

## SuperShuttle QA Check List

Serial # \_\_\_\_\_ Date \_\_\_\_\_

Shuttle Type \_\_\_\_\_ Order # \_\_\_\_\_

Customer \_\_\_\_\_

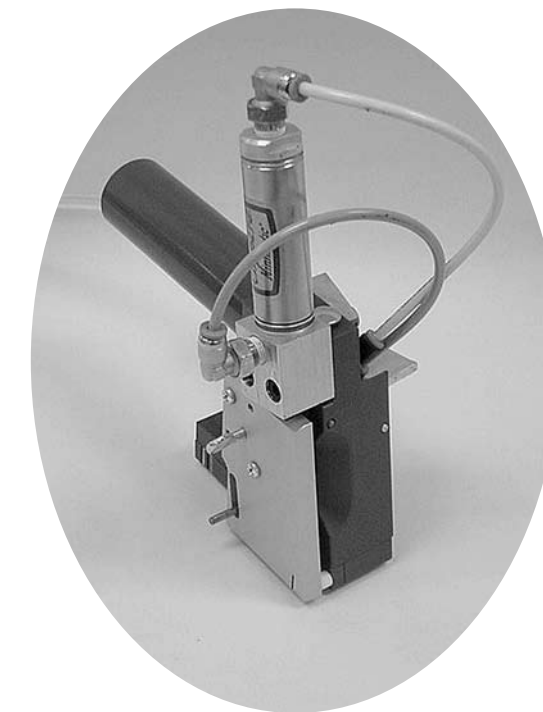
Check Points	QA #1	Comments
Tighten <b>Screws</b>	<input type="checkbox"/>	_____
Tighten <b>Handle</b>	<input type="checkbox"/>	_____
Set <b>Notcher</b> depth	<input type="checkbox"/>	_____
Verify <b>Cutting Blade</b> engagement	<input type="checkbox"/>	_____
Check for air leaks	<input type="checkbox"/>	_____
Secure <b>Punch Collar</b>	<input type="checkbox"/>	_____
Verify that proper <b>Offset Kit</b> is installed	<input type="checkbox"/>	_____
Verify that proper <b>Faceplate</b> is installed	<input type="checkbox"/>	_____
Verify that <b>Pressure Wheel</b> spins freely	<input type="checkbox"/>	_____
Verify that <b>Pressure Holder</b> moves freely	<input type="checkbox"/>	_____
Verify that <b>Spacer</b> moves freely	<input type="checkbox"/>	_____
Perform <b>Spacer Notching Test</b>	<input type="checkbox"/>	_____

QA Signature #1 \_\_\_\_\_

# SuperShuttle

Operator's Manual

Series 100



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Rev. 05/2010

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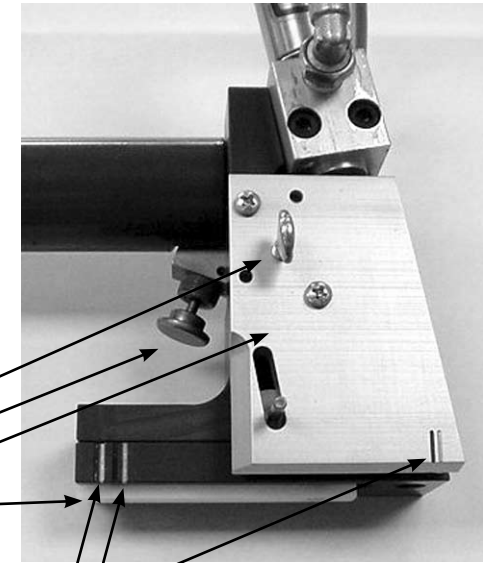
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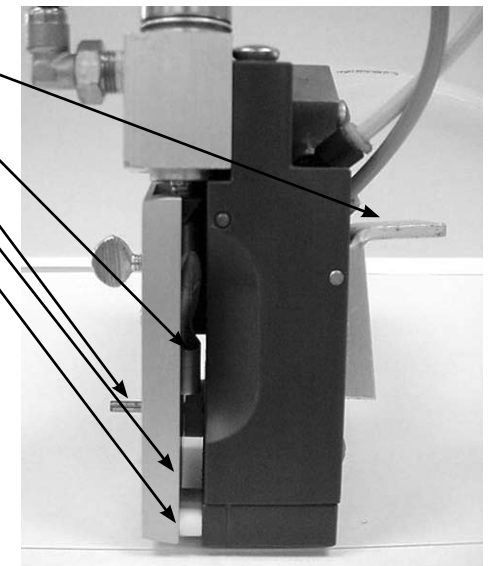
- A .....Pressure Wheel Adjustment Screw
- F .....Notcher Punch Trigger
- I .....Faceplate
- E .....Guide Block



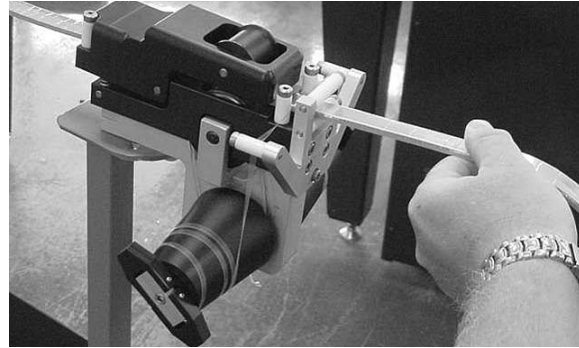
X Y Z

\*\*For different spacer setback distances, use the red X,Y and Z marks for 3/16" (4.76mm) and the yellow X,Y and Z marks for 1/4" (6.35mm) setback.

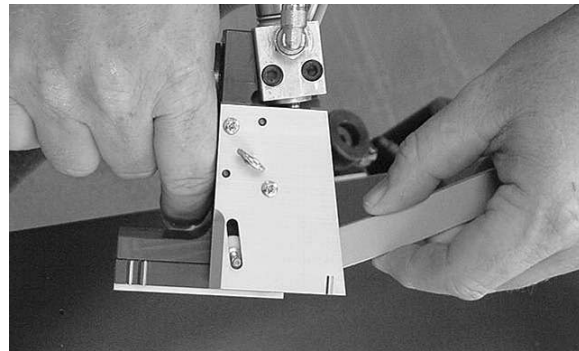
- H .....Cutting Blade Trigger
- G .....Notcher Punch
- B .....Pressure Wheel Extension Pin
- D .....Pressure Wheel
- C .....Guide Roller



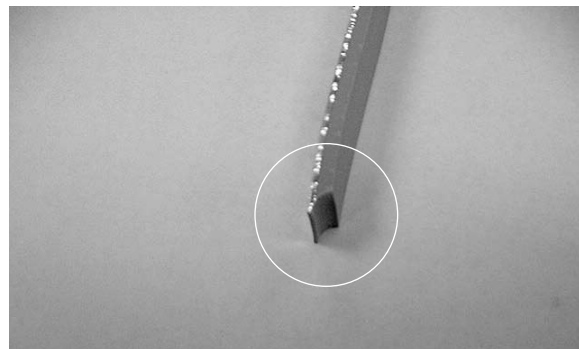
## Operating the SuperShuttle



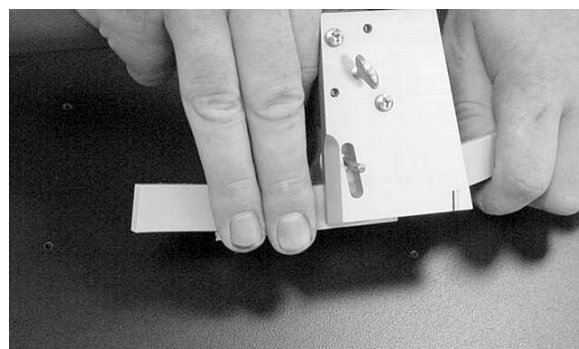
1. Feed the spacer through the liner stripper as directed in the Liner Stripper Operator's Manual.



2. With foil surface facing the operator, insert spacer between the pressure wheel and the guide roller.



3. When starting a new roll, the spacer must be prenotched and sliced.



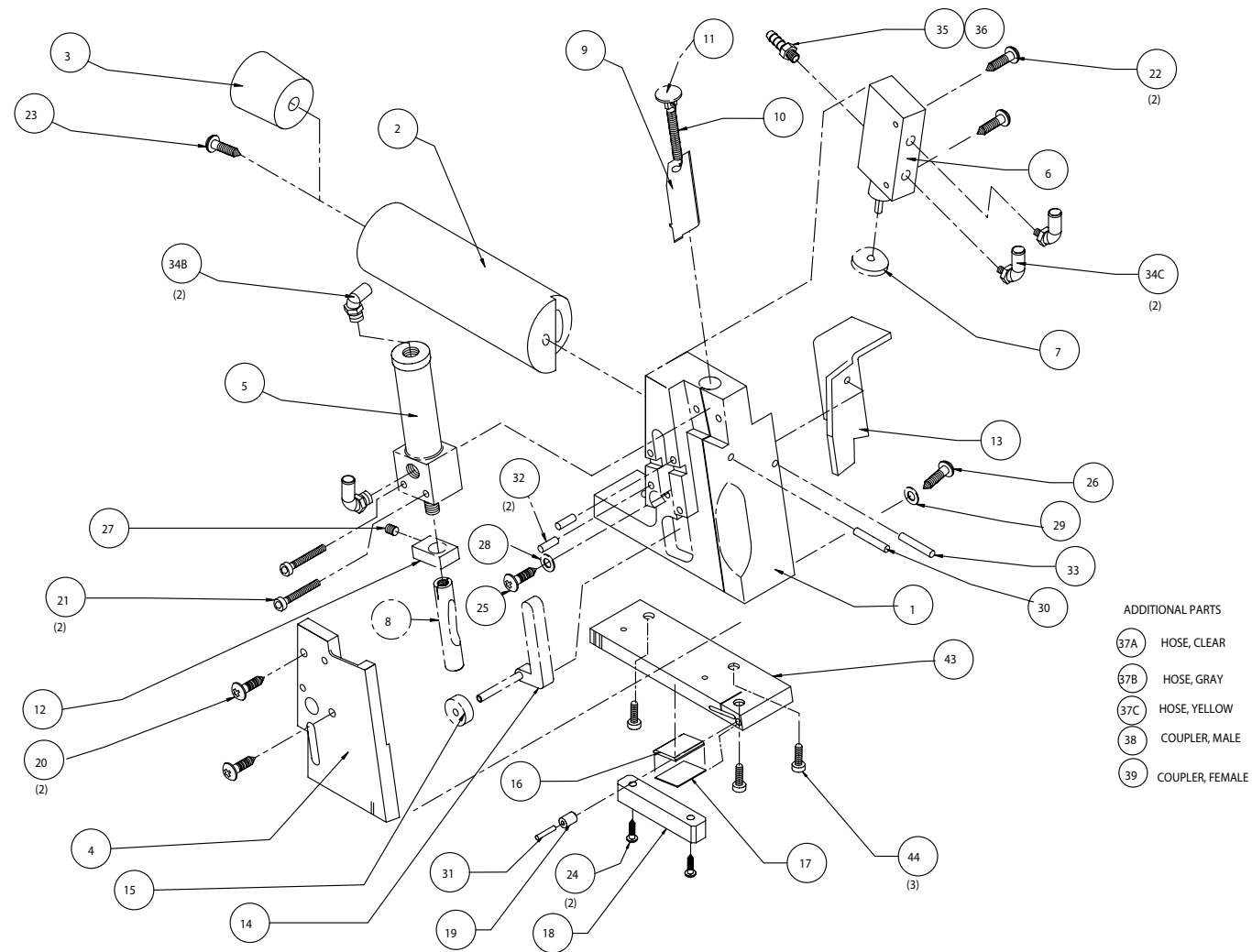
4. To load, pull spacer through so that it extends beyond the pressure wheel and parallel to the base of the tool.

## Parts List

Item	Part No.	Description
1		Body
1c	001097	Body (Straight) (SSII)
1d	001098	Body (Curve) (SSII)
2	001099	Handle
3	001100	Stopper
4		Faceplate
4a	001101	Faceplate, Slimline for Gas Notcher
4b	001102	Faceplate, Slimline
4c	001103	Faceplate, Standard for Gas Notcher
4d	001104	Faceplate, Standard
5	001108	Cylinder
6	001109	Valve
7	001110	Trigger Button
8	001112	Notcher Punch
9	001113	Cutting Blade
10	001114	Spring
11	001115	Spring Button
12	001116	Punch Collar
13	001117	Cutting Blade Trigger
14	001119	Pressure Wheel Holder
15		Pressure Wheel
15a	001120	Pressure Wheel (Slimline Straight)
15b	001121	Pressure Wheel (Standard Straight)
15c	001122	Pressure Wheel, Cone (Slimline Curve)
15d	001123	Pressure Wheel, Cone (Standard Curve)
16	001126	Cutting Pad
17	001127	Backing Plate
18		Guide Block
18e	001130	Guide Block, 3/16" offset (SSII)
18f	001131	Guide Block, 1/4" offset (SSII)
19		Guide Roller
19a	001132	Guide Roller (Slimline)
19b	001133	Guide Roller (Standard)
20	001134	Screw, Faceplate Mounting
21	001136	Screw, Cylinder Mounting

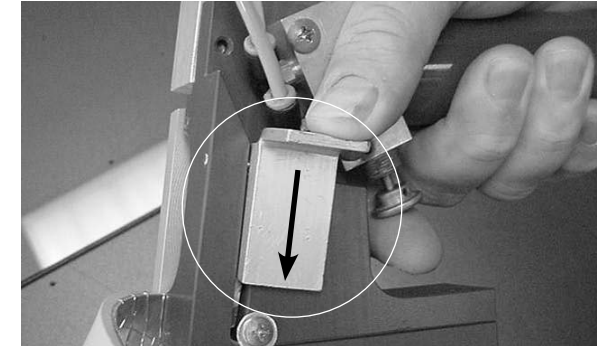
Item	Part No.	Description
22	001137	Screw, Valve Mounting
23	001137-23	Screw, Handle Mounting
24		Screw, Guide Block Mounting
24b	001134	Screw, Guide Block Mounting, 3/16" (SSII)
24c	001138	Screw, Guide Block Mounting, 1/4" (SSII)
25	001139	Screw, Pressure Wheel Adjusting
26	001140	Screw, Trigger Stop
27	001141	Screw, Set, Punch Collar
28	001142	Washer, Pressure Wheel Adjusting
29	001143	Washer, Trigger Stop
30	001144	Dowel, Cutting Blade Pivot
31	001145	Dowel, Guide Roller
32	001146	Dowel, Faceplate Alignment
33	001147	Spring Pin, Trigger Pivot
34		Fitting, Elbow
34b	001149	Fitting, Elbow (Cylinder) (SSII)
34c	001150	Fitting, Elbow (Valve) (SSII)
35	001151	Fitting, Hose Barb
36	001152	Gasket
37		Hose
37a	001153	Hose, Clear
37b	001154	Hose, Gray (SSII)
37c	001155	Hose, Yellow (SSII)
38	001156	Coupler, Male
39	001157	Coupler, Female
40		Guide Wheel
40a	001158	Guide Wheel, 3/16" Offset
40b	001159	Guide Wheel, 1/4" Offset
41		Rubber Ring
41a	001160	Rubber Ring, 3/16" Offset
41b	001161	Rubber Ring, 1/4" Offset
42	001162	Screw, Guide Wheel Mounting
43	001163	Wear Plate
44	001164	Screw, Wear Plate Mounting
45	001473	Screw, Pressure Wheel Adjusting

## Parts Diagram

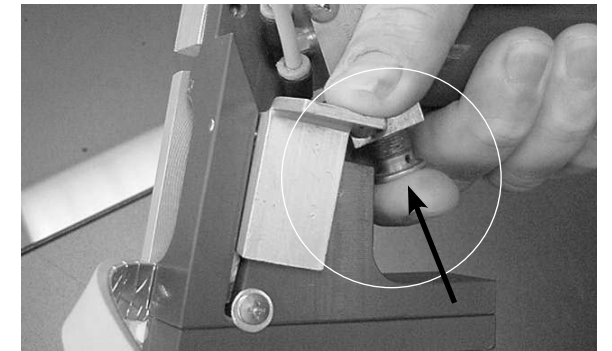


## Operating the SuperShuttle

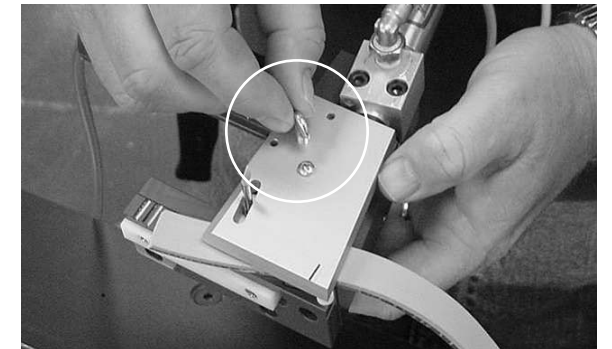
5. With thumb of right hand, press cutting blade trigger.



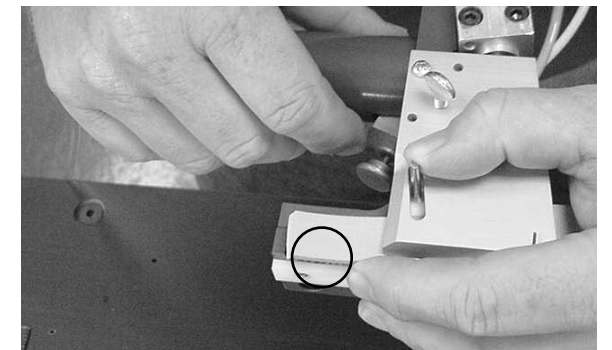
6. Once the cutting blade is engaged, activate the notcher punch trigger.

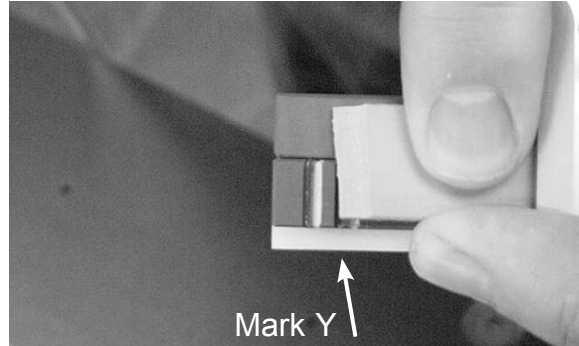


7. For spacer width adjustment, loosen the pressure wheel adjustment screw so that the pressure wheel extension pin moves freely.

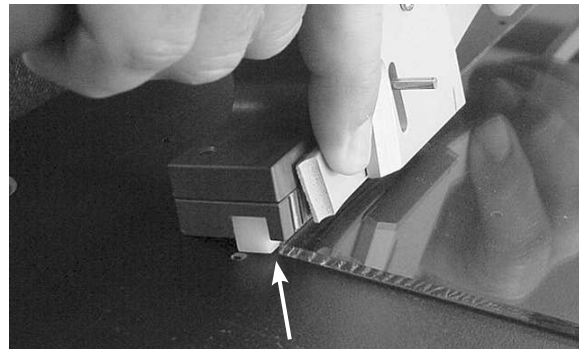


8. Using the pressure wheel extension pin, position the pressure wheel on the spacer so that the bottom spacer edge exceeds the tool base by about 1/32" (0.8mm).

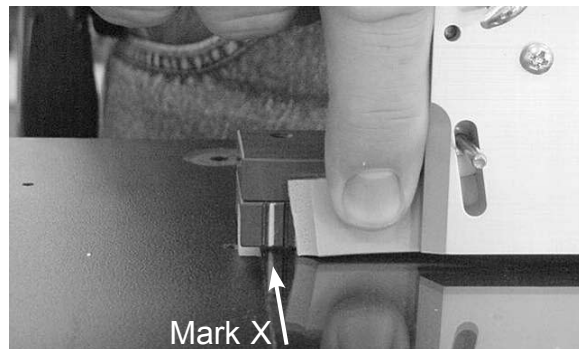




9. Line up prenotched and sliced spacer end with mark Y, holding it with one finger of right hand.



10. Place guide block against the side of the first glass lite.



11. Align mark X with the starting corner of the glass.



12. Once aligned, tack down by applying pressure with one finger of the right hand.

### **Punch doesn't cut spacer completely**

- Sharpen
- Adjust depth
- Replace punch
  - (Replace cutting pad)
  - (Check air hoses for kinks)
  - (Check valve for proper movement and clear exhausts)
  - (Check cylinder rod for excessive side-to-side movement)

### **Final cut off blade doesn't cut spacer completely**

- See above

### **Slugs get jammed in the punch**

- Clean with alcohol
  - (Make sure the punch is notching deep enough and cutting straight through the spacer)
  - (Make sure the notcher punch collar is tight and flush with top of punch)
  - (Replace punch if barb is worn)

### **Faceplate is scratching the glass**

- Replace wear plate
  - (Check pressure wheel height setting)

### **Pressure wheel is not functioning properly**

- Check for correct setting
- Replace if brass insert missing
- Check for correct size

### **Final cut off blade is stuck behind notch in the punch**

- Slide it back into the slot with a flat head screwdriver
- Check for correct alignment in the slot in the punch
- Avoid engaging the final cut off blade with the punch extended

## Maintenance

See page 24 for parts diagram

### Daily or every 400 units

- Check cutting pad, and replace if worn.
- Check notcher punch. Clean inside with isopropyl alcohol, and sharpen, if necessary.
- Check condition of guide block. Replace or rotate block if worn. A worn guide block will affect grid insertion, sight line and consistent set back.
- Clean inside of shuttle, and remove any slugs and adhesives with isopropyl alcohol or glass cleaner.

### Weekly or every 2000 units

- Perform 400-unit checklist.
- Inspect fittings for leaks.
- Check the wear plate for excessive wear. A worn wear plate will allow the faceplate to scratch the glass.
- Check cutting blade for damage and wear. Sharpen or replace, if necessary.

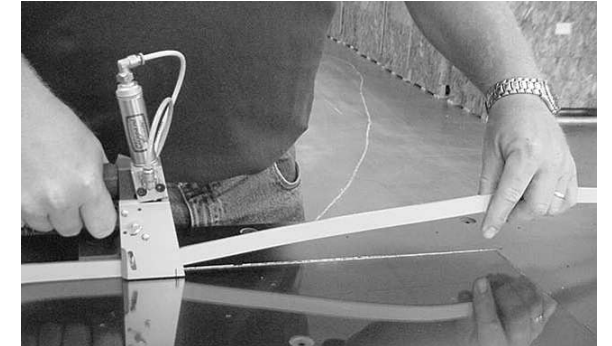
### Always maintain a minimum stock level of critical wear items including:

<u>Description</u>	<u>Min. Qty. per shuttle</u>
Cutting pads	25
Cutting blades	1
Notcher punches	1
Guide blocks	5
Wear plates	1
Pressure wheels	1
Guide rollers	2

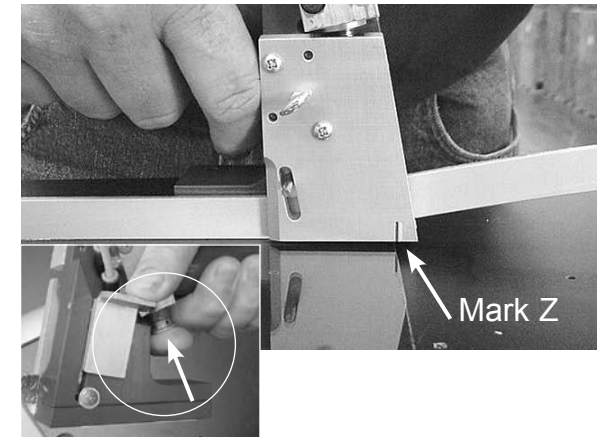
When ordering parts, please specify Slimline or Standard; 3/16" or 1/4" offset; SSI , SSII or EuroShuttle.

## Operating the SuperShuttle

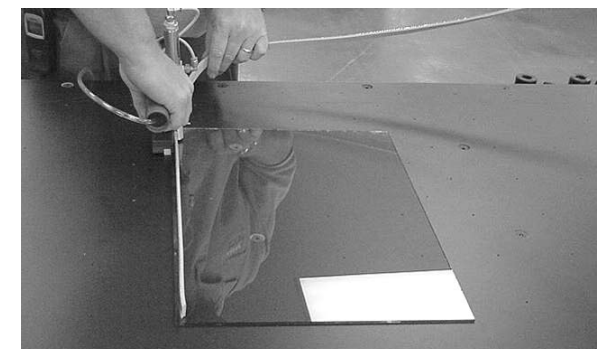
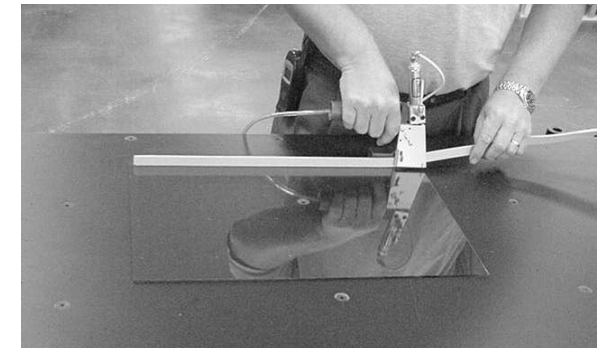
- Using left hand, support the spacer tape slightly above glass surface. While maintaining the tape perpendicular to the glass, apply slight downward pressure and glide the tool along the glass edge toward the second corner.



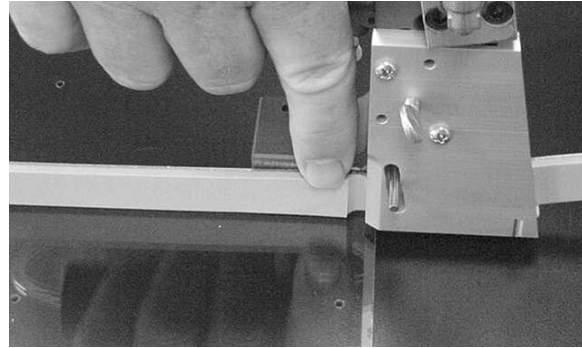
- Glide the tool along the glass edge until mark Z aligns with the upcoming corner. Press the notcher punch trigger to activate the notcher punch.



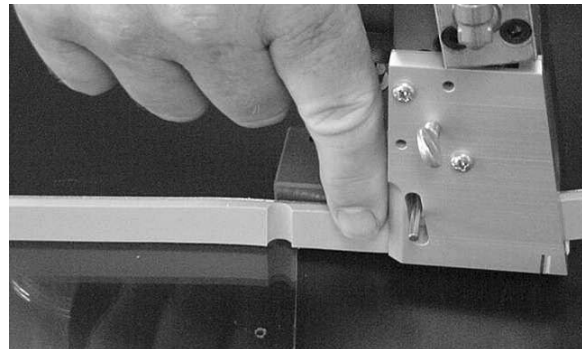
- Activate the table-indexing mechanism, and take care to keep tool in place as the glass is rotated 90°.



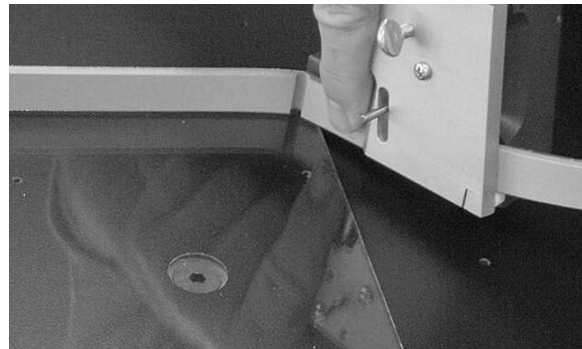
## Operating the SuperShuttle



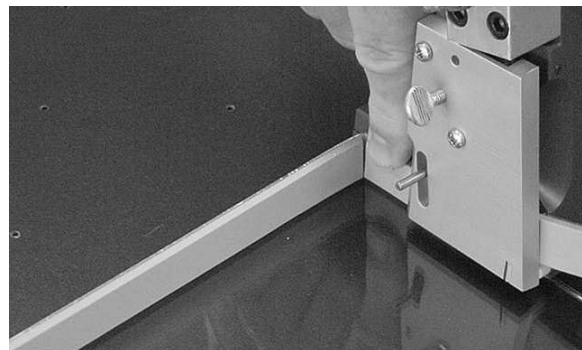
16. Continue moving the tool straight ahead until the left side of the notch is aligned with back edge of the faceplate. With one finger from the right hand, press down on the spacer to ensure good adhesion.



17. Advance tool approximately 1 1/2" (40mm) beyond the corner notch.



18. While holding the spacer against the tool base with one finger, tilt the tool so that the front end is approximately 1/4" (6mm) above the glass surface. Without moving the tool forward and without pulling on the spacer, pivot the tool until the guide block meets the glass edge.



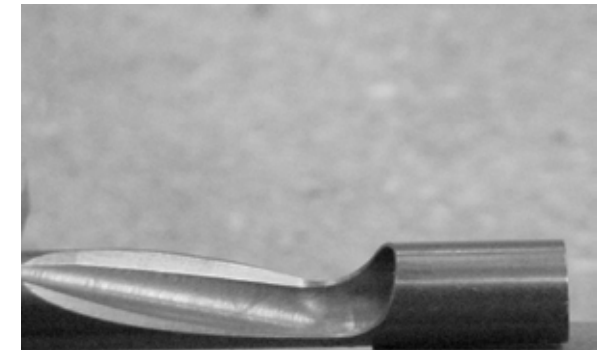
19. Move finger to top edge and tack down spacer at about 1" (25mm) distance from the corner. Proceed with spacer application, repeating steps 13-19 at the second and third corner.

## Sharpening the Notcher Punch

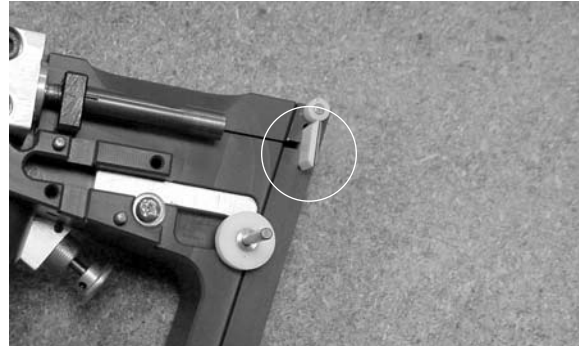
1. Align the center of the spherical sharpening stone with the center of the notcher punch. Rotate the stone in your fingertips to evenly sharpen the cutting surface. Apply only slight pressure to the punch. Oversharpening will make premature replacement necessary.



2. Once the outside edge is sharp, burrs can be removed by using the outside edge of the flat stone.



## Replacing the Notcher Punch



15. Place the cutting pad on top of the backing plate and into the slot.



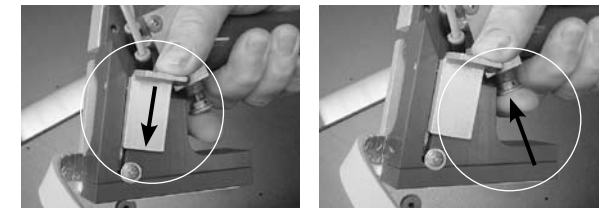
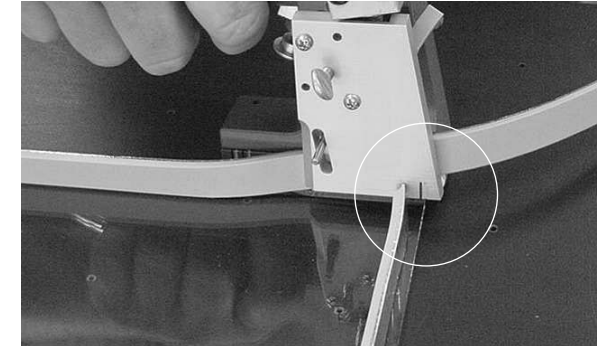
16. Place grey and yellow hoses into elbow fittings.



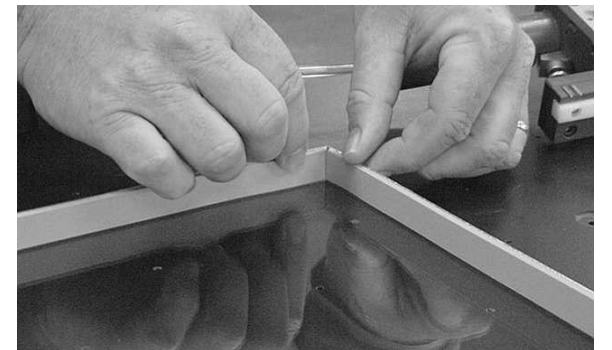
17. Replace aluminum faceplate, and tighten screws.

## Operating the SuperShuttle

20. At a point approximately 1" (25mm) from the final corner, guide the tool slightly outward to avoid hitting the starting end of the spacer. Advance tool until mark Z aligns with the corner edge of glass. Notch and cut off spacer end as in steps 6 & 7, and remove tool by pulling it forward and off the previously applied spacer.

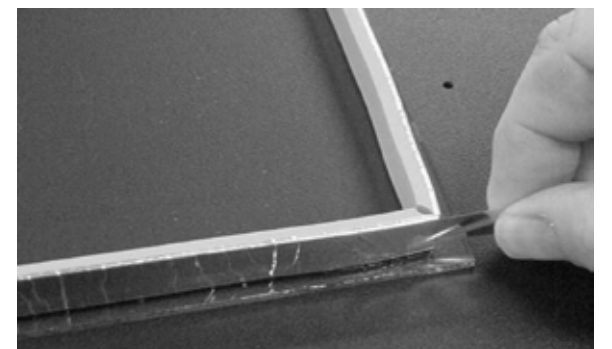
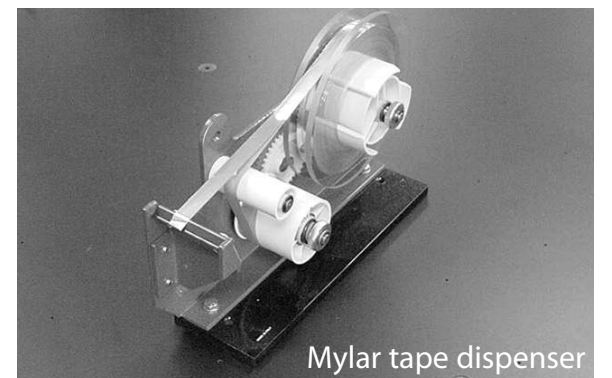


21. Manually align the spacer ends to form the final corner joint.



### \*\* Special note for gas filled units:

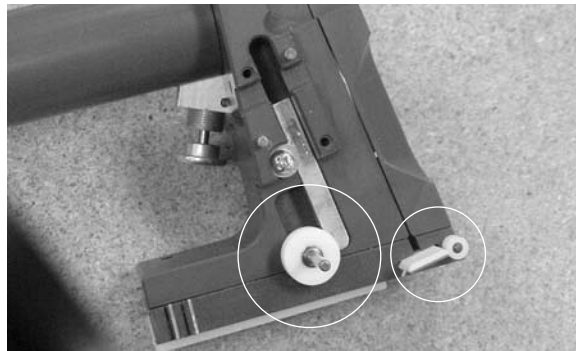
For gas filled units, wrap a 1" length of approved barrier tape over the final joint, and apply pressure to ensure good adhesion. The barrier tape must be applied to the spacer only and should not roll up onto the glass surfaces.



## Replacing the Cutting Blade



1. Disconnect the air inlet. Loosen the two face plate mounting screws, and remove the face plate.



2. Ensure the pressure wheel holder is pressed all the way down. Remove the pressure wheel, guide roller, cutting pad and backing plate.

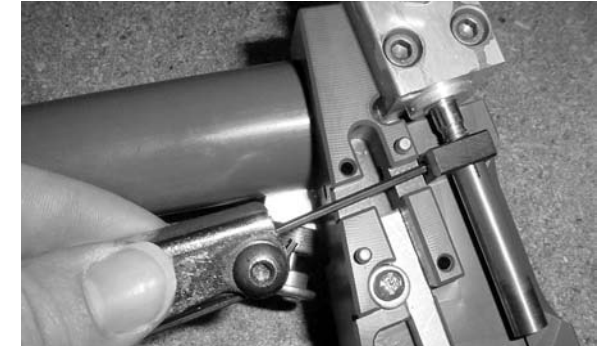


3. Remove the gray and yellow hoses from cylinder elbow fittings.

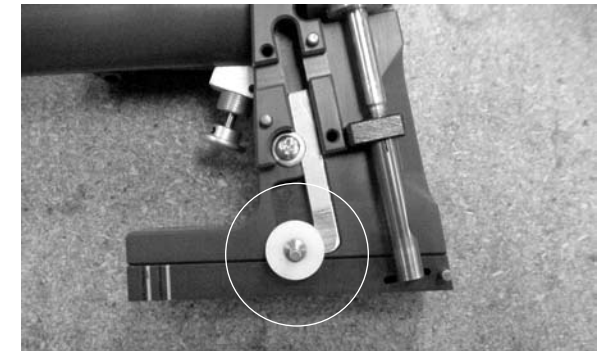


4. Loosen the two cylinder mounting screws, and remove the cylinder.

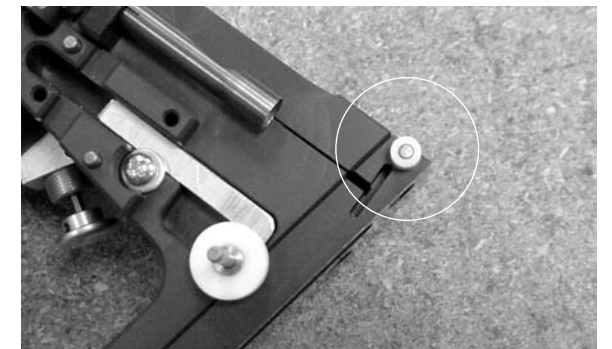
## Replacing the Notcher Punch



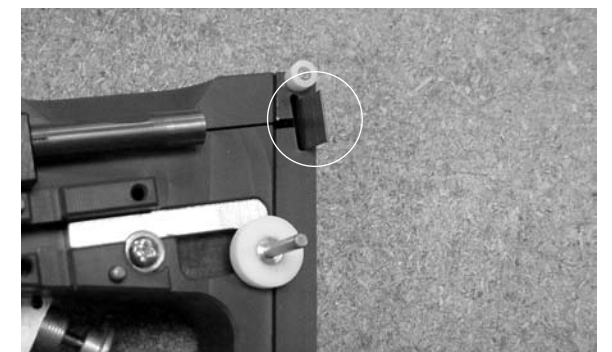
11. Ensure that the top of the notcher punch collar is placed flush with the top of the notcher punch. Screw the collar in place with the allen key.



12. Place the pressure wheel back onto pressure wheel holder.



13. Place the guide roller back onto the guide roller pin.

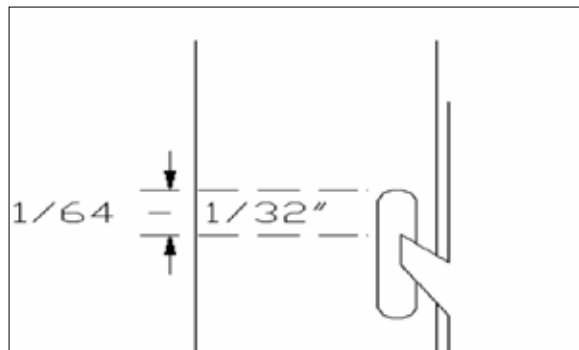
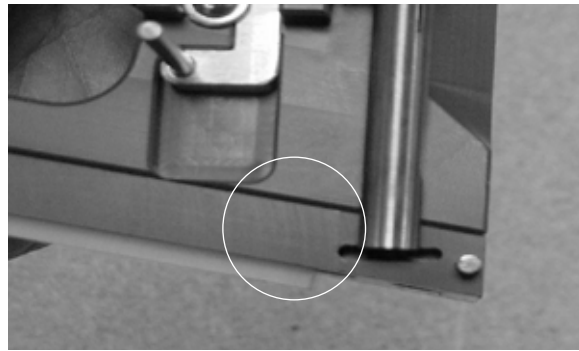


14. Place the backing plate into the slot.

## Replacing the Notcher Punch



- When the cylinder is in full extension, be certain that the notcher punch just passes the cutting pad/backing plate slot to ensure proper positioning. If not, turn the notcher punch to adjust.



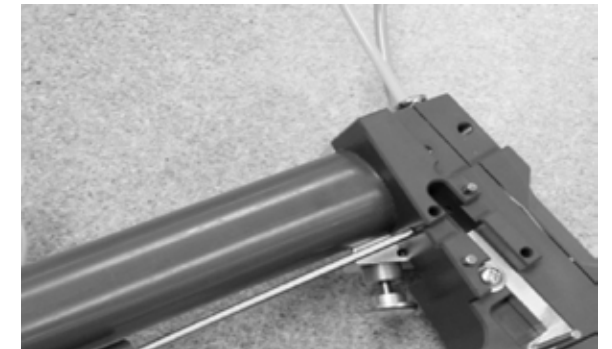
- Turn the cylinder rod to align the notcher punch slot with the cutting blade slot. Ensure that the blade moves freely within the notcher punch slot. (See diagrams at left.)

Note: Do not use the notcher punch to align as it will loosen the notcher punch adjustment.

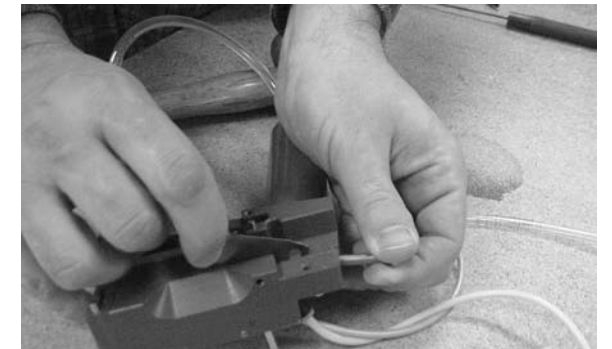


## Replacing the Cutting Blade

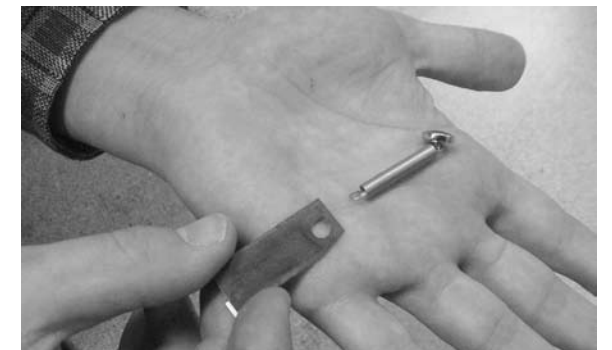
- Use a 1/8" drift punch to remove the cutting blade pivot dowel pin.



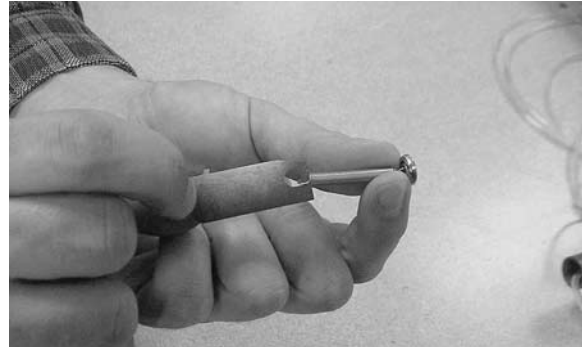
- Pull on the spring button silver cap. The spring and the cutting blade will come out from the top.



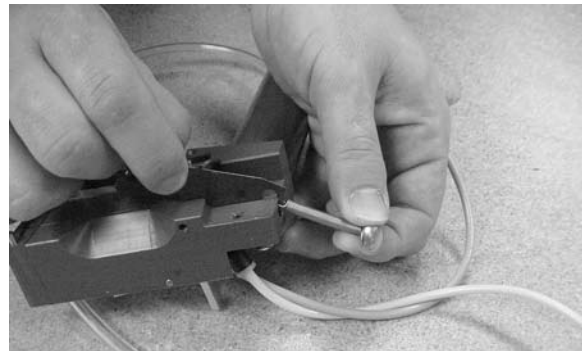
- Carefully disconnect the cutting blade from the spring.



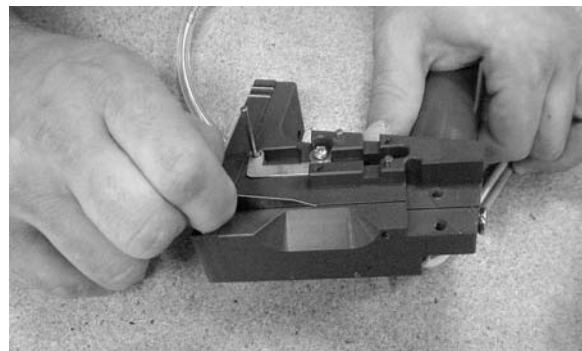
## Replacing the Cutting Blade



8. Attach a new blade to the spring.



9. Insert the blade into the tool until the silver cap is properly positioned.



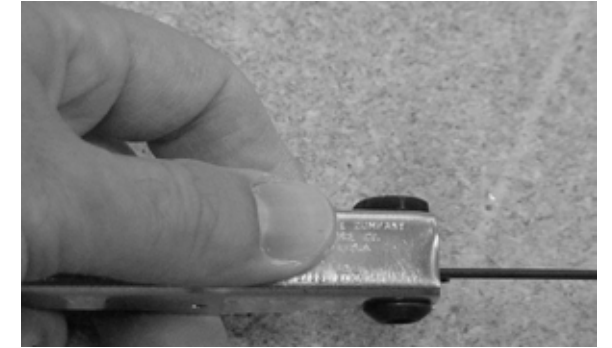
10. Pull the blade downward using the engaging notch.



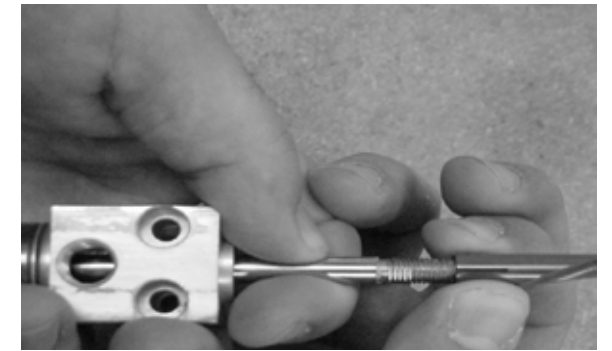
11. Insert the dowel pin to keep the blade assembly in a tensioned position.

## Replacing the Notcher Punch

5. Using a 5/64" allen key, unscrew the notcher punch collar. Slide the collar off the punch.



6. To remove the notcher punch, hold the cylinder rod with one hand while unscrewing the punch. Screw in place the new or resharpened punch.



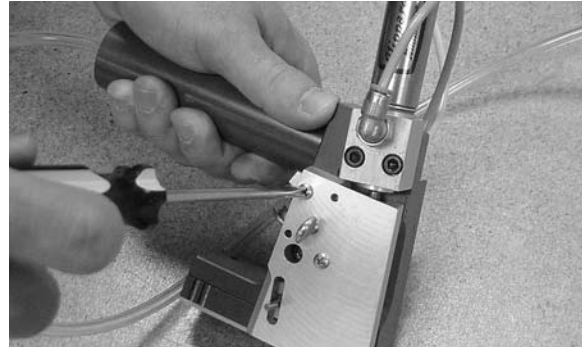
7. Slide the notcher punch collar up over the notcher punch. Do not yet screw in place.



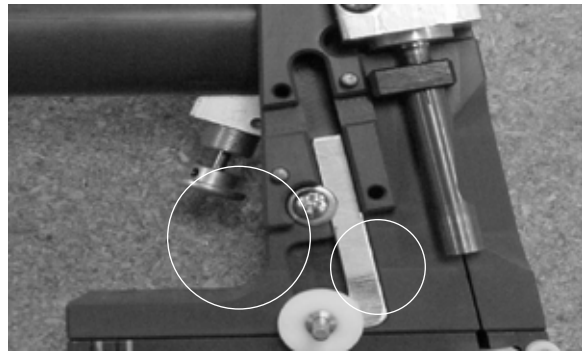
8. Reattach the cylinder.



## Replacing the Notcher Punch



1. Disconnect the air inlet. Remove the two face plate mounting screws, and remove the face plate.



2. Ensure the pressure wheel holder is pressed all the way down. Also remove the pressure wheel, guide roller, cutting pad and backing plate.



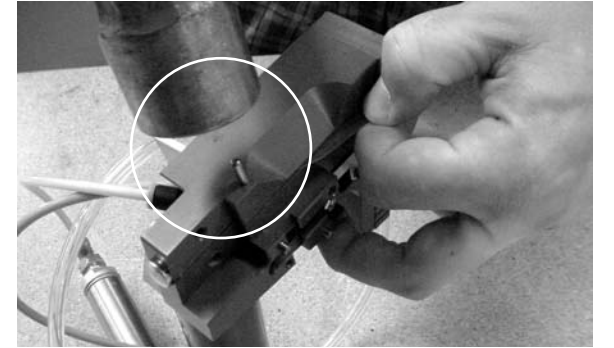
3. Remove the gray and yellow hoses from cylinder elbow fittings.



4. Loosen the two cylinder mounting screws, and remove the cylinder.

## Replacing the Cutting Blade

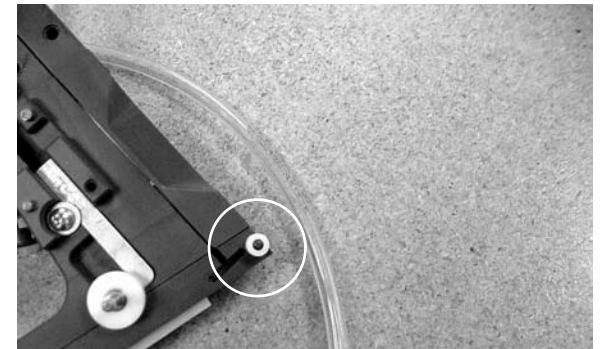
12. Hammer the pin flush with the body.



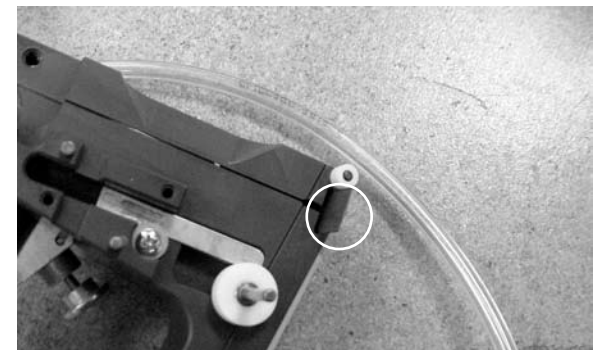
13. Place the pressure wheel back onto pressure wheel holder.



14. Place the guide roller back onto the pin.

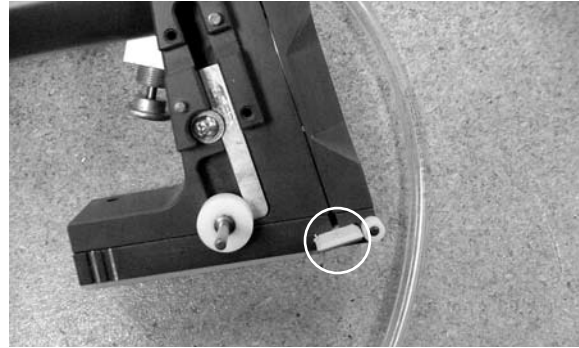


15. Place the backing plate into the slot.



## Replacing the Cutting Blade

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16. Place the cutting pad on top of the backing plate and into the slot.



17. Replace cylinder and tighten screws.



18. Place grey and yellow hoses into elbow fittings.



19. Replace aluminum faceplate and tighten screws.