



OPERATOR'S MANUAL

ACCU-CUT Q-9

Carpet and Vinyl Cut & Roll Machine

**For Parts or Service contact
Accu-Cut Support 1-800-222-8288**

Brockie International Inc. 28114 County Road 561, Tavares, Florida 32778
voice 800.527.7057 ♦ 352.742.0902 fax 352.742.0702
e-mail: info@accu-cut.com ♦ www.accu-cut.com

CONTENTS

INTRODUCTION	4
SAFETY PRECAUTIONS	5
DEFINITIONS	6
ABOUT THE MACHINE	7
OPERATING PROCEDURES.....	8

•*Procedures for cutting*

Loading the material.....	8
Adjusting the shuttle cradle	8
Adjusting the size of the load cradle	8
Unwrapping new & tightening loose rolls	9
Positioning the material.....	9
Entering the cut length.....	10
Setting the speed control.....	10
Rolling up the material	11
Monitoring the roll	11
Cutting the material	12
Sharpening the blade.....	12
Wrapping the cut length.....	12
Dumping the cut length	13
Dumping material in the load cradle	13

•*Measuring roll balances*

Loading the material.....	13
Programming the counter	13

•*Procedures for reverse rolling*

Rolling up the material	14
A few words about reverse rolling	14

PLC COUNTER FEATURES AND OPTIONS..... 16

•Customizing Settings

- Accessing the master menu -----16
- Changing the password-----16
- Changing the timer-----17
- Eliminating the timer -----17
- Changing the cutter (blade reminder) -----17

•Preset Measurements

- Storing a preset measurement -----18
- Selecting a stored preset measurement -----18

SET UP INSTRUCTIONS..... 20

PREVENTIVE MAINTENANCE..... 21

CIRCULAR CUTTER MAINTENANCE 22

TEST STRIP INSTRUCTIONS..... 23

TROUBLE SHOOTING 24

PARTS DIAGRAMS..... 26

ELECTRICAL DIAGRAM..... 37

INTRODUCTION

Congratulations on the purchase of your **ACCU-CUT Q-9** carpet and vinyl cutting and rolling machine. Your **ACCU-CUT** machine has been carefully engineered and manufactured to provide you with many years of dependable service and trouble free operation.

Proper operation and maintenance is essential to ensure precise and dependable operation of your **ACCU-CUT**. We encourage you and your employees to read this manual carefully and become familiar with the operating and maintenance procedures for this machine.

This manual is designed to cover all areas of operation, maintenance, and troubleshooting in order to minimize problems. Always follow all safety rules and precautions when operating or performing maintenance work on the machine.

Again, congratulations and thank you for choosing **ACCU-CUT** to provide you with quality equipment and quality service. The confidence you and hundreds of others have placed in us has helped to make **ACCU-CUT** the most respected name in floor covering cutting and merchandising equipment. Should you ever have any questions or concerns regarding your **ACCU-CUT** please do not hesitate to contact us.

BROCKIE INTERNATIONAL, INC.

SAFETY PRECAUTIONS

In order to avoid personal injury, make sure the operator(s) and/or maintenance person(s) of the machine have been oriented with the machine's operating procedures and are aware of all safety precautions.

- 1. Unplug power cord before making any adjustments or repairs.**
- 2. A qualified electrician should perform electrical repairs.**
- 3. Do not operate machine on a wet floor.**
- 4. Use extreme caution when replacing cutter blades.**
- 5. Keep hands clear of all moving components while machine is running.**
- 6. Keep loose clothing and articles away from all moving components while machine is running.**
- 7. Keep machine unplugged while not in use.**
- 8. Do not allow children near the machine.**
- 9. Keep machine clean of all plastic wrap, carpet fibers, and all other debris.**
- 10. Ensure machine is stationary and will not roll on casters.**
- 11. Stay clear of moving load side shuttle cradle.**
- 12. Do not remove chain covers except for servicing.**
- 13. Keep space beside cradles (dumping areas) clear.**

DEFINITIONS

ACCU-CUT: Trade name of equipment you have purchased.

LOAD SIDE CRADLE: Refers to the roller carriage located on the side of the machine where the operator places the full or partial roll of flooring.

ROLL UP CRADLE: Refers to the roller cradle located on the opposite side to the Load Side Cradle which rolls up the flooring.

CONTROL PANEL: The area where your equipment is operated. This panel houses the directional controls, variable speed control, and the programmable logic control display.

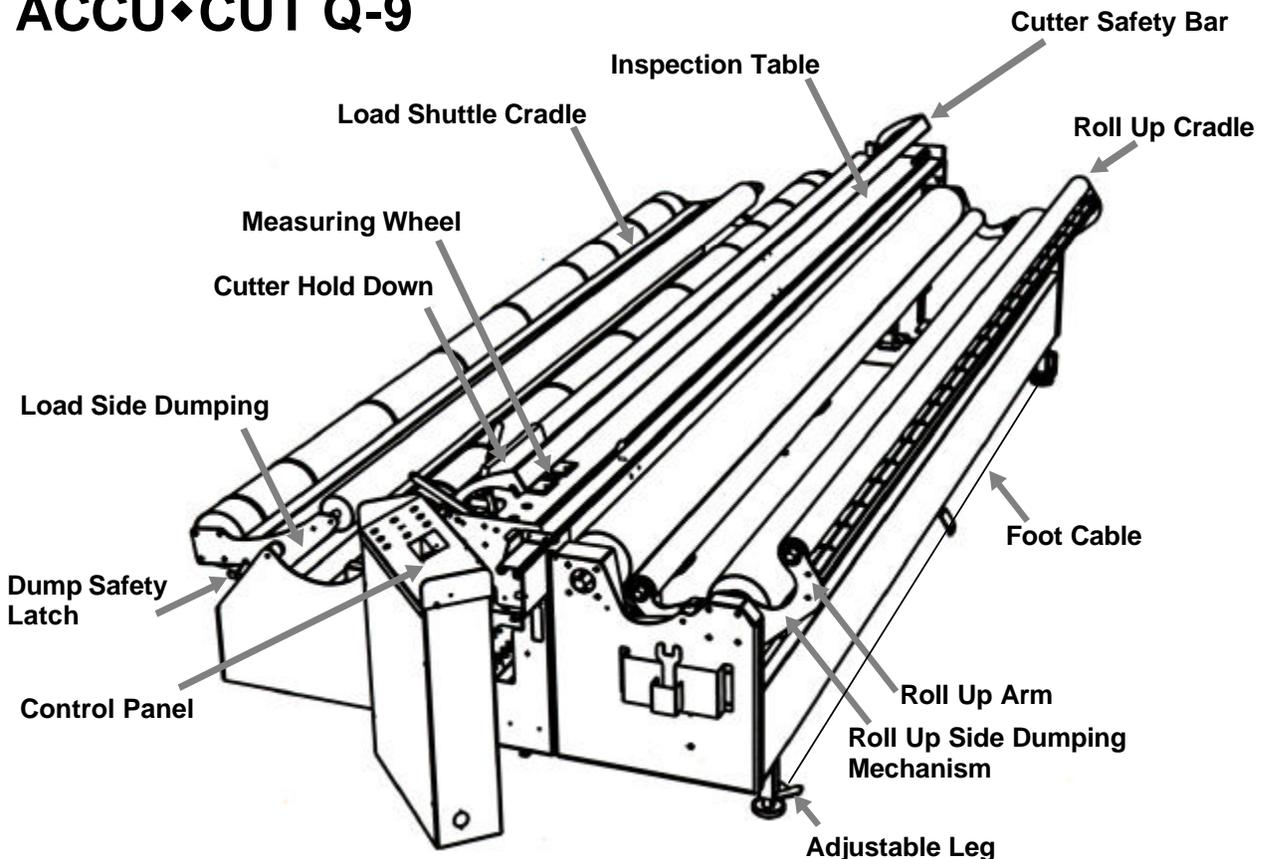
PROGRAMMABLE LOGIC CONTROL: (PLC) display. This display has the foot and inch counter, shuttle cradle control as well as other advanced controls.

INSPECTION TABLE: Area used by the operator to visually inspect the goods being measured and cut for the customer.

HOLD DOWN ARM: This is the arm that holds flooring firmly on counting wheel.

MEASURING WHEEL: This device is connected to the advanced encoder that emits 600 pulses per revolution.

ACCU♦CUT Q-9



ABOUT THE MACHINE

The **ACCU•CUT Q-9** cut and roll machine consists of two sets of steel rollers that are referred to as cradles. The side where material is loaded is the **load side cradle**, while the opposite side is the **roll up cradle**. The roll up cradle is designed to run slightly faster than the load side to ensure a tight roll up of material. Each cradle is chain driven by heavy duty UL & CSA approved electric motors.

The Q-9 is operated from the **control panel**, which includes the **directional controls**, **variable speed control** and the Programmable Logic Control or **PLC Interface display** which houses the **foot & inch counter**, **shuttle cradle control** as well as other advanced controls.

The **ACCU•CUT Q-9** measuring system is extremely accurate. It consists of a large diameter, knurled **measuring wheel** located in a cutout of the **inspection table** below the **hold down arm**. The measuring wheel is connected to an advanced encoder that emits 600 pulses per revolution. The encoder communicates with the foot & inch counter in the PLC to provide you with an accurate measurement.

The cutter assembly on the Q-9 consists of 5 1/2" or 4 1/2" circular blade positioned within a cutter assembly inside the **cutting track**. The Q-9 also has a **cutter bar** that not only covers the blade while making a cut but also holds the material tight. The cutter assembly is chain driven by a dedicated cutter motor. (*The 4 1/2" circular blade is used primarily for commercial vinyl.*)

The circular blade is self sharpening.
(*see sharpening blade on page 10 for details*)

A wrap around **foot control cable** is provided to operate the machine "hands free" while inspecting wrapping, unwrapping, or tending the roll. It can be set to be on only when you step on the foot cable or as a toggle. So the machine stays in an on position.

The IVC 15 also includes a **dumping mechanism** on both the **load side cradle** and **roll up cradle** that will quickly and simply offload the material onto the floor allowing another roll to be loaded without removing the goods with a forklift. The **load side dumping mechanism** is particularly useful when used in conjunction with a feed table.

OPERATING PROCEDURES

PROCEDURES FOR UNROLLING AND CUTTING

Loading the material

Place the material on the **shuttle load cradle**, making sure the leading edge of the material is feeding across the **inspection table** from the **bottom of the roll** with the **pile side up and the backing down** – vinyl can be measured pattern up or down. Place the roll in the cradle with the end of the roll just past the last belt on the front end of the cradle



Photo 1A

Roll-Improver

This feature is useful to position the roll in the load cradle, as well as squaring the leading edge to the cutting line. In normal operations make sure the roll improver is down at both ends while roll is rotating. By moving either end of the roll improver up and squeezing the roll at the same time you can cause the roll to walk to the front or back of the load cradle, when the roll is positioned ensure that both ends of the roll improver are down. When the leading edge of the material is off square you may adjust this by activating the roll improver as well as the amount of squeeze on the roll in the load cradle. Make sure that the roll improver is back in the lower position after material has traveled several feet



Photo 1B

Adjusting the size of the load cradle

The size of the **load cradle** can be adjusted by moving the **load side dumping mechanism** and altering the position of the outside roller. Adjusting the size of this cradle to a size consistent with the diameter of the material provides the operator with greater control over the material, by squeezing the roll it keeps the roll squared to the cradle.

Adjusting the shuttle cradle

The Q-9 is equipped with a **shuttle cradle** that can be used to properly line up the material on inspection table. The edge of the material should be within a few inches of the bumper at the front of the inspection table. Adjusted by arrows (Photo 1B) buttons on PLC.



Photo 1C
Shuttle Cradle Forward Position



Photo 1D
Shuttle Cradle Back Position

Unwrapping new rolls and tightening loose rolls

After loading the wrapped roll, cut the plastic the full length of the roll and at each end. Position the load cradle **roller directional switch** in the reverse position, and then step on the **foot cable control** while pulling off the plastic wrapping.

If you have a loose roll, run the **load cradle** rollers in reverse by placing the load cradle **roller directional switch** in the reverse position and pressing the **jog button** or stepping on the **foot cable control** to activate the load cradle rollers. Continue to run the rollers in reverse until the roll has tightened.

Positioning the material

Raise the **hold down arm**, lifting it off the **measuring wheel**. Set both **roller directional switches** to forward. Step on the **foot cable control** or press the **jog button**, advancing the material to the center of the **cutting track** (see photo 3A). Now lower the **hold down arm** back on to the **measuring wheel**. Failure to lower the **hold down arm** will result in an inaccurate measurement.



Photo 3A

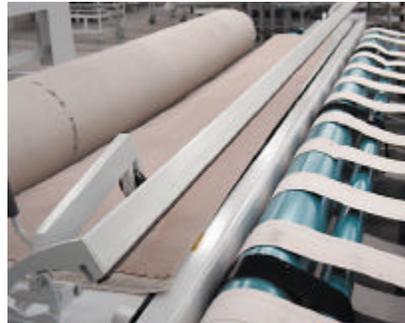


Photo 3B

Note: If the material is off square, line the trailing edge of the material with the **cutting track** (see photo 3B).

Entering the cut length

With the material lined up in the center of the **cutting track** the counter must now be reset to zero by pressing “Count Clear” button on PLC it can now also be programmed with the desired cut length.

To enter your desired cut length:

- ◆ Press clear to erase the previous measurement – *in this example the previous measurement was 18’ 6” (see photo 4A)*
- ◆ Enter the number of feet & inches to be cut – *in this example 12’ (see photo 4B)* – Press enter
- ◆ If 12 ft. 8 inches enter 1208 if 12 ft. 11 inches enter 1211

The desired cut length is now entered into the counter and the roll up process can begin.



Photo 4A



Photo 4B



Photo 4C

Note: ENSURE THAT CARPET 1 IS SELECTED. This will be indicated in the display by “CARPET 1” Failure to have carpet 1 selected could result in inaccurate measurements.

Setting the speed control

The speed at which the rollers turn can be quickly and simply adjusted by turning the **variable speed control knob** located on the control panel. It is recommended keeping the speed at a low setting when beginning the roll up process and increasing the speed as the roll increases in size.



Photo 5

Rolling up the material

Now that the counter is set to zero (0) advance the leading edge of the material just past the center of the 2nd. big roller on the roll up cradle, (see photo 8A) *(if using a paper core, place it on top of the material in the cradle now)*. Now close up roll-up arm (see photo 8B).

Warning: Keep hands clear of the roll-up arm.



Photo 8A



Photo 8A

Advance the material till the desired length.

NOTE: After the material has made several revolutions open roll-up arm (see photo 8C) *(If roll-up arm is not opened early enough the material may pile up on the inspection table)*.

Keep pressure on the roll to ensure a tight roll (see photo 8D).

(You may also tighten the roll by continuing to rotate it after the cut).

Should the roll need to be adjusted in the cradle, open roll-up arms and adjust by hand.



Photo 8C



Photo 8D

Cutting the material

When there is less than one foot remaining to be measured the machine will automatically slow down and stop precisely at the programmed length. Before activating the cutter ensure the length of cut that the counter registers is the desired length and if it is not jog the material accordingly; now lower cutter safety bar and turn cutter switch knob in the direction the cutter needs to travel. Release knob when cutter reaches the end.

Note: When processing 15' wide material the cutter should be stored at the **control panel** end of the machine. If the cutter is left at the far end of the machine it may interfere with the material as it moves across the **inspection table**.

Sharpening the blade

The cutting system on the Q-9 is equipped with a self-sharpening mechanism – it is not necessary to remove the blade for sharpening. When the blade reaches the front end of the machine a “clutch” engages leaving the blade stationary while rotating against the sharpening mechanism. To sharpen the blade simply keep the cutter engaged when it reaches the end of the cutting track. It is recommended that the blade be sharpened for 7 to 10 seconds after every 50 cuts.

Wrapping the cut length

To wrap the cut length, keep the roll-up cradle **roller directional switch** in the forward position and place the load cradle **roller directional switch** in the off position. Place the wrapping material inside the flap of the material you are wrapping. Stepping on the **foot cable control** will rotate the roll, letting you wrap the material while it is still on the machine.



Photo 11A



Photo 11B



Photo 11C

Caution: Keep hands and all loose clothing away from moving parts.

Dumping the cut length

The cut length can be dumped on to the floor by opening the roll-up arm fully. To assist the dumping process jog the roll-up cradle forward.



Photo 12A



Photo 12B



Photo 12C

Caution: Make sure the area is clear before dumping the cut length.

Dumping the material in the load cradle

The material in the **load cradle** can be dumped on to the floor by releasing the dump safety latch (Pull latch towards you) and at the same time open load cradle fully. To assist the dumping process jog the roll-up cradle in reverse.

Caution: Make sure the area is clear before dumping the cut length.

MEASURING ROLL BALANCES

To determine the balance remaining on a roll or to check the length of a new roll perform the following procedures:

- ◆ Program the counter:
 1. **Press clear**
 2. **Enter a large number i.e. 5000'** – since the length of the roll is unknown it is necessary to enter a number much larger than the estimated length of the roll
 3. **Press enter**
- ◆ Line up the edge of the material to be measured to the center of the **measuring wheel** pile side up. (see photo 13)
- ◆ **Press clear** count to reset the counter to zero
- ◆ Follow the procedures for “Rolling up the material” detailed on page 9



Photo 13

- ◆ Continue rolling up the material until the final few feet of the roll is reached. At this point slow down the speed of the rollers using the **variable speed control knob** and continue advancing the material until it is centered with the **measuring wheel**.
- ◆ The measurement indicated on the counter is the length of the material.
- ◆ **Note:** Failure to slow down the rollers at the end of the measurement may result in the measuring wheel continuing to turn *and* measure even after the trailing edge of the material has passed the wheel. This will result in an inaccurate measurement.

PROCEDURES FOR REVERSE ROLLING

Reverse rolling is an effective manner of merchandising remnants. Several dealers even merchandise full rolls pile side out. An optional **top counter** and **pinch roller** may be necessary for reverse rolling full rolls.

The procedures for reverse rolling are identical to the procedures for “*Measuring roll balances*” (page 13) with the following exceptions:

Rolling up the material

After setting the **counter**, either press the **jog button** or step on the **foot cable control**. Place the paper tube in the roll-up cradle and advance the leading edge of the material until it reaches the second, big roller on the roll-up cradle (see photo 14A). Position the material on top of the tube.

Leave the load cradle **roller directional switch** in the forward position but place the *roll-up cradle roller directional switch* in the reverse position.

Close the **roll-up arm** and engage the rollers by stepping on the **foot cable control** or pressing the **jog button**. The **roll-up arm** will cause the material to begin rolling in reverse around the cardboard tube and start the roll-up procedure. (see photo 14B). After the material has made several revolutions open the roll-up arm. (see photo 14C).

NOTE: If the material is walking up on the inspection table momentarily shut off the roll-up cradle to allow load cradle to catch up.



Photo 14A



Photo 14B



Photo 14C

A FEW WORDS ABOUT REVERSE ROLLING

Reverse rolling is a simple process but often takes time to perfect and learn – be patient. There are numerous times when and how reverse rolling can occur. We have tried to list the most common below.

Reverse rolling the balance of a roll after making a cut:

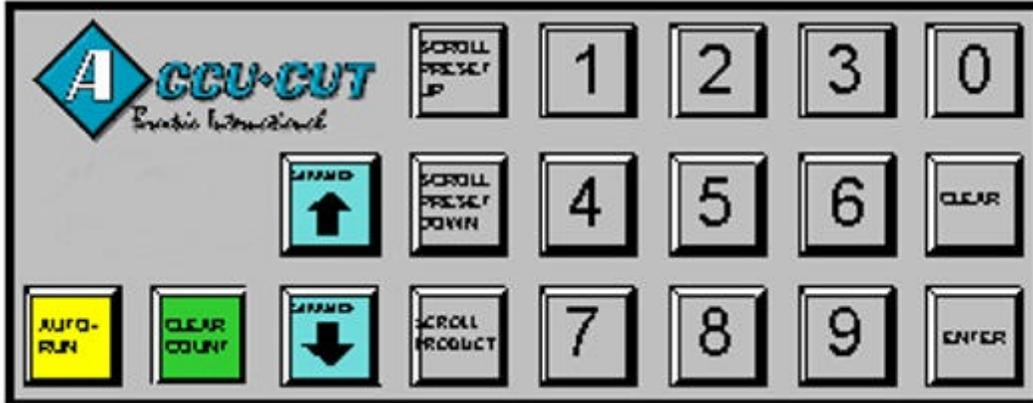
After removing the cut length from the roll-up cradle, reverse the material in the load cradle so that the leading edge is centered with the measuring wheel. Reset the counter to zero then follow the steps at the top of the page. The measurement indicated on the counter is the length of the material.

Reverse rolling with the material coming off the top of the roll and pile side down:

If the length of a roll is already known, some operators will choose to reverse roll the material having the material feed from the top of the roll with pile side down. This method allows the operator to keep roll-up cradles in the forward position, load side reverse and use the roll-up arm in the same manner as when making a cut. *Please note that it is not possible to get an accurate measurement with the pile side down.*

COUNTER OPERATING INSTRUCTIONS Ver. 2.02

Congratulations on your purchase from **Brockie International / Vidir Machine Inc.** This machine is equipped with an advanced 16-bit microprocessor PLC unit to ensure accurate measurement. To communicate with this PLC we have provided a user-friendly interface. Simply enter your commands into the keypad and watch the machine do the work for you.



Keypad Familiarization

Grey keys-	Data entry / Presets / Product
Yellow key-	Auto run
Blue key-	Carriage control
Red keys-	Cutter and cutter safety

Password Protection

This unit is equipped with a "Password Protection" feature. Every time the machine is turned off or is unused for a designated time the machine prompts the user to

"ENTER PASSWORD"

- To enter the password:
1. Press **CLEAR** to remove asterisks
 2. Type in the four digit security code (Factory preset is "4321")
 3. Press **ENTER**

You have now gained access to the machine and may begin to roll, measure and cut the product.

Setting Preset Length

This unit is equipped with a multi-preset feature that enables the user to enter the required length of material into the machine's memory. This will prompt the machine to automatically slow down the rolling process approximately one foot before the desired length has been reached. It then slowly rolls to the preset length.

- To enter a preset length:
1. Press **CLEAR** to erase the previous measurement
 2. Type in the desired amount of feet & inches
(last 2 digits are inches if imperial or centimeters if metric)
 3. Press **ENTER**

Your desired length is now entered into the counter. You are now ready to roll and cut the product.

Multi-Cutting

This unit is equipped with nine pre-programmable lengths. You now have your first preset selected. To change to another preset press **SCROLL PRESET** up or down. This will change your preprogrammed length. Press clear to change the pre-programmed length. . To program all 9 presets simply repeat the procedure described in "Setting Preset Length". Once you have completed this, the lengths are stored in the memory of the machine and remain present even when the machine is unplugged. This feature is very useful when cutting a series of same size pieces for a given house plan for example.

Rolling the Product

1. Bring carpet to the center of the cutting bar.
2. Verify that your desired carpet length is in the display
3. Press **CLEAR COUNT** to clear the counter
4. Advance the carpet to the middle of second roller on IVC 15
5. Lift the roll-up cradle
6. Run the machine until it stops
7. Verify the count (reverse direction if necessary)

Cutting the Carpet

Now that you have accurately measured the carpet you are ready to proceed with a cut. Turning the cutter switch with the cutting bar down controls the bi-directional cutter. A beep provides the user with a warning that cut is being performed. The counter also keeps track of the number of cuts the machine has made. This is helpful to help gauge your blade life expectancy.

CUTTER and cutting bar down: **CUTTING CARPET NOW
(CUT #)**

Carriage Control

Your machine is equipped with a movable carriage which may be adjusted through the interface

When **CARRIAGE** is pressed and the machine's carriage travels away from the operator.

When **CARRIAGE** is pressed and the machine's carriage travels towards the operator.

Multiple Scale Factors

Sometimes different products grip the count wheel differently due to their adhesive nature. We have taken this into consideration by allowing this machine to retain six separate scale factors to accommodate a variety of materials. Differently product may be selected at any time by pressing **SCROLL PRODUCT**. This changes the screen to display another product.

Examples of different presets measuring differently:

	<u>IMPERIAL</u>		<u>METRIC</u>	
Scroll product once:	CUT 1	0' 0"	CUT 1	0 CM
	CARPET	120' 0"	CARPET 1	608 CM
Scroll product twice:	CUT 1	0' 0"	CUT 1	0 CM
	CARPET	19' 10"	CARPET 2	603 CM
Scroll product thrice:	CUT 1	0' 0"	CUT 1	0 CM
	CARPET	3 20' 1"	CARPET 3	611 CM
	(etc...)			

The user is responsible to verify the accuracy of the count for the product sold and to arrange required certification. The manufacturer or its agents cannot be held responsible for any inaccuracies in cut lengths.

Master User's Menu

This counter may be tailored to better suit the user of the machine. When 3 fingers are depressed on the logo a MASTER PASSWORD is brought up.

MASTER PASSWORD

To enter the master password

1. Press **CLEAR** to remove asterisks
2. Type in the 4 digit master password
3. Press **ENTER**

Upon entering the correct password you now have gained access to the Master Users Menu.

The word menu will then appear followed by a scrolling line below it:

MENU
1 CHANGE PASSWORD 2 CHANGE TIMER 3 CHANGE BLADE 4 METRIC/IMP
5 SLOW DOWN 6 CALIBRATION 7 FS AUTO RUN

The user selects one of the options by pressing **1, 2, 3, 4, 5, 6, or 7** and now has gained access to their desired feature.

Changing the Password

The four-digit security code is changeable for your convenience.

To change the code:

1. Access the master menu as described above
2. Press **1**

The following then appears:

ENTER NEW PASSWORD

To enter a new password:

1. Press **CLEAR** to remove asterisks
2. Type in a new password
3. Press **ENTER**

Changing the Password Timer

When the unit is left idle for a period of time, the user is locked out. However, that period of time may be varied by the user for up to 999 seconds. If 0 is entered, the password timer and password is disabled.

To change timer:

1. Access the master user menu as described earlier
2. Press 2

The following screen now appears:

**NEW PASSWORD TIMER
SECONDS**

To change the timer value:

1. Press **CLEAR** to remove old timer value
2. Type in the desired time in seconds
3. Press **ENTER**

You have now changed the length of time the machine requires before it turns itself off without input.

Factory preset is 120 seconds. If the machine will be located in a publicly accessible location we recommend a time of 15 seconds. The operator should never leave the machine unattended while the password is active and the cutting blade is in the garage. The manufacturer or its agents cannot be held responsible for any injuries to anyone of any kind howsoever caused. The operator is solely responsible for safe operations and mechanical and electrical condition of the machine at all times.

Metric/Imperial Measurement

This counter is able to measure in feet and inches as well as centimeters. It may be used in imperial mode, metric mode, or be switched between the two at the press of a button.

To change measurement mode:

1. Access the master menu
2. Press 4

The following then appears: **1 IMPERIAL 2 METRIC**

Press the number of the desired mode in which you wish to count in.

Slowdown

The user is now able to determine how many inches before completion the carpet cutting machine enters its slow down mode.

To access slow down:

1. Access the master menu
2. Press 5

The following then appears:

**SLOW DONE _ _"
BEFORE STOPPING**

To change the length:

1. Press **CLEAR**
2. Type in the desired length in inches
3. Press **ENTER**

Your machine will now slow down your entered amount of inches before stopping.

Calibrating the Machine

The calibration of all 6 scale factors of this machine may be changed using the master menu.

CAUTION: Do not attempt to adjust the scale factor. For technical support please contact Brockie International at (800) 527-7057

Foot Switch Auto Run

This machine is capable of rolling automatically to a stop without having a finger depressed on the jog button (although the user must always pay full attention to the machine). This feature can also be useful in stretch wrapping. Instead of having to walk along the side of the machine hobbling along with one foot on the cable the user steps on the cable once and the rollers turn until the foot cable is stepped on a second time or by pressing the auto run button.

To activate auto run: 1. Access the master menu
 2. Press **Z**

The following then appears:

F. S. AUTO RUN
1 YES 2 NO

To activate feature: 1. Press **CLEAR**
 2. Type in **1** to activate
 3. Press **ENTER**

The feature has now been activated.

SET UP INSTRUCTIONS

MACHINE SETUP

When lifting the machine with the forklift, always lift from the load side inserting the forks through loops provided.

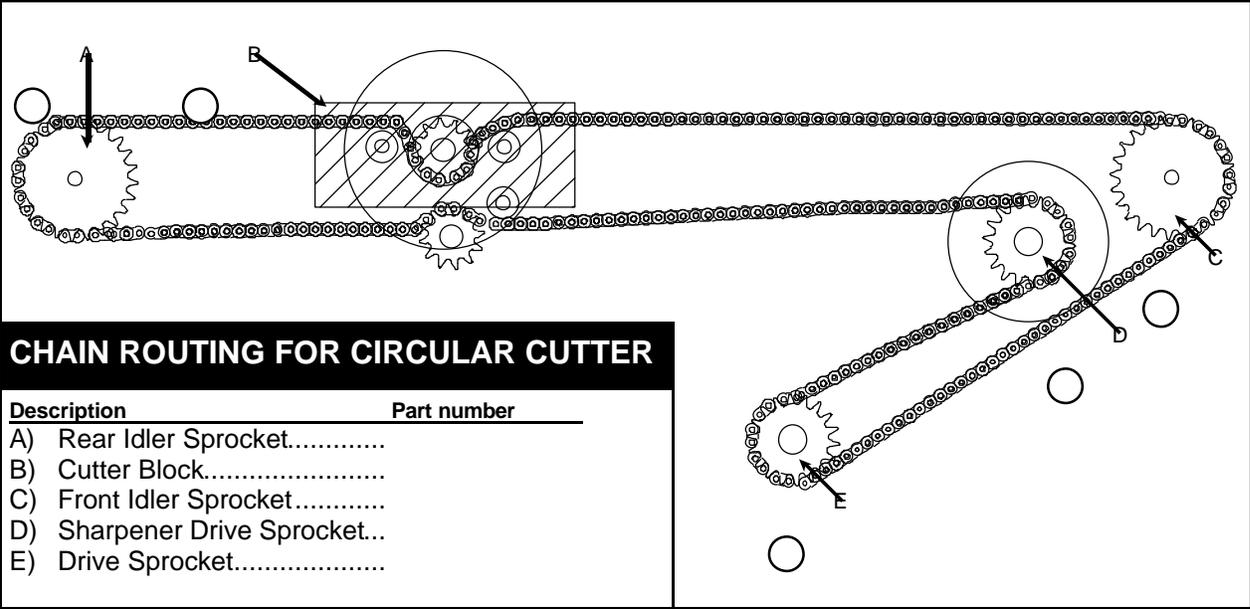
Attach foot cable to links (5 Links)
 Attach Eye-Bolts and tighten. Do not overtighten, or machine stays in the on position.

Attach air line. Lift latch and hinge control panel out of the way . Operation pressure is 100 to 125 PSI. A compressor that will supply a minimum of 4 cubic feet per minute at 90 PSI is recommended.

Plug cord into 220 volt outlet. Keep cord and airline away from forklift traffic.
 With wrench provided, screw legs down taking weight off the wheels. (4 legs)

MAINTENANCE

- Drain water from water separator regularly.
- Keep cutting blade sharp. Replace sanding disks as needed.
- Check chain tensions periodically and tighten as needed. To check cutter chain tension, bring cutter 2 ft. from end of machine. Sag in the chain should not be more than 1" (25mm).



PREVENTIVE MAINTENANCE

Weekly:

1. **Check conditions of belts and belt lacing.** Repair, if possible, any damaged belt lacing contact Accu-Cut for replacement belts.
2. **Check control switches** for proper operation.
3. **Check operation of counter assembly.**
 - ◆ Check that measuring wheel is secure and does not have any cracks or excessive wobble.
 - ◆ Check the “grooves” or “knurls” on the measuring wheel. Ensure the wheel does not have smooth or bald spots.
 - ◆ Make sure wheel is at proper height above opening in the table. Wheel must be at least a credit card thickness above opening or the pads on either side of the opening.
 - ◆ Check condition of measuring wheel shaft and its connection to the counting device. Make sure the shaft is secure and not bent.
4. **Clean machine** of debris and/or carpet fibers, particularly on or around the motor areas, chains, sprockets and cutting track.
5. **Check tension on all cables and chains.** Adjust as necessary for proper operation.
6. **Check calibration of counter.** Follow the Test Strip Instruction sheet in this manual to check your calibration. Contact your Accu-cut Service Representative before attempting re-calibration.

Monthly:

1. **Check the alignment** of all sprockets, pulleys and rollers for proper operation.
2. **Check allen screws** on all sprockets, pulleys and locking collars.
3. **Check condition of the electrical outlet** on machine. Ensure outlet is secure.
4. **Check gearboxes** for proper oil level. Use 90-weight gear oil, if needed.
5. **Lubricate all drive chains** with light oil.

Yearly:

1. **Lubricate all roller bearings** with grease gun
2. **Lubricate all bearings for cutter drive assembly** with grease gun.
3. **Lubricate counter shaft bearings** with grease gun.
4. **Lubricate swivel castor wheels** with grease gun.

CIRCULAR CUTTER MAINTENANCE

How to perform maintenance on your cutter:

1. Remove blade from cutter assembly. Flush cutter block assembly and clutch mechanism, (white metal piece attached to bottom of the blue cutter block assembly), with an aerosol spray such as WD-40 or similar product. Run the cutter up and down table a few times to remove excess cleaner. Wipe dry as much as possible.
2. Use a Silicone or Teflon based spray to lubricate all moving parts of the cutter assembly. Avoid spraying Silicone into the bronze bushings of the clutch mechanism.
3. Clean blade and spray with silicone or Teflon spray.
4. Inspect pulleys and drive belt on cutter motor. Make sure the belt is in good condition, (no cuts, fraying or glazed look on its sides), and is kept tight at all times. Make sure there is no foreign matter on the pulleys or drive belt.

This procedure only takes about 10-15 minutes to complete. Depending on the amount of cuts you make a day will determine how often this procedure should be repeated.

Example: 50 or more cuts a day – once a week.

***Do not over tighten the cutter chain or clutch assembly. Over tightening of these may cause failure of assembly and / or cutting operation. The cutter chain should be tight enough so the chain will not slip off of the sprockets but also, not so loose that the upper and lower part of the chain “slaps” together as the cutter moves down the cutting track. If after maintenance of the cutter assembly and chain adjustment, the cutter is still not cutting correctly, make $\frac{1}{4}$ turn on each of the tension bolts on the “legs” of the clutch mechanism. Ensure that each spring on those bolts are compressed equally. Again, please do not over tighten clutch mechanism.**

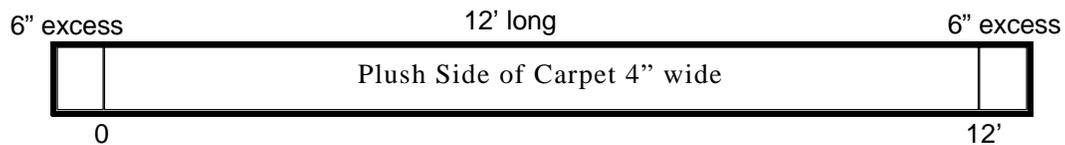
***Depending on the amount of cuts you make per day, the blade should be flipped over to ensure proper sharpening of the cutter blade. If you make over 50 cuts per day, you should flip the blade over at least once a week. Do not forget to use a Silicone or Teflon spray on the blade to help prevent latex build up on the blade.**

In following these procedures you will find that your cutter will operate to its fullest capabilities and prolong the life of your cutting assembly. If you have any questions concerning these procedures contact the Accu-Cut Service Department at 1-800-222-8288.

TEST STRIP INSTRUCTIONS

How to make a test strip:

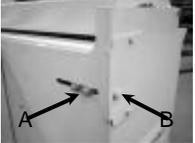
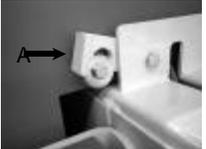
1. Cut a strip of carpet that is 4 " wide by 13' long.
2. Center your tape measure on strip of carpet.
3. Draw a line at 0 and a line at 12'.
4. DO NOT cut off excess material.



How to use a test strip:

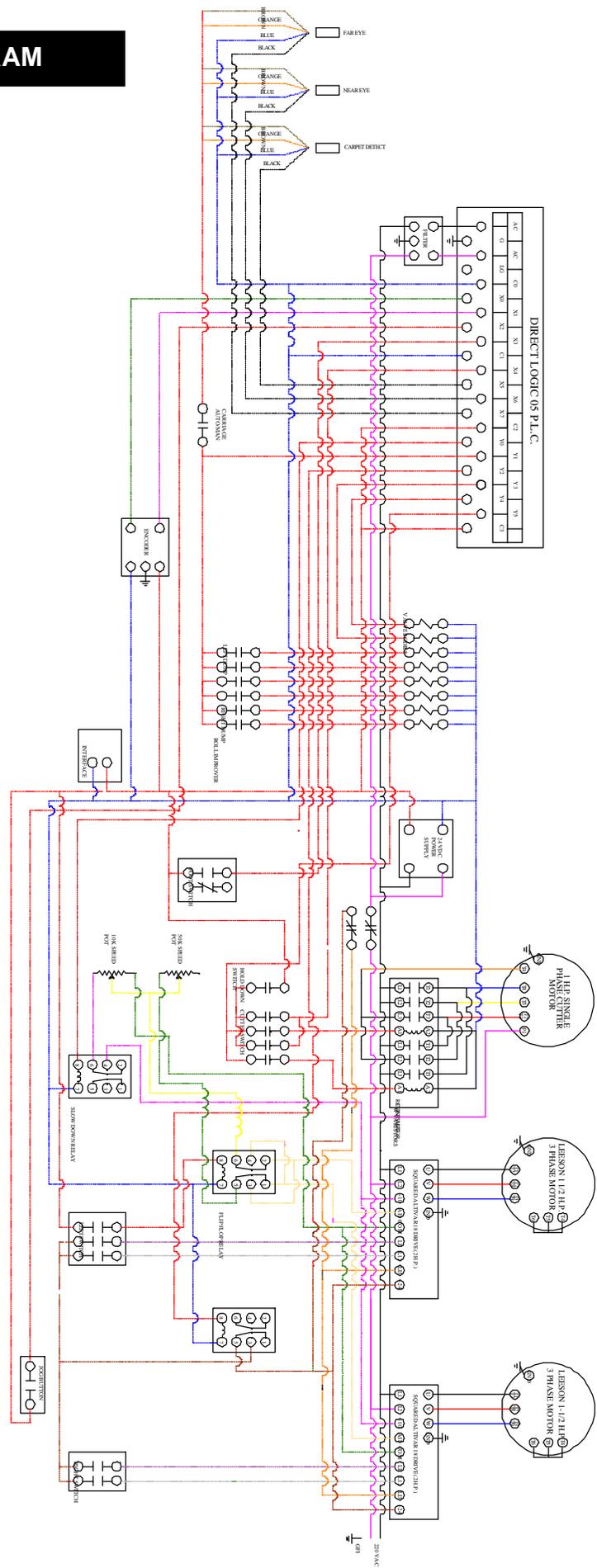
1. Unwind test strip plush side up, line up the black hold down arm over wheel with 1st black line on test strip.
2. Reset counter to zero.
3. Slowly pull test strip across the measuring wheel.
4. Stop at 2nd black line, counter should read 12 feet.
5. Repeat the test 3 or 4 times.
6. If measurement is off contact your Accu-Cut Service Representative.

TROUBLE SHOOTING

Problem	Solution
Machine will not run at all	<ul style="list-style-type: none"> ◆ Is the emergency shut off button down? Lift button and try running machine again ◆ Check extension cord connections
PLC lit up, but machine will not run	<ul style="list-style-type: none"> ◆ Enter password
Cutter stops or moves very slowly part way into the cut	<ul style="list-style-type: none"> ◆ Sharpen blade ◆ Tighten the 2 springs on the cutter unit Use 7/16 wrench. ◆ Note: if too tight blade will not spin for sharpening. ◆ Check cutter drive belt. To tighten, loosen motor mount bolts and tighten cutter drive belt 
Cutter makes excessive noise at either end	<ul style="list-style-type: none"> ◆ Tighten cutter chain. Use 9/16" wrench. Loosen both lock bolts (A) and tighten chain tension bold (B). Retighten lock bolts (A). ◆ Loosen the 2 springs on the cutter unit. 
Blade is not sharpening	<ul style="list-style-type: none"> ◆ Replace sanding disk ◆ Move sanding disk closer to blade. Loosen 2 set screws, (Use 5/32" allen wrench), slide hub 
Cutter does not run at all	<ul style="list-style-type: none"> ◆ Cutter safety bar must be down for cut to be performed ◆ Control panel must be latched in place (A). 
Roll up arm moves slowly	<ul style="list-style-type: none"> ◆ Check air pressure at compressor, should be 110 PSI ◆ Check for air leaks
Carriage movement is too slow or too fast	<ul style="list-style-type: none"> ◆ Adjust flow controls of 4th air valve.
Drive Chain noise	<ul style="list-style-type: none"> ◆ Tighten chain: Load side: Loosen bolts of the gearbox and slide gearbox down. ◆ Rollup Side: Adjust chain tightener sprocket.

Roll up arm is not closing evenly	<ul style="list-style-type: none"> ◆ Check chain tension front and back. Tighten chains by loosening bolts on bracket . Using bolt on bottom, pull chain tight, retighten bracket bolts. ◆ Add or remove spacer washer on back sprocket.
Foot control is not working	<ul style="list-style-type: none"> ◆ Ensure control panel is latched in place ◆ Tighten foot cable.
Starting the roll up process is difficult	<ul style="list-style-type: none"> ◆ Roll up cradle closes too far. Minimum of 3/4" gap between rollers. ◆ Adjust gap at clevis. 

ELECTRICAL DIAGRAM



Q-9 WIRING DIAGRAM