

To Order Parts:
Visit www.propacksolutions.com or call 770-554-1187.
If you want to see color pictures of the parts, cut and paste
the following link: [http://www.propacksolutions.com/
catalog/index.php?cPath=527_590_591](http://www.propacksolutions.com/catalog/index.php?cPath=527_590_591)

instructions

ZCM
1000



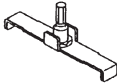







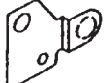

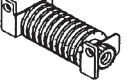
ZCM
2000



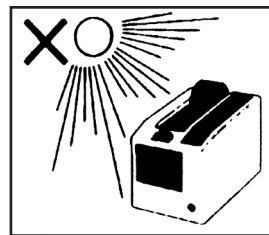
START International
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japan@startinternational.com

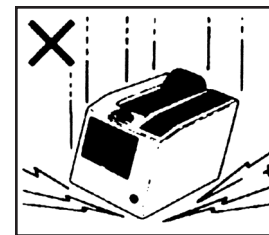


Part Number	Description	Drawing
ZCM1000P517	Roller Pressure Unit 2	
ZCM1000P518	Front Holder 3 Unit	
ZCM1000P519	Front Holder 3	
ZCM1000P520	Cut Lever Pressure 2	
ZCM1000P521	Cut Lever Liner 2	
ZCM1000P522	Cut Lever Shaft Collar	
ZCM1000P523	Cut Lever Unit 2	
ZCM1000P526	Open Set Knob & Spring	
ZCM1000P527	Pinion Gear Stopper	
ZCM1000P528	Pinion Gear Unit 2	
ZCM1000P533	Separating Roller Holder Unit	

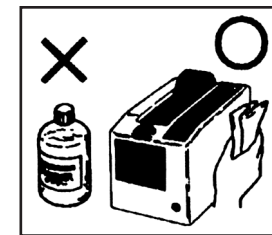
NOTES



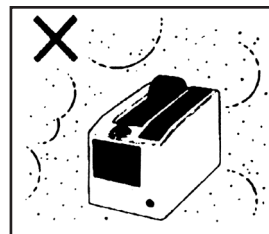
Do not leave the tape dispenser in direct sunlight.



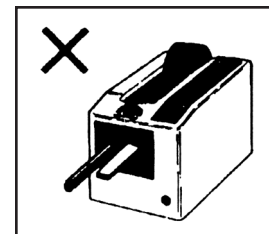
Do not drop the tape dispenser or subject it to heavy shocks.



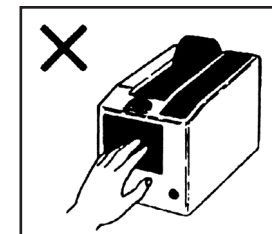
Do not use volatile liquids (thinner, benzene, etc.) to clean the dispenser. Wipe with dry cloth only.



Do not use the tape dispenser in humid or dusty places.



Do not insert bars or plates into the tape outlet - this will damage the blade.

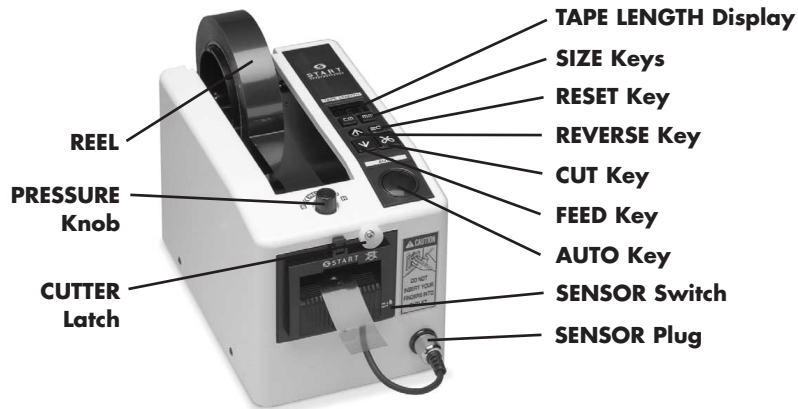


Do not insert your fingers into the tape outlet!

FEATURES

- If using automatic feed, when one piece of tape is removed, the unit will automatically feed and cut the next piece at the preset length.
- The tape length is easily seen on the LED display, and operation is simple — press the CM key or MM key to set the length (Setting limit: 20mm to 999mm).
- If a piece of long tape is needed, press FEED key for desired length, then press CUT key to cut.
- The blade unit can be removed and replaced easily. (Tape jamming is also easily fixed by removing the blade unit.)

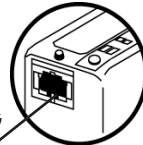
DESCRIPTION OF PARTS AND FUNCTIONS



POWER Switch



FEED Roller



SEPARATING Roller



- **POWER Switch**
Press to turn power **ON** or **OFF**.



- **REVERSE Key**
Feed Roller reverses. Use this key to change tape.

TAPE LENGTH

123

- **TAPE LENGTH Display**
The last digit indicates millimeters and the first two digits centimeters.



- **RESET Key**
Length display is reset to 20mm. This key can be used as an emergency stop.



- **SIZE Keys**
Press mm key to set tape length in mm. Press cm key to set tape length in cm.



- **FEED Key**
Tape dispenses as long as key is pressed.



- **CUT Key**
Press to cut tape.

AUTO




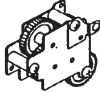










- **AUTO Key**
Feeds tape to the preset length and cuts automatically.



- **PRESSURE Knob**
Adjusts top roller to change pressure on tape.

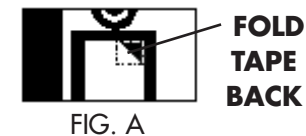
Part Number	Description	Drawing
ZCM1000P433	Gear Cover 2 Unit (for cutter)	
ZCM1000P435	Motor Unit 4 12VDC Red & Brown	
ZCM1000P501	Left Plate Unit 2	
ZCM1000P502	Right Plate Unit 3	
ZCM1000P503	Separating Roller Holder	
ZCM1000P504	Main Board Unit 2	
ZCM1000P507	Blade Holder 2	
ZCM1000P508	Cutter Holder Unit 2 with Blades	
ZCM1000P512	E-Ring	
ZCM1000P513	Roller Pressure Shaft 2	
ZCM1000P514	Hexagon Nut	
ZCM1000P515	Roller Pressure Plate 2	

Part Number	Description	Drawing
ZCM1000P406	Flat Gear Shaft 14	
ZCM1000P407	Flat Gear Shaft 13	
ZCM1000P408	Collar 2	
ZCM1000P418	Gear Plate Installation Unit	
ZCM1000P421	Flat Gear 11	
ZCM1000P422	Flat Gear 12	
ZCM1000P423	Flat Gear 13	
ZCM1000P424	Flat Gear 14	
ZCM1000P427	Feeder Roller Gear 2	
ZCM1000P428	Small Screw w/ Cross Hole	
ZCM1000P430	Separating Roller Gear 2	
ZCM1000P431	Cutter Gear Unit 2	

OPERATION

Using Automatic Feed:

1. Plug in power cord and turn unit on.
2. Set tape on the center of reel and stick the end of the tape onto the metal feed roller. Press FEED key until tape feeds through cutting unit. If the tape will not feed through the cutter, fold corners of the tape to form a triangle shape and re-feed (Fig. A).
3. Press CUT key to cut tape.
4. Set the tape length.
Press MM key to set length of 0-9mm.
Press CM key to set length of 20-990 mm.
5. Set PRESSURE knob
 - If tape curls or slips, increase pressure.
 - If tape creases, decrease pressure.
6. Turn sensor switch ON. Tape will be fed to set length and cut. When the piece of tape is removed from machine, another piece will be fed and cut. (Turn sensor switch OFF when not in use.)



Using AUTO key

With sensor switch OFF, press AUTO key. Tape will be fed to set length and cut.

Using FEED key

Press FEED key until desired tape length has been fed. (This key overrides the preset length.) Press CUT to cut tape.

Changing tape

Press the REVERSE key. The feed roller will rewind the tape away from cutter area. Remove the tape manually.

In case of tape jam

Press REVERSE key to remove tape from cutter area. Rewind and replace tape on roller. Also, remove cutter unit to verify no tape is stuck on roller or cutter.

OPERATION (CONT'D)

To Replace Cutter Unit

Turn off sensor and power before removing cutter unit. Pull sensor plug out, then pull cutter unit forward while pressing the knob on the top of the unit (Fig. 1).

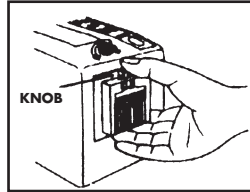


FIG. 1

To replace blades, remove the two screws inside head. Blade can then be lifted out and replaced. Before remounting the cutter unit to the frame, the lower blade must be bottomed out. If it is not completely down, use a screwdriver to lower it (Fig. 2).

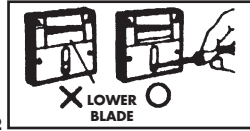


FIG. 2

Remount the cutter unit by aligning the bottom of the unit then pushing in the top.

Replacing the Separating Roller

Turn off the sensor and power before removing the separating roller. Remove the cutter unit, then remove the two screws (Fig. 3).

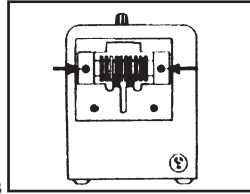


FIG. 3

To remove roller holder, grip rubber ring in the center of separating roller and pull. Then remove the screws on the left and right of the roller holder and pull off shaft and gear (Fig. 4).

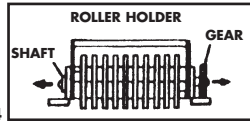



FIG. 4

PRECAUTIONS

- Set the tape properly as described in these instructions. (If the end of the tape is folded when the tape is set, the tape may jam at the tape outlet.)
- This machine will cut virtually any type of pressure sensitive tape (cloth, aluminum, filament, etc.). If tape is thicker than .05", test for compatibility.
- Because of tape differences (elasticity, stickiness, etc.), some tapes may not cut at the set length. If this occurs, adjust the set length accordingly.
- If tape sticks to the blade, remove the cutter unit, clean with alcohol and apply silicone oil to the blade.
- To reduce jamming, remove tape from machine when not in use.

Part Number	Description	Drawing
ZCM1000P250	Switch Button 3 (20)	
ZCM1000P251	Switch Button 3 (Reverse)	
ZCM1000P254	Blade Set	
ZCM1000P256	Top Blade Holder	
ZCM1000P257	Blade Spring	
ZCM1000P258	Blade Guide (right)	
ZCM1000P259	Blade Guide (left)	
ZCM1000P289	Silicone Oil	
ZCM1000P312	Feed Roller	
ZCM1000P403	Flat Gear 15	
ZCM1000P404	Flat Gear 16	

Part Number	Description	Drawing
ZCM1000P228	Screw Cross Tip	
ZCM1000P229	Tapping Screw Cross Tip	
ZCM1000P230	Small Screw Cross Tip	
ZCM1000P231	Cutter Gear Cover Screw/Cross Tip	
ZCM1000P232	Cutter Spring Control Screw/Cross Tip	
ZCM1000P233	Body Cover Screw Cross tip	
ZCM1000P234	Tapping Screw Cross Tip	
ZCM1000P245	Auto Button	
ZCM1000P246	Switch Button 1 (cm)	
ZCM1000P247	Switch Button 1 (mm)	
ZCM1000P248	Switch Button 2 (cut)	
ZCM1000P249	Switch Button 2 (feed)	

SPECIFICATIONS

Model	ZCM1000	ZCM2000
Display	3-Digit LED	
Applicable Tape Width	.28"-2" (7-50mm)	
Core Diameter	3" (optional 1", 1.25", 1.5")	
Tape Length Set Limit	.79"-39" (20-999mm) ± .040"	
Memory Settings	1	3
Drive	DC Motor for Tape Feed and Tape Cut	
Power Consumption	18W	
Power (AC)	117V 50/60Hz or 220V 50/60Hz	
Ambient Temperature	41°-104°F (5°-40°C)	
Ambient Humidity	Less than 80% RH	
Dimensions	5.4 x 8.6 x 6" (14 x 22 x 15cm)	
Weight	5.3 lb (2.4 kg)	

TROUBLESHOOTING

When problems occur, carry out the following procedures. If the tape dispenser does not operate normally after following the troubleshooting procedures, contact your supplier.

- If the motor does not drive:
 - Check that the power cord is plugged in.
 - Check that the power switch is turned on.
- If the tape does not cut:
 - Make sure the cutter unit is set properly and clean.
- If the LED does not light:
 - Check that the power cord is plugged in.
 - Check that the power switch is turned on.
- If the tape does not feed:
 - Check if the tape is jammed at the roller or in the cutter unit.
 - Check that the tape is set properly.
- If the auto feed does not work:
 - Check that the sensor plug is plugged in.
 - Check that the sensor switch of cutter unit is on.
 - Check that the sensor part of the cutter unit is not stained.
- If the tape feeding does not stop:
 - Check that the tape is centered. If not, set the tape at the center of the feed roller so that the sensor will see the tape.

PREVENTIVE MAINTENANCE

WEEKLY - Remove cutting head and clean, and look for missing roller rings. Replace as needed.

MONTHLY- Remove blade spring and blades to inspect cutter liners. Place one drop of silicone oil on each liner, or replace if worn. Inspect feed roller and blades for tape fragments or adhesive buildup. Clean with alcohol.








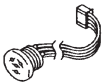


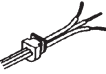

ADDITIONAL INFORMATION FOR ZCM2000



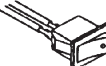









MEMORY Key

The reverse key on the ZCM1000 is changed to the MEMORY (M) key on the ZCM2000. (The reverse function can be accessed by pressing the FEED key and the M key at the same time. This function is for changing tape.)

Setting Memories

1. Press and hold the M key until the LED display flashes.
2. Using the cm and mm keys, set the desired length for first cut.
 - A. The mm key controls the millimeter setting (1 digit).
 - B. The cm key controls the centimeter setting (2 digits). (Ex: 125mm = 12cm and 5mm.)
 - C. Press M key to record memory. (The display will then flash "999".)
3. Set additional lengths as shown in #2. (If only two lengths are needed, record "999" as last length — "999" length will not be memorized.)
4. After lengths are set, the display will flash "0". Press mm key to switch between "0" and "5":
 - On "0", the machine will feed and cut the first set length until the M key is pressed, then it will feed the second length until the M key is pressed, and so on.
 - On "5", the machine will feed and cut the recorded lengths in series.
5. When set correctly, press and hold the M key until the display stops flashing. The first preset length will be shown on the display and the unit is ready to use.
6. Programmed tape lengths will be fed and cut in order when using either the sensor unit automatic feed and cut or the AUTO button.
7. If RESET (20) key is pressed, all of the memory will be erased.

Part Number	Description	Drawing
ZCM1000P150	Tapping Screw Cross Tip	
ZCM1000P154	Pressure Roller	
ZCM1000P155	Pressure Roller Collar	
ZCM1000P161	Cutter Holder Spring 2	
ZCM1000P164	Roller Pressure Spring	
ZCM1000P178	Spring	
ZCM1000P187	Motor Unit 2 12VDC Blue & Yellow	
ZCM1000P200	Connector 4 Red, Brown, Blue & Yellow	
ZCM1000P204	Pinion Gear 12	
ZCM1000P206	Power Cord (V-6) 117V	
ZCM1000P206-2	Power Cord (3 lead) (220V ~ 240V)	
ZCM1000P215	Cover for Non-contact	

Part Number	Description	Drawing
ZCM1000P115	Bottom Plate	
ZCM1000P116	Rubber Feet	
ZCM1000P118	Power Switch	
ZCM1000P120	Fuse 1Amp	
ZCM1000P121	Fuse Holder	
ZCM1000P124	Plate	
ZCM1000P134	Main Board Shaft	
ZCM1000P136	Separating Roller With Roller Rings	
ZCM1000P138	Separating Roller Ring Silicone Rubber	
ZCM1000P141	Roller Shaft	
ZCM1000P142	Screw Cross Tip	
ZCM1000P146	Bearings	

EXPLODED VIEWS / PARTS BREAKDOWN

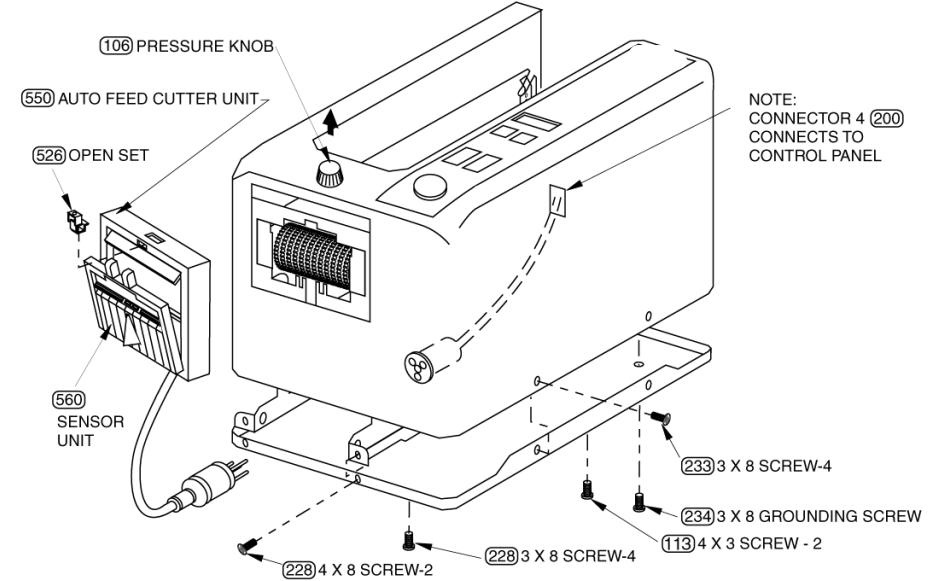
REMOVE BODY COVER AND BOTTOM PLATE

TO REMOVE BODY COVER:

1. REMOVE AUTO FEED CUTTER UNIT (550)
2. REMOVE FOUR SCREWS (233)
3. REMOVE PRESSURE KNOB (106)
4. LIFT COVER FROM UNIT

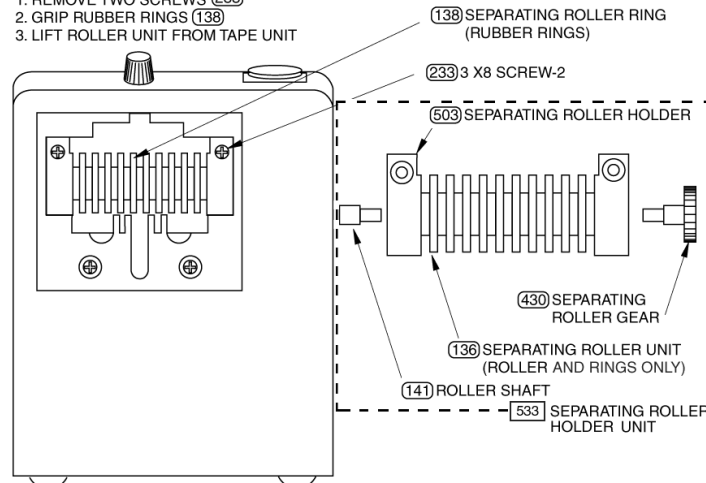
TO REMOVE BOTTOM PLATE:

1. REMOVE GROUND SCREW FROM BASE (234)
2. REMOVE FOUR SCREWS FROM BOTTOM OF UNIT (228)
3. REMOVE TWO SCREWS FROM BOTTOM OF UNIT (113)
4. REMOVE TWO SCREWS FROM FRONT OF BASE (228)



CHANGE THE SEPARATING ROLLER

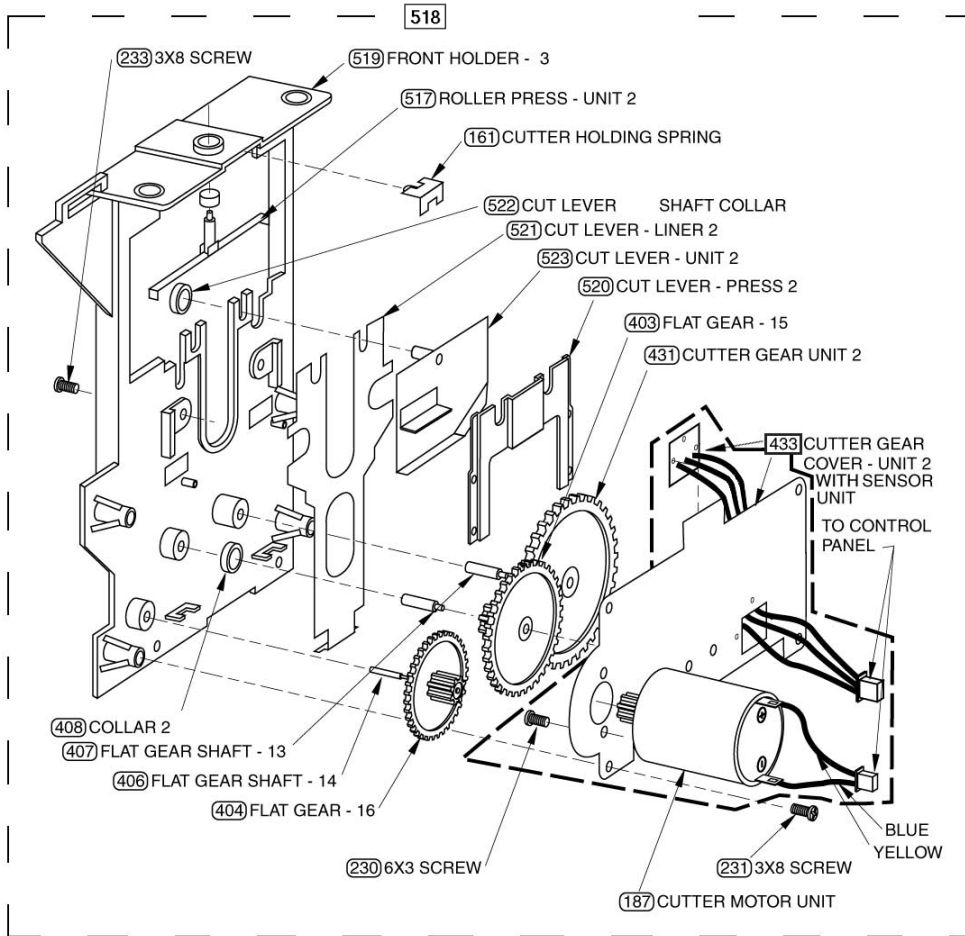
1. REMOVE TWO SCREWS (233)
2. GRIP RUBBER RINGS (138)
3. LIFT ROLLER UNIT FROM TAPE UNIT



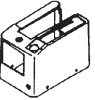
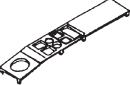










Numbers in balloons (100) represent the last three digits in replacement part number.
When ordering, ask for ZCM1000P_ _ _ .

EXPLODED VIEWS / PARTS BREAKDOWN

FRONT HOLDER STRUCTURE

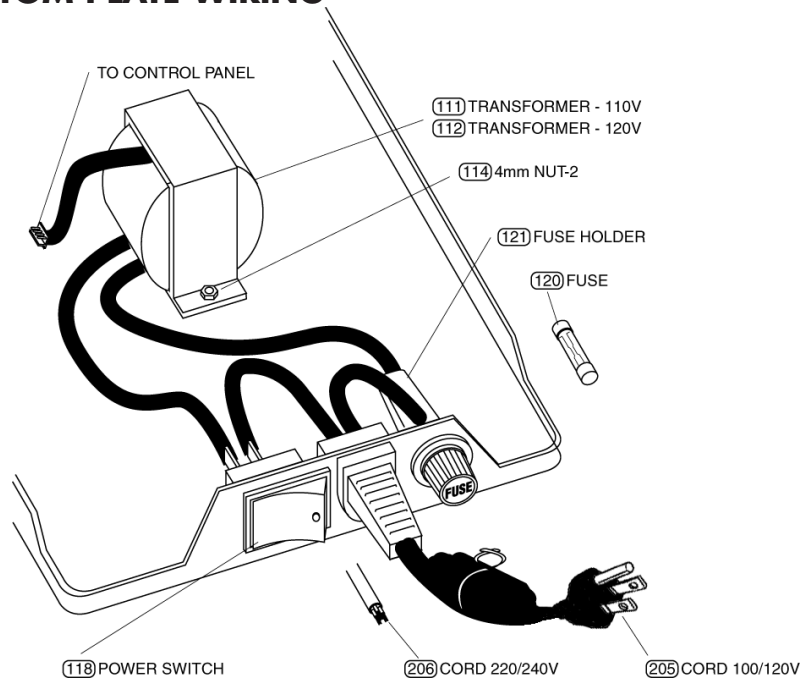


Numbers in balloons (100) represent the last three digits in replacement part number.
When ordering, ask for ZCM1000P_ _ _ _.

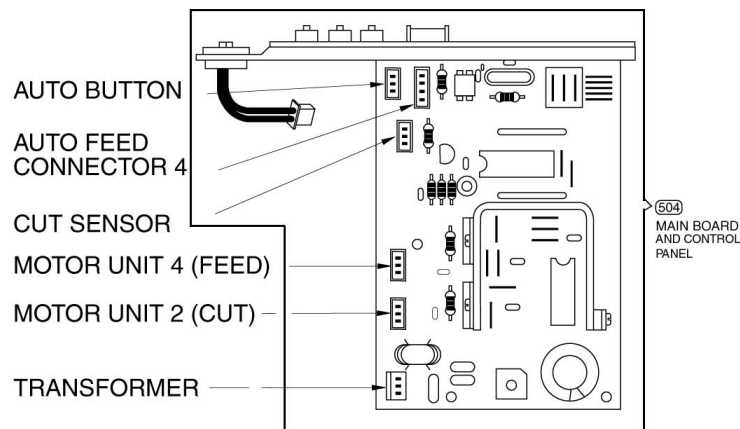
Part Number	Description	Drawing
ZCM1000P101	Main Unit Cover	
ZCM1000P102	Face Decoration Plate	
ZCM1000P105	Clear Plate	
ZCM1000P106	Pressure Knob	
ZCM1000P107	3" Reel Unit	
ZCM1000P108	1" Reel	
ZCM1000P109	1-1/4" Reel	
ZCM1000P110	1-1/2" Reel	
ZCM1000P111	Transformer 110V	
ZCM1000P112	Transformer 220V	
ZCM1000P113	Small Screw Cross Hole	
ZCM1000P114	Hexagonal Nut w/ Spring Washer	

EXPLODED VIEWS / PARTS BREAKDOWN

BOTTOM PLATE WIRING



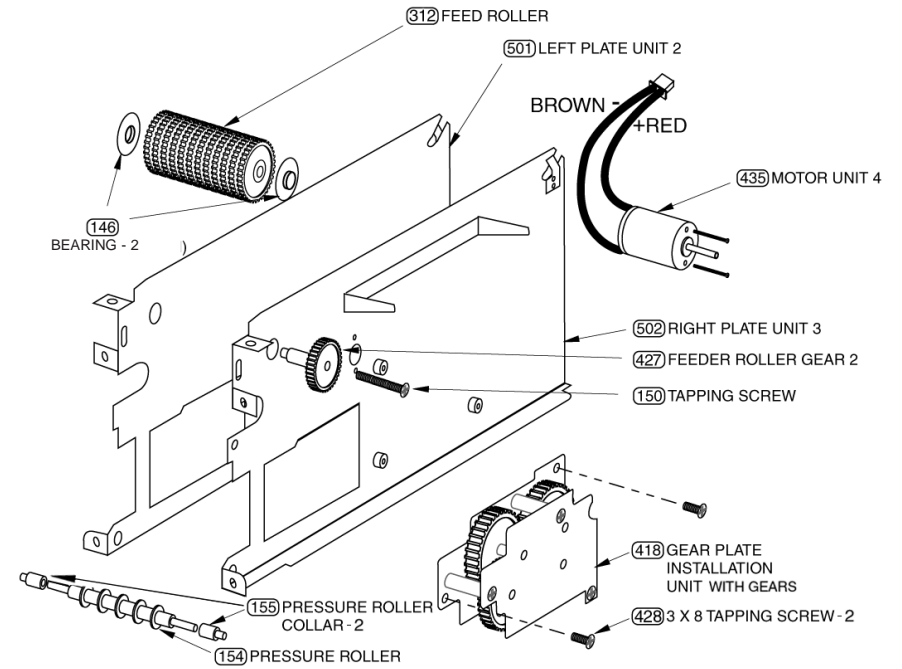
CONTROL PANEL CONNECTIONS



Numbers in balloons (100) represent the last three digits in replacement part number.
When ordering, ask for ZCM1000P_ _ _.

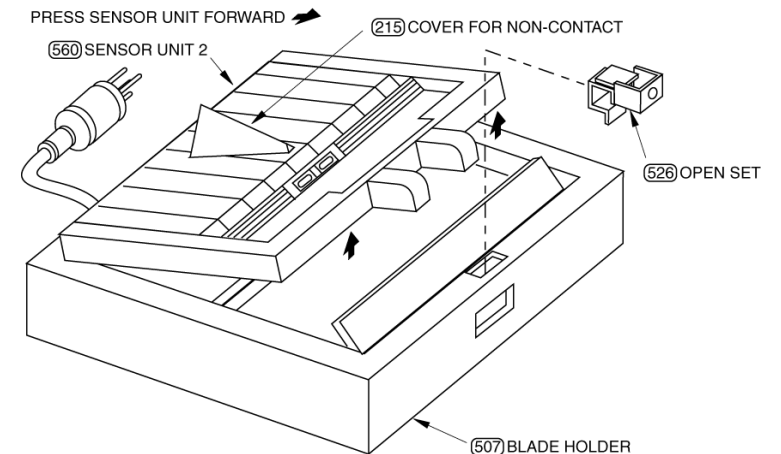
EXPLODED VIEWS / PARTS BREAKDOWN

FEED STRUCTURE



REMOVING SENSOR UNIT

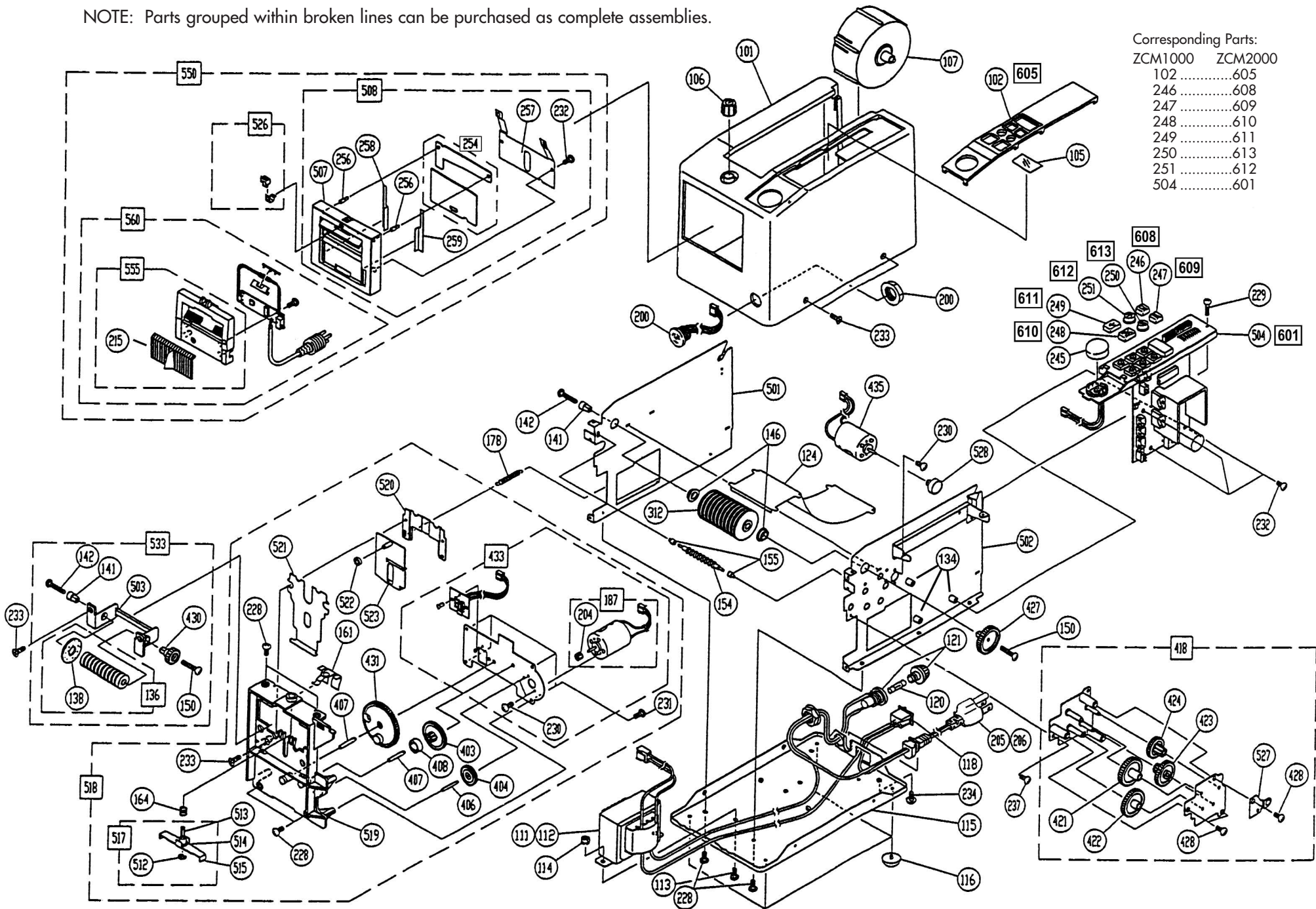
1. OPEN SENSOR UNIT FROM BLADE HOLDER UNIT
2. PRESS SENSOR UNIT FORWARD (UP) TO REMOVE FROM CUTTER HOLDER UNIT



Numbers in balloons (100) represent the last three digits in replacement part number.
When ordering, ask for ZCM1000P_ _ _.

EXPLODED VIEWS / PARTS BREAKDOWN

NOTE: Parts grouped within broken lines can be purchased as complete assemblies.



Corresponding Parts:

ZCM1000	ZCM2000
102	605
246	608
247	609
248	610
249	611
250	613
251	612
504	601

CONTENTS

Read this user's manual before use to ensure proper operation. Keep the manual on hand for reference in case there is a problem.

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WARRANTY POLICY FOR ZCM SERIES TAPE DISPENSERS

Start International warrants all parts on ZCM series tape dispensers against defects in design, materials and workmanship for a period of 180 days. Parts excluded from this are: cutting blades, silicone rollers and cutter liners; these parts are considered "wear parts". Labor to replace defective parts will be performed at no charge for the first 90 days after date of purchase. Warranty does not cover transportation costs.

Our sole obligation under this warranty is limited to repair, replacement or credit of the purchase price, at our option, for the machines listed above, which do not perform properly the function for which they were designed.

Warranty repair is contingent upon our examination and determination that alleged defects have not been caused by misuse, abuse, improper installation or application, repair, alteration, accident or neglect in use, storage, transportation or handling.

The above warranty and remedy constitutes Start International's sole liability hereunder and are in lieu and exclusive of all other warranties and remedies expressed, implied, or statutory, including, but not limited to, those of merchantability and fitness for a particular purpose.

REPAIR POLICY

Contact START INTERNATIONAL to determine nature of problem.

Furnish START with the following information:

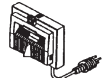

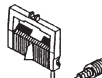


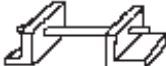

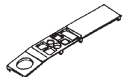





1. Who the unit was purchased from.
2. Model number and serial number.
3. Date purchased (copy of invoice or packing slip required).

START will issue an RMA (Return Material Authorization) for the repair.

Return machine to START by UPS, insured and prepaid.

START will notify the customer if there is a repair charge.

A \$25.00 evaluation charge will apply to all non-warranty repairs, which will be applied to repair change.

Part Number	Description	Drawing
ZCM1000P550	Auto Feed Cutter Control Unit w/Blade	
ZCM1000P555	Sensor Cover 2	
ZCM1000P560	Sensor Unit	
ZCM1000P680	Finger Guard	
ZCM1000P901	Cutter Latch	
ZCM1500P131	Tape Magnetic Guide	
ZCM2000P601	Main Board Unit 2	
ZCM2000P605	Face Decoration Plate	
ZCM2000P608	Switch Button 1 (cm)	
ZCM2000P609	Switch Button 1 (mm)	
ZCM2000P610	Switch Button 2 (cut)	
ZCM2000P611	Switch Button 2 (feed)	
ZCM2000P612	Switch Button 3 (memory)	
ZCM2000P613	Switch Button 3 (20)	