

Wavy Cut

(A) Vertical shading across edge of lift can be seen or felt as wavy areas.

Cause

Heavy print in certain areas causes large thickness differences across the sheets. This produces uneven clamp pressure in areas of dense print. Knife finds these areas harder to cut since they are packed tighter and deflects slightly.

Correction

Even distribute clamp pressure by applying felt or foam pad to face of clamp.

Cause

Knife burned in grinding which caused soft spots that dull too easily.

Correction

Regrind knife correctly taking of at least 1/16" width to remove damaged steel.

Cause

Knife angle too sharp causing deflection in high density areas.

Correction

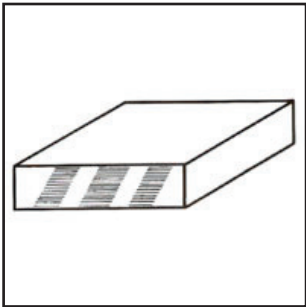
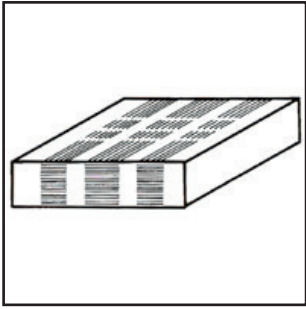
Increase bevel angle by 2°, i.e., 22° to 24°

Cause

Inconsistent paper quality thickness.

Correction

Change paper.



(B) Diagonal shaded areas in direction of knife travel can be seen or felt.

Cause

Knife bevel too sharp and deflects easily.

Correction

Increase bevel angle by 2°, i.e., 22° to 24°.

Cause

Knife burned in grinding which caused soft spots that dull too easily.

Correction

Regrind knife correctly taking of at least 1/16" width to remove damaged steel.

Overcut

Overcut is when the lower sheets in the lift are longer than the top sheets after trimming.

Cause

Dull Knife.

Correction

Change Knife.

Cause

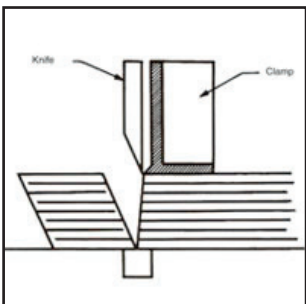
Wrong bevel on knife.

Correction

Decrease bevel.

Cause

Too much clamp pressure - as knife gets further into lift of paper the density increases causing deflection of knife.



Correction

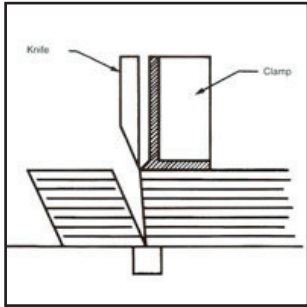
Reduce clamp pressure.

Cause

Back gauge not set square to vertical.

Correction

Correct back gauge.



Undercut

Undercut is when the lower sheets in the lift are shorter than the upper sheets after trimming.

Cause

Clamp pressure too low causing sheets to pull out at bottom.

Correction

Increase clamp pressure.

Cause

Wrong bevel on knife.

Correction

Decrease bevel.

Cause

Rough or uneven material being cut, such as gummed labels or embossed stock.

Correction

Adjust clamp pressure.

Cause

Back gauge not set square to vertical.

Correction

Correct back gauge setting.

Hollow Cut

Sheets of paper are longer at ends and shorter in the centre (not cut square).

Cause

Lift is clamped only at ends of paper and not in the middle.

Correction

Check clamp edge and apply felt or foam pad to distribute clamp pressure.

Arc Cut

Sheets of paper are shorter at ends and longer in the centre.

Cause

Lift is clamped only at centre and not at ends of sheets.

Correction

Check clamp edge and apply felt or foam pad to distribute clamp pressure.

Knife Rubbing

Knife face rubs clamp causing scratches on knife face and clamp.

Cause

Knife is dull.

Correction

Resharpen knife more often.

Cause

Knife too thick.

Correction

Decrease knife thickness.

Cause

Wrong bevel.

Correction

Decrease bevel.

Cause

Gibs worn on cutter.

Correction

Repair machine.

Cause

Combinations of above plus lifts too high.

Correction

Reduce size of lifts being cut and look for improvement.

Knife Nicks Badly

Knife Nicks Badly.

Cause

Knife at wrong bevel.

Correction

Increase bevel angle by 2°, i.e., 22° to 24°.

Cause

Knife burned in grinding producing small heat cracks which chip out.

Correction

Regrind knife correctly taking off at least 1/16" width to remove damaged steel.

Cause

Knife set too deeply into cutting stick or stick groove has trash in it.

Correction

Rotate to fresh stick surface and set depth of cut correctly (max. 0.1mm / 0.004").

Cause

Poor cutting sticks.

Correction

Choose better quality stick. Use FASSCO YELLOW stick.

Cause

Contaminated chip board.

Correction

Try increasing bevel, do not use carbide knives.