



Model i-536 Addendum

General Notes:

Please familiarize yourself with all operating procedures listed in your cutter system manual as most procedures for the Model i-536 are achieved in exactly the same manner.

- 1) **Pinch wheels** – must be in the down position at all times when cutting. Inferior cut quality may result if pinch wheels are not used.
- 2) **Clutch knob** – (located on the left side of the machine, protruding from side of control panel), **must be tight while machine is in operation**. Failure to do so can result in material bunching and also can result in main sprocket drive belt coming off the drive pulleys. See “Tensioning Material”.
- 3) **Tangential Emulation** – When cutting heavy materials such as sandblast resist or materials that require a force setting of above 20, the Model i-536 has a “tangential emulation” mode which allows for excellent cut quality in extra thick materials. This feature is characterized by the knife blade lifting in the corners and aligning itself for the next direction of cut. Additional information on this feature can be found on page 2.
- 4) **i-Tech Remote Panel Program** – The i-TECH Remote Panel (located on the cutter system operation/support CD) allows the end user to adjust all the cutter’s parameters through the PC. Parameters such as calibration, force, speed, anticipation, custom setups, and more can be easily adjusted using this useful program.

NOTE: Loading this program on to your PC should be done during your system installation process.

Loading Material:

- 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.
- Pass your material under the lift gates and pinch wheels.
- 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.
- Loosen the clutch knob, located at the left side of the machine, by turning counterclockwise.
- At this point, the front sprockets should be free to rotate by hand to facilitate alignment of the sprockets to the material holes.
- 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.

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.

Tangential Emulation:

- The term “Tangential Emulation” refers to the routine that the Model i-536 uses to insure that all square corners and intricate patterns are cut properly in heavy materials or sandblast masking. This feature is automatically activated in the Model i-536 when a force selection of more than 20 is selected by the user.
- This routine is characterized by the cutter head doing a slight move in the opposite direction of the next cut, slightly scratching the surface of the material to properly align the knife, and plunging in at the point of intersection.
- A different cut test pattern will also be activated at a force selection above 20, or whatever this threshold is selected through the i-Tech Remote Panel.

Cutter Control Panel Operation:

- Force, speed, and all other features are the same as any i-TECH Cutter. Please refer to your Cutter System Manual (on the System CD in your Accessory Kit), for these operating procedures.

i-TECH Remote Panel:

- All operating parameters and system diagnostic routines are adjustable through the **i-TECH Remote Panel**. Please load this program on your PC at the time of system installation and familiarize yourself with its operation. This is a useful tool in the setup and operation of your cutter and facilitates our service support to you should you need to contact the Allen Datagraph Systems, Inc. Service Department.

Adjustable Parameters Document:

- Please refer to the Model i-536 Adjustable Parameters on your system CD.