



Technical Bulletin

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Instructions for Setting up Hot Wire Film Cutting

This bulletin outlines the parameters for setting up a flex HPA or LPA hotwire film tail treatment.

1. Wiring: Wire 12V for Hot Wire Cutters on Flex machines.
2. Fuses: 3A slow burn fuse (ATQR3). 5A is an acceptable replacement, although our testing proved 5A is not needed.
 - a. 2.5amps is the baseline and max. amp draw @12V.
3. HMI Parameters: The maximum time of 7 seconds is confirmed and acceptable.
4. Flow Controls: Set flow controls to control the speed of wiper/cut arm in the outward motion. The correct speed is achieved when the film is cut once the wire touches it. If the film deflects from the wire more than an inch or two the speed is too fast.

Troubleshooting

1. If the wire is turning red or does not shut off:
 - a. The relay could be shorted in the closed position and is probably wired as 24V
 - b. Replace relay CR309
 - c. Wire to 12V
2. If wired for 24V the Relay CR309 is not the correct relay and may short circuit in the closed position.