add moisture to board. Print water over score area
Cutting incomplete (not cutting through board)	• Damaged cutting rule edge	• Repair or replace rule.
	• Poorly made rule to rule joints	• Reinforce rule joint. Replace rule to eliminate joint.
	• Defective anvil	• Rotate or replace as required.
	• Too much stripping rubber, improper rubber location	• Rerubber die using proper height, hardness, and location of rubber.
	• Improper score to cutting rule joint	• Relieve score rule at joint with cutting rule.
Stripping (not complete or inconsistent)	• Product ejection rubber too close to product/scrap cutting rule	• Place product ejection rubber 1 in. (25 mm) from scrap cutting rule.
	• Improper stripping rubber and location	• Replace — rubber must "roll" out the scrap.
	• Incomplete cutting	• See "Cutting" above.
	• Nicks holding scrap to blank	• Reknife die to eliminate rule joints. Redesign blank to eliminate rule joints.
	• Improper blank design	• Redesign blank. Eliminate square corners and parallel sides in feed direction.
Loss of dimensional stability	• Lack of pull rubber	• Check pull rubber.
	• Over penetration of rule	• Check cutting impression.
	• Uneven anvils	• Rotate anvils more frequently.
	• Scoring rule height too low	• Rerule die with proper height score rule.