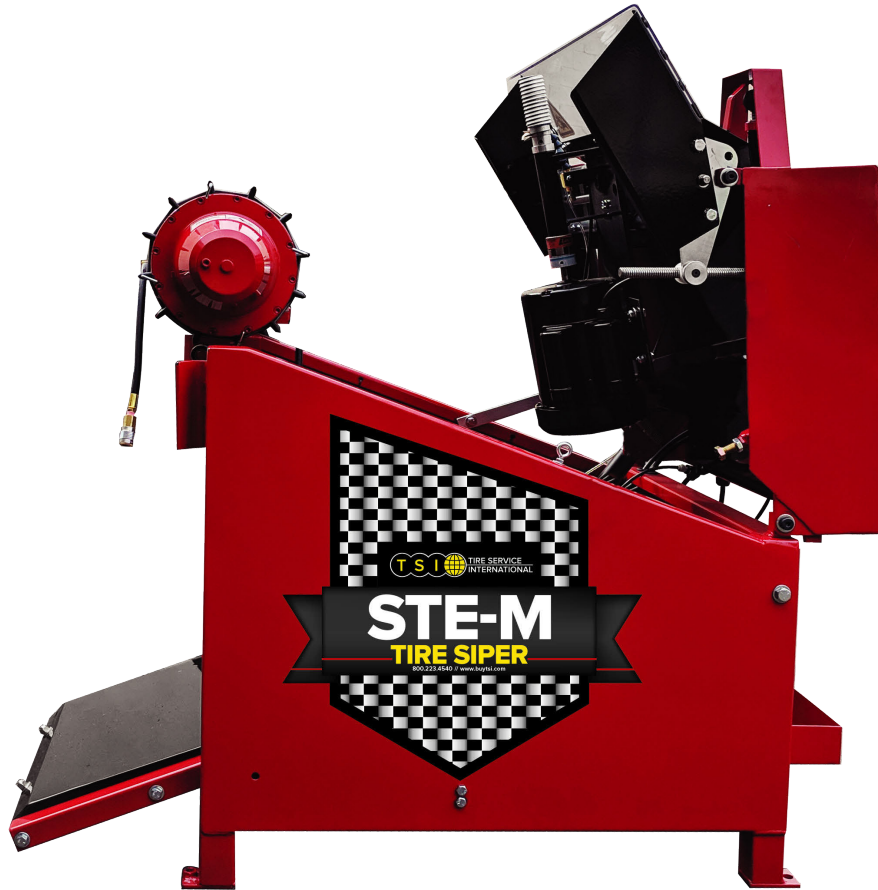


OPERATION & TROUBLESHOOTING

STE-M AUTOMATIC CYCLE FEED



July 01, 2019

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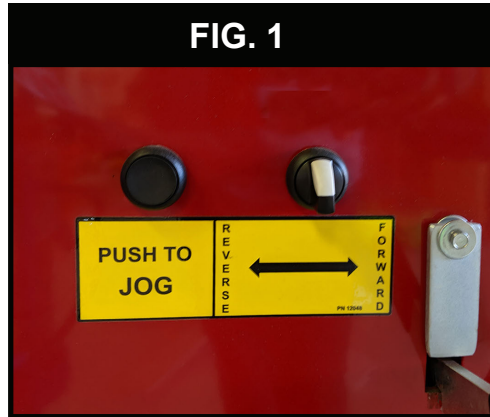
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TIRE SIPING MACHINE

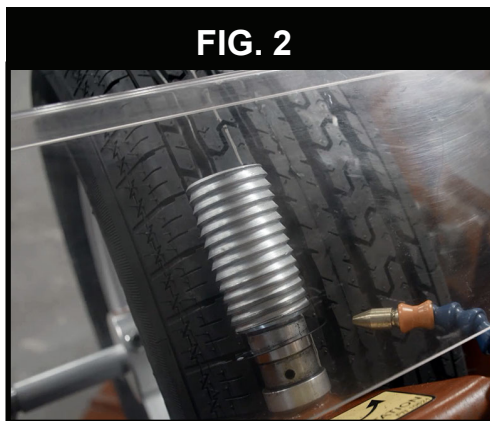
OPTIONS - STE-M AUTOMATIC CYCLE FEED

OPERATION - #6005



STEP 1.

Turn switch to the left to reverse motor into position on the tire to be siped.
See (Fig. 1)



Approximate blade guide positioning shown on tire.
See (Fig. 2)

Position blade at same starting position as with the manual crank machine.



STEP 2.

Squeeze handle switch to start machine operation. Engage spray unit mist. After tire turns one revolution PRESS TO JOG BUTTON to move blade guide set over to proper cutting row position.
See (Fig. 3)

**Repeat this operation until complete tire is siped.

TIRE SIPING MACHINE

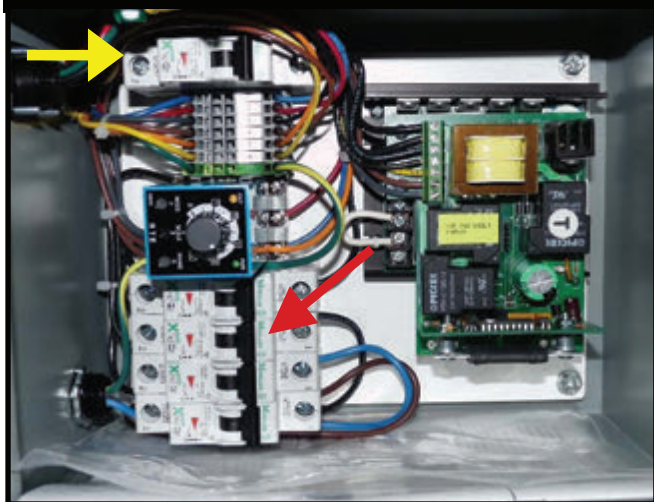
OPTIONS - STE-M AUTOMATIC CYCLE FEED

AUTOFEED CONTROL BOX BASICS - TROUBLESHOOTING



Disconnect power before opening control box

FIG. 1 - INSIDE OF CONTROL BOX

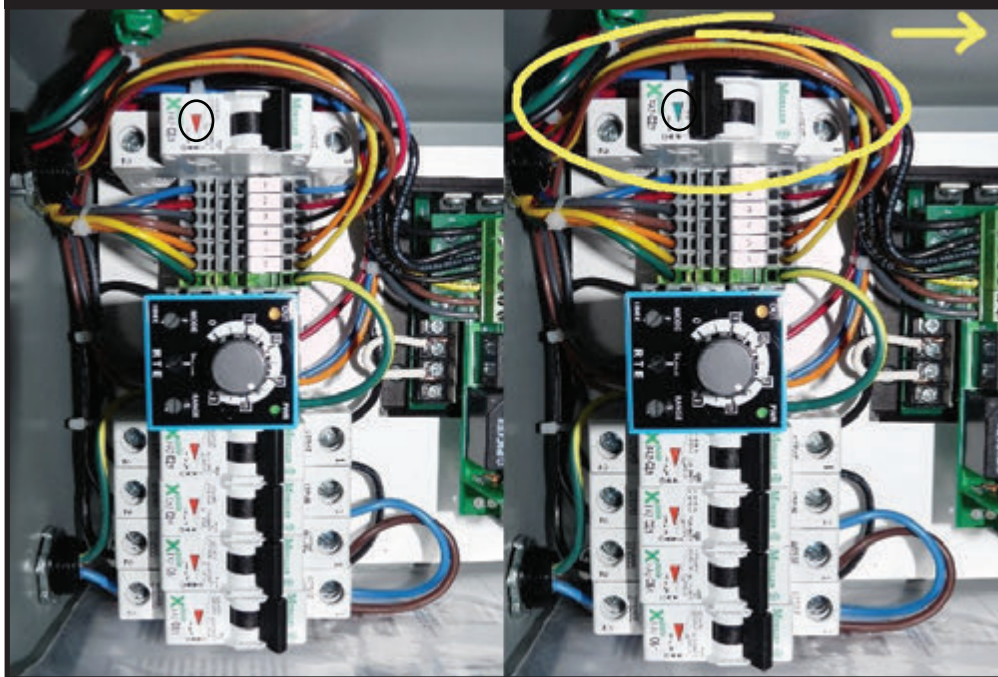


NOTE: Prior to shipping, the electronic components in each control box are factory set, tested and approved for optimum performance.

If, upon installing a Siper STE-M with an Automatic Cycle Feed (ACF) feature and it fails to work, please review this guideline.

Disconnect your power source. Open the control box located on the side of the machine. Visually check to see if the breaker has 'tripped.' Reset the breaker.

FIG. 2 - YELLOW CIRCLE INDICATES THE BREAKER 'TRIPPED'



In Fig. 2 a circuit breaker is tripped (circled in yellow). Note the position of the toggle switch and the red arrow changing to green. If any breakers 'trip,' flip the toggle and return it to an "ON" position

TIRE SIPING MACHINE

OPTIONS - STE-M AUTOMATIC CYCLE FEED

AUTOFEED CONTROL BOX BASICS - TROUBLESHOOTING



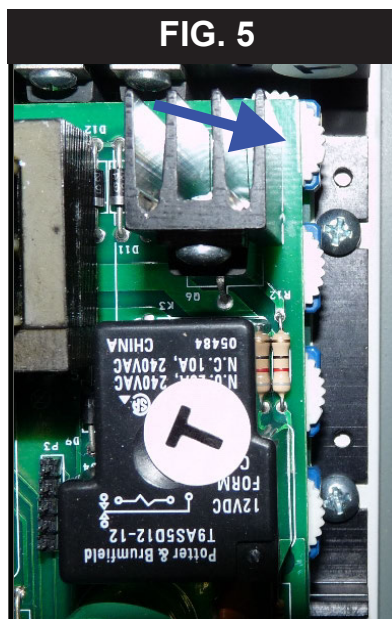
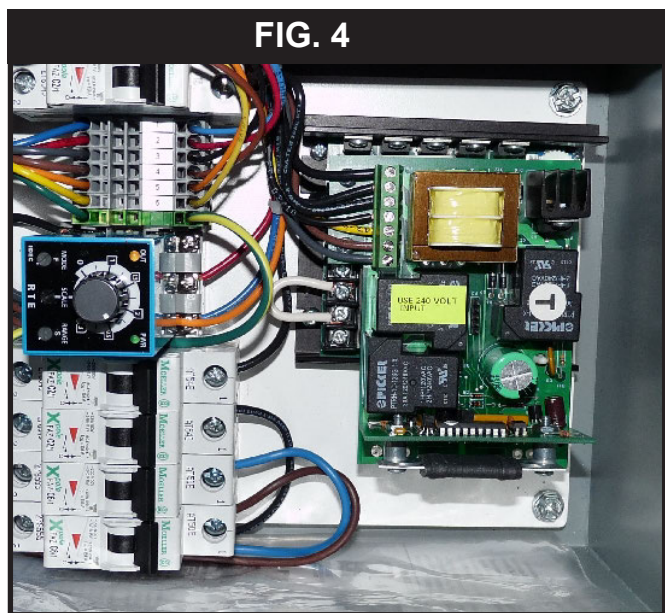
Reconnect power to the unit and turn "ON."

Look for a green light indicating the power is ON.
See green arrow. (Fig. 3)

If the green light is not on recheck the breakers.

FYI: The orange arrow points to where an orange light comes on when the unit is in "JOG" mode. This should not be a factor but that's what the orange light is for. The dial changes the Jog distance. This too is a pre-set and should not be a factor.

The photos below identify the PC board in the control box. (Fig. 4 & 5)
There are four adjustment wheels that are key to setting the Siper Autofeed.



POWER

PULSE/ SURGE

This procedure covers adjusting the first wheel, power and possibly the second wheel, pulse/surge.
Only change one of these at a time and ONLY one notch at a time.

See Fig. 5 and turn wheel clock wise one notch.

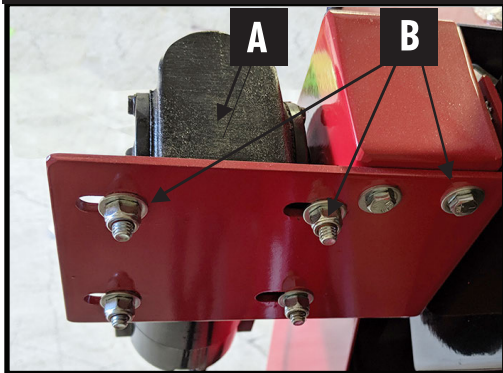
It may be necessary to adjust the power setting by as many as 3 notches. Once the gear motor begins operating it may operate intermittently. Turn pulse adjustment wheel one notch counter clockwise. Fine tune this setting one notch at a time.

When complete close and secure the control box cover.

TIRE SIPING MACHINE

OPTIONS - STE-M AUTOMATIC CYCLE FEED

FIG. 1

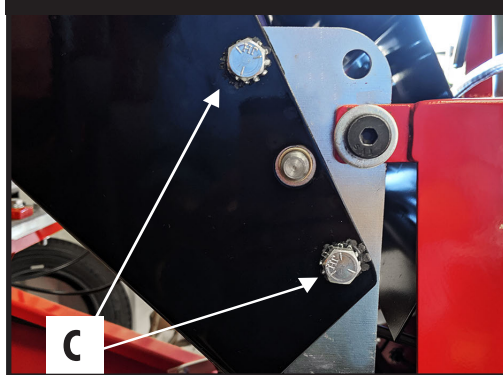


MOTOR GUIDE ADJUSTMENT:

Occasionally due to machine use and movement the cross feed guide bars may become misaligned causing the right angle motor (Fig I. A) to pull hard and blow a fuse. Unplug the unit.

To realign, loosen cap screw (Fig. 2C) reposition guide bars so they are parallel and retighten.

FIG. 2



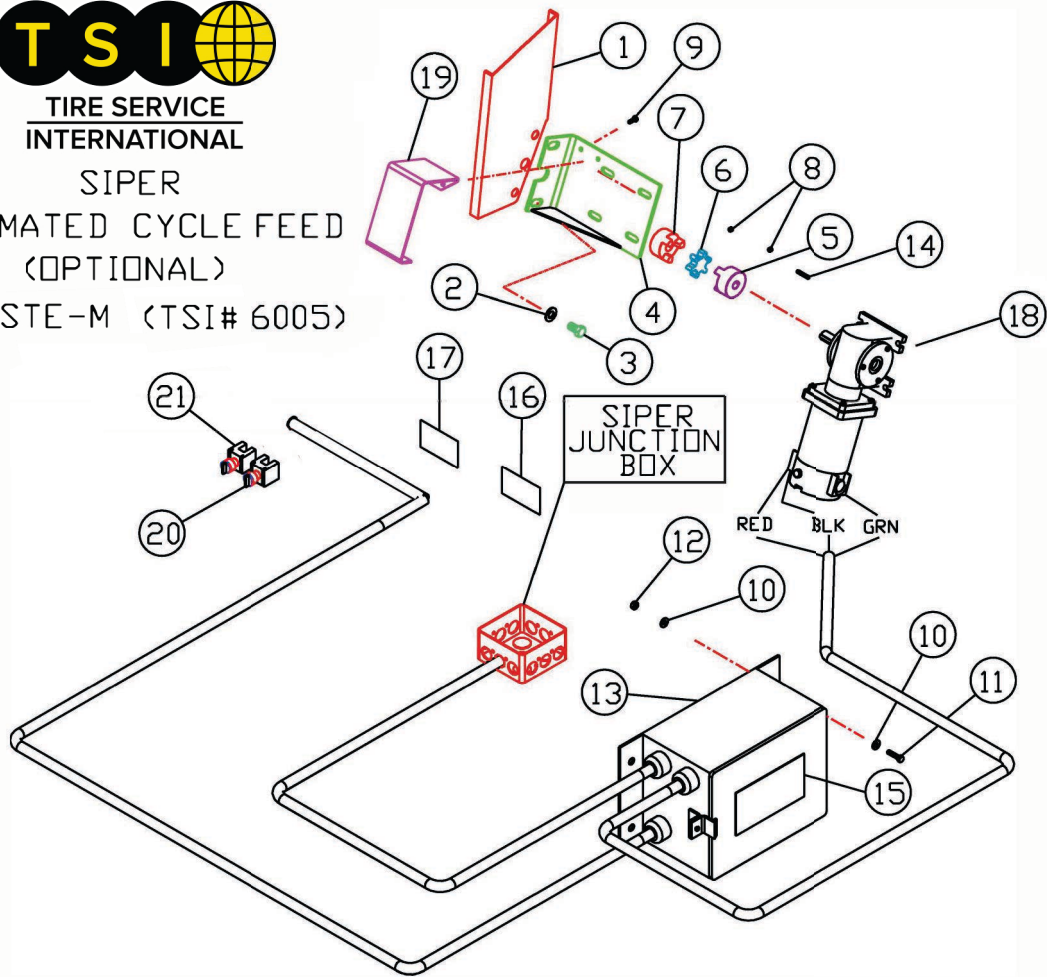
MANUAL OPERATION:

Please remove motor (Fig. 1A) by loosening bolts and nuts (Fig. 1B) and replace with the manual crank.



**TIRE SERVICE
INTERNATIONAL**

SIPER
AUTOMATED CYCLE FEED
(OPTIONAL)
ACF-STE-M (TSI# 6005)



PARTS LIST

ITEM	PART NO.	DESCRIPTION	QTY
1	4461L	GUARD, SIDE (L.H.) [PART OF SIPER]	1
2	5.108	LOCK WASHER STAR EXT. 7/16	2
3	10896	CAP SCREW 7/16-20 X 1	2
4	6017	BRACKET, MOTOR	1
5	10959	COUPLER 5/8 DIA. BORE	1
6	10961	SPIDER	1
7	10960	COUPLER 1/2 DIA. BORE	1
8	4241	SET SCREW 1/4-20 X 1/4	2
9	903	CAP SCREW 1/4-20 X 3/4	4
10	445	WASHER 1/4	12
11	444	CAP SCREW 1/4-20 X 1	8
12	214	NUT, HEX 1/4-20	6
13	10893	AUTOMATED CYCLE FEED CONTROL BOX	1
14	33.251	KEY 1/8 X 3/4	1
15	10872	DECAL, CAUTION ELECTRICAL	1
16	10870	DECAL, JOG	1
17	10869	DECAL, FORWARD/REVERSE	1
18	10894	GEAR MOTOR	1
19	10956	BRACKET, COUPLING COVER	1
20	10957	SWITCH, JOG	1
21	10958	SWITCH, FORWARD/REVERSE	1