

Perforator Problem Solving Tips-n-Hints

Problem	What to look for...	What should you do...
Stock is "two sheeting"	a. Caliper.	a. Adjust feed caliper down to single sheet thickness.
Stock does not feed or feeds very slowly	a. Feed rolls may be loaded. b. Side guide clearance. c. Too much stock on feed table. d. Feed roll may be worn out.	a. Clean glaze from feed rolls with alcohol. b. Loosen side guides slightly to provide proper clearance. c. Remove excess stock from feed tables. d. Replace worn out feed rolls.
Perforation is straight but does not register	a. Side guides may not be square. b. Check for excessive or tight side guide clearance.	a. Readjust side guide alignment. b. Readjust side guides accordingly.
Perforation is straight except for last 3"	a. Burr rollers may not be square. b. Burr rollers should be used on both stock edges.	a. Square burr rollers. b. Make sure both burr rollers are being used and spaced same distance from sheet edge.
Perforation path is "bowed"	a. Check setting of both upper and lower cutter heads.	a. Replace dull cutters.
Stock does not deliver properly	a. Delivery table angle. b. Speed of machine.	a. Change delivery table angle. b. Change stock feed speed.
Front edge of perforation is torn	a. Check for clearance on caliper. b. Check for even pull on drive rolls. c. Side guides are too tight.	a. Readjust stock backstop. b. Readjust drive rolls. c. Loosen side guides slightly to provide proper clearance.
Secondary feed rolls scuffing	a. Friction feed caliper. b. Too much stock on feed table.	a. Readjust caliper. b. Remove excess stock from feed table.