

Accu-Cut Autorun Cutting Procedure (Maple)

1. Load carpet onto the machine so that the carpet when rotating anticlockwise will feed the carpet from the bottom of the roll across the machine with the backing facing down and the pattern facing upwards
2. Turn the left (load) roller switch to the Reverse position
3. Using the jog foot cable rotate the carpet until you can cut the tape and remove all of the tape
4. Repeat the above step until all tape is removed
5. Rotate carpet until start of the carpet is near the top of the roll
6. Turn the left (load) roller switch to the Forward position – check that right (cut side) roller switch is also in the Forward position
7. Flick the start of the carpet onto the machine
8. Jog the carpet to the centre of the cutting slot – **important #1**
9. Lower the counter counterweight arm – **important #2**
10. Reset the length counter to Zero by pressing the **green** Clear Count button – **important #3**
11. Enter the length to be cut into the display by pressing the **grey** Clear button, entering the length in centimetres and then pressing Enter
12. Jog the carpet to about the middle of the middle roller on the cut side, pulling the carpet across with your right hand if necessary
13. Fold over the clamp roller and hold tight
14. Gently jog the carpet to start the roll up process
15. Jog about 4 to 6 rotations and then slowly release the clamp roller
16. Now press the **yellow** Autorun button. The machine will now run until the entered length is reached, or will stop (pause) if one of the following is pressed – the **yellow** Autorun button again, the jog button, the jog cable on either side of the machine or the Emergency Stop. If the Emergency Stop is used, then the whole process must be started from the beginning as the count will have been lost. For the rest, Autorun can be resumed by pressing the **yellow** Autorun button again. If after stopping, the machine has overrun, reverse both roller switches, jog as required, then return both roller switches to forwards
17. Lower the cutter guard
18. **Recheck** that the length shown on the machine is the length according to your cut schedule
19. Cut the carpet by pressing and holding the **red** Cutter Safety button as well as the appropriate **red** Cutter direction button until the cutter has run full travel
20. Lift the cutter guard
21. Turn the left (load) roller switch to the O (off) position
22. Reset the counter to Zero by pressing the **green** Clear Count button – this will restore full speed to the rollers
23. Move to the cut side of the machine and tape up the carpet – hint: start the tape from under the flap of the carpet
24. Write the length and job name/number on the cut piece
25. Dump or remove the cut carpet from the machine
26. Turn the left (load) roller switch to the Forward position
27. To start the next cut from the same roll, go back to step 10 in red above and repeat for the other cuts from the same roll of carpet
28. When the last cut has been done, turn the left (load) roller switch to Reverse, then go to the load side and tape up the balance
29. Remove the balance from the machine with your forklift