PCUT
Users
Manual

Contents

Welcome

Thank you for choosing the PCut cutter from USCutter.

The PCut is an exciting advancement in the world of vinyl cutting. It allows the user to perform advanced cutting functions that were previously unavailable to entry level machines.

This manual is here to help provide a starting point in the learning process of the PCut cutter or to vinyl cutting in general. Please read it thoroughly and follow the steps carefully to help insure a trouble free experience with your new machine.

If you have any questions along the way, we have provided a few locations to go to get those questions answered. You can post on the USCutter forums at forum.uscutter.com, submit a request for support on the support site at support.uscutter.com or call customer service at 888-298-8143.

We hope you enjoy your experience with the Pcut and the USCutter family.

PCut Parts

Before you start cutting, you should familiarize yourself with the cutter and its basic parts and functions:

Front View
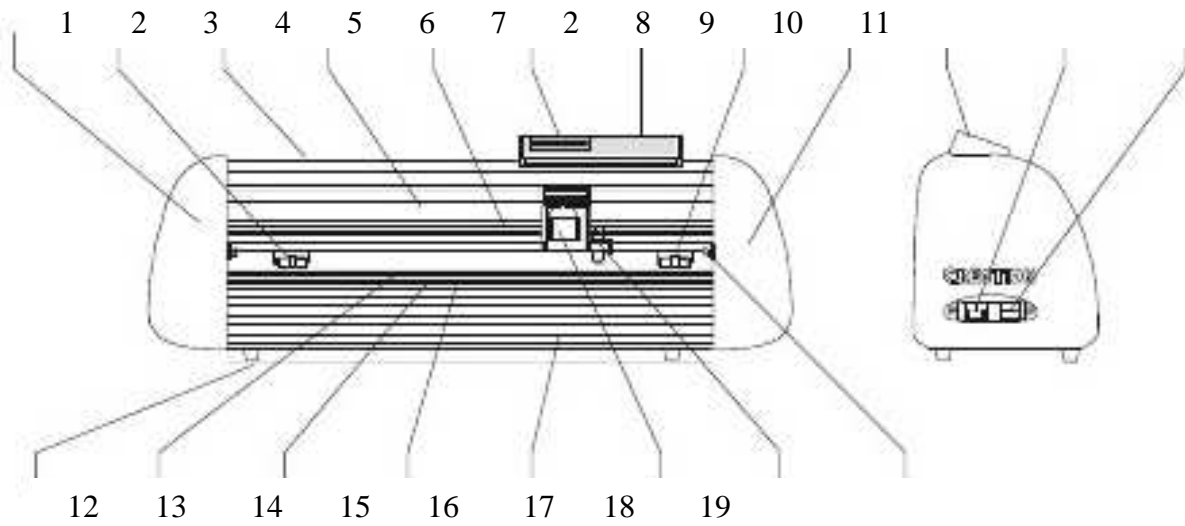
1) Left end cap
2) Pinch roller
3) Top cover
4) Beam
5) Carriage drive belt
6) LCD (Liquid Crystal Display)
7) Keypad
8) Right endcap
9) Control panel
10) Power Socket
11) Power Switch

12) Rubber foot
13) Feed Roller
14) Scale
15) Strip Cushion
16) Trimming Groove
17) Carriage
18) Carriage Arm
19) Kill Switch

1   1
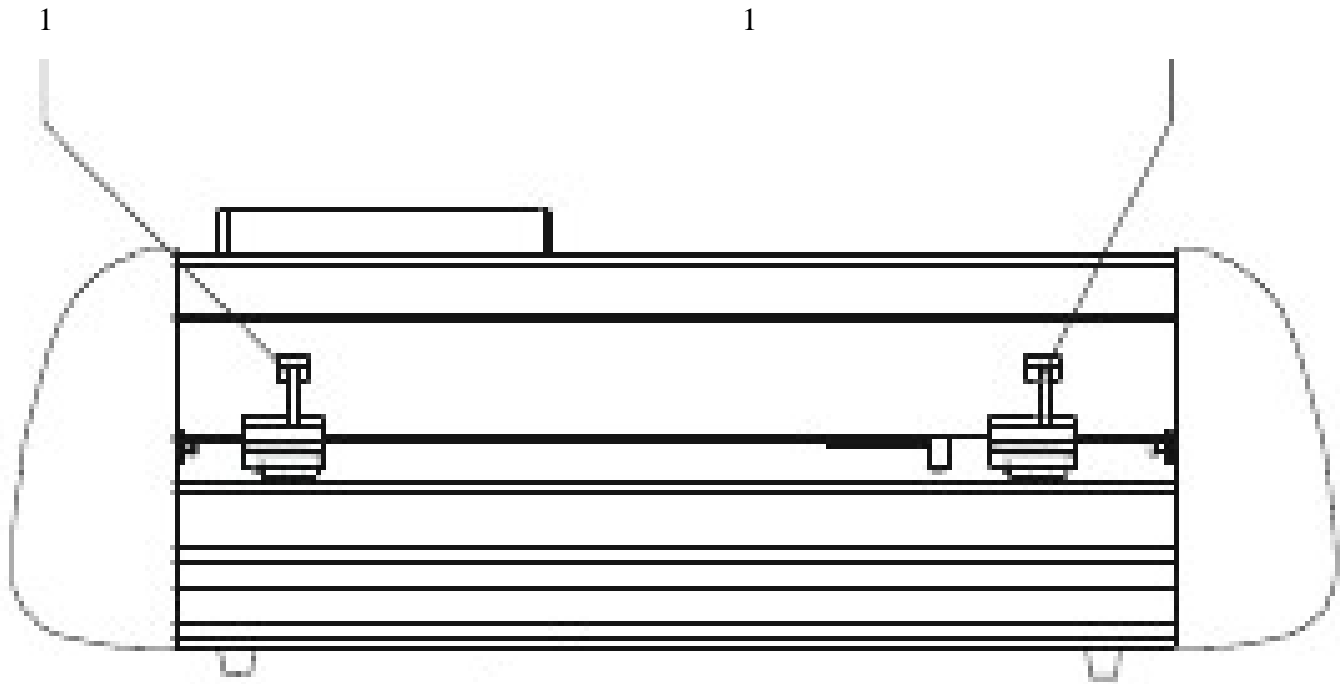
1)   Pinch Roller Release Levers

Pinch Rollers can be released (either to be moved from side to side or to allow vinyl to be easily fed below them bylowering the release levers. Pinch rollers should be adjusted so that one is positioned on each side of the vinyl (or other media) to be cut and should only be lowered onto an area of the feed roller below that has traction (the rough area).

Control Panel

Control Panel Overview
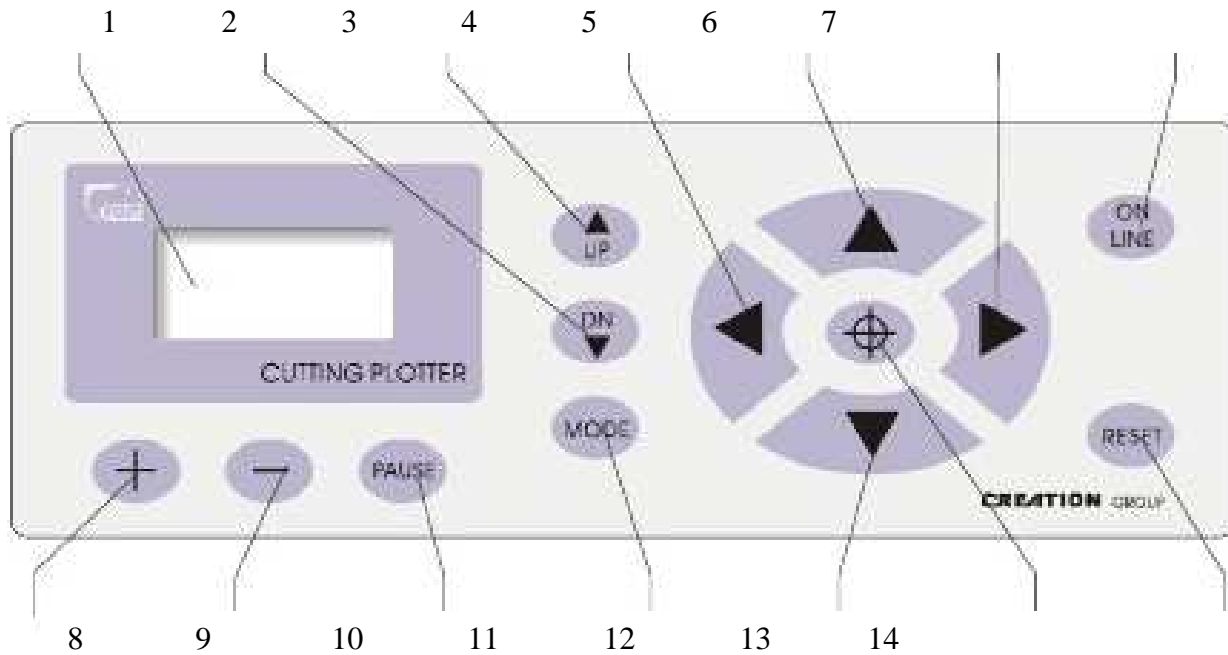
1) LCD Display
2) Blade Down
3) Blade Up
4) Blade left
5) Media feed in
6) Blade right
7) Online/Offline

8) Setting Increase
9) Setting Decrease
10) Pause
11) Mode Select
12) Media feed out
13) Origin set
14) Reset button

First, to be able to use/adjust any of the functions from the cutter, it must be "Off Line".

When you first turn on the cutter you will see
a short startup process followed by this display

On Line

CUTTING PLOTTER

To switch the machine to offline mode press the online button (7).

X=+0.00
Y=+0.00

CUTTING PLOTTER

This is Jog mode, the first in the 7 available Off Line modes.

From here, you can now press the Mode button (11) to cycle through the modes

Jog Mode

Jog Mode is used to position the vinyl and cutting blade. You can use the target button to reset the origin of the next cut to be made. You can also make a test cut to witness the current speed and pressure settings or check the blade depth while in the down cutting position. Make sure that when setting the blade position it is clear of the red emergency "kill" switches on either side of the cutter.

Pause button	Cuts a small rectangle with the current speed and pressure settings. Useful in determining the proper pressure/speed settings to be used.
On Line Button	Returns the cutter to its origin location and returns to "On Line" status.
Mode Button	Cycles through the 7 Off Line modes.
Directional Buttons	Moves the vinyl and blade.
Target Button	Sets the current vinyl/cutting blade location as the new origin. The origin will be the starting position of the vinyl/blade on the next cutting job that is sent to the cutter.
Up/Down Buttons	The Down Button will lower the cutting blade into the down cutting position. This can help you determine if the pressure setting needs to be adjusted before cutting. If the blade is left in the down cutting position then the progress of the pressure setting can be seen while adjusting the pressure setting in the Pressure Setting Mode. The Up Button will return the cutting blade to its regular position.
Plus/Minus Buttons	(has no function in this mode).

Pressure Setting Mode

 The Pressure Setting Mode is used to adjust the pressure of the cutting blade. Thicker materials can require more pressure. The pressure should be strong enough to fully cut the top vinyl but not strong enough to cut through the backing attached to your vinyl. If you are unsure of the cutting pressure that you should use, it is advised to make a test cut. This can be done by holding the Test Button in this mode or by returning to Jog Mode and pressing the Test Button. You can see how the pressure effects the down cutting position of the blade by returning to Jog Mode and using the Up/Down Buttons.

On Line Button	(has no function in this mode).
Mode Button	Cycles through the 7 Off Line modes.
Pause Button	Returns the cutter to Jog Mode.
Directional Buttons	(has no function in this mode).
Target Button	(has no function in this mode).
Up/Down Buttons	(has no function in this mode).
Plus/Minus Buttons	Increases/decreases the pressure used during cutting (ranges from 0 to 200). Thicker materials may require more pressure. The amount of pressure used can be seen by going to the Jog Mode and using the Up/Down buttons to switch the blade from the original position to the Down cutting position.

Test Mode

Test Mode is used to create a test pattern that shows various cuts in a number of directions. Most simple tests (those to check the pressure and speed settings) can be done more efficiently by pressing and holding the Test Button from any of the other modes. If you would like the test to be performed multiple times, you can set the number shown on the display screen to the amount of times you would like to test (from 1 to 255). For most situations, 1 test will be sufficient.

Online Button	Cuts a test pattern the number of times shown on the display screen, using the current speed and pressure settings. (has no function in this mode).
Mode Button	Cycles through the 7 Off Line modes. Returns the cutter to Jog Mode.
Directional Buttons	(has no function in this mode).
Target Button	(has no function in this mode).
Up/Down Buttons	(has no function in this mode).
Plus/Minus Buttons	Decreases the number of test patterns to/Increases be cut (ranges from 0 to 255).
	This should not be set to 0 (zero), as this will cause the cutter to cut test patterns until it is turned off.

Repeat Mode

Repeat Mode allows you to cut an exact duplicate of the last cut that was sent to your cutter. The number of repeats made can be selected with the Plus/Minus Buttons. When you are ready for the repeat cuts to be made, press the On Line Button. Although some software allows you to jog (move) the cutter before cuts are made, since you are bypassing the software by making a cut directly from the cutter, no software adjustments will be accounted for. If the blade or vinyl needs to be moved, please use the Jog Mode.

Mode Button	Returns the cutter to Jog Mode (If held down, a test cut will be made).
On Line Button	Starts the Repeat function.
Pause Button	Returns the cutter to Jog Mode.
Directional Buttons	(has no function in this mode).
Target Button	(has no function in this mode).
Up/Down Buttons	(has no function in this mode).
Plus/Minus Buttons	Plus/Minus Buttons Increases/Decreases the number of repeat cuts to be made. These will be a repeat of the last cut that was sent to the cutter.
	Once the On Line button is pressed, all of the cuts will be made in succession.

Cutting Speed Mode

Cutting Speed Mode is used to adjust the speed of the cutter. Most cuts can be made at high speeds but if a problem is occurring where accuracy or detail is being lost in the cut, a slower cutting speed may solve the problem.

On Line Button	Returns the cutter to Jog Mode (If held down, the cutters status will return to On Line).
Mode Button	Cycles through the 7 Off Line modes.
Pause Button	Returns the cutter to Jog Mode.
Directional Buttons	(has no function in this mode).
Target Button	(has no function in this mode).
Up/Down Buttons	(has no function in this mode).
Plus/Minus Buttons	Increases/Decreases the speed of the cutter (from 10 to 80 in increments of 10).

The X and Y Axis Scale Compensation Modes are used to correct problems when the cuts being made are not the same scale as they are intended. The X axis effects the size of cuts across the width of the vinyl while the Y axis effects the size of cuts along the length of the vinyl. If the cuts being made are not the correct size, increase or decrease the number that coincides with the problem axis until the cuts are correct.

On Line Button	(has no function in this mode).
Mode Button	Cycles through the 7 Off Line modes.
Pause Button	Returns the cutter to Jog Mode.
Directional Buttons	(has no function in this mode).
Target Button	(has no function in this mode).
Up/Down Buttons	(has no function in this mode).
Plus/Minus Buttons	Increases/Decreases the amount of X/Y scale compensation. The larger the number is, the larger the cut made will be. This compensation can be used to remedy problems where the cut being made is smaller or larger than it was intended.

Setting up

Selecting a Location for Your Cutter

The first step to setting up a PCut is finding a good location for the machine. Consider these factors when you are selecting a suitable place:

The stand has a footprint of approximately 25" x 35". If you intend on using the PCut without the stand, you will need a desktop space of approximately 35" x 18" with the included media rollers attached, or 35" x 11" without.

You will need to have access to both the front and rear of the machine for operations as well as for loading and unloading new vinyl rolls. Try to find a space with adequate access to both the front and back of the machine.

Since the PCut is a precision cutting device, you will want to find a location that will be stable to insure cutting accuracy. Whether placing the unit on the floor or a table top, the accuracy of the machine will be directly related to the stability of the platform it is placed on. Find a sturdy floor space or table top for the machine and consider a location that will be out of the way of people and other machines with moving parts while the cutter will be operating. Excessive moving of the machine can not only disrupt accuracy of cutting but may also cause electrical components inside the machine to dislodge and require otherwise unnecessary repairs and maintenance.

Fans, located inside of the PCut cutter, can draw in outside dust from the area surrounding the cutter. Excessive buildup of dust can cause either mechanical or electronic malfunctions. Keeping the PCut cutter as dust free as possible will help ensure trouble free operation. Try to find an area for the PCut cutter that will be free of any excessive dust.

All cutters will produce a small amount of noise while operating. Please take this into consideration when selecting a location for your cutting purposes.

Do not remove the grounding pin from the power cord or attempt to use the cutter when it has not been properly grounded.

Unpacking

Remove all contents from your shipping box. If you have not already done so, please refer to the Unpacking Guide to take account of all of the included components.

Cut the restraining plastic straps from the cutter. Be careful to not cut anything but the restraints.

If you purchased your PCut cutter with a stand, please refer to the included PCut stand assembly guide at this time and complete assembly of the stand.

If you will be using your PCut as a table top unit without a stand and would like to use the included table top rollers, please refer to the table top roller instructions.

Installing the Pen Holder

Most new users will benefit from practice "cutting" with the supplied pen carriage until they are comfortable with normal operations of the PCut and cutting software.
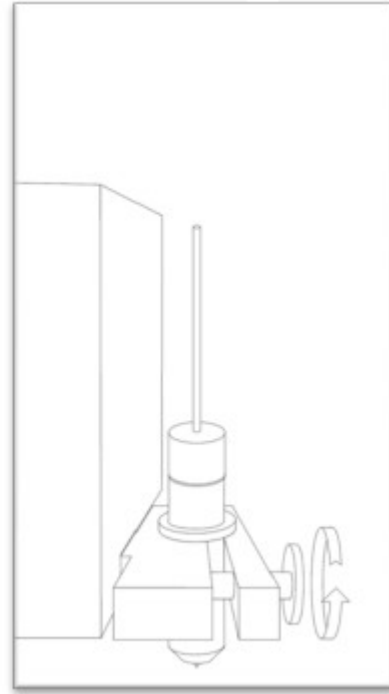
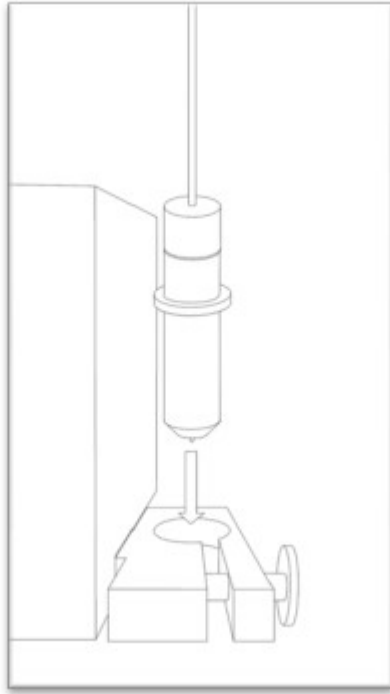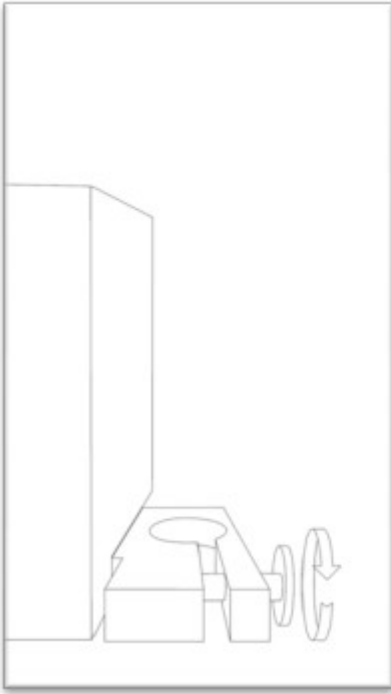To install the pen holder:
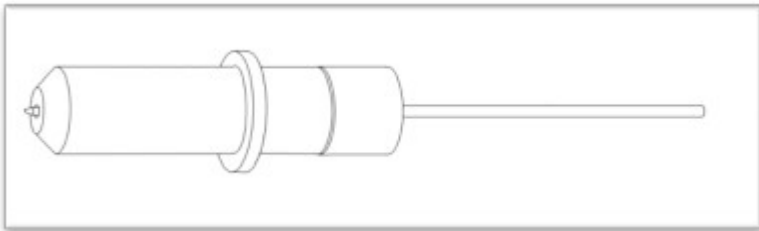
Loosen the locking knob on the carriage arm.

Drop the pen attachment into place.

Tighten the locking knob on the carriage arm.

It may be easier to install the pen (or blade) carriage after the lid on the PCut has been raised allowing more working room.

Remove the top cap, the pen and the spring. Replace the pen and/or spring as necessary. Slide the spring onto the pen from the top and insert it back into the pen carriage.
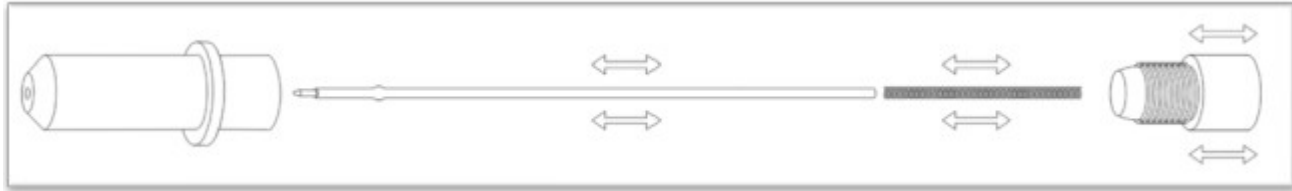
Replace the holder cap and screw into place.

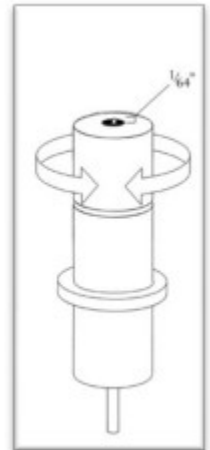Once you are ready to make cuts with the PCut you can attach the blade carriage.

Installing a New Blade

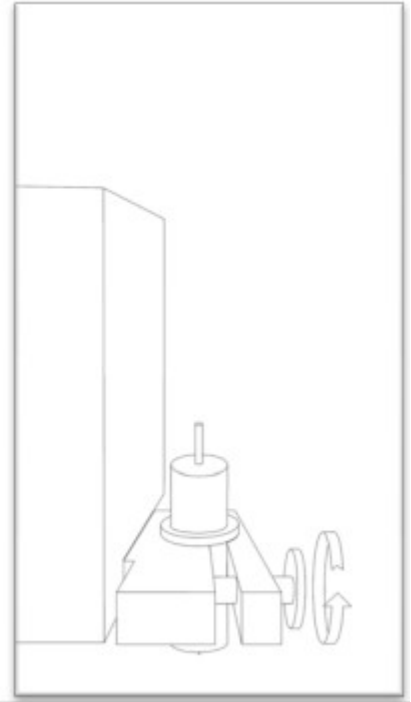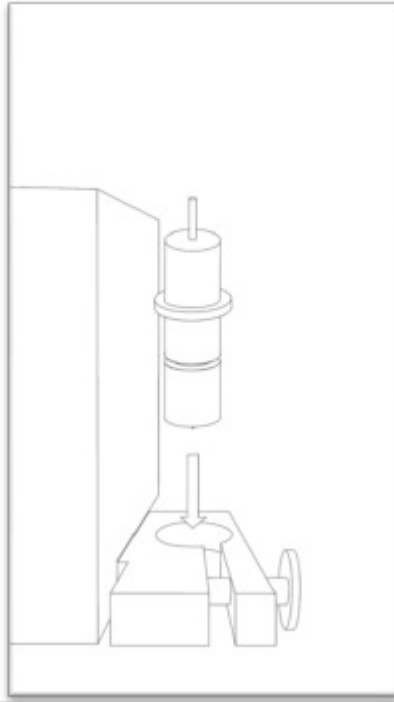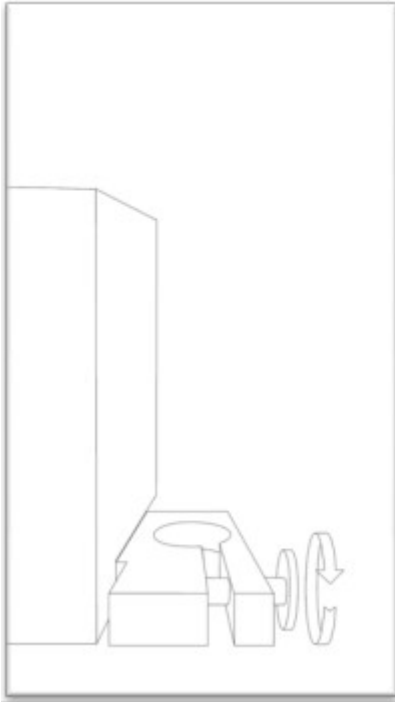| Unscrew the cap from the Blade holder.	Remove the protective cover from a new blade.	Insert the blade into the top of the Blade holder.	Screw the cap back on and Adjust the blade exposure until the blade tip is protruding approximately 1/64th an inch.

Loosen the locking knob on the carriage arm.

Place Blade carriage (blade side down) into the carriage arm.

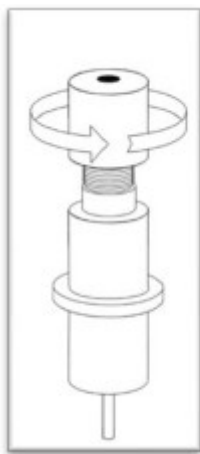Tighten the locking knob on the carriage arm.

Replacing a Worn Blade

First remove the blade carriage from the carriage arm

Unscrew the cap off of the blade holder.

Press up on the release button located on the bottom of the blade holder to raise the blade and remove it.

Follow the remaining steps from "Installing a New Blade" above.

Connecting the PCut to a Computer

Attach the power cord first to the PCut unit.

Plug in the unit and turn on the power.

If Using the Serial Cable to connect the PCut to a Computer:

Connect Serial Cable (first to the PCut, then to the computer).

Your PCut setup is now complete and you are ready to move to the software installation section.

If Using the USB Cable to connect the PCut to a Computer:

Connect the USB cable (first to the PCut, then to the computer)
If Windows automatically installs the needed drivers, your installation is complete proceed to "Finding your COM port".
If Windows does not install the needed drivers, but the found new hardware wizard appears, follow the instructions on screen, using the supplied drivers from the banana digital driver disk or download the FTDI driver from the support.uscutter.com website under downloads.
If the found new hardware wizard does not appear, navigate to Control Panel>Add Hardware, to initiate
it. Then follow the on screen instructions using the supplied drivers from the banana digital driver disk.

-Finding Your COM Port

First navigate to the Device Manager by following the below instructions for your operating system:

Windows95/98/Me:

Click Start, then select Settings -> Control Panel.

Select Device Manager.

Windows2000/XP:

Click Start, Then Right-click "My Computer" then select Properties.

Select the Hardware tab.

Click the Device Manager button.
Windows Vista/7

Click Start, Then in the "Start Search" box, Type "Dev" (without pressing enter);
wait for a list to show up.

Click Device Manager.

Expand the section labeled "Ports (COM & LPT)".

Make a note of which number COM Port is associated with "USB Serial Port".

You will need this information to properly install your software.

Install SignBlazer Software

Insert the SignBlazer Elements CD into your computer.

Select "Run Setup" .

Follow the on screen instructions.

When asked what cutter you want to use, select the Creation PCut CTE 630

When asked what port your cutter uses select the COM Port that corresponds with your setup (Noted above from the "Finding Your COM Port" section of the manual).

Do not change the Baud Rate, Data Bits, Stop Bits, or Parity options.

Make sure the Flow Control option is set to Hardware.

Preparing the PCut for Cutting

If you are going to be cutting from a roll of vinyl (or other material), and did not purchase a stand with your PCut cutter, then you may want to use the included table top rollers to hold the roll. The table top rollers will work best if they are allowed to hang slightly over the edge of a table so that the hooks on the cutter side are allowed to fully connect with the cutter, increasing stability.

If you are going to cut from a single sheet instead of a roll, then skip the next step on placing a vinyl roll. All other steps will be the same.

Place the roll on top of the rollers. If using the stand, you can move the roller caps up against either side of the vinyl roll to keep the roll from shifting right or left during cutting.
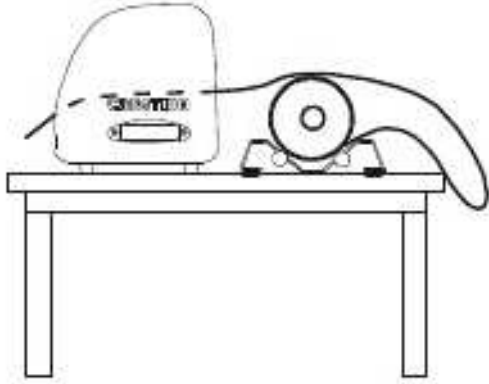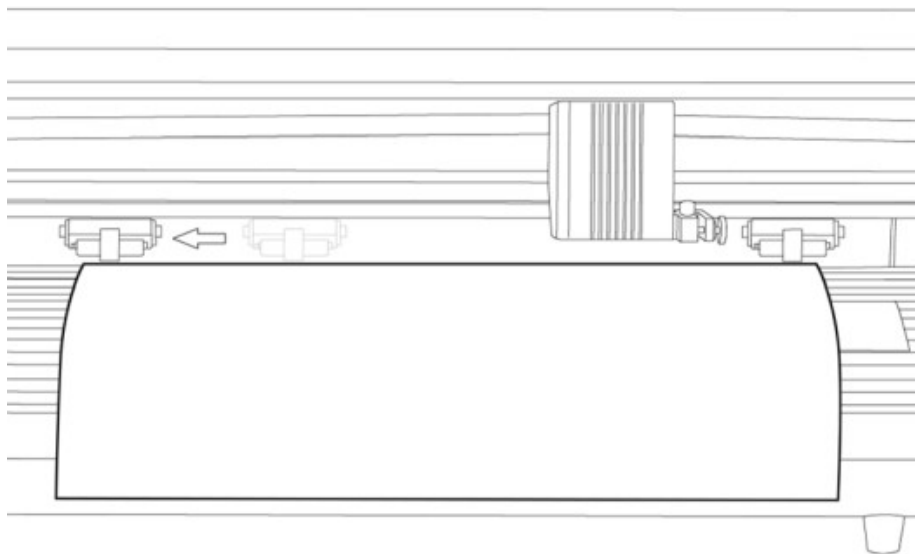
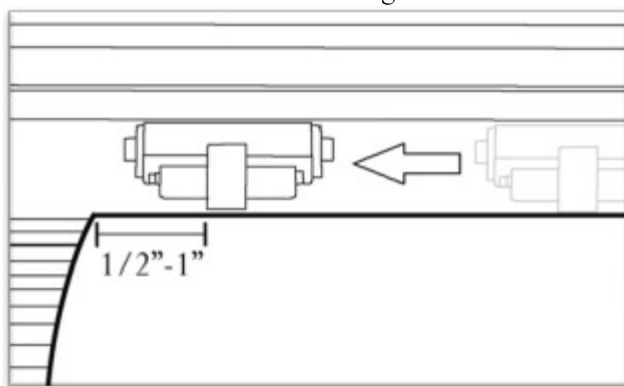Release the Pinch Rollers by lowering the Pinch Roller Release Levers.
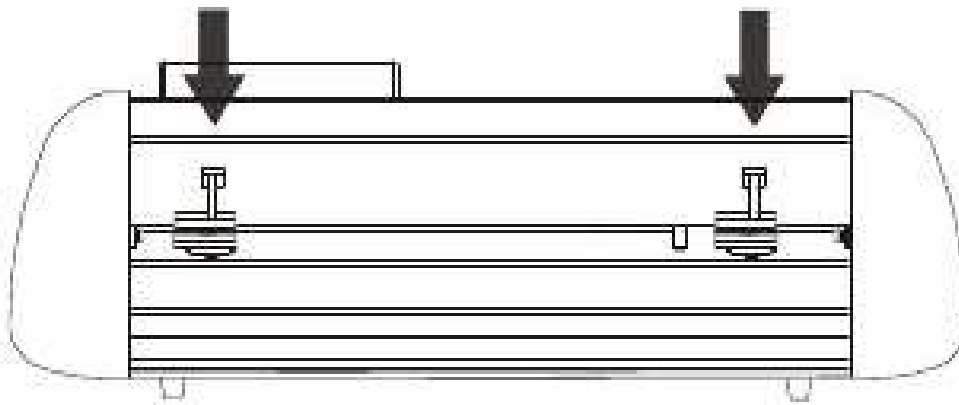
Feed the vinyl underneath the pinch rollers (if working from a single sheet instead of a roll the vinyl can also be feed from the front).
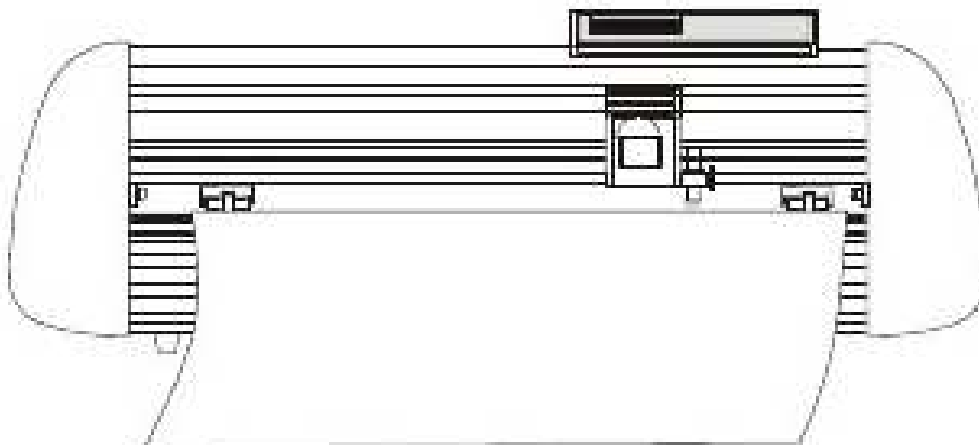
Adjust the pinch rollers from side to side so there is one roller on each side of the vinyl.

Leave a gap of between ½-1 inch from the edge of the roller and the edge of the vinyl on both sides.

Engage the Pinch Rollers by pulling up the Pinch Roller Release Levers.

If the PCut is not already on, turn it on now

Take the cutter Off Line and make sure it is in Jog Mode (If you are unsure of how to do this, please refer back to the Control Panel section of this manual).

Adjust the vinyl to where you want to make your cut by using the Up and Down Arrow Keys on the Control Panel.
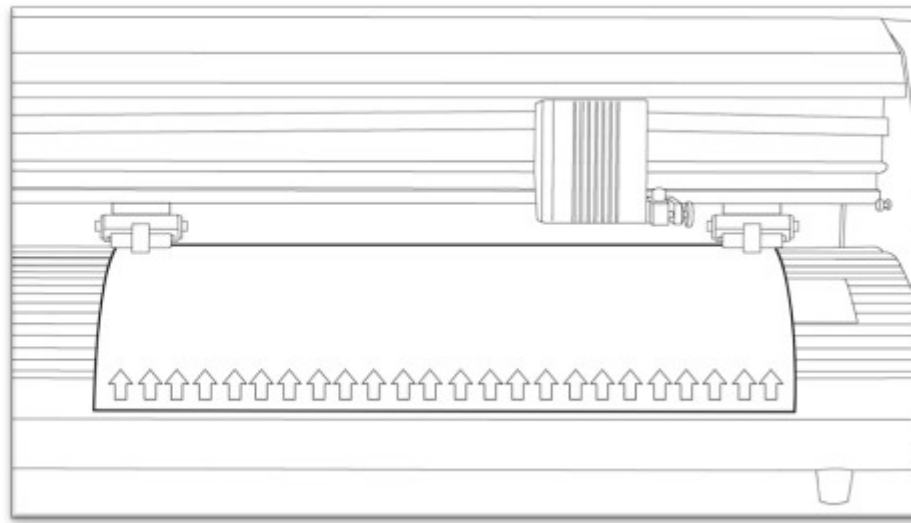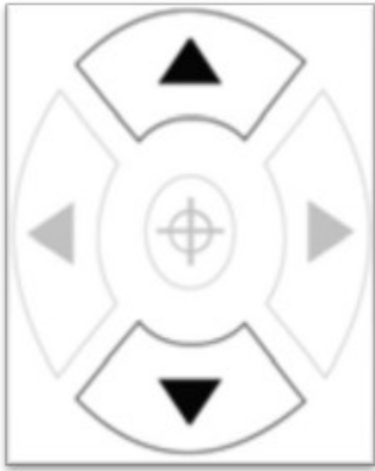
Now, adjust the Blade to where you want your cut to be made by using the Left and Right Arrow Keys.

Now press the target key to tell the cutter that this is the location where you would like the cut to begin.
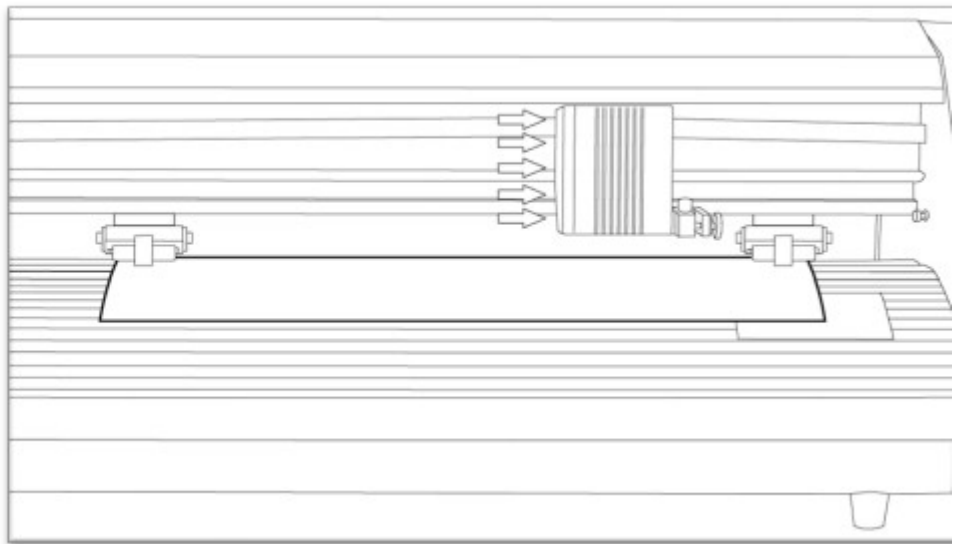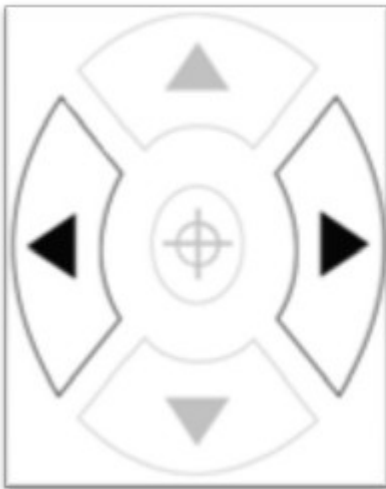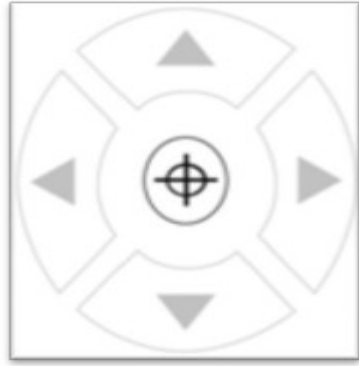

If you would like to make other adjustments to the pressure, speed, or other settings you can do so now. If you are setting up for your first cut with the machine then the default values should be a good starting point.

You can now return to Online Mode. Your cutter is now ready.

Step By Step Instructions

Starting SignBlazer

Making sure that the USCutter PCut is turned on and in On Line mode before starting the SignBlazer software will help avoid communication problems between the cutter and software.

Open the SignBlazer Software (The Default location will be in the Programs Folders under "SignBlazer Elements for USCutter").
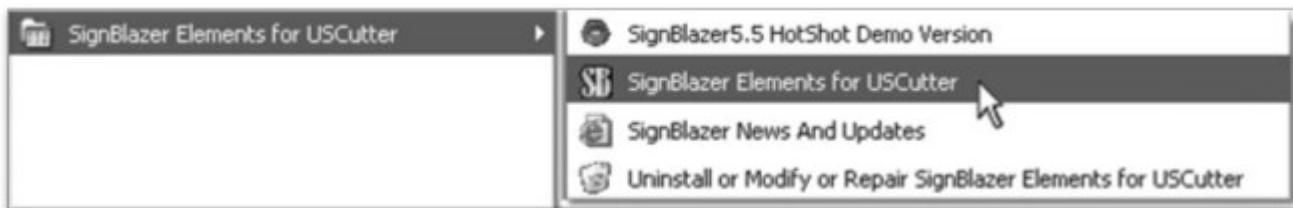
Navigate to this folder and select "SignBlazer Elements for USCutter".

SignBlazer will attempt to download update files.
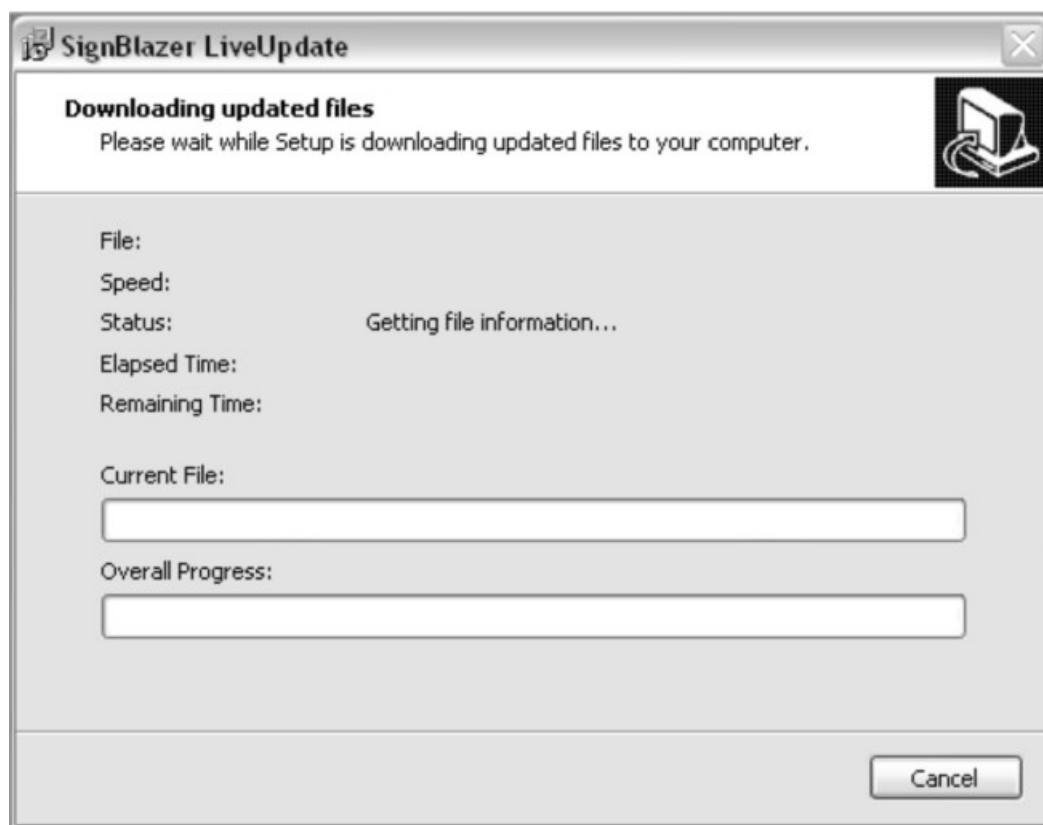
If it fails, cancel the update process (By Pressing the Cancel button on the error window and then the OK on the confirmation window) and the program will start regularly.
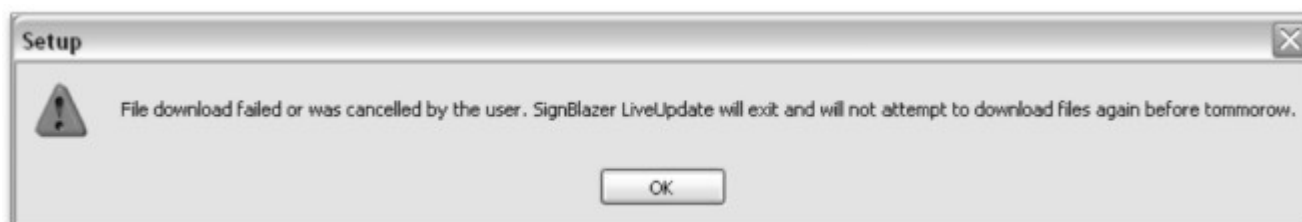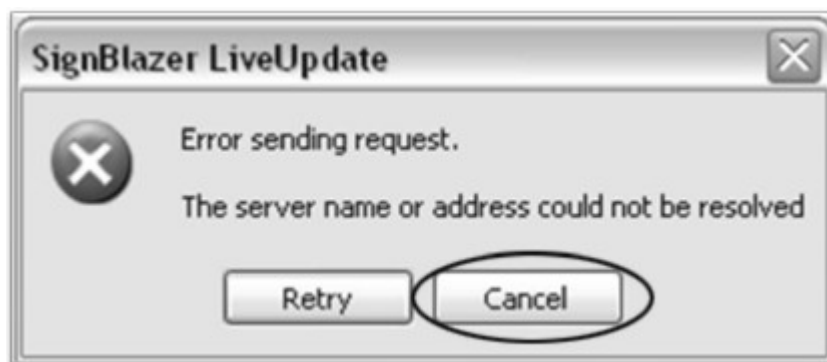
We will be working in Trial Mode. Select "Trial Mode" from the following screen, then select "Yes" from the confirmation window.

Now SignBlazer is open and you are looking at the main SignBlazer screen.
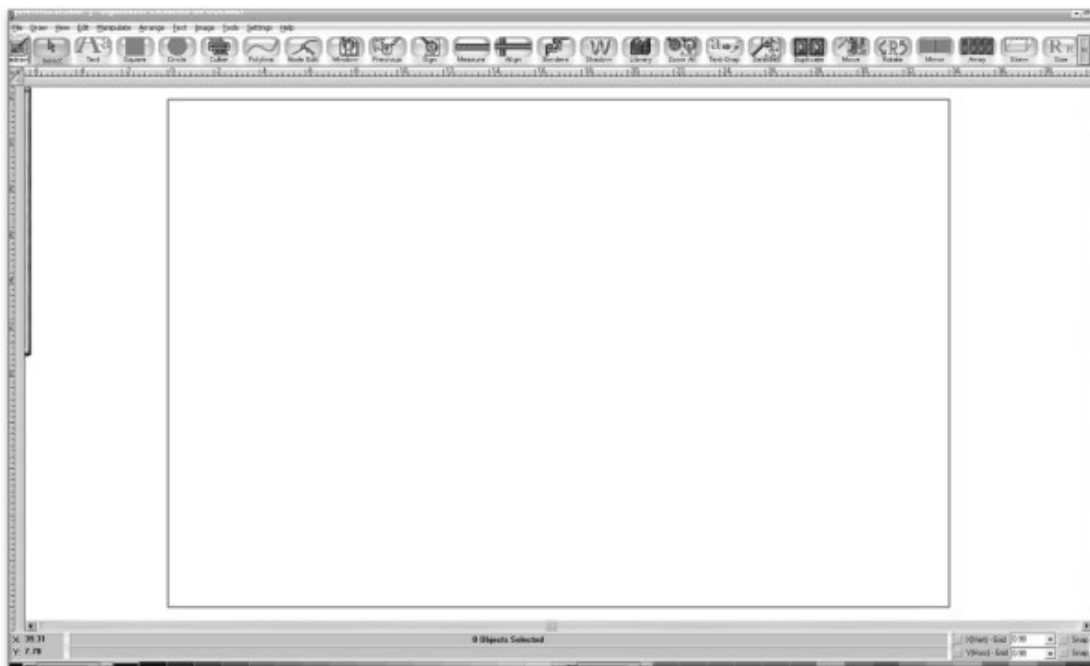
Making a Simple Cut in SignBlazer

You can create images from scratch using the various tools in SignBlazer. For this tutorial, we will be drawing a simple square just to show the steps of making a cut from SignBlazer.

Select the Square tool at the top of the window.
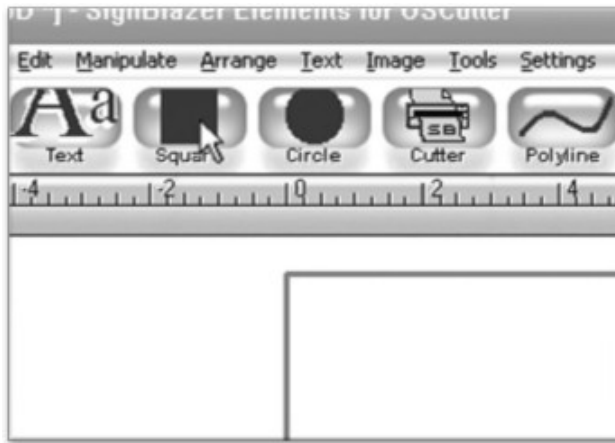
Now draw a square by clicking first in the main window…   And then moving the mouse to determine the size of the square desired, and clicking a second time.
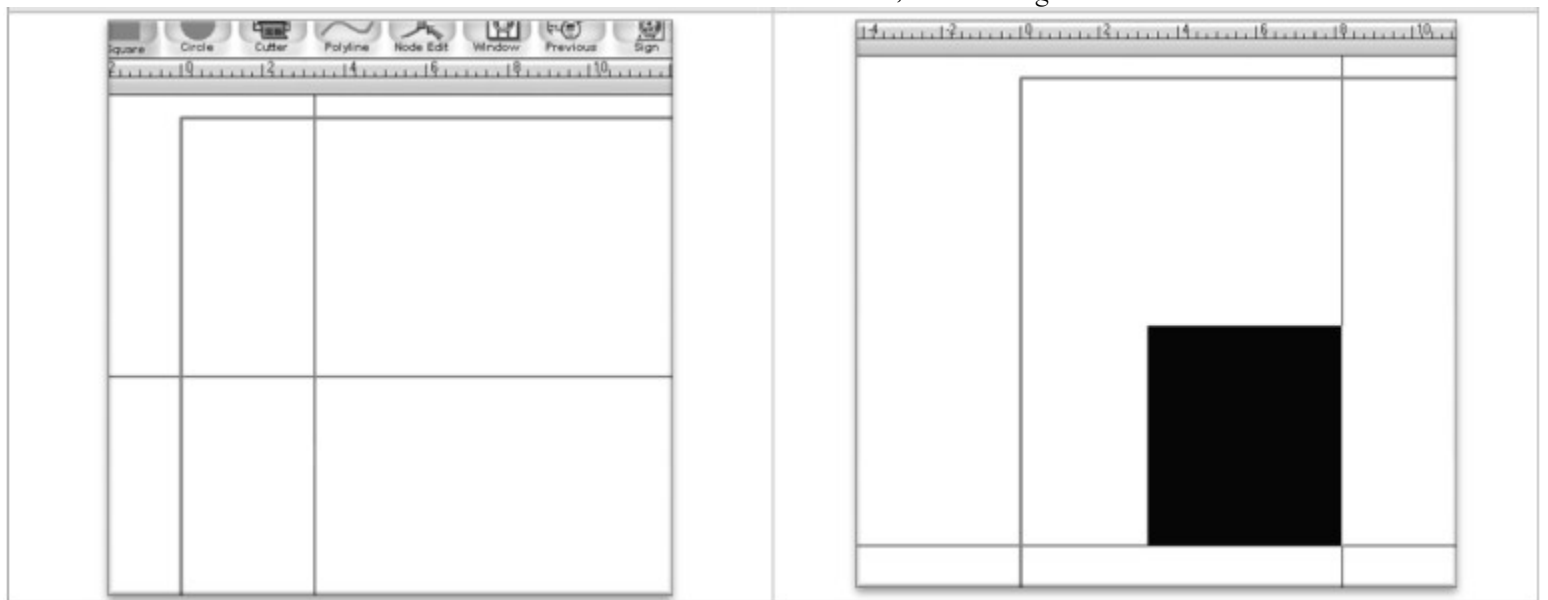
Now to cut this simple shape from the cutter:

Select Cutter from the top selection menu.

Please make sure that your cutter is turned on and in On Line mode before proceeding. Also make sure that you have vinyl (or another cuttable material) in the cutter and ready to go by following the steps in the "Preparing the Pcut for Cutting" (page 20) section of this manual. It is always best to start the SignBlazer software with the cutter turned on and in On Line mode. If this step is missed you may experience communication issues between the cutter and the software. If this occurs, please turn off the cutter, go back to the main SignBlazer screen by pressing the Finish button from the top selection menu of any of the sub-screens, and then turn the cutter back on and ensure that it is in On Line mode.

This will take you to the cutter screen of SignBlazer Elements where you can see a representation of how your cut will be made when sent to the cutter and other various cutter options.
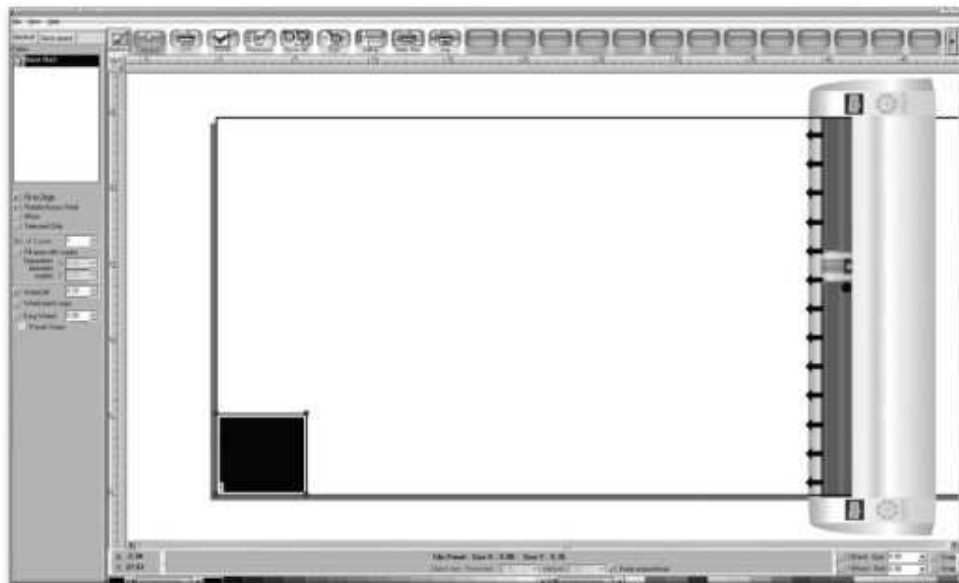
Since this is a simple cut, no adjustments need to be made here. We can tell the software we are ready to cut by pressing the cut button in the top selection menu.
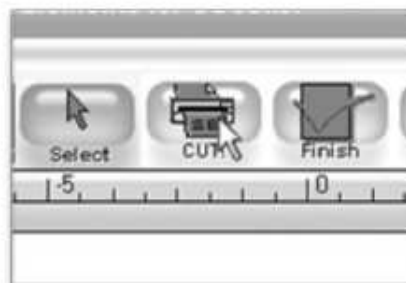
And then pressing "Cut Tile" in the Cut Tile window:

When you are finished, you can go back to the main SignBlazer screen by pressing the Finish button in the top selection menu.

Importing

Drawing images from scratch in SignBlazer may prove to be somewhat different than imaging software that you are more familiar with. If you would rather create the images to be cut in another software or you already have designs finished that need to be cut, then you can just import the finished artwork into SignBlazer and cut from there.

Most major raster and vector image files are supported in SignBlazer Elements including dxf, eps, ai, bmp, tif, gif, pcx, tga, jpg, pcd, pct, psd, cmx, ps,and wmf.

You can import to SignBlazer one of two ways:

Using the Clipboard

You can import from the clipboard by first copying or cutting an image opened from another software program, and then placing it into SignBlazer by selecting Clipboard Paste from the Edit drop down menu.

Images imported via Clipboard Paste may not retain the same dimensions that they held in another software program.

Using the Import Function

You can import an image that has been saved from another program by first selecting Import from the File drop down menu:
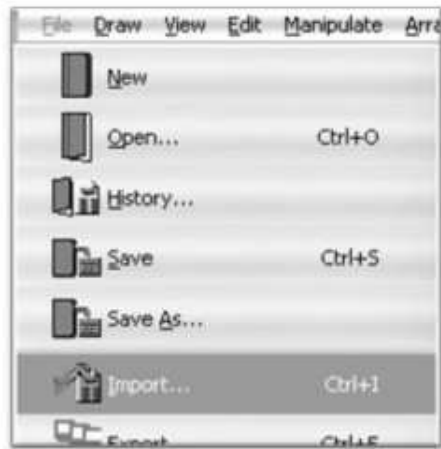
Then navigate to the saved file by using the Folder and Drives menus:

Then Select the image to import,

And select the OK button.

If you are having trouble locating your file, make sure that the file type is selected from the "List Files of Type", or "All Graphic Files" is selected.
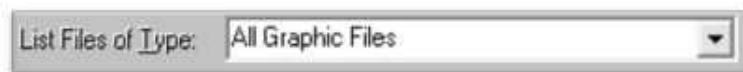
Cutting From an Imported File

If the file imported is already a vector image then it is now ready to cut or be further edited within SignBlazer. If you are ready to cut, you can follow the steps in the previous section "Making a Simple Cut in SignBlazer"(page 26).

If the image imported is a raster image then a few more steps will need to be taken to get the file ready for cutting.

Converting a Raster Image to Vector Image

The difficulty of converting a raster image to a vector image will vary greatly depending on the amount of contrast in the image. The image to be cut should be darker than the background and should have a significant amount of contrast and separation from the rest of the image. If possible, the image should be completely separated from the background and be black in color (though the image we chose for this demonstration has a background and is not completely darkened to demonstrate that the process is possible with a variety of images).

First make sure that the image has been properly imported into SignBlazer and that the image is selected.

You can tell an image is selected when it shows a Border and Square Bounding Boxes in its parameter.

With the image selected, select "Monochrome – 1 bit" from the Mode section of the Image drop down menu.
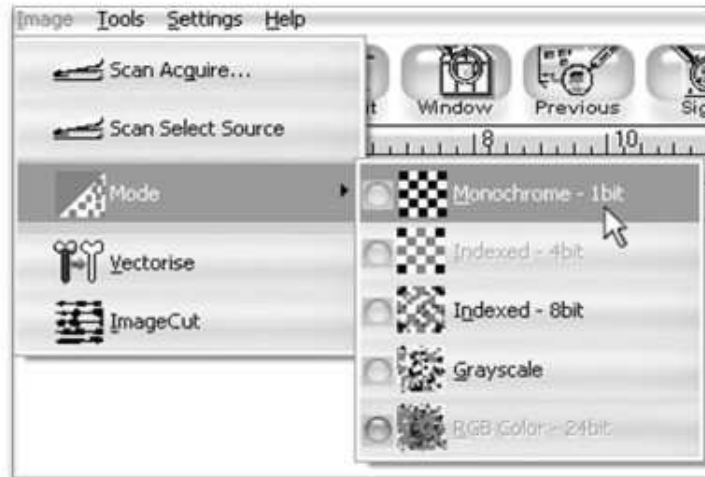
Sometimes an imported image will already be in monochrome but will still need to be vectorized before being cut. If the image imported is monochrome than you can skip ahead to the "vectorise" section.

The "Convert Image to monochrome" window will appear.
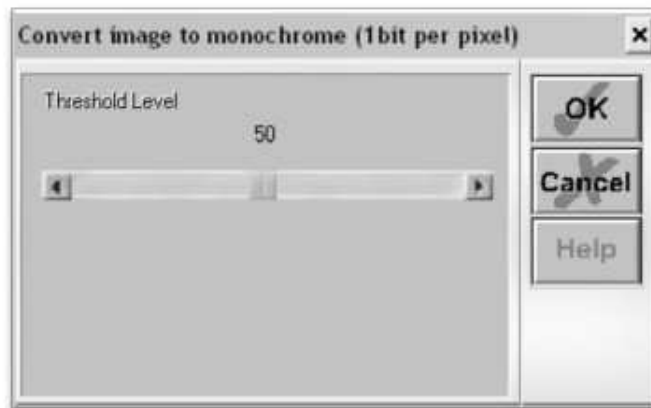
 Where you place the slider will determine how much of .Now you can adjust the Threshold Level sliderthe image will be included in the monochrome conversion (which is to become the image that will be cut). Anything darker than the level set on the Threshold slider will be included in the cut and anything lighter will not.

Since we chose an image with good contrast and separation for our example this process will be easy. We simply check that our image to be cut shows up in light grey or black and that there is no areas of the background or other parts of the image that are unnecessarily included.
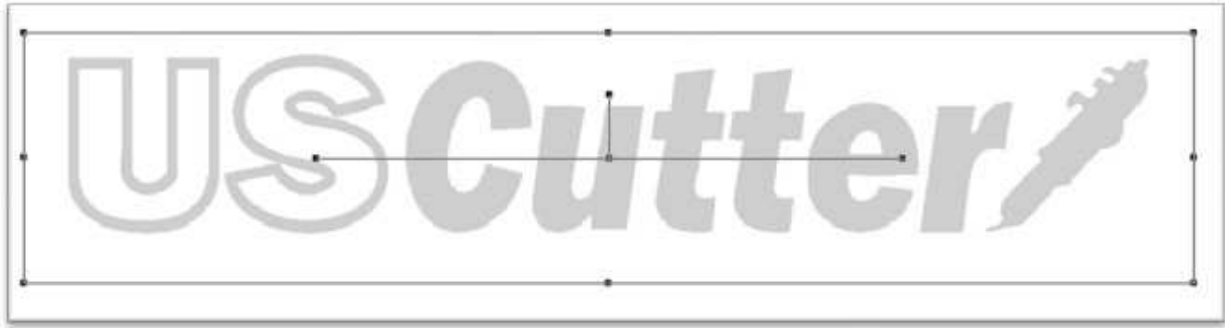
Now press the OK button on the "Convert Image to monochrome" window.

Now to convert a monochrome image to a vector, select "Vectorise" from the Image drop down menu.

And press the OK button on the Vectorise Image window.

You are now left with 1 monochrome image and 1 vectorized image. This may be difficult to see as they are probably layered directly on top of one another. If you grab one image and drag it you will see the other image left behind. You can now delete the monochrome image that has been left behind as it is no longer needed.

The cutting process for a vectorized image is the same as it is for cutting a simple image. You can now follow the steps from the "Making a Simple cut in SignBlazer" (page 26) section of this manual to make your cut.

Specifications

PCut Release Date	October, 2007
Controller	16 bit CPU
Control Panel	2x8 LCD 13 button thin-film keyboard
Driver:	High stepping motor, micro-step driver
Maximum Paper Feed Width	28.74 inches (730mm) - 24 inch model
	39.37 inches (1000mm) - 36 inch model
	51.18 inches (1300mm) - 48 inch model
	25.20 inches (640mm) - 24 inch model
Maximum Cutting Width	35.63 inches (905mm) - 36 inch model
	47.64 inches (1210mm) - 48 inch model
	15.75 inches (400mm) per second
	.039 inches (1mm)
Maximum Cutting Speed	0 - 400g
Maximum Cutting Thickness	.1mm
Pressure Range	All 11.4mm diameter plotting pens
Precision	DM-PL HP/GL; automatic identification
Plotting Pen	USB (Universal Serial Bus) and RS-232 Serial (9 pin
Communications Protocol	110 VAC/ 220 VAC 50 Hz / 60 Hz (auto-switching)
Communications Interface	Standard power cord included with unit is US-standard 110 VAC
Input Power	grounded plug.
Power Consumption	Less than 100VA
Customer Service Line	425-481-3555; option #3. Available 8am - 5pm, Mon-Fri
Technical Support Line	425-481-3555; option #2 Available 9am - 4pm, Mon-Fri
Technical Support Website	support.uscutter.com
Customer Forums	forum.uscutter.com
Manufactured For and Sold Directly By	19510 114th NE, Suite C-1
	Woodinville, WA 98072
	425-481-3555 phone
	888-640-0720 fax
	www.USCutter.com

Troubleshooting

placed in the on position.

<table>
<tr><th>Problem</th><th>Solution</th></tr>
<tr><td>The cutter is unresponsive to communications from the computer and software.</td><td>Communication issues can arise if the cutter was powered on while the software is trying to send data to or from the cutter. Exiting the cutter screen of SignBlazer and returning to the main SignBlazer screen may resolve this issue. If not, save all work and try exiting SignBlazer and restarting with the cutter powered on. It is good practice to start SignBlazer with the cutter powered on to avoid communication problems.</td></tr>
<tr><td></td><td>Make sure that your output device in SignBlazer (Found by selecting File>Cutter from the menu on the main SignBlazer screen, and then selecting Setup from the top menu buttons) is set to the correct COM port. (Your COM port can be found by following the instructions in the "Finding Your COM Port" section of this manual on page 19). You can change your COM Port by right-clicking on the COM Port in the device manager and going to the advanced section of the Port Settings tab.</td></tr>
<tr><td></td><td>Adjust your Flow Control settings to Hardware by first locating your COM Port in the device manager (By following the instructions on page 19), then right-click the COM Port and select Properties. On the Port Settings tab, change to Flow Control option to Hardware.</td></tr>
<tr><td>Black boxes show up on the Display Screen of the Control Panel when cutter is turned on.</td><td>One of the Emergency Kill Switches may be pressed or otherwise engaged. Make sure that nothing is pressing on either of the Kill Switches or that they have not become stuck in the pressed position. If a problem persists, with power off and the power cord removed, check for crossed wires from one of the kill switches to the motherboard.</td></tr>
<tr><td>The Display Screen on the Control Panel of the cutter is not outputting a display.</td><td>The cable transmitting data to the Display Screen may have become disconnected. With power off and the power cord removed, remove the Right side panel from the PCut cutter and verify that the cable is connected. If the cable appears to be connected but there are still display problems, you can disconnect the cable and reconnect it to make sure that a proper connection has been established.</td></tr>
<tr><td>The Laser is not emitting light.</td><td>If the laser is not lit while the power of the PCut is on, then there may be a defect with the laser. Contact USCutter for laser replacement options.</td></tr>
<tr><td>The PCut is not powering on when the Power Button is</td><td>Try another outlet or surge protector or verify that the outlet being used is sufficiently powered.</td></tr>
</table>

The PCut is not powering Power issues can be a result of a faulty or damaged power cord.
on when the Power Button is Try another cord on the PCut or test the power cord with
placed in the on another device to verify that the power cord is working properly.
position.(continued)

If the problem is not a result of either the outlet or power cord,
there may be a connection problem inside of the machine. With
the power switch in the off position and the power cord
removed, remove the left side panel of the PCut cutter and
check all of the connections from the power cord and power
switch. Repair or replace as necessary.

While attempting to cut, the The Locking Knob of the Carriage Arm may have become over
Blade of the PCut will not tightened and is protruding through the back of the Carriage Arm,
lower. blocking the arm from lowering. Loosen this until there is no
longer a blockage.

When starting the SignBlazer This is a regular occurrence of the SignBlazer software and should
Software it fails to find not be considered a problem. All features of the software will
updates. continue to work in trial mode without updates.

To deactivate the update process, redirect the shortcut (of either the
desktop icon or start menu selection that you use to open the SignBlazer
software) to SignBlazer. Right-click it and select Properties. From
the Properties menu, change last section of the Target option from
"sb.exe" to "sbnt.exe". Press the Apply button, then the OK
button. This will bypass the update process.

Cuts are jagged or inconsistent. The Blade may be dulled or damaged. Replace with a new blade
and try again. Make sure that the blade can turn freely (by
attempting to turn it with your fingers while the release button of the Blade
Carriage is pressed).

Adjust the blade depth of the Blade Carriage(page 17) and Pressure
Setting on the cutter(Page 9) until you are getting solid, uniform
cuts. Start with a blade depth of around 1/64th of an inch and a
pressure setting of 120 and try an increased pressure setting before
attempting to increase the blade depth.

Other solutions may be found by visiting the Customer Forums or Technical Support Website, or by calling the
Technical Support Line (Web page addresses and Phone number on the specifications page, 46).