



**INSTALLATION  
&  
OPERATING INSTRUCTIONS**

**MK205VLC  
VINYL LOG  
CUTTING MACHINE**

# **OPERATING INSTRUCTIONS**

## **safety precautions** read them carefully

- 1 ensure that area around machine is clear of material not used on machine
- 2 before starting machine make sure nobody stands in area marked **danger zone**
- 3 use steel gloves when changing blades
- 4 check that all guards are closed before starting machine

## **machine features**

- 1 the machine comprises two basic sub assemblies
  - 1.1 cutting head...includes
    - 1.1.1. welded frame bolted to floor
    - 1.1.2. blade pulleys
    - 1.1.3. blade
    - 1.1.4. blade guarding
    - 1.1.5. blade guiding
    - 1.1.6. control cabinet & pendant control
    - 1.1.7. log axis control
  - 1.2 log carrier...includes
    - 1.2.1 fixed welded base frame
    - 1.2.2 swing frame bolted to floor
    - 1.2.3 swing frame actuator (log cutting control)

## **operating procedure**

### **2 ROLL LOADING & POSITIONING**

- check that **danger area** is clear
- 2.1 using pendant control press black button to turn machine on and move log carrier out and away from machine and turn machine off (red button).
  - 2.2 position 4 carriages to accept roll with two on cut off end and 2 on chuck end, place cut off carriage nearest to blade approx 200 mm from blade, away from chuck, and, place chuck end carriage nearest to blade approx in line with blade, place carriage nearest to chuck approx 200mm from chuck end stop, lock all carriages together, and make sure **common carriage lock** is released.
  - 2.3 load roll(**oriented with roll flap down at knife**

**side**) gently onto carrier with chuck end approx 100mm from chuck, tape flap tightly to roll in cutting area to prevent uncontrolled movement, and entrance of knife, tape at all carriages

- 2.4 move chuck to “correct” height. “correct” height is bias towards lower setting.
- 2.5 move roll into chuck just covering chuck teeth, then tighten chuck, then tighten **common carriage lock**
- 2.6 using laser place roll in position for cutting, then clamp main track
- 2.7 check to see knife guides will clear both carriages, and bottom of roll

### 3 **ROLL CUTTING**

ensure **danger area** is clear, and **remains clear** during cutting operation and operator is in operating position near control cabinet.

- 3.1 using pendant control, move roll in making sure knife guides are clearing carriages, and bottom of roll, if not turn off knife and reset
- 3.2 once set turn on roll axis, move to operator position ensure **danger area** is clear, using pendant control, start knife, rotate feed knob to “2”, and using roll feed control flip switch to right (in) and start cutting into roll, once knife is fully in feed can be increased. If knife buckles reduce feed.
- 3.3 Cutting is completed when roll is cut in two, if there is a difference in height between “cut off roll” and “chuck roll” it should be corrected at this stage, by either adjusting carriage roller height using knobs provided, or adjusting center location brass bush.
- 3.4 using pendant control, flip feed switch to left thro stop then turn feed control to max”10” this will return frame to unload/load position. Then using pendant control hit red button. This will switch off all axis

### 4 **ROLL REMOVAL**

ensure machine is turned off, release chuck by rotating knob in anticlockwise direction, pushing knob in to release jaws, then remove rolls carefully.