

Rubber Loading

Material is loaded into the Model i-536 by raising the pinch wheels as well as the front and rear lift gates. These gates are spring-loaded and will remain up when raised to the full up position.

1. Place roll of media on stand and align right edge of material with sprocket guides.
2. Raise lift gates. Insert media from the back of the cutter, passing the media over the sprocket guides.
3. Align material onto rear sprocket wheels first; making sure that your material is not skewed in any way. Lower rear lift gate, making sure that the grooves in the retaining collars are aligned over sprockets.
4. Loosen the clutch knob, located at the left side of the machine, by turning counterclockwise.
5. At this point, the front sprockets should be free to rotate by hand to facilitate alignment of the sprockets to the material holes.
6. When you have aligned the sprockets to the material, lower the front lift gate, again checking to be sure the grooves in the retaining collars are aligned over sprockets.
7. Pinch wheels are movable. The right hand pinch wheel should be aligned with the white triangle on the top of the pinch wheel pointing to either the solid white triangle for unpunched material and to the triangle with a hole in it for punched material. To move the pinch wheel raise the pinch wheels with the large black handle. Grab wheel from front and back at same time and push. Takes about 10 pounds of force to move the wheel.
8. The left hand pinch wheel should be placed at the left edge of the material. There should be less the $\frac{1}{4}$ inch between edge of the material and the rubber of the tire.
9. Center pinch wheels (the number of pinch wheels is model dependant), should be spread evenly across the media. Avoid bald spots in your grit wheel indicated by the red dot on the top rail above them.

Tensioning Material:

- After you have the material loaded into the Model i-536, the material will need to be tensioned slightly.
- **NOTE:** Be sure the pinch wheels are in the up position during this procedure.
- Tensioning is accomplished by pulling downward with light to moderate pressure on the front edge of the material. The machine will automatically go into "high gain", which is characterized by a slight humming noise coming from the area of the cutting head. (This allows 15 seconds to tension the material before the cutter goes to "low gain".)

- Tighten the clutch by turning it clockwise and lower your pinch wheels. You are ready for cutting.