

E-Z CUT INC.

BBC

10 BLADE CARPET BASE CUTTING MACHINE



OPERATING MANUAL

REV 1

Serial Number of Your Machine:

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INTRODUCTION AND SAFETY

- Read these instructions carefully and thoroughly 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.
- Use extreme care and caution when operating this machine. All necessary safety precautions should be taken and protective wear should be worn during the operation of this machine.

ARRIVAL AND PREPARATION

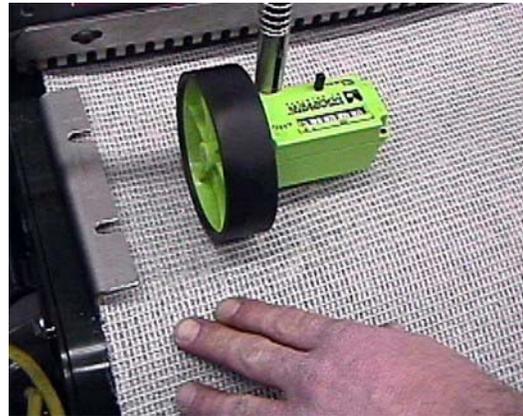
- Uncrate the machine and be sure to remove any and all packaging material.
- Check for any damage that may have occurred during shipment.
- Ensure you have the proper **220V (Single Phase) / 60hz / 20 Amp** dedicated power supply in place:
 - Use a minimum **12 Gauge** extension cord that is no longer than **25 feet** long.
 - Adjust the Leveling Legs to your desired height and ensure the machine is sitting level on your floor.

CUTTING CARPET BASE

Plug the machine into the proper dedicated power supply (220V (Single Phase)/ 60hz / 20 Amp). Once plugged in, you will hear the machine's Cooling Fan turn on automatically.

Operational/Control features:

- Locate the Control Box with LCD read out on the machine's left hand side.
- Press the **Green** start button to start the machine.
- Press the **Left/Right** (↔) arrow button for your blade direction.
- Press the **Up** (▲) or **Down** (▼) arrow buttons to adjust the speed of the cutting process.
- Press the **Red** stop button to stop the cutting process.
- Press and hold the **JOG** button to move the carpet slowly.
- Feed the edge of the carpet into the cutting system.
- Keep the edge of the carpet flush against the Table Guide to ensure a straight cut.
- Once you reach the end of the piece that you are cutting, turn the machine OFF.



Notes:

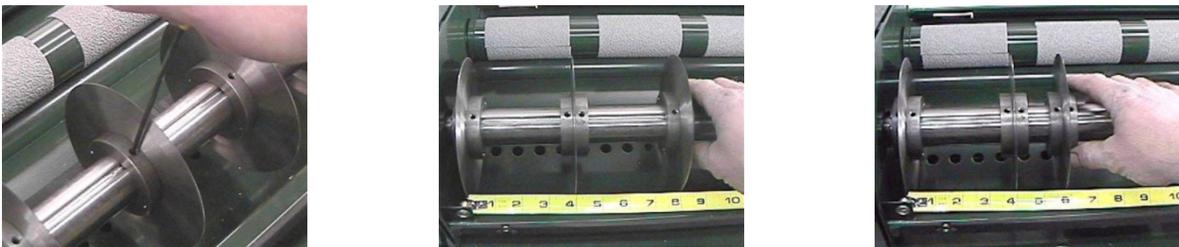
- With larger pieces of material, you may find it easiest to utilize the machine's detachable "Cradle/Rollers" which fits on the front of the machine.
- With smaller/narrower pieces of material, you may find it easiest to remove the "Cradle/Rollers" for better access to the cutting assembly.

ADJUSTING THE BLADE POSITIONS/WIDTHS

- Unplug the machine from its power source.
- Use a 5/32" Allen Wrench to remove the Allen bolts attaching the Top “Fingers” Grate to the back of the machine. Slide the Top “Fingers” out of machine from the back.
- Remove the Allen bolt from the front of the Blade Cover in order to be able to raise it to the open position.
- Remove the Allen bolts from the Bottom “Fingers” Grate. Slide the Bottom “Fingers” out from the front of the machine.



- Using a 1/8" Allen Wrench, adjust the position of the Blades on the Cutting Shaft. Position the Blades to your desired widths in reference to the Table Guide.
- Before running the machine make sure the setscrews on all the Collars that secure the Blades to the Shaft are tight. You must also re-attach the Bottom “Fingers”, secure the Blade Cover in the closed position and bolt the Top “Fingers” back into place.



Note: The bolts that attach the Top “Fingers” to the back of the machine are also used for adjusting the height of the Top “Fingers”. The bolts should only be tightened until there is a quarter to half an inch gap between the Top and Bottom “Fingers”. You may need to further adjust the “Fingers” by tightening or loosening the Allen bolts for different carpet types.

TROUBLESHOOTING AND SAFETY

- **Always make sure machine is disconnected from its power source when not in use and before performing any maintenance.**

- **Ensure your blades are sharp. Dull blades cause excessive drag and friction against the carpet, which leads to the slitter not cutting as cleanly as it should and the carpet bunching up in front of the blade assembly. See page 9 for blade sharpening instructions.**

- **Ensure your blades are the correct size (diameter). To ensure a proper cut, your blades should be sitting at least a half-inch below the top surface of the bottom grate. Excessive use and sharpening will result in a decreased blade size (diameter) and a poor cutting performance.**

- **Check the "fingers" on the top grate for unusual and/or inconsistent bends and the bottom grate for unusual and/or inconsistent wearing and flexing. The main purpose of the top grate's "fingers" is to prevent the carpet from buckling by providing a small amount of pressure and drag on the carpet. The gap between the top and bottom grates should be about one quarter to a half inch, but should be adjusted depending on the thickness of the material being cut. To Increase the drag lower the Top "Fingers" by loosening the Allen bolts that attach the Top "Fingers" to the back of the machine. Decrease the drag by tightening the Allen bolts to raise the Top "Fingers". You must always ensure that the Allen bolts are never fully tightened.**

- **Use extreme caution and care when operating the machine at all times. Keep the operating area clear of all unauthorized personnel and potential hazards. Your "E-Z Cut" is a machine not a toy, never allow children near it!**

- **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 SCHEDULE

DAILY:

- Check for any oil leakage from the gearboxes. If there is a leakage, discontinue the use of the machine and call E-Z CUT immediately
- Vacuum or blowout floor covering residue, fibres, and dust build from the cutting assembly area and surface of machine.
- Ensure all blades are sharp and secure and check that all the setscrews are tightly in place.
- Check the Top and Bottom "Fingers" for any unusual or inconsistent wearing or bending.

YEARLY:

- Change the oil in the Gearbox (see page 8).

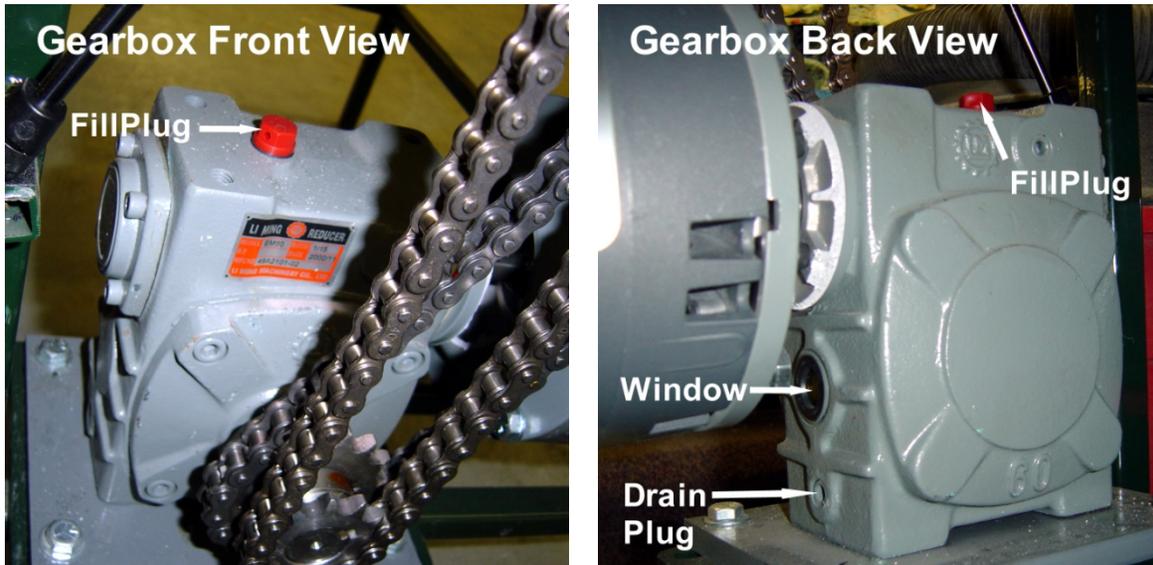
RECORD OF MAINTENANCE

Record Date of Delivery:			
Length Of Time Since Delivery:	Maintenance Required:	Maintenance Performed By:	Date:
1 Year	Oil Change		
2 Years	Oil Change		
3 Years	Oil Change		
4 Years	Oil Change		
5 Years	Oil Change		
6 Years	Oil Change		
7 Years	Oil Change		
8 Years	Oil Change		
9 Years	Oil Change		
10 Years	Oil Change		

NOTES:

- Continue to perform the scheduled maintenance for the life of the machine.
- 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.

GEARBOX OIL REPLACEMENT



When changing the oil fill until the oil is at the halfway mark in the Viewing Window of the Gearbox. Let the oil settle and if necessary top up so it is at the halfway mark. You must ensure that the Gearbox is never more or less than half filled with oil at all times! Quaker State Synthetic Gear Oil is recommended but any brand between 75W to 90W Synthetic Gear Oil or Synthetic High Pressure Gear Oil is acceptable.

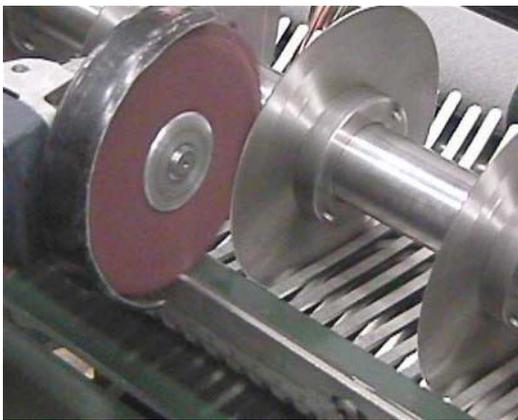
1. Disconnect the electrical power supply to your machine.
2. Remove the bottom Allen bolt located under the Viewing Window to drain oil. Ensure that the Allen bolt is put back in place when done draining.
3. Remove the (red) Breather Plug from the top of the Gearbox and fill to the halfway point of the Viewing Window. Let the oil settle, ensure that the Gearbox is about half filled with oil and then reinstall the top Breather Plug.

SHARPENING THE BLADES

Blades must be kept sharp at all times to prevent damage to your machine and to ensure that carpet is cut quickly and cleanly. Your machine is equipped with ten Stainless Steel Blades that have a bevel on both sides of each Blade. Therefore, when sharpening the Blades, you will need to sharpen **both sides** of each Blade.

To sharpen the Blades, we recommend that you follow these steps:

1. Release and raise the protective Blade Cover that covers the Blades.
2. Turn the machine ON and increase the speed to approximately "50" on the Blade speed setting.
3. Use an electric or air powered portable hand grinder equipped with a **120 to 220** grit-sanding disc (the finer the grit the better your results). Hold the running grinder at a **15 to 20 degree angle** on one side of the Blade for approximately **5 seconds**. Repeat the same procedure on the other side of the Blade.
4. Turn the machine OFF and inspect the Blade for any burrs or nicks. Repeat step 3 if necessary.
5. Repeat steps 2, 3 and 4 for all of the Blades.
6. Lower and re-secure the protective Blade Cover.



NOTE: USE EXTREME CARE AND CAUTION WHEN SHARPENING THE BLADES! ALL NECESSARY SAFETY PRECAUTIONS SHOULD BE TAKEN AND PROTECTIVE WEAR SHOULD BE WORN DURING THE BLADE SHARPENING PROCESS.

WARRANTY

E-Z CUT Inc. guarantees all E-Z CUT machines sold or leased to the original owner or lessee to be free from defects in workmanship and design, under normal operating conditions, for a period of three (3) years from the date of delivery. All electronic, electrical, electro-mechanical, pneumatic, and drive components (excluding Cradle Belts) are covered, under normal operating conditions, for a period of one (1) year from the date of delivery.

This limited warranty shall not apply to any defects resulting from, but not limited to, abuse, lack of maintenance, unauthorized modifications, overloading, power surges, inadequate power supply, or normal wear on parts and components. E-Z CUT Inc. reserves the right to repair or replace, at its own option, any defects found with the machine and/or its components, within the warranty period.

During the warranty period, E-Z CUT Inc. will ship replacement parts via normal ground freight, pre-paid to the owner/lessee. It is the responsibility of the owner/lessee to return all defective materials, freight pre-paid, to E-Z CUT Inc. within 30 days for warranty consideration. Any extra freight costs for special shipping, such as airfreight or expedited shipments, is the responsibility of the owner/lessee.

E-Z CUT Inc.'s liability under this warranty shall be solely limited to the repair and/or replacement of defective materials and shall not be liable, under any circumstances, for consequential or incidental damages, lost income due to downtime, personal injuries, damage to floor covering material, or associated labour costs, without the prior written approval from E-Z CUT Inc.