

"MK10" OPERATING INSTRUCTIONS (REV 1.0)

1) INTRODUCTION

- * Read these instructions carefully and thoroughly so as to ensure that you are familiar with the machine's features and general operating functions.
- * Never allow children near the machine and only personnel who are familiar with the machine and its operation should use it.
- * Keep the area of operation clear of any and all potential hazards.
- * The following procedures are intended to acquaint you with the safe and efficient operation of your E-Z CUT Cutting Machine. Try to abide by the rule: "If at first you don't succeed, try again". This machine is a proven tool for improving your warehouse and cutting efficiency. Take your time, be patient, and enjoy the benefits of this machine for many years to come.
- * If assistance is required or if any of the following procedures are unclear, please do not hesitate to contact an E-Z CUT representative directly.

2) MACHINE'S ARRIVAL & PREPARATION

- * Once the machine has arrived, proceed with removing the four sides and top portion of the crating as well as the metal banding/strapping that secure the machine to the base crate. Upon completion of this, you can now raise the machine only (excluding the bottom portion of the base crate) with your forklift from the "broad side". Insert the fork lift forks between the base of the machine and the bottom crating and gently raise the machine. At this time, re-engage the two Caster Wheels located at the front right hand side of the machine closest to the control panel. The two *pins* and *secure clips* necessary for this procedure are located inside the Operating Manual envelope. Align the two Casters, insert the necessary *pins*, and then slide on the *secure clips* so as to hold the wheels in place and prevent them from disengaging. Once both Casters are secured in place, remove the bottom crate and gently lower the machine back down onto the floor.

* For raising/lowering the machine on and off of its Caster Wheels to the machine's Base Leg Pads, you must charge up the machine's air lifting system. Do this by plugging your compressor into the white plastic/vinyl air hose on the machine. Your air supply system should meet the following minimum specifications:

- **4.5 H.P. motor.**
- **5-8 CFM.**
- **125 Psi.**
- **20 Gallon tank.**

Once charged use the "AIR LEGS" switch located on the left side of the control panel to lift the machine onto the castor wheels you can now move the machine to the desired position for operation on your warehouse floor. When you have located the machine to your desired position, use the switch to lower the machine back down to its Base Leg Pads so as to prevent any movement during actual operation.

NOTE: **Do not** try to raise/lower the machine when you have a roll of material on one or both cradles. This will result in excess stress on the wheel itself and cause damage in a very short time.

* In your box of accessories, you will find three (3) lengths of Foot Switch Tape ("FST") - two lengths that are each approx. 11' long and one length that is approx. 5' long. Once installed, you will be able to activate the machine's rollers by stepping on any section of the FST. Install these three sections of FST around the machine as follows:

- Lay out the short length (approx. 5 feet) of FST on the floor along the Front of the machine, with the plug end on the right hand side. Plug this section into one of the two mating plugs located on the right inside edge of the machine's front panel.
- Lay out one of the two longer lengths (approx. 11 feet) of FST on the floor along the Right Side of the machine, with the plug end closest to the front of the machine. Plug this section into the remaining mating plug on the right inside edge of the machine's front panel.
- Lay out the second of the two longer lengths of FST on the floor along the Left Side of the machine, again with the plug end closest to the front of the machine. Plug this section into the one mating plug located on the left inside edge of the machine's front panel.

NOTE: Depending on your operation, the location of the machine, and whether or not you move the machine around on a regular basis, you may want to secure the sections of FST to the floor with the use of duct or masking tape. By taping the FST to the floor, you will avoid possible twisting of and reduce potential damage to the FST. Should you need to move your machine for cleaning purposes, remove the duct/masking tape from the FST, lift and drape the FST sections onto the machine, and then re-secure the FST to the floor with more duct/masking tape when you re-locate the machine. **DO NOT detach the FST from the plug connections on the machine as continued plugging/unplugging will cause damage to the plug ends.**

- Hook-up the machine's power cord into the following power source (hardwired or plug).

220V (Single Phase) / 60 Hz / 20 Amp

* Test the activation of the rollers by turning both Roller Switches to FWD and then press and hold the JOG button. The rollers should now turn and then stop when you remove your finger from the button. Next, with the Roller Switches still in FWD, step on the Foot Switch Tape. Again, the rollers should turn and then stop when you remove your foot from the hose.

* Using the “F3” button check that all 3 speed levels (Low; Medium; & High) of the machine are working along with both roller directions (FWD & REV).

* Check the Cutting Bar by pressing “E-Z ACTION”, & then press & hold “F4” or “K3” to activate the cutter.. You will hear a Warning Beeper for approximately 3 seconds prior to the Cutting Bar being activated. This is your notice to keep hands and any other potential hazards clear of the Cutting Track. Since it is a Two-Way Cutter, you can make your next cut by using “F4” or “K4” as required.

NOTE: PLEASE NOTE THAT THE CUTTING BAR ONLY TAKES ABOUT 2 TO 3 SECONDS TO TRAVEL THE LENGTH OF THE CUTTING TRACK. SHOULD YOU EVER HAVE TO STOP THE CUTTING BAR, JUST RELEASE THE TOGGLE SWITCH AND THE CUTTER WILL STOP IMMEDIATELY. **USE EXTREME CAUTION, CARE AND COMMON SENSE WHEN OPERATING THIS CUTTER!**

***** IMPORTANT REMINDERS:**

> Be sure to use extra care & caution when loading/unloading rolls on the LHS Cradle so as to avoid damaging the two sets of "Shuttle Control Arms" located in the middle of this Cradle.

> It is best to always turn the Rollers Switches "OFF" when the machine is not in use. In addition, your machine is equipped with an "Emergency Stop" button on the side of the Control Panel. By pressing this button, you stop the power going to the entire machine instantly. To re-set the machine, just turn the button until it pops back out.

MAIN OPERATING PROCEDURES

LOADING THE ROLL OF CARPET

Place the roll on the LHS Cradle and ensure that the "feed edge" is coming from the BOTTOM towards the Counter with the "Pile" facing UP. NEVER MEASURE WITH THE PILE FACING DOWN AS THIS WILL RESULT IN INACCURATE READINGS. For best results, turn the LHS Rollers in REVERSE (REV), depress the Foot Switch Tape (FST) or Jog Button (JB), and allow the roll to rotate for a few turns until it tightens itself up.

NOTE: Again, be sure to use extra care & caution when loading/unloading rolls on the LHS Cradle so as to avoid damaging the two "Carpet Shuttle Control Arms" located in the middle of this Cradle.

PREPARING TO MEASURE

Lift the Counter Weight Arm to the UP position. Advance the carpet towards the RHS by switching both the Left & Right Side Rollers to FORWARD (FWD), and depressing the FST or JB. You may find it easier to get the roll started by using the JB instead of the FST. Stop the advancement of the carpet at the Cutting Track and lower the Counter Weight Arm down onto the carpet.

PROGRAMMING THE COUNTER TO MAKE A CUT

- 1) Key in your "PASS CODE" (If required). Press **ENTER**.
- 2) Key in the desired "FEET". Press **ENTER**.
- 3) Press "->". Key in desired "INCHES". Press **ENTER**.
- 4) Press "->". Press "**SHIFT**", then press "**^ or **" to select "**TYPE**".
Press **ENTER**.
- 5) Press "**R**" to reset the Counting Row to zero (0).

***** IMPORTANT NOTE:** Although we have only provided you with the necessary steps to program and perform a single cut above, your PLC can perform many other functions and procedures. For a complete list of the PLC's "Main Operating Functions" and "Programming Instructions", please refer to pages 14 through to 18 at the back of this manual.

STARTING THE ROLL UP PROCESS

With both Rollers in the FWD position, advance the carpet by depressing the FST or JB as well as assisting the carpet by hand until it is into the RHS Cradle and stop its progress when it advances just past the middle of the RHS Cradle (approx. 4" to 6"). Although it is not necessary, should you require a core, it can be placed on top of the carpet in the RHS Cradle at this time.

ROLLING UP THE CARPET

- For starters, you are best to keep the machine in LOW speed until you get more comfortable and familiar with how the machine works.
- With both rollers in FWD, press the Air Assist Button (AAB) located at the top of the Roll-Up Handle on the RHS Cradle with your right thumb.
- Simultaneously, lift the Cradle up and over top of the carpet and release your thumb from the AAB at the same time.
- Step on the FST or press the JB to advance the carpet further into the RHS Cradle. You will notice that the carpet will curl over and start to reroll itself.
- Once you have rolled up approximately 3' to 5' (3 to 5 turns), you can pull the RHS Cradle back to its NORMAL locked position - **DO NOT PRESS THE AAB TO DO THIS.**
- You can now increase the speed to MEDIUM or HIGH - whatever you are more comfortable with at this time.

NOTE:

- Once you practice more and become more familiar with the machine, these steps will become more integrated and much easier to perform.
- If the carpet does not seem to want to roll up in the RHS Cradle immediately, just stop the process, reverse the carpet back a little and start over. You may have to jog/bounce the RHS Cradle Handle a little bit during the roll-up to assist in getting the carpet started. Also, if you experience "buckling" of the carpet during this process, just turn the LHS Rollers to OFF and then back to FWD once the buckling is removed. **BE PATIENT - IT WILL WORK!**
- Should you prefer a more loose roll-up of your carpet, just pull the RHS Cradle Handle back earlier than after 3 to 5 turns or don't even engage the RHS Cradle at the start. You will have to experiment to meet your needs.

***** REMEMBER: IF YOU CONTINUE THE ROLL-UP PROCEDURE BY PRESSING THE "JOG BUTTON" INSTEAD OF THE "FOOT SWITCH TAPE", THE MACHINE WILL NOT STOP AUTOMATICALLY AT YOUR PRE-SET LENGTH. THEREFORE, BE SURE TO USE THE "FST" AFTER YOU HAVE GOT THE CARPET STARTED SO THIS FUNCTION CAN PERFORM PROPERLY.**

ROLLING UP THE CARPET STRAIGHT

If your floor is level, your machine's Adjustable Legs are even, and the main roll on the LHS Cradle is rolled up relatively straight, then the carpet will roll-up fairly straight on the RHS. If any of these three factors do not apply, then they should be corrected immediately.

Minor coning or telescoping problems can be overcome quite easily by having the operator move along the RHS of the machine near the front corner. As the carpet continues to come across and roll-up, the operator can adjust the carpet by hand in the cradle much like he would if he were rolling it up on the floor. This procedure will eliminate any serious coning and as long as the carpet rolls up relatively straight on the RHS, then your cut will be straight & square.

AUTOMATIC SLOW DOWN

Your machine has an Automatic Slow Down Mode programmed into the Counter as well. Therefore, if you have the machine programmed for "20.00", the machine will automatically slow down to LOW speed at approximately "18.06" and stop automatically at exactly "20.00" - AS LONG AS YOU ARE ADVANCING THE CARPET WITH THE "FST" AND NOT THE "JB".

NOTE: If you wish to give a couple of extra inches to the programmed cut, you must do so by pressing the JB. If you try to step on the FST, the machine's rollers will not work because they are locked out after the pre-set length is reached. To re-activate the FST, you must press the "R" (Reset) button on the Keypad.

PRIOR TO CUTTING

Prior to making your cut, there may be a slight buckle of carpet on the table. To eliminate this, turn the RHS Rollers into FWD and the LHS Rollers in REV, and then tap the JB.

CUTTING THE CARPET

- Turn BOTH Rollers Switches to their "OFF" positions - **VERY IMPORTANT!**
- Clear the area of any potential hazards (i.e. someone may be leaning on the machine or have their hand in the path of the Cutting Bar).
- Press **"E-Z ACTION"**, & then press & hold **"F4"** or **"K3"** to activate the cutter.
- A Warning Beep will sound for approximately 3 seconds before the Cutter will start.
- Once the Cutter has completed the cut, release the button.
- Again, since it is a Two-Way Cutter, you do not have to return the Cutting Bar back to the home end of the machine for the next cut.

NOTE: USE EXTREME CAUTION AND COMMON SENSE WHEN ACTIVATING THE CUTTING BAR. SHOULD YOU NEED TO STOP THE CUTTING BAR'S PROGRESS AT ANY TIME DURING A CUT, JUST RELEASE THE BUTTON IMMEDIATELY.

WRAPPING THE ROLLS

To wrap your cut piece, turn the RHS Rollers to FWD and the LHS Rollers to OFF. Secure your stretchfilm or plastic under the edge of the carpet, step on the FST along the RHS of the machine, and wrap the roll accordingly. The same can be done to the balance roll on the LHS by turning the LHS Rollers in REV and the RHS Rollers to OFF.

REMOVING/DUMPING ROLLS FROM THE MACHINE

Once cutting and wrapping is complete, you can now remove the cut piece from the machine's RHS Cradle without the need of a lift truck. Switch both the LHS & the RHS Rollers to OFF. Press the AAB on the RHS Cradle Handle and gently lower the cradle to its DOWN position. Press and hold the ROLL DUMP button and an air piston located in the middle of the RHS Cradle will come up and push the roll off of the machine's cradle. Once complete, release the ROLL DUMP button and the air piston will return to its original position. Now you can return the RHS Cradle to its NORMAL locked position.

NOTE: Before pressing the ROLL DUMP button, you must first ensure that you open up the RHS Cradle to its DOWN position. Failure to do this will result in damage to the RHS Cradle!

NOTE: Very heavy rolls and cuts should be removed with a lift truck, and NOT by way of the Dumping Mechanism, to avoid damage to your machine and anything or anyone surrounding the machine.

***** IMPORTANT NOTE:** Although the Load Cradle (LHS) is designed to handle heavy rolls up to 40" in diameter, the Roll Up Cradle (RHS) in its *Normal* position is designed to accept rolls only up to 24" in diameter. However, for larger rolls, you can shift the RHS Cradle to its *Expanded Cradle* position. With your RHS Cradle in this expanded position, it can now handle larger rolls (up to approx. 36" in diameter). **ATTEMPTING TO ROLL UP ROLLS LARGER THAN THIS CAN CAUSE SERIOUS DAMAGE TO THE MACHINE AND IS NOT RECOMMENDED!**

Note: The roll capacities noted above along with the machine's overall performance will vary depending on the roll's weight, how tightly it is rolled, and whether or not it is slightly compressed or oblong around its circumference.

Your machine is equipped with a "left side dump" feature for dumping rolls from the left side cradle onto the floor. This feature is activated using the "DUMP LEFT" switch on the machine's control panel. For safety reasons, a warning beeper will activate for several seconds before the dump arms begin to "raise". Care must be taken to ensure personnel are safely out of the way prior to commencing dumping. The material may roll once it hits the floor, so a safe distance must always be maintained. Once the switch is released, the dump arms will return to their "lowered" position.

REVERSE ROLLING PROCEDURES

LOADING THE ROLL OF CARPET

Follow the same steps as previously illustrated for this procedure.

PREPARING TO MEASURE

Follow the same steps as previously illustrated for this procedure.

PROGRAMMING THE COUNTER

Follow the same steps as previously illustrated for this procedure.

STARTING THE ROLL UP PROCESS

- When Reverse Rolling or Back Rolling carpet, a cardboard core (no wider than 4" in diameter) must be used.
- With both Rollers in FWD, advance the carpet into the RHS Cradle bringing the edge of the carpet to rest at about the middle of the cradle.
- Place your core into the cradle and flip the carpet up so it rests on top of and covers the left half of the core.
- Engage the RHS Cradle by pressing the AAB on the cradle's handle and fold the cradle up so it pinches the carpet up against the core.

ROLLING UP THE CARPET

- With the carpet pinched in place and the Roller Speed in LOW, switch the RHS Rollers to REV and keep the LHS Rollers in FWD.
- Press and hold the JB until the carpet starts to wrap itself around the core and completes about 3/4 of it's first full turn.
- At this time, lift up on the Reverse Roll Pressure Plates (RRPP) Handle located to the right of the main control panel. This will engage the series of stainless steel plates that run the length of the machine near the middle of the RHS Cradle.
- While gently holding this Handle in place, press the JB to continue the advancement of the carpet. You will only have to hold this Handle in place for 1 or 2 seconds at which time you will see the plates actually force the carpet around the core. Once you see the carpet is starting to wrap around the core, release the RRPP Handle to it's original position.
- Continue to press the JB or FST until you get 3 to 5 turns on the core, then return the RHS Cradle to it's original locked NORMAL position.
- Adjust the Roller Speed to whatever you prefer.

NOTE:

- Remember the difference between using the JB and the FST with respect to the Pre-set programmed length - using the JB will override this feature.
- Again, if the carpet buckles slightly during the initial start-up, you can eliminate this buckling by momentarily stopping the LHS Rollers and then quickly turning them back to FWD.
- REVERSE ROLLING TAKES A LITTLE MORE PRACTICE AND PATIENCE - TAKE YOUR TIME AND DON'T GIVE UP.

MEASURING THE "TAIL END" OF THE CARPET

You must remember that when measuring a full or partial roll, you have to take into account the last section or "tail end" of carpet that doesn't get measured by the Counter after the material passes over the Counting Wheel. Using a tape, measure the section of material between the back edge of the carpet and the Cutting Track, and add it to the amount that is already recorded on the Counter's Screen. Use the Conversion Table if necessary.

ROLLING UP THE CARPET STRAIGHT

Follow the same steps as previously illustrated for this procedure.

CUTTING & WRAPPING

Follow the same steps as previously illustrated for this procedure.

REMOVAL/DUMPING

Follow the same steps as previously illustrated for this procedure.

VINYL PROCEDURES

PLEASE NOTE THAT VINYL FLOORING CAN BE HANDLED IN THE EXACT SAME FASHION AS PREVIOUSLY DETAILED IN THE CARPET PROCEDURES.

SOME OF THESE EXCEPTIONS OR OPTIONS MAY APPLY:

1) Instead of loading the roll on the LHS with the edge coming up from the BOTTOM, you can also load the material with the edge coming over the TOP with the "Pattern" facing up. In order

to advance the vinyl across to the RHS, you will have to switch the LHS Rollers into REV and provide a little more manual assistance to help the material get started. This is a little tougher procedure and takes practice, but will obviously enable you to detect any flaws or damage to the vinyl's surface during operation.

2) As per the vinyl manufacturer's specifications regarding "Tension Backed" material, you must always tape both the paper and the vinyl securely to the core prior to roll up procedures.

3) To avoid damaging your resilient vinyl flooring, we do not recommend using the "Dumping" mechanism on the machine's RHS. The use of a lift truck or manually by one or two employees is recommended for removing the roll from the machine.

IMPORTANT SAFETY & MAINTENANCE TIPS

*** WHEN PERFORMING ANY MAINTENANCE WORK ON THE MACHINE, ALWAYS DISCONNECT THE MACHINE FROM BOTH IT'S POWER SOURCE AND AIR SUPPLY.**

- * YOUR "E-Z CUT" IS A MACHINE - NOT A TOY! USE EXTREME CAUTION AND CARE WHEN OPERATING THE MACHINE AT ALL TIMES. KEEP THE OPERATING AREA CLEAR OF ALL CHILDREN AND POTENTIAL HAZARDS.**

- * WHEN HANDLING LARGER/HEAVIER ROLLS, DO NOT USE THE MACHINE IN "HIGH" SPEED. ONLY OPERATE IT IN THE "LOW" OR "MEDIUM" SPEEDS.**

- * WHEN THE MACHINE IS NOT IN USE DURING REGULAR BUSINESS HOURS, SWITCH BOTH ROLLERS TO "OFF".**

- * WHEN THE MACHINE IS NOT IN USE, ALWAYS KEEP THE "COUNTER WEIGHT ARM" (THAT IS POSITIONED DIRECTLY ABOVE THE COUNTING WHEEL) IN THE "UP" POSITION. THIS ELIMINATES ANY UNNECESSARY PRESSURE TO THE COUNTING WHEEL'S SENSOR RINGS WHEN NOT IN USE.**

- * THINK BEFORE YOU ACT AND USE COMMON SENSE! SHOULD YOU BE UNSURE WITH ANY OF THE MACHINE'S OPERATING FEATURES, CALL OUR OFFICE DIRECTLY AT TOLL FREE 1-800-661-5156.**

ROUTINE MAINTENANCE CHECK LIST

DAILY:

- > Using the "Air Pressure Hose" attached to the machine or a separate air hose or heavy duty vacuum cleaner, clean off the entire machine with extra attention to both Cradles, the Cradle Belts, and the Cutting Track.
- > Check for any oil leakage from the gear boxes. If there is a leakage, discontinue the use of the machine and call E-Z CUT immediately.

BI-WEEKLY:

- > Front & Back Cutting Track Cover Plates - remove the cover plates and clean out floor covering residue, fibres, and dust build-up.
- > Check that is no substantial grease leakage from the Cutting Track's Air Cylinder.
- > Check that the screws that secure the Bladeholder to it's base are always snug.

AFTER FIRST 3 MONTHS:

(Perform the following checks after the first 3 months of operation and then every 6 months after that):

- > Check all visible Set Screws:
 - Each Roller Bearing.
 - Each Gearbox Shaft.
 - Large Roller located in the center of the RHS (Roll-Up Side) of the machine has 4 small holes located at 4" and 12" in from both ends of the roller. Insert a Set Screw Wrench into these holes and ensure the set screws inside are tight.
- > Bearing Holder Bolts & Nuts.
- > De-grease Cradle Locking Positions on Roll-Up side.
- > Grease all 4 Caster Wheels.

YEARLY:

- > Check and change the oil in the gear box if necessary (contact E-Z CUT for instructions).
- > Check the Cutter's Cable tension by first positioning the Cutting Bar at the far end of the machine and removing the top cover panel at the front of the machine. Press down on the portion of cable that is just past the front pulley. There should be about 1/2" to 1" of 'play' in the cable. If there is more 'play' in the cable or it appears very loose, contact an E-Z CUT representative immediately.
- > The Roller Bearings are already greased and do not require regular greasing.

***** NOTE: IN ORDER TO MAINTAIN YOUR MACHINE'S OPTIMUM PERFORMANCE AND TO ENSURE ANY POTENTIAL MACHINE PROBLEMS ARE COVERED UNDER THE "E-Z CUT WARRANTY", THE ABOVE PROCEDURES MUST BE FOLLOWED AND ADHERED TO AT ALL TIMES.**

AUTOMATIC CARPET SHUTTLE CONTROL

Your machine is equipped with the "Automatic Carpet Shuttle Control" option. You will notice "K3" reads "AUTO SHUTTLE" and also a switch that reads "Cross Feeder".

In order to use the "Cross Feeder" switch, the indicator lite on "K3" must be out (Manual) . When activated, the "Cross Feeder" switch will engage the pneumatically controlled Carpet Shuttle Control arms located in the middle of the Load Side Cradle. This feature will actually

"twist" the roll of carpet that is in the Load Side Cradle so as to shift it from the back of the machine towards the front, or vice-versa, depending on which way you turn the switch. This will aid the roll-up of your carpet in the event that you have a roll that tends to telescope or walk. When the switch is released, the arms will return to their normal centred position.

When the "K3" indicator lite is on(Automatic), the Carpet Shuttle Control arms will automatically engage to keep the carpet straight as it comes across the table.

The "AUTO SHUTTLE " control uses the two "Photo Sensor Eyeholes" that are located on the top of the table between the counting wheel and the control panel. These "eyes" sense the edge of the carpet and automatically adjust the control arms to ensure the carpet edge stays in between the two and comes across straight.

IMPORTANT: The carpet edge must always be positioned and lined up between the two eyes prior to beginning a measurement. Also, the "Automatic Shuttle" system will not work very well if the carpet you are measuring has a salvage edge. The salvage edge will cause the Photo Sensor Eyes to react improperly and thus cause the carpet to move erratically.

NOTES:

- Once you learn this feature, you will notice that you do NOT have to activate this switch for a very long time in order to cause the roll to shift accordingly. Short "Bumps" work well.
- Practice on this feature with a smaller roll until you become accustomed to how it works and prior to utilizing it during a "real" measure and/or cut..
- **DO NOT HOLD & ACTIVATE THIS SWITCH FOR A CONTINUED AND/OR EXCESSIVE LENGTH OF TIME, ESPECIALLY ON LARGER ROLLS, AS IT CAN CAUSE DAMAGE TO YOUR MACHINE'S MOTORS AND SHUTTLE SYSTEM.**

"PLC" - MAIN OPERATING FUNCTIONS

PRE-SETTING A CUT:

1. KEY IN YOUR "PASS CODE" (IF REQUIRED) - PRESS ENTER.
2. KEY IN DESIRED "FEET" - PRESS ENTER.
3. PRESS ">". KEY IN DESIRED "INCHES" - PRESS ENTER.
4. PRESS ">". PRESS "SHIFT" & PRESS "Δ or ▽" TO SELECT "TYPE" - PRESS ENTER.

5. PRESS "R" TO RESET THE COUNTING ROW TO ZERO.

*** NOTE:** IF YOUR MACHINE IS EQUIPPED WITH A BAR CODE SCANNER, YOU CAN SKIP STEPS 2,3, & 4 NOTED ABOVE AND SCAN THE WORK ORDER ACCORDINGLY.

MAKING THE CUT:

1. PRESS "E-Z ACTION", & THEN PRESS & HOLD "F4" OR "K4" TO ACTIVATE THE CUTTER.

AUTOMATIC WRAP:

1. PRESS "E-Z ACTION", & THEN PRESS "F3".

MEASURE ONLY:

1. PRESS "F1".

MULTIPLE CUTS:

1. PRESS "F4".
2. KEY IN FIRST "PRESET" CUT LENGTH USING THE STEPS NOTED ABOVE.
3. PRESS "▽" TO SCROLL DOWN TO NEXT "PRESET" POSITION. KEY IN CUT LENGTH.
4. CONTINUE ON UNTIL ALL PRESET LENGTHS ARE ENTERED.
5. PRESS "ESC" TO RETURN TO THE CUT SCREEN.
6. PRESS "K4" TO TOGGLE TO THE NEXT PRESET CUT LENGTH.

*** NOTE:** IF YOUR MACHINE IS EQUIPPED WITH A BAR CODE SCANNER, YOU CAN SKIP STEPS 2,3, & 4 NOTED ABOVE AND SCAN THE WORK ORDER ACCORDINGLY.

IMPERIAL <=> METRIC:

1. PRESS "F2".

TO RETURN TO THE MAIN SCREEN AT ANYTIME:

1. PRESS "ESC".

"PLC" PROGRAMMING INSTRUCTIONS

1. When you first turn your machine on, your Screen should look like this:

E-Z CUT	press
MK10	ENTER (flashing)

Press: "ENTER".

2. Screen: **PASS CODE DISABLED**
> _<

Press: "F1"

NOTE: The above screen will only show for about 4-5 seconds before it advances into the screen for programming in your cuts. If you do not press the above buttons quick enough, just press "ESC" and repeat Step #1 above.

3. Screen: **ENTER MASTER CODE**
> _<

Key In: "1-2-3-4" and then press "ENTER".

YOU MAY NOW SELECT FROM THE FOLLOWING FEATURES & FUNCTIONS....

4. Screen: **CHANGE OPERATOR CODE**
DISABLE=0 0>>

Feature: This screen allows you to enter a code for safety and security reasons. Key in

your preferred code (up to 7 numbers) and press "**ENTER**". Every time the machine is turned on, it will require this operator's code to function.

Steps: If you key in "**0**", this feature will remain disabled.

Press: \vee (Down arrow key) to advance to the next feature.

5. Screen: **CHANGE MASTER CODE**
CAUTION 1234>>

Feature: This screen is set at our factory for "**1234**" and can be changed following the same steps as in #4 above. This is a higher level of security and it is recommended that you leave this feature enabled as is.

Press: \vee (Down arrow key) to advance to the next feature.

6. Screen: **ENABLE WRAP FEATURE**
CAUTION ENABLED>>

Feature: This feature allows the control of the "Roll-Up" side of your machine by stepping on the Foot Switch Tape only once. After that, the machine's rollers will run continuously for 30 seconds or until you step on the tape again.

Steps: - Press "**SHIFT**" then " \vee " or " \wedge " to select your desired setting.
- Press "**ENTER**" to lock in your selection.

Press: \vee (Down arrow key) to advance to the next screen.

7. Screen: **AUTO SHUT OFF TIME**
1-250 MINUTES 10>>

Feature: This screen shows you how long the machine will stay on before it is automatically shut off if it is not used. The factory setting is 10 minutes.

Steps: Key in your preferred time in minutes - up to 250 - and then press "**ENTER**".

Press: \vee (Down arrow key) to advance to the next screen.

8. Screen: **0' 0" TO END SHIFT**
 OPTION1 0 & F4

Feature: This feature allows you to automatically calibrate and lock in the calibration on a specific type of material so as to ensure exact measurements on that type of material every time. These are in addition to the 4 factory preset options.

Steps: - Measure out a piece of material, at least 35' long, on the floor and mark the piece on the backing of the material at 30'.
 - Key in **30' 0"** on the screen and load your material onto the machine.
 - Advance the front edge of the carpet up to the cutting track, lower the top pressure wheel, reset the counter to "0" by pressing the "R" button, and run the material through the machine until the 30' mark is lined up exactly with the cutting track.
 - Press **"F4"** to lock in this calibration setting.
 - "Option 1" will now be set for this type of material.
 - Repeat these steps for Option 2, etc..

Press: \ (Down arrow key) to advance to the next screen.

9. Screen: **L-ROLL 0.0 HOURS**
 R-ROLL 0.0 HOURS

Feature: This screen shows the hours of motor usage on both the Left & Right sides.

Press: ^ (Up arrow key) to back up to the previous screen OR press **"ESC"** to return to the **"PASS CODE DISABLED"** screen.

*** MODE OF MEASURE:**

Once in the **"PASS CODE DISABLED"** screen, press **F2**.

Screen: **MODE OF MEASUREMENT**
 SELECT FEET_

Feature: This screen allows you to select between FEET (Imperial) or METERS (Metric).

Steps: - Press **SHIFT"** then **"\"** or **"^"** to select your preferred mode.

- Press **"ENTER"** to lock it in.
- Press **"ESC"** to exit back to the **"PASS CODE"** screen.

*** DATE & TIME:**

Once in the **"PASS CODE DISABLED"** screen, press **"F3"**

Screen: **DATE: MAR. 09, 1998**
 TIME: AM 09:00:24
 DAY: MONDAY

Feature: This screen allows you to set the correct Date & Time.

- Steps:
- Press **"F1"**
 - Move the blinking cursor with the arrow keys to select the field to be changed.
 - Press **"SHIFT"** then **"V"** or **"^"** to change a field value.
 - Press **"ENTER"** to lock in a value and then an arrow key to move to the next one.
 - When complete, press **"F4"** to return to the Date/Time screen.
 - Press **"ESC"** to exit back to the **"PASS CODE"** screen.