

## Die Blade Procedure

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### **Bottom Blade Block**

Remove bottom blade block according to Section 10 of the operator's manual.

Remove both strip blades.

Install die blades with the beveled edge towards the inside of the blade block. Install the 1.5mm spacer (part # 003015) in front of the blade towards the outside of the blade block. Refer to drawing #1. Secure all screws.

### **Top Blade Block**

Remove blade block according to Section 10 of the operator's manual.

Remove both strip blades. Install die blades with the beveled edge towards the inside of the blade block. Install the guide plate in front of the blade towards the outside of the blade block. Refer to drawing #2. Secure all screws.

### **Configuring Die Blades in TOPWIN**

Go to configuration menu.

Click on the wire drive.

Click on the tab for the knife unit.

Select (FORM BLADE).

You will now need to re-calibrate the machine according to Section 10 of the operator's manual. Before completing the step for the pull-off side

2. You will have to back up the swivel head to compensate for the guide plate or else the swivel head will rub on the blade securing screw.

# GAMMA 333PC

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### **IMPORTANT NOTE:**

To be sure that the swivel head is not going to rub against the blade block, the following steps must be performed.

Create a wire utilizing the press on side 2.

Use the smallest wire overhang possible.

Single step the machine until you reach the step where the strip blade cuts the insulation but the strip is not executed yet.

Now look and see how much clearance is between the swivel head and the blade block. Ideally you will want the swivel head to be as close as possible to the blade block without any possibility of rubbing.