

\*Picture may not reflect actual chopper detail. Modification may be added for customer specifics or customization add-ons.

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Revision	Date	Written By	Description of Change	Reviewed By
0	03/04/22	BRAD T.	Original CL200 Building Specification	BJT

## FOREWORD

The purpose of this manual is to familiarize qualified individuals with the operational procedures of Sweed Machinery equipment.

The manufacturer recommends that users familiarize themselves with the applications and uses of Sweed Machinery equipment prior to operation. Sweed Machinery equipment should not be used for any purpose other than that for which it is was designed.

In order to provide dependable and safe service, this machinery must be operated by trained personnel wearing eye protection and gloves. Personnel operating the equipment must understand the type of material that it is capable of processing.

Any misuse of Sweed Machinery equipment can be dangerous. All operators should be familiar with the general operating instructions and warnings.

It is the owner's responsibility to install the Sweed Machinery equipment in conformance with applicable federal, state, and local laws and to instruct personnel in safe operating procedures.

Additional Comments:

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## SAFETY

01	Scope	This manual covers all information and requirements to operate the Sweed Chopper CL200AE
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02	Standards / Environment	
02.A	Electrical	Machine is built in accordance with all N.E.C and local requirements.
02.B	Mechanical	Machine/System is design and tested before shipment at Sweed's Facility to ensure correct machine tolerance and electrical integration and operation.
02.C	Machine Location	<p>The CL200 is designed to be easily moved from one location to another while providing excellent stability when in operation. Locate near electrical and compressed air supply line. Ensure that the electrical cord and compressed air line are situated as to prevent a tripping hazard.</p> <p>The CL200 uses a precision traveling knife arrangement to cut plastic strapping. Never weld on the machine housing nor weld the machine in place. The cutter head assembly is designed to be bolted to the cart and the cart designed to be free-standing. Welding on any part of the cutter head assembly could adversely affect the cutting performance. Failure to follow these warnings may result in voiding of the warranty, damage to the machine, and possibly result in bodily injury.</p>
02.D	Machine Clearances	Suitable clearance must be present around all sides of machine. Install machine at ergonomically suitable infeed height. All controls should be between 36" and 72" high.
02.E	Defects	Machine will be free from defects; small paint discontinuities may be present prior to receiving from testing machine at facility.
02.F	Weather Exposure	No Rain; No Direct Sunlight on UV sensitive rubber components or synthetic components.
02.G	Welding	Do not weld to machine or add components to machine of any kind; may result in voiding warranty. Could damage machine or result in bodily injury.

03	Operating Personnel	
03.A	Requirements	Trained operators and maintenance technicians who have read and understand manual only.
03.B	Req. Clearance	Operators should stay in safe zones outline by company standards and guidelines (if applicable).
03.C	Warning Labels	See <i>Figure 1</i> below for all labels used on Sweed equipment; familiarize yourself with them and their meanings before operation.

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## Sweed Machinery Machine Labels















	GENERAL DANGER		ELECTRICAL HAZARD
	HAND ENTANGLEMENT HAZARD		HOT SURFACE BURN HAZARD
	ELECTRICAL PLUG		READ OPERATOR'S MANUAL BEFORE OPERATING OR SERVICING MACHINE
	WEAR EYE PROTECTION WHEN OPERATING OR SERVICING MACHINE		WEAR HEARING PROTECTION WHEN OPERATING MACHINE
	WEAR GLOVES WHEN OPERATING OR SERVICING MACHINE		LOCKOUT / TAGOUT BEFORE SERVICING MACHINE
	STAND TO SIDE WHEN FEEDING MACHINE		DO NOT OPERATE WITH GUARDING REMOVED
	LIFTING POINT		FORKLIFT POINT

Figure 1

04	Operating Risk / Safety	
04.A	E-Stops	If equipped, when pressed, will de-energize entire system. Once pressed, button must be pulled to reset system.
04.B	Lockout	Never operate or remove any system components that are secure unless the system is electrically locked out and all moving parts are motionless.
04.C	Material Discharge	Do not place hands or stand near material discharge area of machine, as the material is ejecting at high velocities.
04.D	Machine Infeed Opening	While rare, it is possible for processed material to kick out of infeed funnel. Stand to the side when feeding material into machine. Do not look into the infeed funnel when the machine is running. Keep hands out of infeed funnel, as it presents a pinch/crush hazard.

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04.E	Entanglement Hazard	When feeding material into the system, be cautious of entanglements in the scrap material as it is draw into the infeed funnel. This material can hook on clothing and wrap around body parts, pulling the operator towards the machine. If entangled, pull on feedworks handle to open feedworks mechanism.
04.F	Types of Material to be Processed	<p>The CL200 is designed to cut a single strand of continuous plastic banding being fed off a roll. The material listed below is the maximum strength material specified for the CL200:</p> <p><b>· 3/4" x .06" PET Banding (single strand)</b></p> <p>Note: Consult Sweed for materials not covered in the above list. Exceeding the recommended capacity voids manufacturer's warranty.</p>
04.G	Machine Safe-Guards	The machine comes equipped with a feedworks release handle located above the feedworks which can be pulled to release the grip on the material.
04.H	Material Jams	Prior to clearing a jam or performing any maintenance, all motors should be turned off and electrically locked out.
04.I	Machine Guards	Never operate the system unless all guards and covers are in place and secure; do not circumvent any safety switches connected to these guards. Guards should not be removed unless all motors are turned off and electrically locked out.
04.J	Fasteners	Extreme care should be taken to see that all bolts are always properly tightened. During operation of the system, bolts may come loose from vibration and should be checked on a weekly basis.
04.K	Dull knives	For safe operation, do not operate with dull knives.
04.L	Feed Material	This machine is designed to chop strands of plastic banding and steel banding. Do not feed any other materials into the machine without first consulting Sweed Machinery Inc. If a jam should occur, pull back on the feedworks handle to release the pressure on the feedrolls in order to pull the material back out of the infeed opening.
04.M	Cleanliness	The system work area must be kept clean and uncluttered during the periods of operation or maintenance. Clean up any fluid spillages immediately. No tools or other metal objects should be left on or around the machines. Any tools or metal objects that mistakenly fall into the hopper feed opening can cause severe damage to internal cutting chamber, knives, or overall machine.

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04.N	Increased Wear	Possible due to allowing material to spin on feedworks for extended time. Ensure material is not slipping during operation. To large of a knife gap can also contribute to increased knife wear as well as cause structural fatigue of the machine.
04.O	Electrostatic Buildup	If necessary, measures must be taken to dissipate electrostatic build-up on machine, containment bin, or processed material.
04.P	Flammable Material	DO NOT cut flammable material.
04.Q	Access by climbing	DO NOT climb on machines. Use aids or stepladders when repairing/cleaning components out of reach.
04.R	Fall/Trip Hazard	User is to ensure utility connections from electrical wiring, pneumatic hoses and hydraulic lines do not present a slip, trip, or fall hazard.
04.S	Decibel Rating	This machine operates at 73 dB when idling with no material being fed. The decibel rating will increase when material is fed, and will fluctuate depending on type of material, quantity being fed, as well as the location the machine is operating at.

<b>05</b>	<b>PPE Requirements</b>	
05.A	Eye Protection	Required when operating or maintaining machines.
05.B	Hand Protection	Required when handling material being processed or maintaining machines.
05.C	Hearing Protection	Required when operating machines.
05.D	Breathing Protection	May be required if processed material creates airborne dust / fiber when processed.

## OPERATION

This section outlines the machine operation and functions. The CL200 comes equipped with a programmable logic controller (PLC) and human-machine interface (HMI).		
<b>06</b>	<b>Machine Operation (Refer to Figures 2 &amp; 3)</b>	
06.A	Power/ Air	Connect machine to the appropriate voltage power and pneumatic source.
06.B	Starting Machine	The machine was designed to cut continuous strands of banding at user programmed lengths. The cut length can be entered manually on the HMI screen. Once this information is entered start the machine by pressing the start button on the HMI. The machine will now start self-feeding.

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06.C	Stopping Machine	To stop the machine at any time simply press the stop button located on the HMI screen. The machine will also shut down once the batch quantity has reached its limit.
06.D	Resetting Machine	The batch count can be reset by pressing the Batch reset button on the HMI screen. When the machine has been stopped mid-batch then the machine will resume once the start button has been pressed again.
06.E	Batch Count	The Batch Count feature allows the user to enter the number of cuts the machine will perform before it automatically shuts off.
06.F	Note	<p>The CL200 starts it's cycle by first cutting any excess material protruding beyond the knives. This ensures that the first piece cut will be the correct length.</p> <p>While the machine is in operation, several things should be adhered to:</p> <ol style="list-style-type: none"> <li>1. Although the CL200 is capable of pulling banding from a spool, it should never be subjected to shock loading.</li> <li>2. Banding should not be tangled or twisted while being fed into the machine.</li> <li>3. Material should flow freely from the machine after being processed.</li> <li>4. Machine should never be operated without strap being fed into the feedworks. Failure to do so will result in accelerated wear on the infeed roll knurling.</li> </ol> <p>The Sweed Model CL200 Cut-To-Length machine is designed to provide many hours of operation with very little maintenance or up-keep. The replacement parts drawing in this manual shows the parts required of the machine and their corresponding part numbers for reference. Regular inspection of the machine will alert the operator of an existing or pending problem and parts can be purchased before the machine is rendered inoperable.</p>

## MAINTENANCE

This section outlines the machine maintenance and upkeep. Maintenance to only be performed by trained personnel and if the machine has been electrically locked out. Sweed Machinery Inc. recommends end user should establish and maintain a maintenance log that includes the following: bolt check/tightening schedule, lubrication schedule and knife rotation/replacement schedule. All Figure #'s located in Appendix A.

07	Lubrication	All machine components come pre-lubricated from the factory and do not require any supplemental grease before service.
07.A	Bearing Lubrication	#2 NLGL or Multipurpose ball bearing grease, add slowly to prevent damage to bearing seals. Add grease until slight leakage seeps past seals.

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07.B	Lubrication Time Interval	
	Run Time:	Lubrication Frequency:
	8 hrs./day	All bearings every 12 weeks.
	16 hrs./day	All bearings every 7 weeks.
	24 hrs./day	All bearings every 5 weeks.

### Knife Rotation and Replacement

08	Dynamic & Stationary Knife	<p><b>When replacing or rotating knives, always use new knife bolts (See replacement parts list). Failure to do so can result in knife damage and or injury. Rotating knives is on a visual inspection basis. If a knife edge becomes dull or a knife gap is out of spec, it is time to rotate the knives and reset the knife gap.</b></p> <ul style="list-style-type: none"> <li>· The knives are produced from hardened tool steel for maximum performance and life.</li> <li>· The stationary knife cannot be rotated, but can be sharpened with a machine grinding process. Contact Sweed Machinery, Inc. for sharpening information.</li> <li>· The dynamic knife can be rotated once but cannot be sharpened.</li> <li>· The unique cut-down / cut-up design of the CL200 means the cutting action is divided over two sets of cutting edges, essentially doubling the amount of time between knife rotations (versus a single cutting edge design).</li> <li>· After many cuts a dull edge may reduce the quality of the cut or may prevent cutting altogether.</li> </ul>
	Step 1	Lockout/tag out power. Unplug the Air supply to the cylinder.
	Step 2	Unbolt the rear guard and remove from machine.
	Step 3	Remove the air supply tubes to the air cylinder by pressing down on the fitting's collar and pulling out on the tube.
	Step 4	Remove the (4) bolts mounting the cutter head assembly to the feedworks and move the assembly to a workbench.
	Step 5	Replace and/or rotate the traveling knife: <ol style="list-style-type: none"> <li>1. Remove the (2) traveling knife bolts and remove knife.</li> <li>2. Blow out and wipe down knife pocket to clear it of any debris.</li> <li>3. Re-bolt the knife to the knife pocket with the sharp side against the stationary knife. Torque the 1/4-20 Grade 8 socket head cap screws to 12 ft-lbs. dry (no lube), 9 ft-lbs. lubricated. Use caution not to over-torque the knife bolts.</li> </ol>

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Step 5 Cont.	<p>Replace the stationary knife:</p> <ol style="list-style-type: none"> <li>1. Remove the (4) stationary knife bolts.</li> <li>2. Blow out and wipe down knife pocket to clear it of any debris.</li> <li>3. Bolt a new or sharpened stationary knife to the knife pocket with the sharp side against the traveling knife. Torque the 1/4-20 Grade 8 socket head cap screws to 12 ft-lbs. dry (no lube), 9 ft-lbs. lubricated. Use caution not to over-torque the knife bolts.</li> </ol>
Step 6	<p>Inspect the knife gap by pushing/pulling the traveling knife along its path. The correct gap (less than .003" using a feeler gauge) is one where the same bit of drag can be felt between the knives during the entire length of travel while still easily moved by hand. <i>See Section 10</i> for adjusting the knife gap.</p>
Step 7	<p>Bolt cutter head assembly back into place using thread locking compound, making sure the mounting surfaces are clean of any debris.</p>
Step 8	<p>Check knife gap again before reconnecting air cylinder tubes and rear guard.</p>

### Gap Adjustments

10	Knife Gap	
	Function	<p>Normal operation and rotation/replacement of knives do not necessitate knife gap adjustment. However, if the traveling knife holder and/or cutting cylinder are removed, it is necessary to reset the knife gap. Knife gap adjustment should always be done with both knives having been rotated and/or replaced to fresh edges.</p> <p>The CL200 traveling knife is designed to run vertically, parallel to the surface of the stationary knife. Although the traveling knife may rub against the stationary knife as it moves, it should never be forced against the stationary knife. The eccentric cam followers along with the air cylinder adjustment screws are used to adjust the knife gap. The cam followers should never be adjusted so tight against the housing side plate cam slot that they are not able to spin freely.</p>
	<b>Use the following steps to set the proper knife gap:</b>	
	Step 1	Remove cutter head assembly from machine and move to a workbench. <i>See Figures 4a – 4b.</i>
	Step 2	Locate the traveling knife at the bottom of the cylinder stroke.

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	Step 3	Loosen air cylinder adjustment jam nuts and grub screws.
	Step 4	Locate air cylinder trunnion studs roughly in the center of the adjustment slot.
	Step 5	Snug the grub screws up against the trunnion stud.
	Step 6	Loosen the cam follower using a hex wrench and an open-end wrench on its interior nylock nut.
	Step 7	Turn the hex wrench until the cam follower contacts the side plate slot, reducing the knife gap to less than .003". Repeat on the opposite side.
	Step 8	Locate the traveling knife at the top of the cylinder stroke.
	Step 9	Adjust the cylinder adjustment screws in small increments to adjust the knife gap to less than .003".
	Step 10	Further adjustments will may likely be necessary in small increments at both the top and bottom of the cylinder stroke using the cam followers and cylinder adjustment screws to achieve a uniform knife gap along the entire stroke length.
	Step 11	Lock down the cam follower's nylock nuts and the cylinder adjustment jam nuts.
	Step 12	Recheck knife gap.
11	<b>Feedroll Gap</b>	
	Function	This is the gap between the roll contact surfaces. <b>DO NOT</b> allow the upper roll and lower roll to contact one another for an extended period. If the rolls are touching, turn off the machine immediately and adjust the feedroll gap. Operating the machine with the rolls in contact will rapidly erode the knurling on the rolls, reducing material feeding efficiency.
	Step 1	To change the feedroll gap, adjust the two screws located on the upper feedroll bracket. Turning the screws clockwise will increase the roll gap and counterclockwise decreases the gap. Adjust the screws to obtain an even gap across the full width of the roll. <i>(See Figure 5)</i>
	Note	<b>The gap needs to be at least half the thickness of the thinnest material processed.</b>
12	<b>Air Supply Maintenance</b> <i>(Refer to Figure 7)</i>	
12.A	<b>Lubricator</b>	The machine's air lubricator should be filled on a regular basis with a light oil suitable for any air tools; doing so will prolong the life of the air valve and cylinder.
	Step 1	Disconnect power and compressed air supply to the machine.
	Step 2	Unscrew retaining collar and remove oil reservoir.

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	Step 3	Fill oil reservoir to fill line indicated on reservoir.
	Step 4	Reconnect reservoir.
	Note:	Turn the knob, as the markings indicate, on top of the air lubricator to achieve the desired flow of oil into the air stream.
12.B	Filter	Inspect and empty the air supply filter on a regular basis to help keep moisture out of the CL200 pneumatic system.
	Step 1	Disconnect power and compressed air supply to the machine.
	Step 2	Loosen the stopcock at the bottom of the filter to allow water to purge.
	Step 3	Tighten the stopcock.
12.C	Regulator	Adjustments to the air pressure firing the cutting cylinder may need to be made as the knife edges break-in and wear through their life cycle. If the cutter stalls or struggles to cut through the strapping, follow the procedure below to set the correct cutter pressure:
	Step 1	Check that the facility's compressed air supply pressure is greater than 80 PSI.
	Step 2	Unlock the regulator by lifting up on the adjustment knob.
	Step 3	Using the HMI, set the batch size to 10 and the cut length to 8 inches.
	Step 4	With the program running, turn the regulator adjustment knob until the machine easily cycles through its cuts.
	Step 5	Push down on the adjustment knob to lock the pressure setting.
13	Tightening Schedule	<b>Failure to do so may result in damage to the machine, injury to the operator and/or voiding of the machine's warranty.</b>
	Function	Due to the vibratory impact associated with the Sweed Machinery Inc machines, it is imperative to follow a strict bolt tightening schedule. Failure to do so may result in damage to the machine, injury to the operator and/or voiding of the machine's warranty.
	Shipping	Inspect the machine after shipping before operating; fasteners may have loosened during shipping.
	Break-In Period	Inspect and tighten loose fasteners after a break-in period of 8 hours.
	60 Hours Operation	Inspect and tighten loose fasteners every 60 hours of machine operation after break-in period.
	Incrementally	Always tighten fasteners incrementally in a pattern up to the torque specifications where applicable.
	Table	Critical fasteners and their required torque specs are listed in the table below:

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<b>14</b>	<b>Bolt Torque Specifications</b>	
	Knife Bolts Initial Torque	15-20 ft-lb (0.15 max friction coefficient lubricant req.)
	Knife Bolts Final Torque	38 ft-lb
	Cylinder Mount Bolts	38 ft-lb

<b>15</b>	<b>Trouble Shooting</b>	
	<b>Problem</b>	<b>Solution</b>
<b>15.A</b>	<b>Material Feeding Stops</b>	
	Too large of a gap exists between the feed rolls for the material being fed	Adjust the set screw on the top of the feedworks to close the feedroll gap
	Banding is twisted or bent	Straighten out bent portion or remove it entirely
	Worn feedrolls	Replace the worn feedrolls
<b>15.B</b>	<b>Machine Fails to Cut</b>	
	Material is too large for machine	Run appropriately sized material into the machine
	Poor knife gap	Inspect knife gap to ensure it is within tolerance
	Knife edges are dull	Rotate or replace knives
	Air Pressure too low	See Section 12 for adjusting air pressure
<b>15.C</b>	<b>Cut length Incorrect</b>	
	Material Slips	Reduce drag on supply spool
		Replace Feedroll
		Adjust Feedroll gap
		Proximity switch is loose, adjust and tighten
<b>15.D</b>	<b>Machine will not start/stop running</b>	

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	Motor protection tripped	Reset motor
	Broken drive belt	Replace belt
	Failed electrical service	Check circuit power
	Switch failure	Replace switch

<b>16</b>	<b>Recommended Spare Parts List</b>	
QTY	Part#	Description
1	KX000299	DYNAMIC KNIFE KIT CL200
1	KX000302	STATIONARY KNIFE KIT CL200
1	AB055494	IDLER ROLL ASSEMBLY
1	CB027942	DRIVE FEEDROLL, KNURLED

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## HMI HOME SCREEN

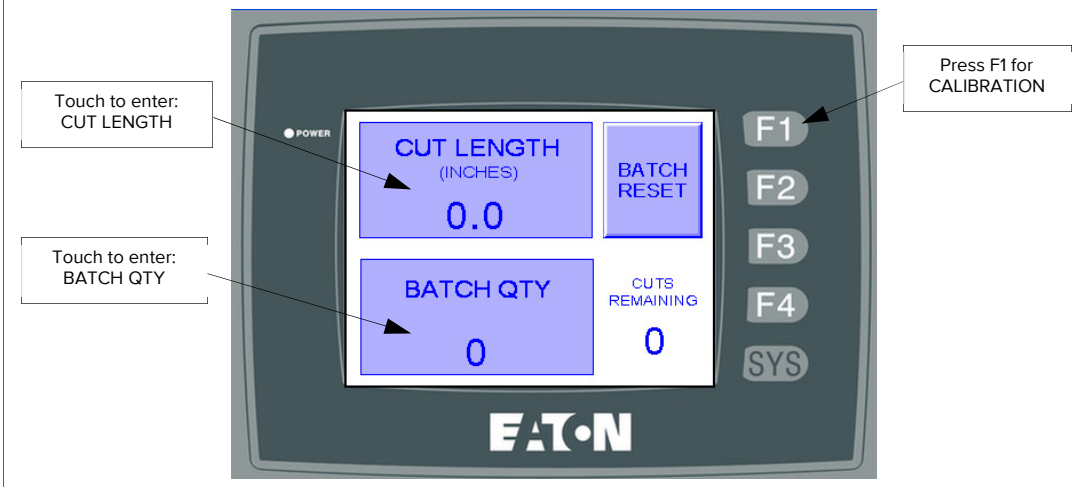


Figure 2

## HMI CALIBRATION

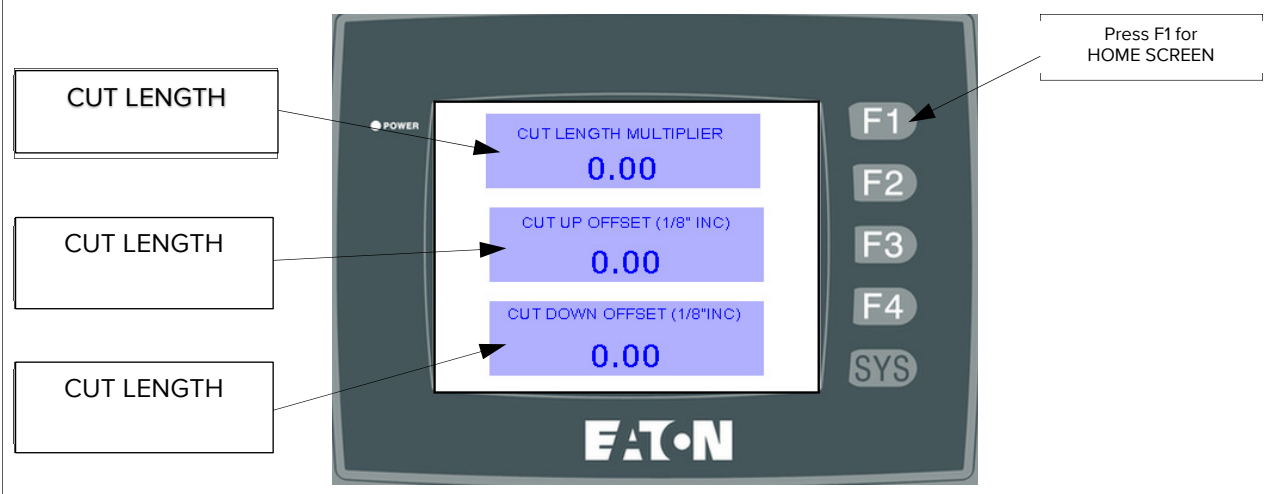
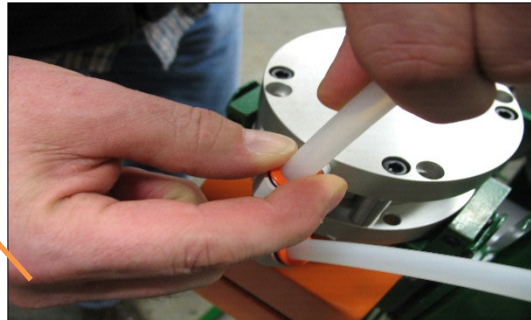


Figure 3

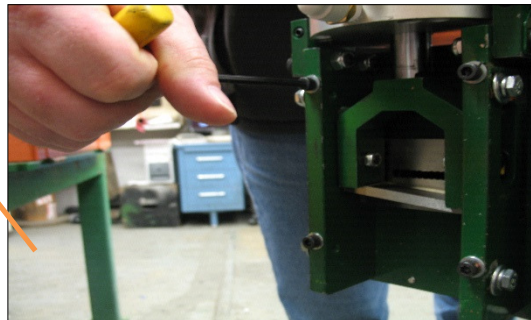
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Figure 4a



REMOVING AIR SUPPLY TUBES

Figure 4b



REMOVING MOUNTING BOLTS

Figure 4c



REMOVING KNIFE BOLTS

Figure 4

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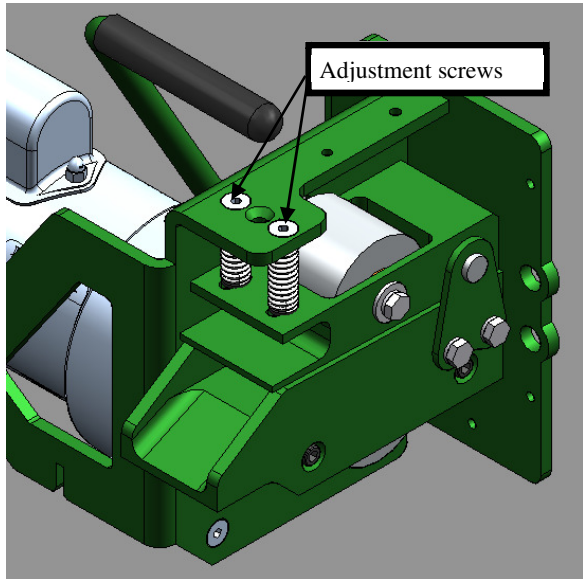


Figure 5

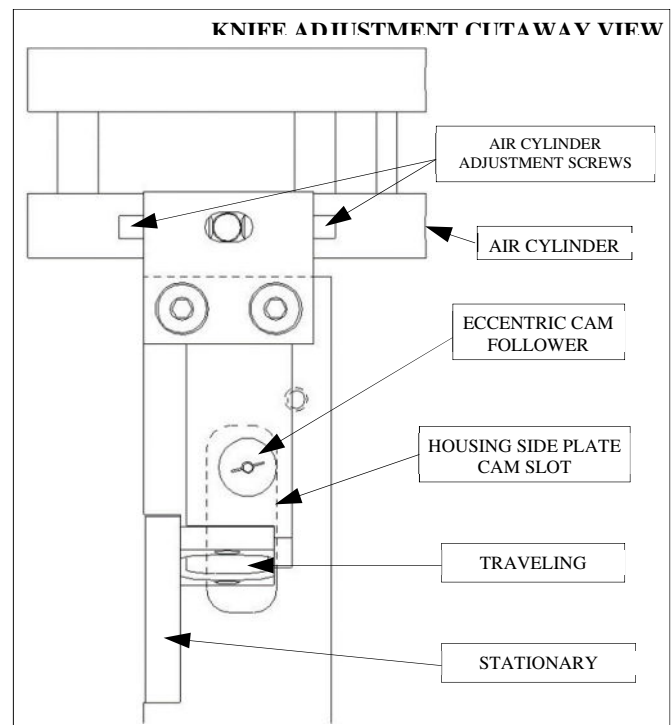


Figure 6

## AIR SUPPLY CONTROLS

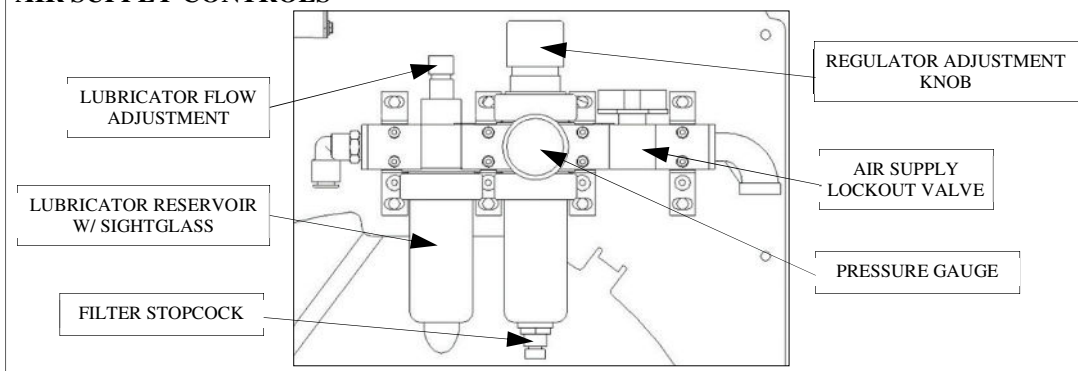


Figure 7

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### WARRANTY

SWEED MACHINERY, INC WARRANTIES AGAINST DEFECTS AND WORKMANSHIP FOR A PERIOD OF ONE YEAR FROM DATE OF SHIPMENT ON ALL NEW MACHINES AND 90 DAYS ON REFURBISHED MACHINES. PARTS CLAIMED TO BE DEFECTIVE MUST BE RETURNED, FREIGHT PREPAID, TO OUR PLANT IN GOLD HILL, OREGON. ANY PARTS DETERMINED DEFECTIVE DUE TO FAULTY WORKMANSHIP OR MATERIALS WILL BE REPLACED OR REPAIRED ( AT OUR OPTION ) FREE OF CHARGE, F.O.B. OUR PLANT. EXCEPT AS EXPRESSLY PROVIDED HEREIN, THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING A WARRANTY OF MERCHANT ABILITY OF FITNESS FOR A PARTICULAR PURPOSE. THIS WARRANTY IS VOID IF THE UNIT HAS BEEN TAMPERED WITH, MODIFIED, ALTERED, OR OPERATED WITH PARTS OTHER THAN SUPPLIED OR RECOMMENDED BY SWEED MACHINERY, INC. IN NO EVENT SHALL SWEED MACHINERY, INC., BE LIABLE FOR SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES, HOWEVER ARISING.

SWEED MACHINERY, INC DOES NOT WARRANTY TO MEET THE REQUIREMENTS OF ANY SAFETY CODES OF ANY STATE, MUNICIPALITY, OR OTHER JURISDICTION, AND THE PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER RESULTING FROM THE USE THEREOF WHETHER USED SINGULARLY OR IN COMBINATION WITH OTHER MACHINERY OR APPARATUS.

ANY CHANGE IN MATERIALS, DESIGN, OR PERFORMANCE INTENDED TO IMPROVE ANY PRODUCT OF SWEED MACHINERY, INC., SHALL NOT OBLIGATE SWEED MACHINERY, INC. TO MODIFY ANY PREVIOUSLY MANUFACTURED EQUIPMENT.

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**NOTE: ALL RETURNED MATERIAL MUST BE ACCOMPANIED BY A SWEED RETURN MATERIAL (RMA) AUTHORIZATION NUMBER. PLEASE CALL OUR SERVICE DEPARTMENT AT 1-800-888-1352 IF YOU NEED ASSISTANCE.**

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