

**MK IV
OPERATOR'S MANUAL**

E-Z CUT INC.

SAFETY RULES

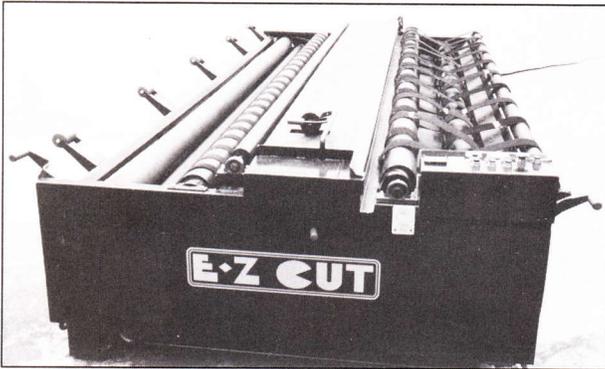
GENERAL

1. Read the Operator's Manual carefully and ensure that you are familiar with the controls and the proper step by step operation of the machine.
2. Never allow children to operate the machine and only properly trained personnel who are familiar with the machine should use it.
3. Keep the area of operation clear of all persons and potential hazards.
4. Should you have any problems with the operation of the machine, consult the Troubleshooting and Maintenance Sections at the back of the manual.
5. If help is needed or if any of these procedures are unclear, please do not hesitate to contact us at E-Z Cut Inc. directly.

OPERATING PROCEDURES

The following is the cutting machine's operating procedures. The steps in this section are set up for a normal sequence of operations. The arrangement is intended primarily to acquaint you with the fundamental operating procedures to ensure the safe and efficient operation of your cutting machine. Take your time, be patient, and enjoy the benefits of this machine for many years to come.

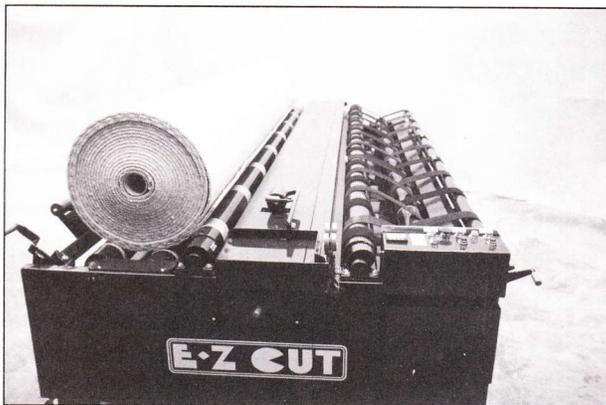
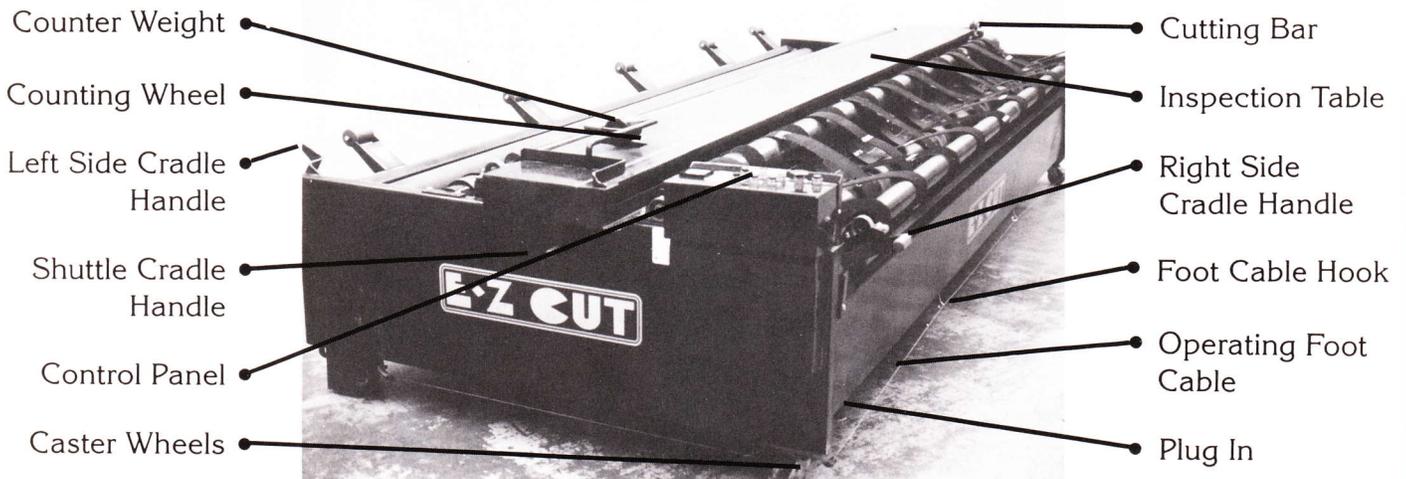
E-Z CUT INC.



The Machine's Arrival

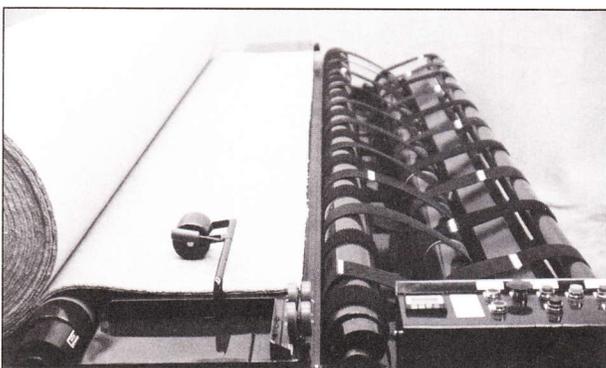
Once the machine has arrived and the crating has been removed, give your machine a complete wiping and dusting to remove any pieces of wood or plastic that still might remain after uncrating. Also, ensure that the Operating Foot Cable is secure around the entire machine. Once the machine is clean and positioned to where it will be operated from, release the machine down from its Caster Wheels to prevent it from moving during the loading of rolls and operation.

MAIN OPERATING FEATURES



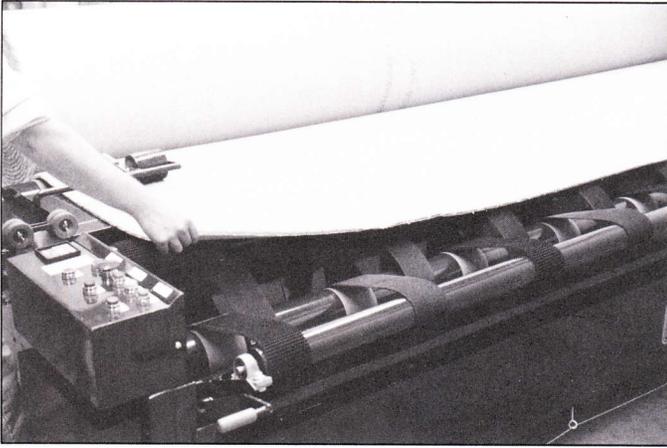
Loading the Roll of Carpet

When you place the roll on the Left Side of the machine, ensure that the feed is coming from the bottom towards the Counter with the "Pile" facing up. This provides an accurate measurement from the carpet backing - NEVER measure with the "Pile" facing down as you will get an inaccurate measurement. As well, for best results, the roll of carpet should be rolled up fairly tight. To tighten a loose roll of carpet, press the Left Side Roller Button in REVERSE, depress the Foot Cable, and allow the roll to rotate for a few turns until it tightens itself up.



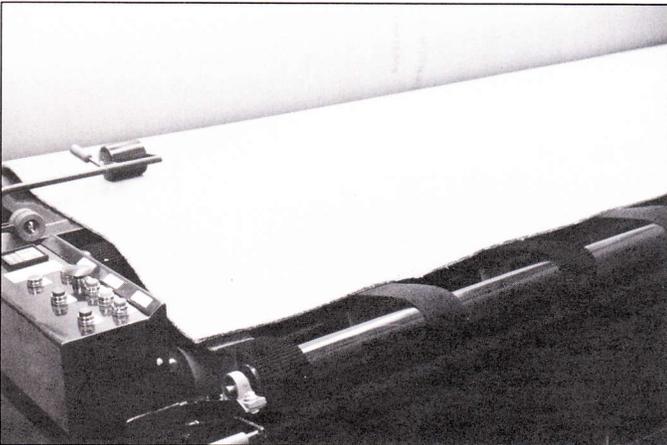
Preparing to Measure

Advance the carpet to the Right Side by pressing both the Roller Buttons in the FORWARD direction and depress the Foot Cable. At the same time, lift the Counter Weight and guide the carpet through to the Cutting Track. Stop the carpet at the edge of the Cutting Track and gently lower the Counter Weight down onto the carpet. By using the Shuttle Cradle Shifting Handle, you can shift the cradle so as to better align the carpet with the Cutting Track. But as a rule and for best results, the Shuttle Cradle should remain in the center lock position until you become more familiar with the machine.
NOTE: THIS STEP DOES NOT AUTOMATICALLY SQUARE THE CARPET AND CAREFUL ATTENTION MUST STILL BE GIVEN TO ROLLING IT UP STRAIGHT.



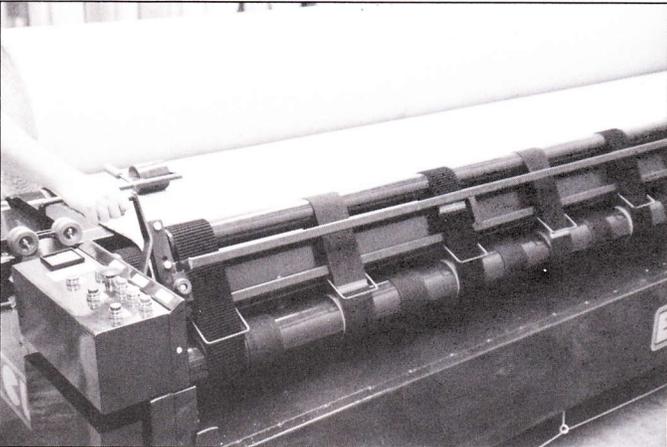
Starting the Roll Up Process

With both Roller Buttons in the FORWARD position, depress the Foot Cable and gently pull the edge of the carpet across with your right hand for the first couple of feet.



Guiding the Flooring

Guide the flooring until it is just past the lower middle roller on the Right Side Cradle and stop the flow at this point. Should you require one, you can now place a cardboard core on top of the carpet laying in the cradle or just continue without one.



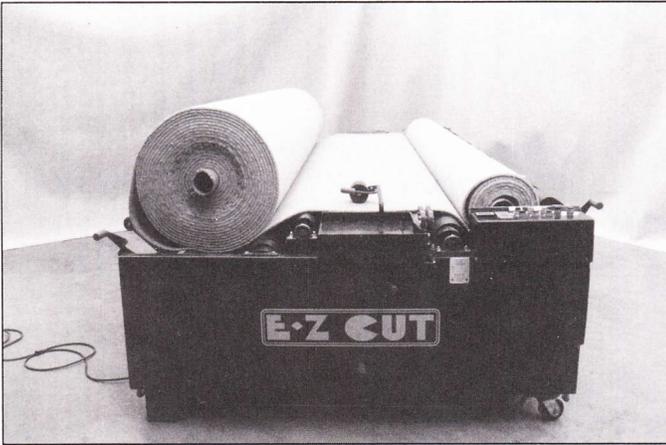
Rolling Up the Carpet

To get the roll started, release the Right Side Cradle's top roller from its Latch and allow this Spring Loaded Cradle to curl itself over the carpet. Apply some pressure by holding the Cradle Handle in place over the carpet, step on the Foot Cable, and roll up the first two or three feet. Slowly release the Handle over the next two or three feet while continuing to roll up the carpet and allow the Spring Loaded Cradle's tension to keep the roll tight. Once your programmed length has been reached, the motor for the rollers will stop, indicating you are now at your desired length.



Rolling Up the Carpet Straight

Contrary to what you may have been told, no cutting machine can square a roll of carpet. The only way to make sure that your carpet is going to be cut square is to ensure that it is rolled up square and flush on the Right Side Cradle. To prevent coning or telescoping, move to the right side of the machine once you've got the first two or three feet started and activate the rollers with the Foot Cable that runs down the length of the machine. By adjusting the carpet by hand as it rolls up, (just like you would if you were rolling it up on the floor) you can eliminate any serious coning. If the carpet is rolled up straight and the end of the roll is fairly flush and not coned, then your cut will be straight and square.



Prior to Cutting the Carpet

Prior to cutting, there may be a slight “bubble” or “buckle” of carpet on the Inspection Area caused by the momentum of the carpet after the rollers stop moving. To correct this, just press the Right Side’s roller button in the FORWARD position and the Left Side’s roller button in the REVERSE position. Now, tap the Fine Tuning Button once or twice and this will flatten out the carpet on the table.



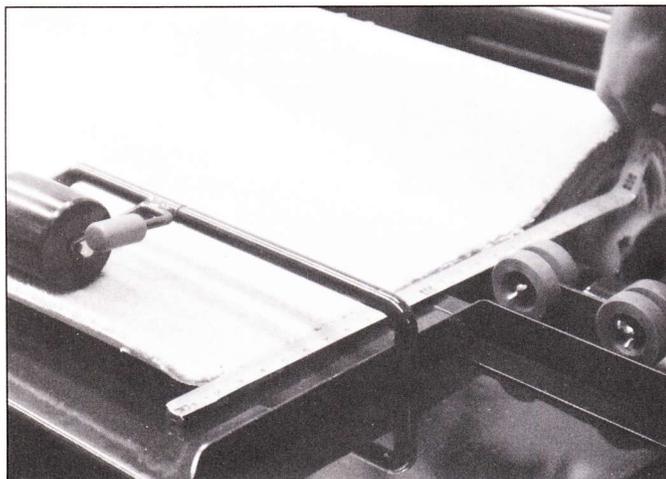
Cutting the Carpet

To prevent the carpet from moving during the cutting process, press the red Emergency Stop Button which stops the rollers from moving in any direction. To cut the flooring, press the Cutting Bar button in the FORWARD position and the blade will run the entire length of the machine. Once the blade reaches the end of the machine it will automatically stop. Since it is a 2-way cutting blade, you don’t have to return it to the home end of the machine for the next cut. Should you wish to stop the blade at any time, just hit the red Emergency Stop Button.



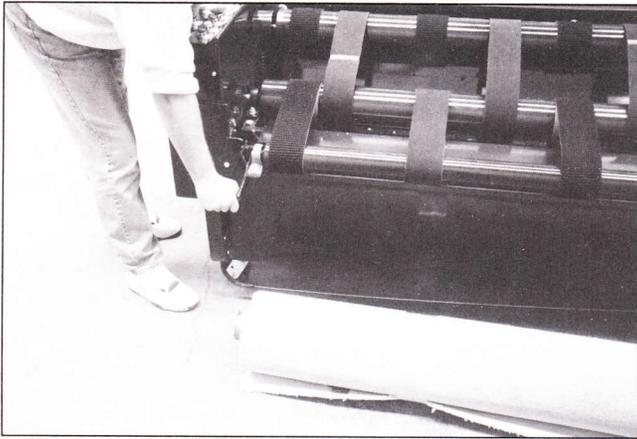
Wrapping the Rolls

Firstly, press the red Emergency Stop Button so as to ensure all buttons are clear. To wrap up the cut piece, just press only the Right Side Cradle rollers in the FORWARD position and move to the right side of the machine with your stretchfilm. Place the stretchfilm under the edge of the carpet, step on the Foot Cable and allow the stretchfilm to wrap itself around the flooring. Three full turns should be sufficient. This same procedure can be done on the balance roll as well. Once again, hit the red Emergency Stop Button to clear all buttons. Press only the Left Side Cradle rollers in the REVERSE position, move to the left side of the machine, and perform the same task.



Measuring Full/Partial Rolls

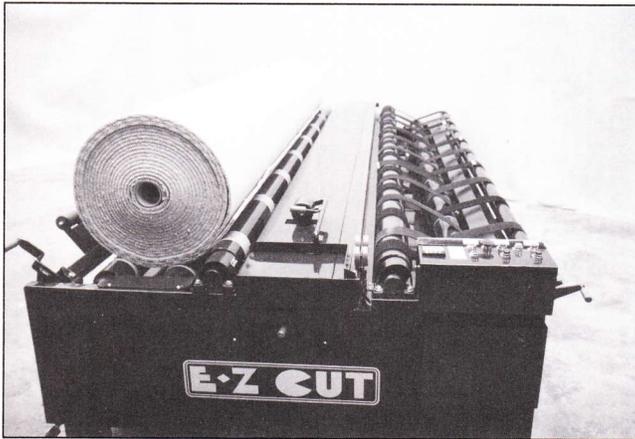
If you want to just remeasure a full or partial roll, and not make any cuts, you have to remember one important procedure. Since the Counter stops counting once the back edge of the carpet passes by the Counting Wheel, you have to take into account the small piece of flooring that doesn’t get counted between the Counting Wheel and the Cutting Track. Therefore, prior to the back edge of the carpet passing over the Counting Wheel, measure the carpet from the back edge to the Cutting Track and add this amount to the reading on the Counter Display. Use the Conversion Table on the Control Panel.



Removing the Rolls from the Cradles

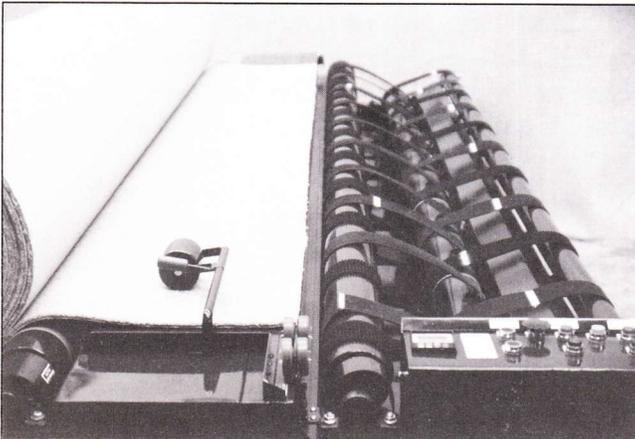
Once cutting and wrapping is complete, you can now remove the rolls from the cradles without the need of a lift truck. Just release each cradle from its Latch and Safety Latch, push down on the Cradle Handle, and the flooring will roll right off the cradle and onto the floor. Obviously, be sure no one is standing in the path of the roll prior to releasing it off of the cradle.

REVERSE ROLLING CARPET “PILE” SIDE OUT



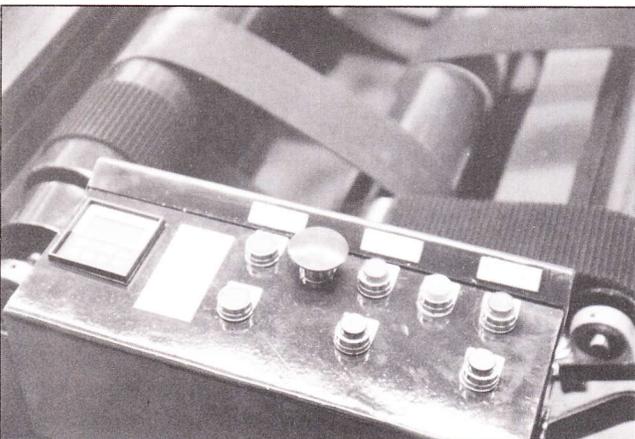
Loading the Roll

As before, place the roll of carpet on the Left Side Cradle and ensure that the carpet feed is coming from the bottom towards the Counter with the “Pile” side facing up.



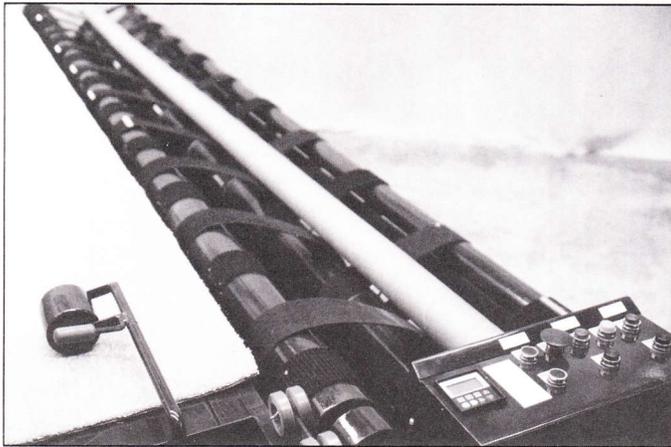
Preparing to Measure

Advance the carpet to the Right Side by pressing both Roller Buttons in the FORWARD position and depressing the Foot Cable. Once again, guide the carpet through and stop it at the Cutting Track, remembering to lift and lower the Counter Weight.



Programming the Electronic Counter

With the edge of the carpet flush along the Cutting Track, you are now ready for the counting and roll up process to begin. Should you wish, you can now program your counter to a desired length by following the steps previously outlined in the manual. Should you wish not to program a desired length, just record what is being measured by referring to the P1 screen's top row.



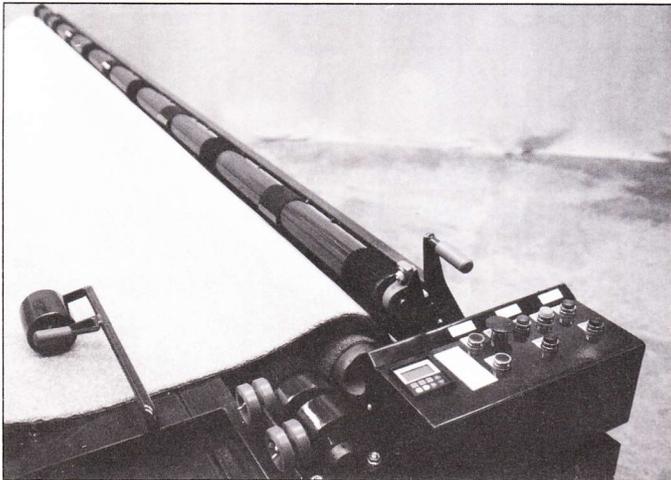
Starting the Roll Up Process

Reverse rolling carpet requires the use of a cardboard core, no wider than 4" in diameter. Prior to guiding the flooring across onto the Right Side, place the core in position on the Right Side Cradle. Now, guide the flooring only about 8" until it is slightly draped over the first large roller on the Right Side.



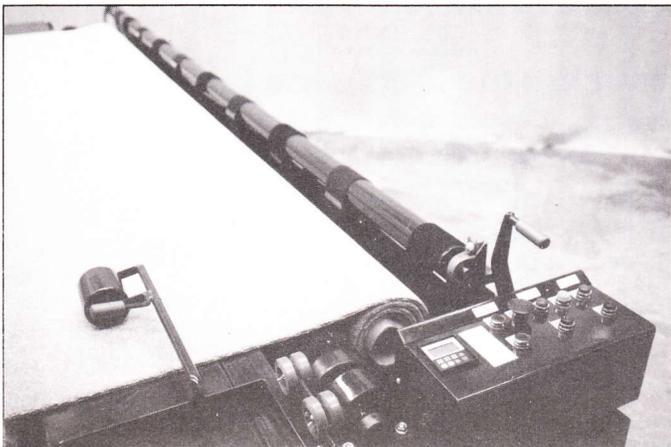
Securing the Carpet Around the Core

Release the Right Side Roller from its Latch and fold it over the core so the carpet is pinched between the small top roller and the first large roller. Now, press the Right Side rollers button in REVERSE and the Left Side rollers button in FORWARD, and advance the carpet across the Fine Tuning Button so it wraps itself around the core (one wrap around the core is sufficient). You may have to adjust the amount of pressure you apply on the Right Side Cradle Handle so as to get the carpet started.



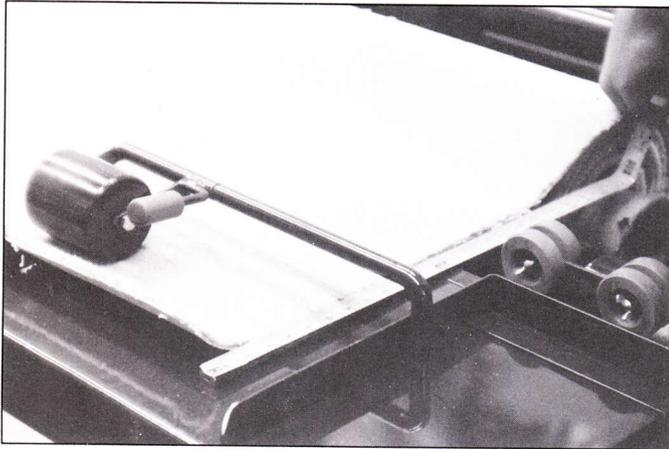
Continuing the Roll Up Process

Once the carpet has started itself around the core, you will notice that the carpet has begun to "bubble" or "buckle" near the full roll on the Inspection Area. To eliminate this, first press both the Right and Left Side roller buttons in the REVERSE position. Now, as you maintain the pressure on the amount of carpet rolled up on the core, tap the Fine Tuning Button a few times until the carpet is flat again. At this point, you can return the Left Side rollers button to the FORWARD position and leave the Right Side rollers button in the REVERSE position.



Continuing the Roll Up Process

Maintain a slight amount of pressure on the carpet being rolled up and step on the Foot Cable to continue the roll up. Once again, after the first two or three feet are rolled up, you can release the Right Side Cradle Handle and allow the machine to do the work.



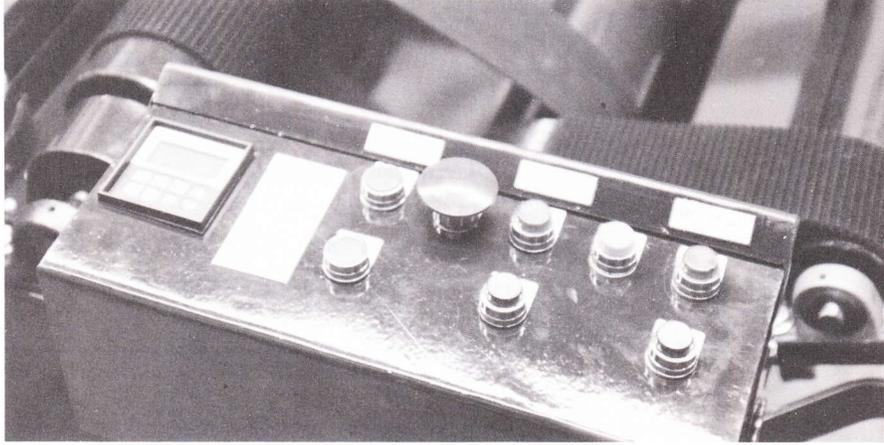
Measuring the “Tail End” of the Carpet

Remember, when measuring a full or partial roll, you have to take into account the last piece or “tail end” of carpet that doesn’t get measured by the Counter after it passes over the Counting Wheel. Follow the same procedure as before – measure the amount that hasn’t passed over the Counting Wheel and add it to the amount on the Counter’s screen. Use the Conversion Table.

SUMMARY

Once again, take your time and experiment with the machine until you feel comfortable operating it. Obviously, it is a good idea to practice rerolling smaller rolls of carpet and vinyl before attempting to make any cuts. Don’t expect to be an expert after just one or two tries as it takes a little practice and patience before you get the “hang” of it. Once you become familiar with the machine and confident in what it can do for you, measuring and cutting floor covering will become a simple and easy exercise.

MAINTENANCE TIPS

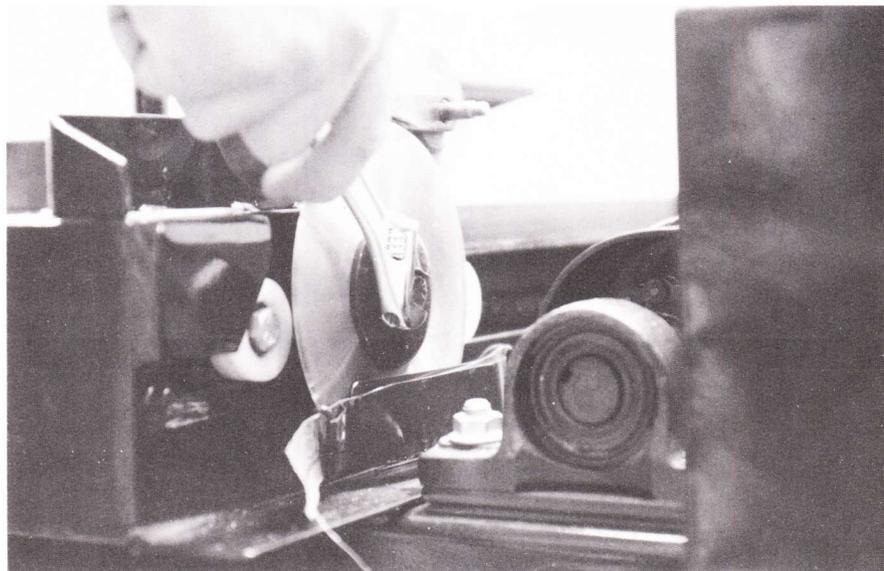


Adjusting Counter Scale

If the Counter is not measuring properly, call an E-Z Cut technician and go through the following steps:

- 1) Simultaneously, press the small button under the control panel dash and the "RUN/PGM" button. Then press the "ENT" button.
- 2) The screen will read "Program Scalers". Press the "SEL" button and the screen will read "C Scaler". Press the "SEL" button and the far left digit will begin to flash.
- 3) Press the "SEL" button until you reach the desired digit position to change. Press the "+/-" button to reach the desired value at each position. Press the "SEL" button to move to the next digit position.
- 4) When each desired value is reached, press "ENT", then press "EXIT", then press "RUN/PGM", then press "RST/CLR".

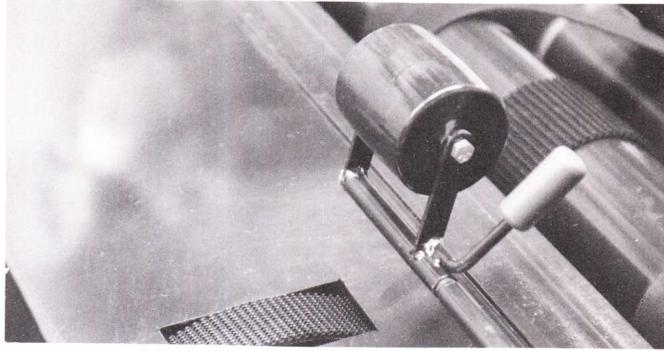
NOTE: Decreasing the "C Scaler" by .01 will result in the customer getting an extra 1/2" of carpet every 20 Feet (approx.)



Changing the Blade on the Cutting Bar

To replace a dull blade, remove the two wingnuts facing the Right Side and slide off both grey guide wheels facing the Right Side. Remove the center bolt, the small silver washer, and the larger round plate/washer. Remove and replace the blade (Bevelled side out) and reattach all the proper components in their respective places. Also, adjust the Sanding Pad so it is always rubbing up against the blade to keep it relatively clean.

MAINTENANCE TIPS



Counting Wheel and Counter Weight

The 12" Counting Wheel does the counting while the Counter Weight pressures the flooring up against the Counting Wheel to ensure an accurate measurement. Be careful when loading and unloading rolls so as not to bang or damage these two integral parts. If damaged or dislodged, it can result in inaccurate measurements.



Foot Cable

Using a thick grease, keep the Foot Cable well lubricated where it passes through the 4 "Eye Tubes" located at the base of the machine in the front end. Failure to keep these areas well lubricated will cause them to wear, fray, and eventually break.

Keep the Cutting Track Clean

Dust and fibers will build up below the Cutting Blade and can cause damage if not cleaned out on a regular basis. Daily cleaning is recommended by either vacuuming or blowing out the Cutting Track area so it remains clear of any build up. This holds true for the Cradles as well, directly below the rollers.

Chains

The chains that run the rollers and the Cutting Bar are lubricated before leaving our plant. These chains and their sprockets do not require a large amount of greasing to operate properly. Should they begin to appear dry and/or shiny, apply a light amount of gear oil. Constant greasing of these areas will just attract more debris and cause more harm than good.

Gearbox

We recommend that you change the oil in the 2 Gearboxes, located under the machine, once every year with a regular 80-W-90 gear oil. The oil level should be at the center of the sight gauge between 2-1/2 and 4-1/2 inches from the bottom of the gearbox.

TROUBLESHOOTING

PROBLEM

1. Machine will not run?

SOLUTION

- Check the extension cord.
- Check your electrical panel.
- Push the reset button on the motors under the machine.
- Check the tension on the Foot Cable.

2. Cutting Bar is not running smoothly across the track?

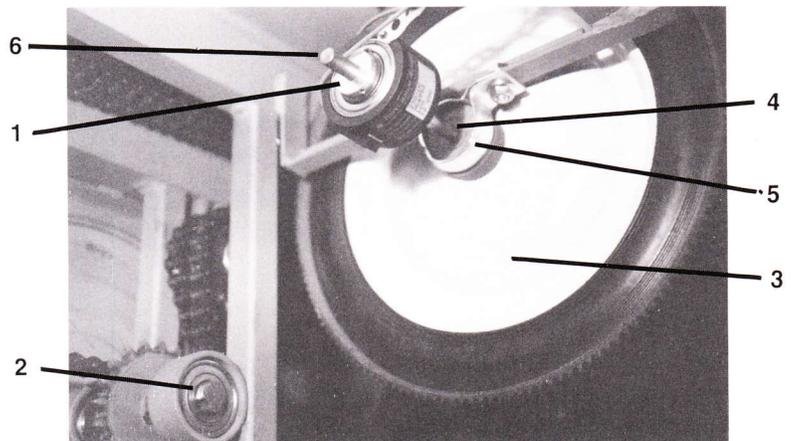
- Check Track and Blade for debris build up.
- Check the sharpness of the blade.
- The Cutting Blade chain may be loose.

3. Roll of flooring is rolling up coned and uneven

- Shuttle Cradle may be off center and angled.
- Machine may be on caster wheels and moving.
- Main roll may be resting on an angle on Left Side
- Too much pressure applied on Right Side Cradle Handle can cause coning during roll up.
- Ensure floor is level.
- If always coning to the FRONT of the machine, shift the Shuttle Cradle Handle one notch to the Right of center. If always coning to the BACK, shift it one notch to the LEFT of center.

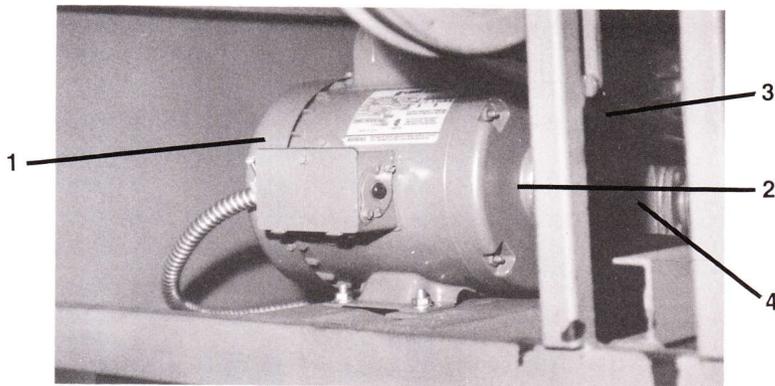
MACHINE PARTS LIST

KEY	PART #	QTY.	DESCRIPTION
1	CEE	1	Counter Encoder
2	B20Y-12	1	3/4" Bearing
3	CW12	1	Counting Wheel
4	BCS	1	Counter Shaft Bearing
5	BS202	1	Pillowblock
6	CS	1	Counter Shaft

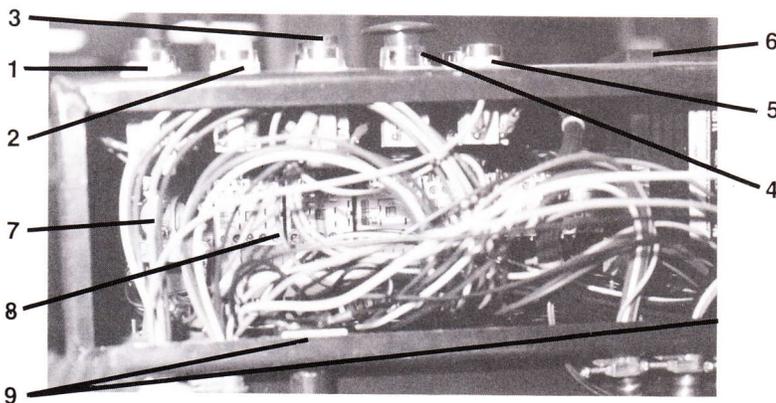


MACHINE PARTS LIST

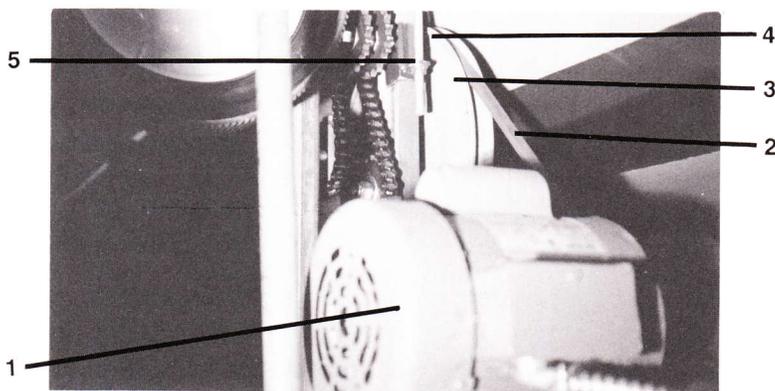
KEY	PART #	QTY.	DESCRIPTION
1	EM34	1	3/4 H.P. Motor
2	DPAA583	1	5/8" x 3" Pulley
3	DBA24	1	A24 Belt
4	DPAA343	1	3/4" x 3" Pulley



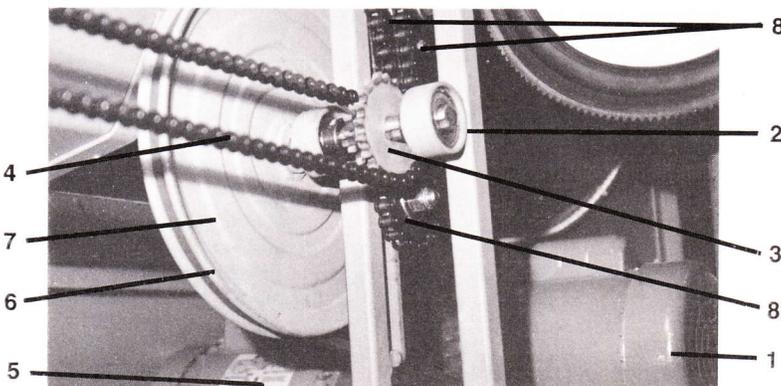
KEY	PART #	QTY.	DESCRIPTION
1	ESF1	1	Blue Push Button (Lit)
2	ESF6	1	Yellow Push Button
3	ESF2	1	Yellow Push Button (Lit)
4	ESMS	1	Red Emerg. Stop Button
5	ESF5	1	Black Push Button
6	CED2	1	Electronic Counter
7	ER2	1	220V Relay
8	ER4910	1	CA4-9-10 Contractors
9	EMS	2	Micro Switch



KEY	PART #	QTY.	DESCRIPTION
1	EM13	1	1/3 H.P. Motor
2	DBA49	1	A49 Belt
3	DPW12	1	12" Pulley
4	NB5	1	Tightener Bolt
5	TM2	1	Tightener Bracket

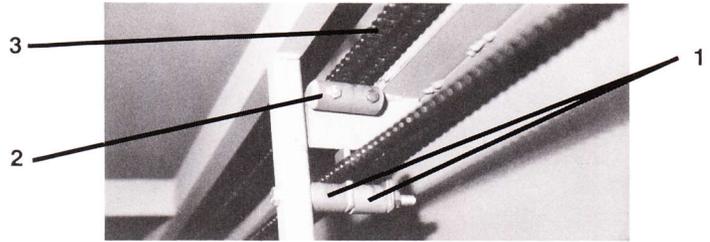


KEY	PART #	QTY.	DESCRIPTION
1	EM13	1	1/3 H.P. Motor
2	B204-14	1	3/4" Bearing
3	S4012-20	1	12 & 20 Sprocket
4	DCB40	1	#40 Chain
5	EM34	1	3/4 H.P. Motor
6	DBA24	1	A24 Belt
7	DPW12	1	12" Pulley
8	S4018B	3	Idler Sprocket

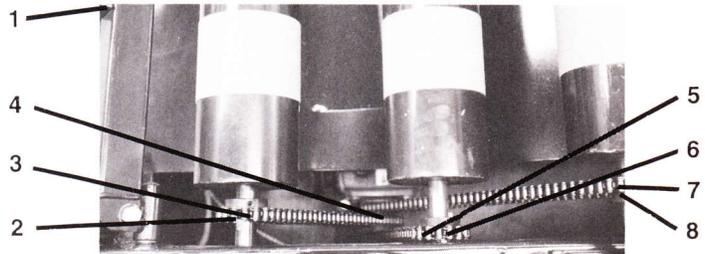


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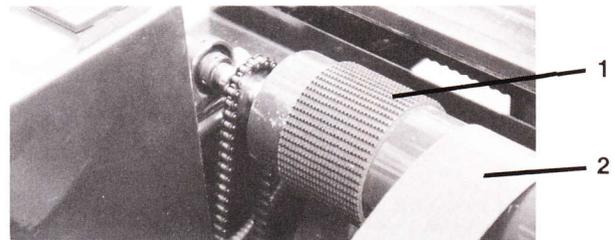
KEY	PART #	QTY.	DESCRIPTION
1	PF12	2	Short Chain Guide
2	PF13	1	Long Chain Guide
3	DCB40	1	#40 Chain



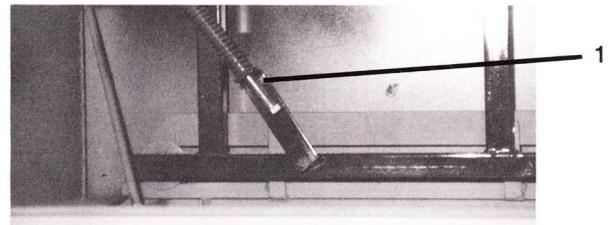
KEY	PART #	QTY.	DESCRIPTION
1	TB4L	1	Left Fold Up Bar
2	S4016S	1	#4016 Sprocket
3	DC402	1	Chain
4	S4016T	1	#4016 Triple Sprocket
5	DC403	1	Chain
6	S4016S	1	Sprocket
7	DC404	1	Chain
8	S4016S	1	Sprocket



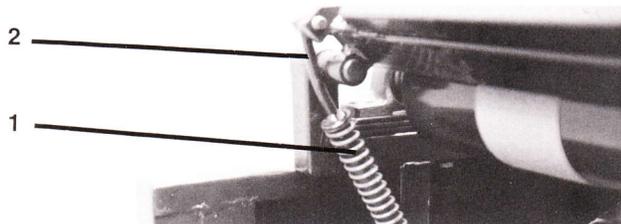
KEY	PART #	QTY.	DESCRIPTION
1	MR43	1	Belt Sleeve
2	MR42C	1	Roll Up Belt (CPU)



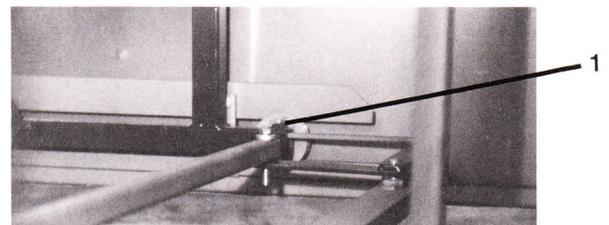
KEY	PART #	QTY.	DESCRIPTION
1	TSC7	1	Compression Spring with Rod End Bolt



KEY	PART #	QTY.	DESCRIPTION
1	TSC7	1	Compression Spring
2	TS4	1	M4 Spring Pin

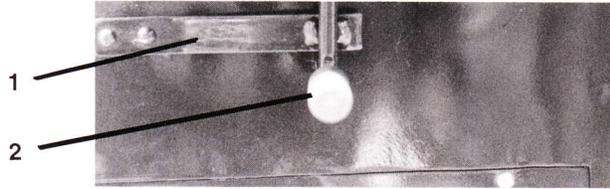


KEY	PART #	QTY.	DESCRIPTION
1	BP2	1	Shuttle Cradle Glider Pulley

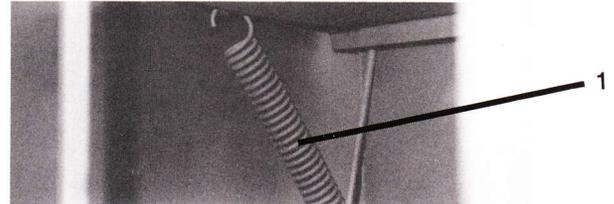


MACHINE PARTS LIST

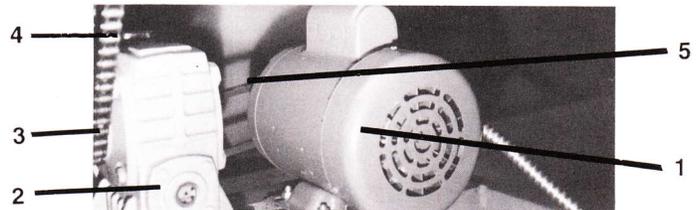
KEY	PART #	QTY.	DESCRIPTION
1	TH41	1	Shuttle Cradle Center Lock
2	THS11	1	M4 Shuttle Cradle Handle



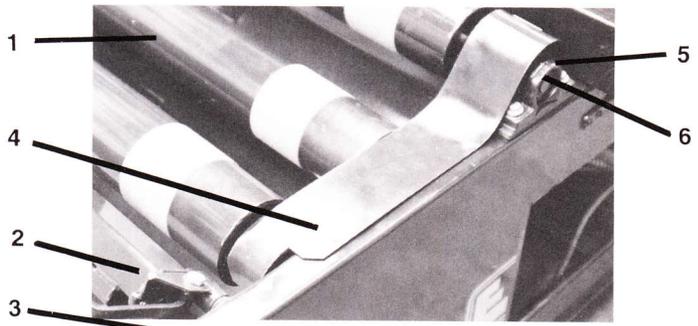
KEY	PART #	QTY.	DESCRIPTION
1	TSE12	1	M4 Extension Spring



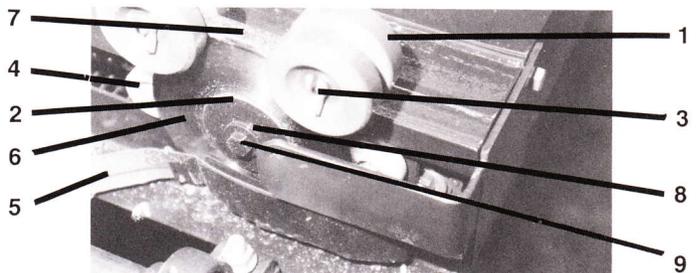
KEY	PART #	QTY.	DESCRIPTION
1	EM34	1	3/4 H.P. Motor
2	DGM60	1	#60 Gearbox
3	S4017-17	1	Sprocket
4	DC401	1	#40 Chain
5	DBA24	1	A24 Drive Belt



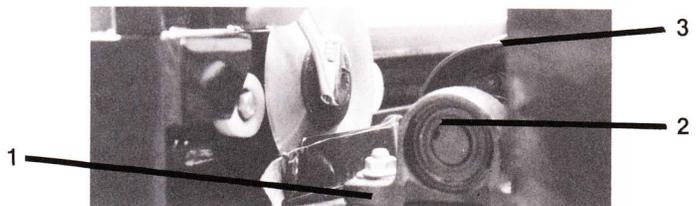
KEY	PART #	QTY.	DESCRIPTION
1	TR05	1	5" Roller
2	TB4L	1	Left Fold Up Bar
3	THL12	1	Left Dump Handle
4	TCM4	1	M4 Chain Guard
5	BSC205	1	P205 Pillowblock
6	B205-16	1	205-16 Bearing

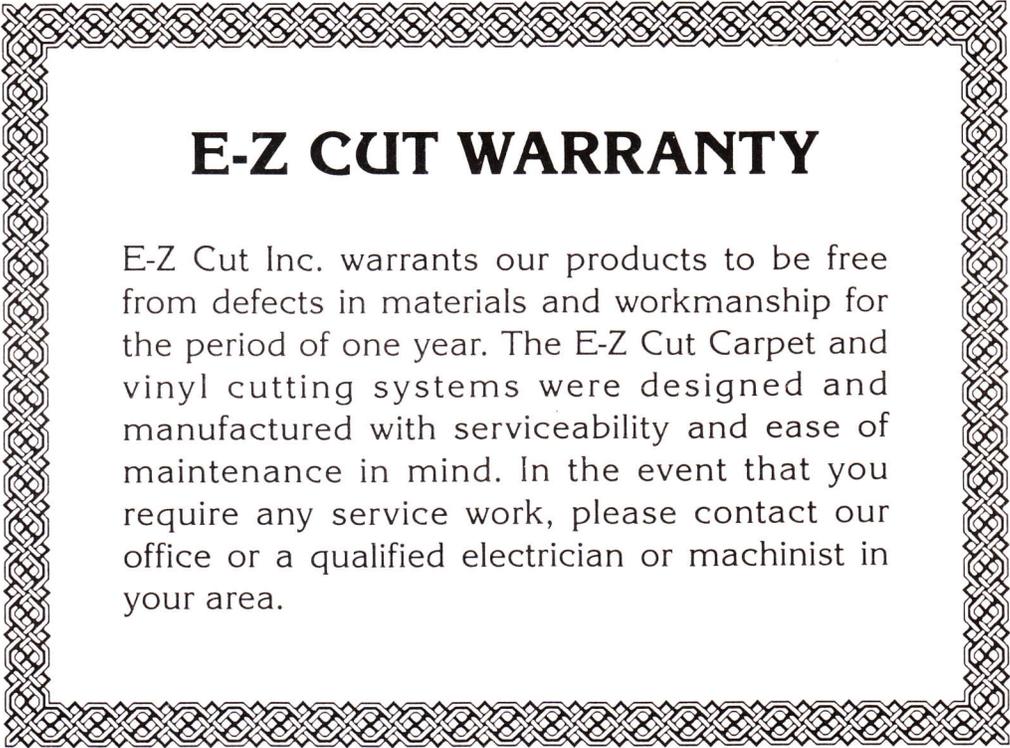


KEY	PART #	QTY.	DESCRIPTION
1	PFHW	4	Bladeholder Wheel
2	DM212	1	2-1/2" Bladeholder Washer
3	NW14	4	1/4" Wingnut
4	PF2	2	Bladeholder Guide Wheels
5	XG1	1	1" #80 Grit Sand Pad
6	Blade	1	Circular Blade
7	DM5	1	Cutting System
8	NFW38	1	3/8" x 1" Flat Washer
9	NB3834	1	3/8" x 3/4" Bolt



KEY	PART #	QTY.	DESCRIPTION
1	BS205	1	#205 Pillowblock
2	B205-16	1	#205 Bearing
3	TCM4	1	M4 Chain Guard





E-Z CUT WARRANTY

E-Z Cut Inc. warrants our products to be free from defects in materials and workmanship for the period of one year. The E-Z Cut Carpet and vinyl cutting systems were designed and manufactured with serviceability and ease of maintenance in mind. In the event that you require any service work, please contact our office or a qualified electrician or machinist in your area.

For further information, contact:

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