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1. Safety precautions

Definition of warning symbols:

	WARNING	Any improper operation may result in hazard to life or damage of equipment.
	CAUTION	Any improper operation may result in hazard to life or damage of other objects.

Definition of sign symbols:

	This symbol is designed to make the operator highly attentive. The symbols in the triangles specify when to be attentive. The symbol in the left warns you of electric shock.
	This symbol specifies the activities to be forbidden. The symbol in the circle specifies the acts to be forbidden. The symbol in the left tells you no detachment.



WARNING



Do not use a power source which does not meet voltage rating. Otherwise, fire or electric shock may result.



If the machine gives off smoke or unpleasant smell, or if it makes excessive noise, do not use it. In such cases, continuing using it may result in fire or electric shock.



To avoid damage to the machine, do not pull out the plug while the power is on.



Make sure the machine is grounded. Otherwise, electric shock or mechanic default may result.



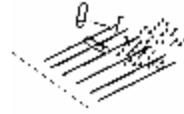
Do not detach, repair, or reconstruct the machine. Otherwise, fire, electric shock, or hazard to life may result.



CAUTION



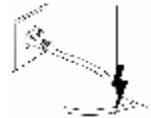
Do not leak any liquid or drop metal into the machine. Such things may result in fire.



To prevent injury and perspiration of knife head, do not touch the knife tip with your finger.



Do not damage or randomly replace the supplied power cable. Do not excessively bend, pull, or bundle the power cable or place weight on it, otherwise the power source may be damaged. Fire or electric shock can also be incurred.



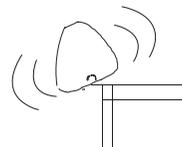
If you are not going to use the machine for a long time, unplug the power cable from the receptacle. Otherwise, fire may result.



To avoid injury when operating the machine, do not place either of your hands on capstan.



Place the machine on a stable surface. Otherwise, the machine may fall and be damaged.



To unplug the power cable from receptacle, hold the plug instead of the cable. Strong pulling of the cable may result in electric shock or fire.

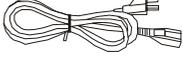
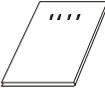
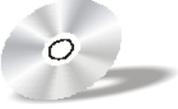


Do not operate in case of storm or lightning. Otherwise, damage to the machine may occur.



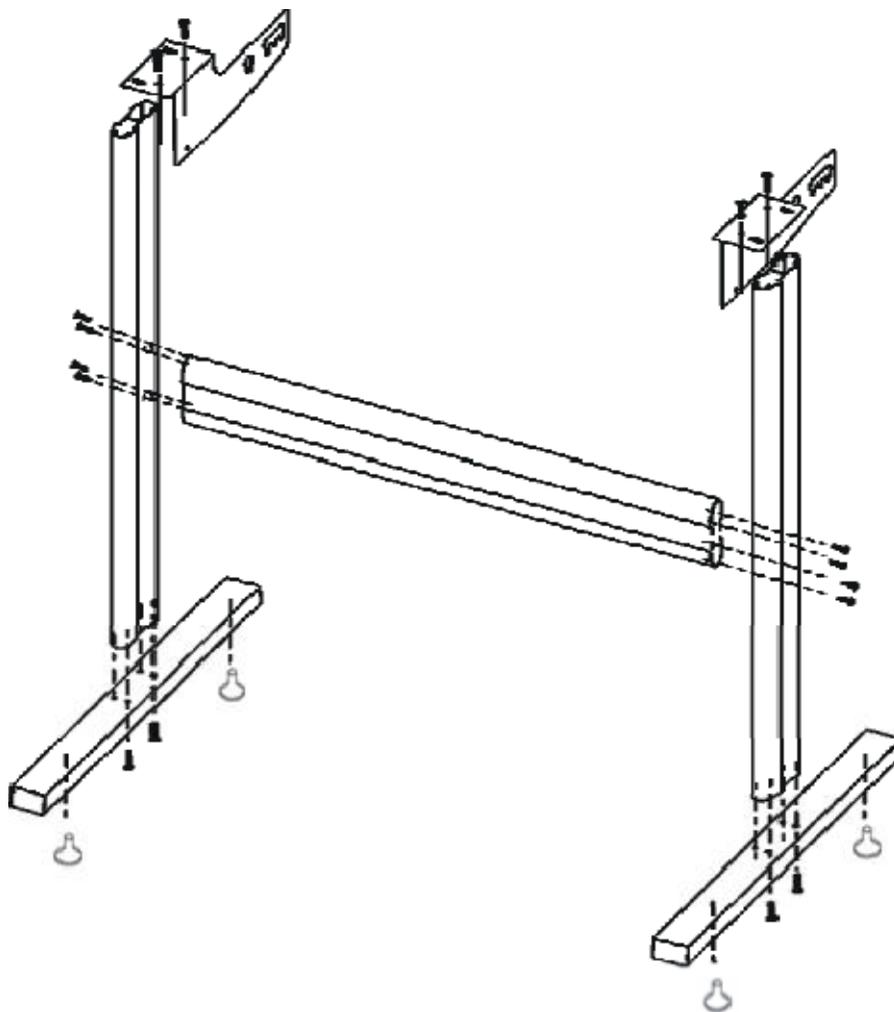
2. Standard accessories

Check following accessories after unpacking, please contact the seller or our company if you find anything missing.

Serial No	Item	Quantity	Icon
1	Power cord	1	
2	USB Cable	1	
3	Blade holder	1	
4	Blade	3	
5	Pen holder	1	
6	Manual	1	
7	FlexiStarter 8.5 software	1	
8	USB Driver	1	
9	Floor Stand	1	

10 Vertical Floor Stand and Installation Sketch Map

(Available for machine with minimum width of 900mm only)



Take parts of the floor stand out of box, and assemble as diagram shows.

After assembly, place your ProCut CR 630/1200 on the support with screw hole targeted, then fasten it with screw.

3. Basic operation

3.1 Installation and connections



WARNING



Make sure the machine is grounded, otherwise electric shock or mechanic default is possible.



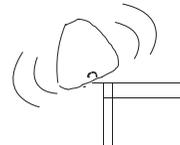
Do not use a power source not meeting voltage rating. Using the wrong power source may result in fire or electric shock.



Do not pull out the plug when the power is on to avoid damage to the machine.

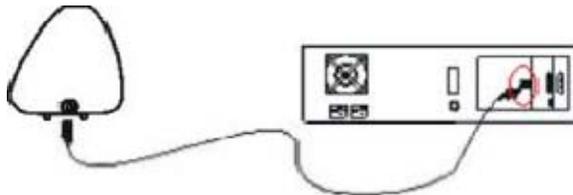


Place the machine on a stable surface. Otherwise, the machine may fall and be damaged.



3.1.1 As with other electrical equipment, keep cutter in a cool, dry environment.

3.1.2 Connect USB cable to USB port of the computer host.



3.1.3 Check voltage of the power source and whether it is grounded, do not connect to power until all are in a good condition.



3.2 Install cutting tool



CAUTION

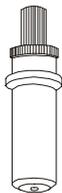


Do not touch the knife tip with your finger to prevent injury .

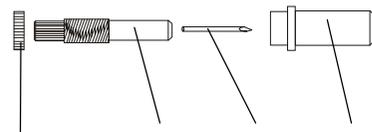


3.2.1 Fit blade into rotary tool, the knife and tool are as shown in following diagrams:

(Front View)

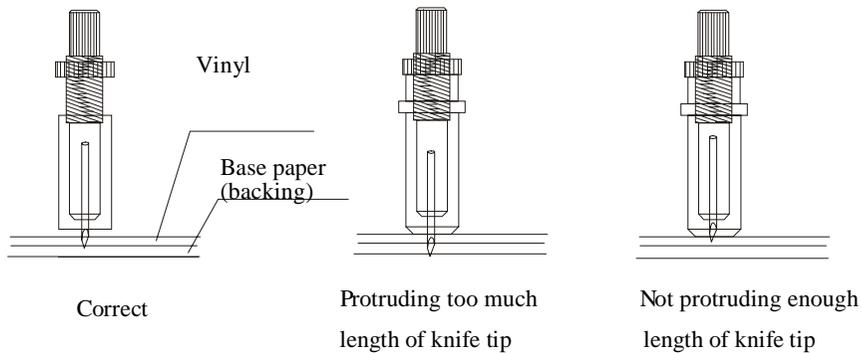


(Disassembly View)



Knife-adjusting Screw Knife Handle Knife Knife Sheath

3.2.2 Adjust the protruding length of the knife top as required for specific cutting media.



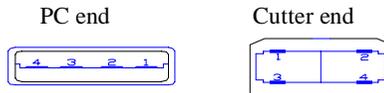
- 3.2.3 (1) Loosen the screw of knife carrier.
 (2) Assemble the tool with knife into the tool carrier.
 (3) When the tool is in appropriate position screw it and fix the screw.



3.3. USB Interface Setup

1. Place the included CD-ROM in the CD-ROM driver, connecting

USB cable to cutter and pc



Windows will open the Hardware Wizard screen

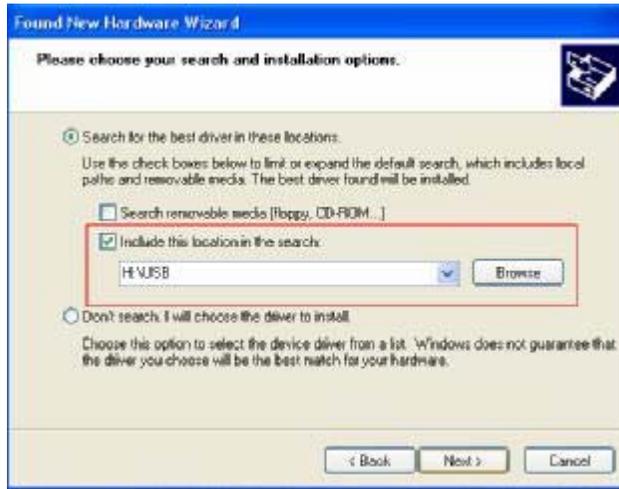


Select No, not this time , click Next >

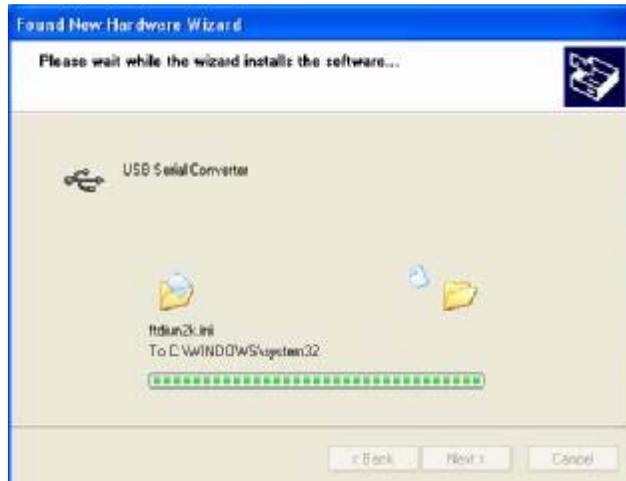


Select “Install from a list or specific location[Advanced]”

click



Select , locate CD-ROM driver, select



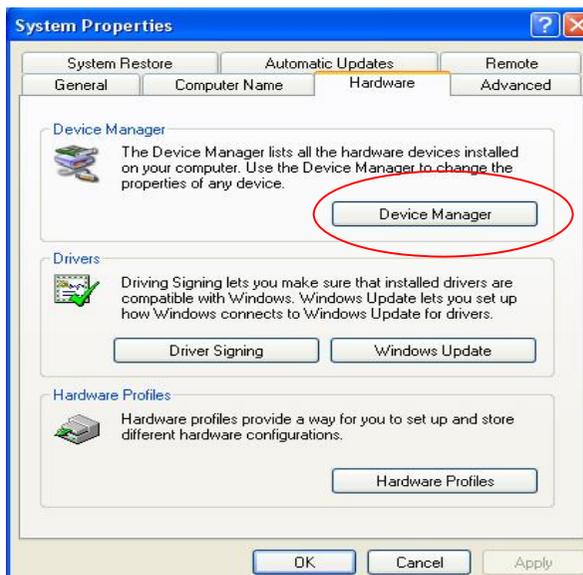
click



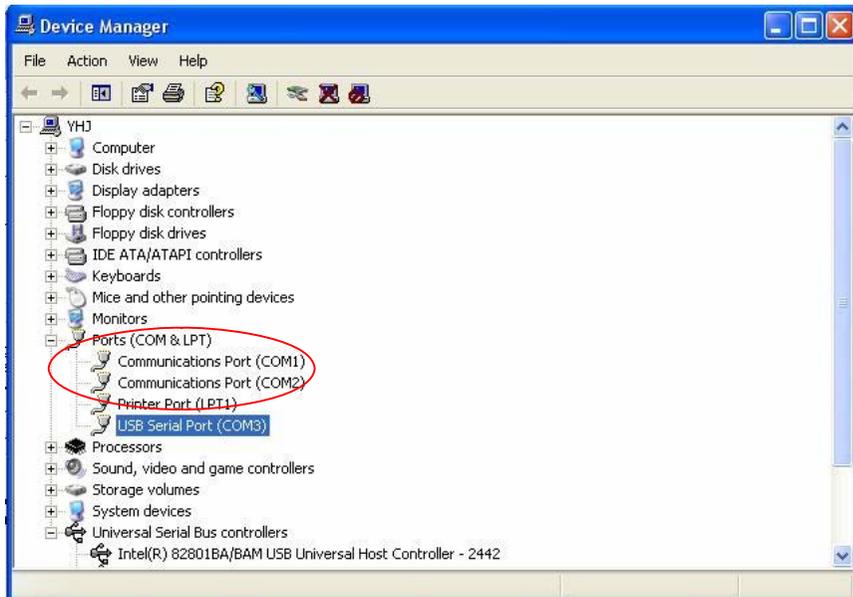
When installation finishes, the screen shown appears, click [Finish] to complete installation.

Default USB port is COM 3. Some old versions of sign software do not support USB. Some only support COM 1 and COM 2 , solution is as follows:

Log “System Properties,” select ”Device Manager,”



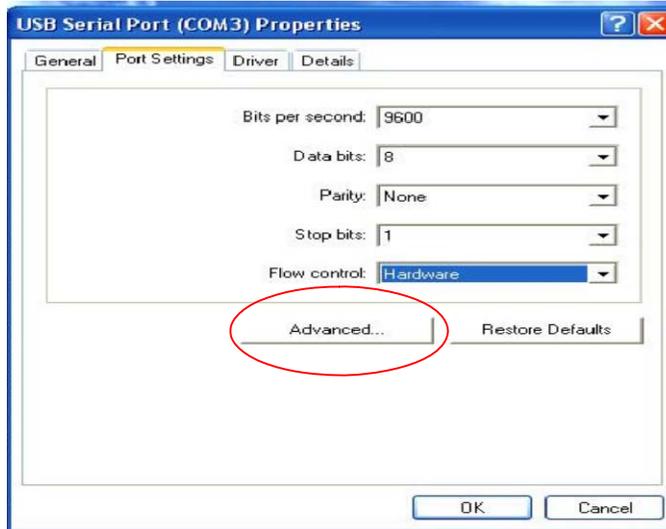
Select COM 1 or COM 2, click the right mouse button



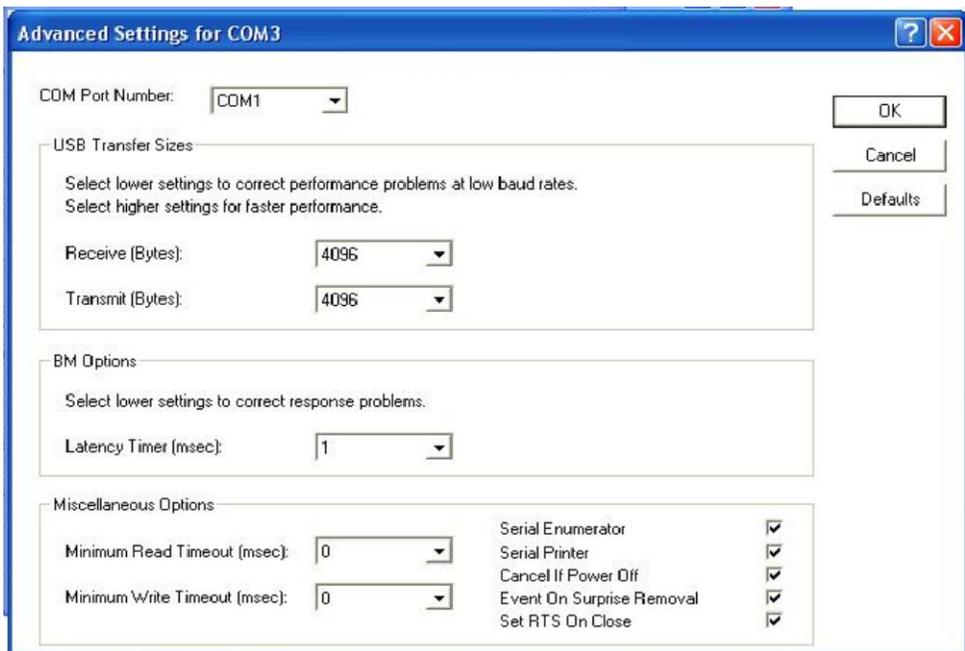
Click “disable”



Select USB “serial port(COM3)”,click right mouse button.



Log “advanced”,



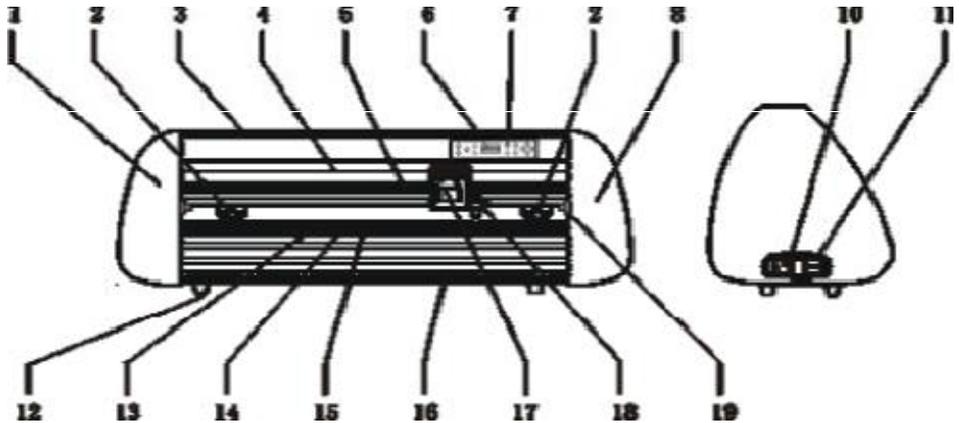
Set com port Number=COM:1 or COM:2

Done

4. Cutting plotter CR operating instructions

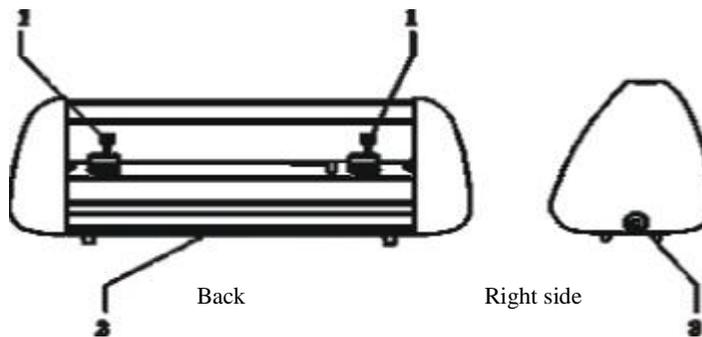
4.1 Name and function of parts

4.1.1 Front view



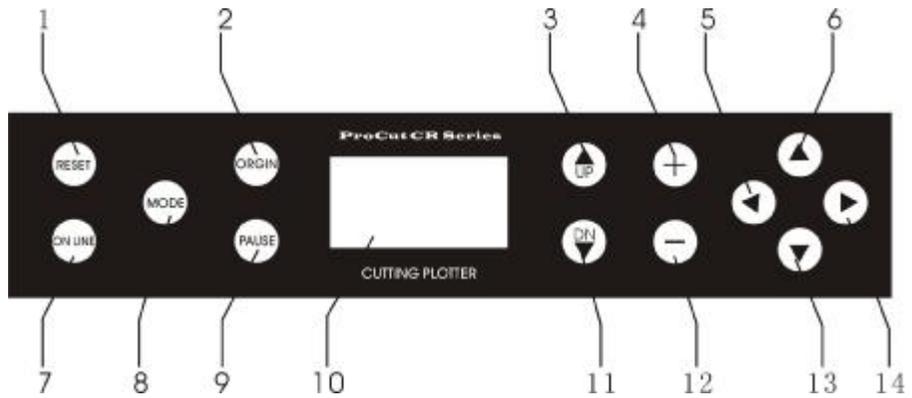
- | | |
|------------------------------------|--------------------------|
| 1. Left cabinet | 11. Power on/off |
| 2. Paperweight wheel | 12. Foot cushion |
| 3. Upper cover | 13. Y Transmission Shaft |
| 4. Beam | 14. Scale |
| 5. Tooth profile transmission belt | 15. Strip cushion |
| 6. LCD (Liquid Crystal Display) | 16. Trimming groove |
| 7. Control keyboard | 17. Slider |
| 8. Right cabinet | 18. Knife clip |
| 10. Receptacle of power source | 19. Reset |

4.1.2 Back view



- | | |
|--------------------------------|--------|
| 1. Handle of paperweight wheel | 3. USB |
| 2. Back | |

4.1.3 Control panel



- | | |
|----------------------------|--------------------------------------|
| 1. Host reset | 8. Systemic parameter setting button |
| 2. Origin setting button | 9. Pause |
| 3. Knife-raising button | 10. LCD Display Paper-feeding button |
| 4. Value + | 11. Knife-dropping button |
| 5. Leftward button | 12. Value - |
| 6. Paper-withdrawal button | 13. Paper-feeding button |
| 7. Online/offline button | 14. Rightward button |

4.2 Basic Operation



CAUTION



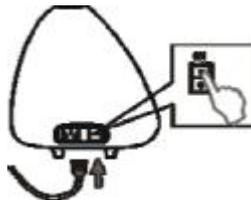
When switching on the power, make sure your hands and other articles are out of reach of such running parts as main shaft and slider to prevent injury.



4.2.1 Turn on machine

4.2.1.1 Check whether the power is in OFF position.

4.2.1.2 Plug the cable into the receptacle of the host power source, press the power on/off on the left.



4.2.1.3 LCD in the control panel is ON and displays the initializing process of the cutter and shows following information:

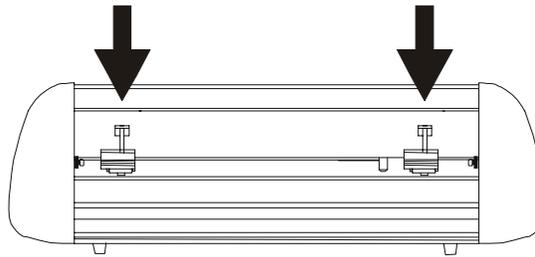


4.2.1.4 When the initializing is over, the machine is in online state and connectable with the computer to be operable.

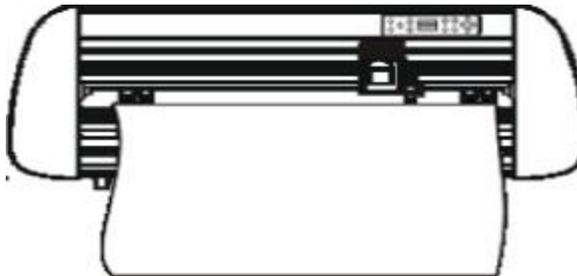
4.2.2 Installation of cutting media

This machine is suitable for single-sheet media as well as a roll of media.

- 4.2.2.1 Press down the handle of paperweight wheel behind the machine to raise the paperweight wheel.



- 4.2.2.2 Insert the media into the space between paperweight wheel and main shaft, and pull out the media to appropriate length from the front of the cutter.

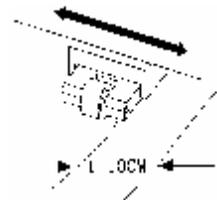


Using roll of media
Pulling it out to required length

Using single sheet of media
Cutting required length from paper roll



- 4.2.2.3 Adjust horizontal position of paperweight wheel according to width of paper. a distance of minimum 1-10CM is set between paperweight wheel and paper edge to ensure good running of paper.



- 4.2.2.4 Raise the two handles of paperweight wheels, to lower the wheels to press paper.

4.2.3 Trial run (adjust knife press and tool)



CAUTION

To prevent injury, do not touch the knife tip with your finger.



The quality of knife used directly relates to the cutting precision and life of your machine. For best results, use good quality knives recommended for your cutter.

4.2.3.1 Press the ON LINE button to make the machine in off-line state.



4.2.3.2 While in “off-line” state, press “ ” twice, the machine will automatically cut a small square from the media.



4.2.3.3 Take off the square, if you fail, the square need to be further cut, because the press is low or the protruding length of knife top is too short; If the base paper is pierced through, it signifies that the protruding length of knife top is too long and the press is too big. Adjust the protruding length of knife top and knife press according to result of trial run and the description of tool installation.

4.2.3.4 Press “ + ” or “ - ” to adjust knife press, for common materials the knife press value ranges from 100 to120.

4.3 Operating instructions

4.3.1 On-line / off-line

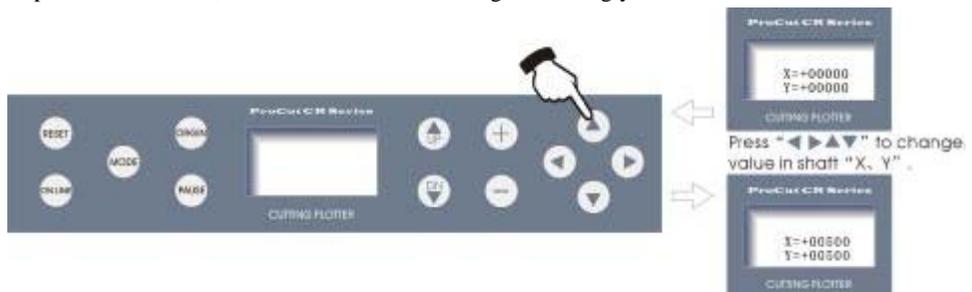
When the cutter starts reset, it becomes in online state. Press ON LINE to switch between online and off-line state. When computer transmits information to the cutting plotter, the cutting plotter must be in online state. However, when setting parameters for the machine or operating it by hand, you should set it in off-line state. The LCD will display the following information.



4.3.2 Moving knife top

While in off-line state, press “←→” buttons to move the slider leftward or rightward.

When pressing “▲▼” buttons the main shaft will rotate forward or backward, and the step value of “ X, Y ” in the LCD will change accordingly.



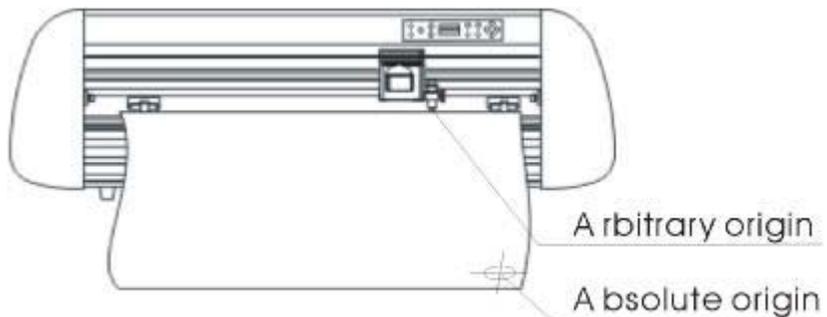
4.3.3 Setting origin of plotting

When move the knife top to the starting position, press the origin setting button “ORGIN”, the values of “X, Y” will be set as 0 , the setting of new origin is completed. The machine will start plotting from the new origin. To save the present origin please refer to chapter “ saving and using relative origin”.

Setting arbitrary origin



Relational map between absolute origin and arbitrary relative origin.



4.3.4 Raising knife, dropping knife

While in off-line state, press DN button, the knife will drop, then press UP button to raise the knife.

Press "DN" to drop the knife

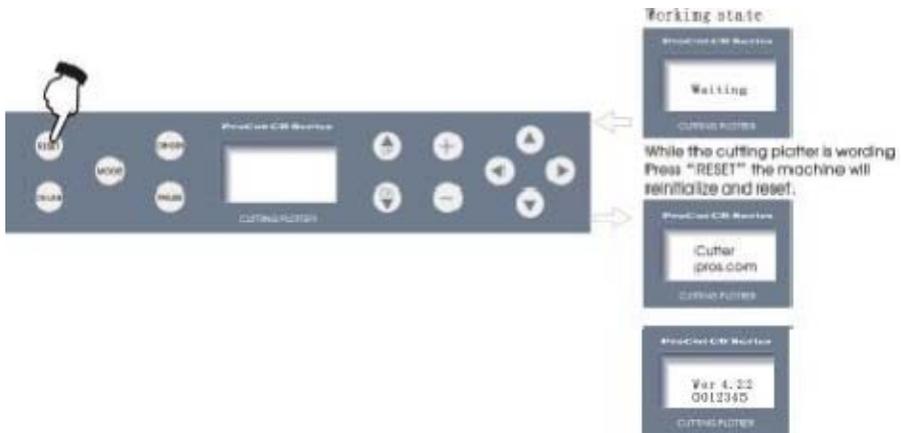


Press "UP" to raise the knife



4.3.5 RESET

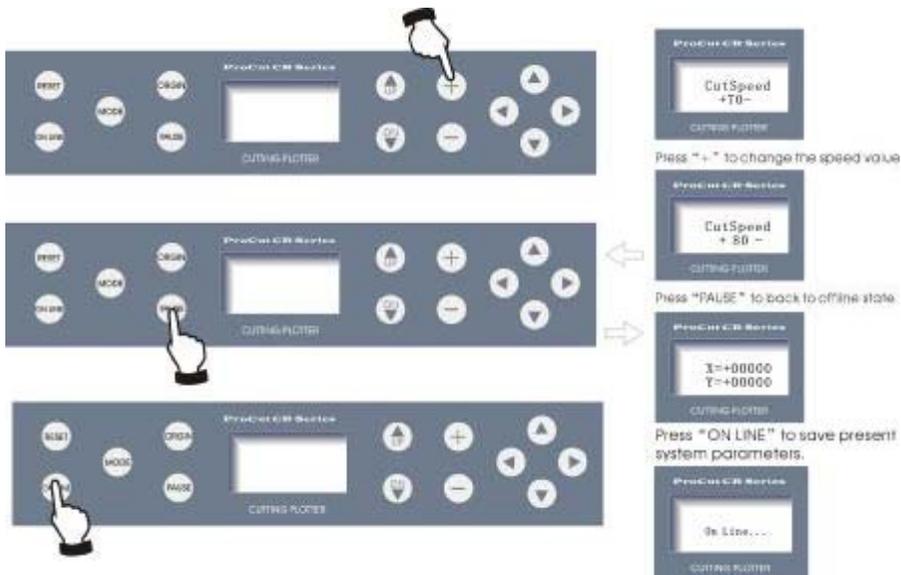
Press RESET button, the machine will reinitialize, the present position of knife top will be set as new starting origin, all data in buffer memory will be cleared.



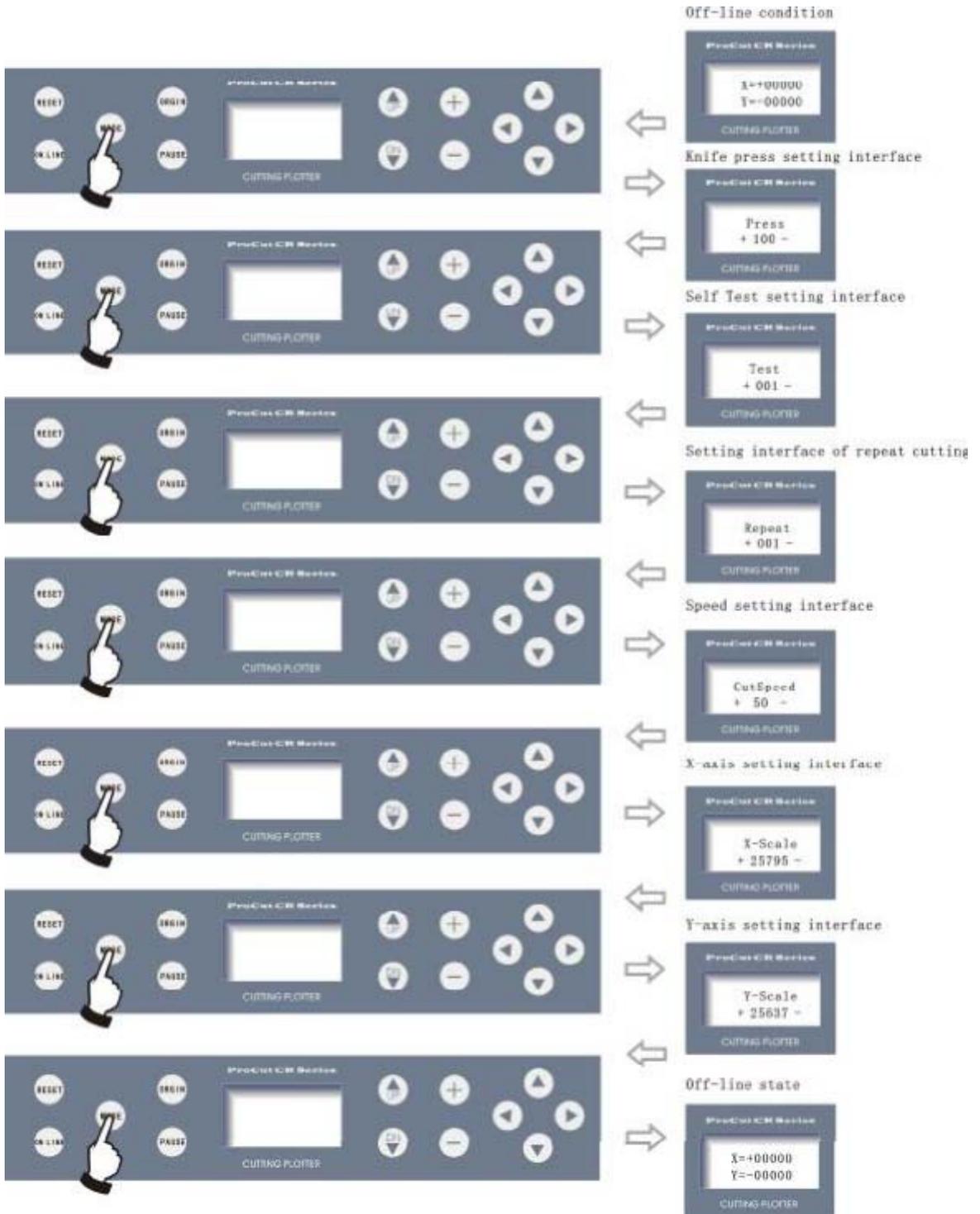
4.3.6 System setting and storage

While in off-line state, press "MODE" button to set system parameters, the LCD will display the options of system parameters. Press "MODE" button to show the options in turn, press "+" or "-" to change the parameter value of selected option. When the setting is completed, press "PAUSE" to escape setting mode, press "ON LINE" and save the setting value.

For example, in speed setting state:



Flow chart of system setting

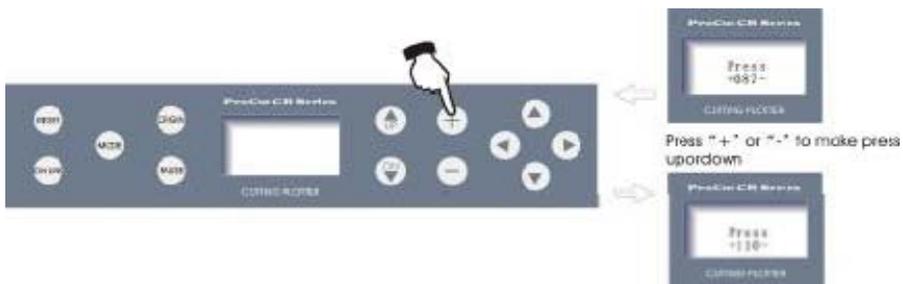


Press “+” and “-” to change the parameters of system. When the machine is switched on the next time, it will automatically default to the last parameters set.

4.3.7 Diagrammatic demonstration of setting parameters for different states

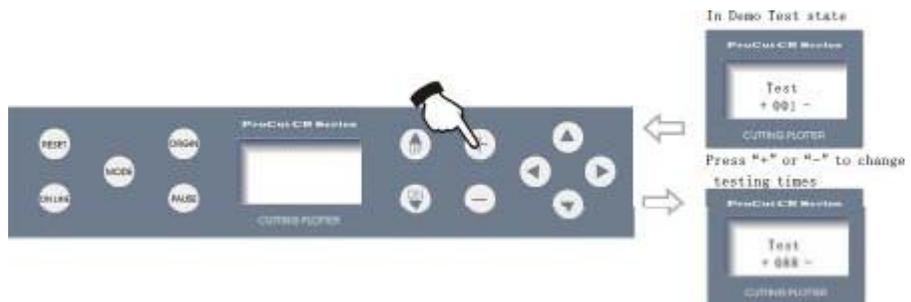
4.3.7.1 Setting knife pressure

In off-line state, the value of “Press” signifies knife pressure. Press “+” to increase it, press “-” to lower it. The setting values range is 0~255. The knife pressure can range within 0~800g. When the machine is running, if the knife pressure is found unsuitable, press the “PAUSE” button, then press “+” or “-” to increase or decrease pressure.



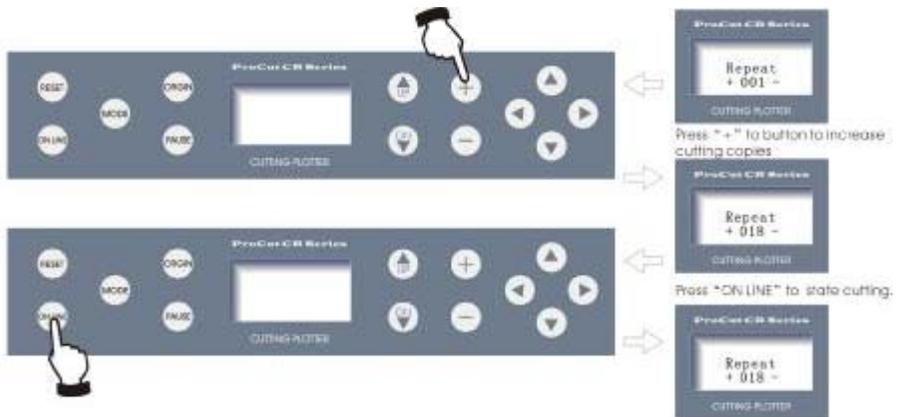
4.3.7.2 Setting Self-Test interface

In “Test” state, press “+” to increase testing times or press “-” to decrease testing times. The range of testing times is 0 ~ 255. Press the ON LINE button to start plotting the Demo Test graph. To repeat the testing, replace the knife with plot pen, with which you can test repeating precision of the machine. If the Self-Test meets requirement, it indicates that parts of the machine are in good condition.



6.3.7.3 Repeat cutting

When the data computer transmits can be totally stored into memory of the machine, this function can be used to plot more than one copy. In “Repeat” state, press “+/-” to adjust total copies to be duplicated, press “ON LINE” to start plotting. A maximum of 255 copies can be duplicated at one time (this function is limited to memory, the capacity of the document shall be lower than 1024kb).



4.3.7.4 Cutting speed

In the speed setting mode, press “+” or “-” to adjust cutting speed, high speed is suitable for cutting big characters or images, while low speed is suitable for exquisite small characters or images. 10-cutting speeds are available for your choice:

10 → 20 → 30 → 40 → 50 → 60 → 70 → 80

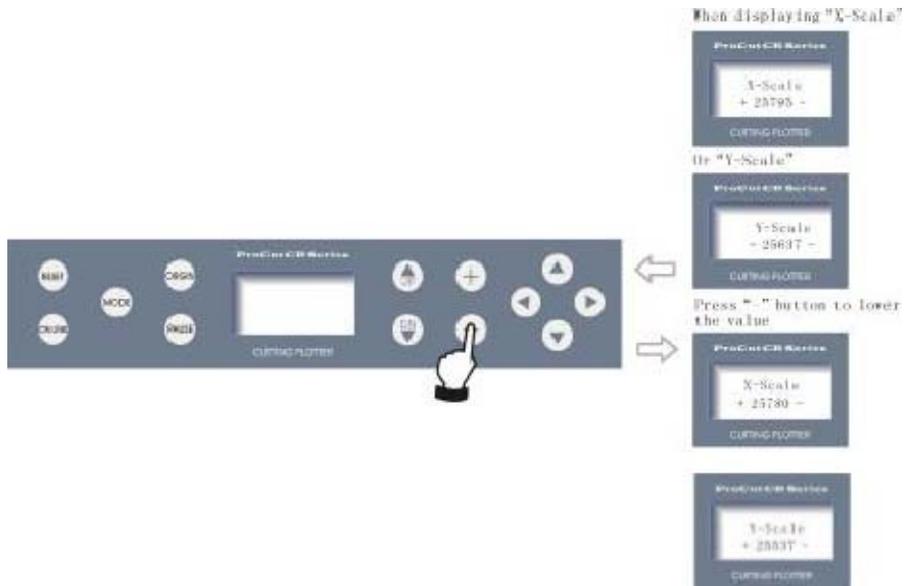


- When cutting at high speed, curves may zigzag. But lowering the speed will eliminate the problem.

4.3.7.5 Interface for setting X-axis, Y-axis

To minimize the error in mechanic size, set ratio of “X, Y” to be adjustable, and make composing size conformed to plotting size.

When real size of shaft “X” or “Y” exceeds composing size.



Conversely, in “X-axis” or “Y-axis” state press “+” to increase the value.

Notes: when using this function, meticulous adjustment to specific speed and media is desirable.

4.3.7.6 Readjusting default parameters

When you need to reset the speed and parameters, follow the following procedure:

Press “MODE” button to “CUT SPEED ” state.



4.4 Drag knife off- setting:

Close compensation or off set value is 0.25-0.35mm, according to the knife

Figure below:

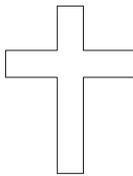


No off set

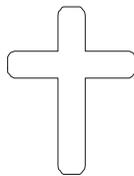


with off- set

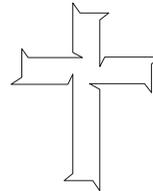
Angle sharp compensation or offset value is 0.25-0.35mm according to the knife



Correct



no enough



over

4.5 Technical features

Type	CR630	CR900	CR1080	CR1200
Bracket and paper feeding mode	Stand			
Main board	32-bit ARM7 CPU , 1 Mb , High-speed CACHE memory			
Control panel	Over-head,2*8 character LCD,13-key light-touch film keyboard			
Driver	PWM ,micro-step driver			
Maximum paper feed width	730mm	1000mm	1100mm	1300mm
Maximum cutting width	635mm	905mm	1005mm	1205mm
Maximum cutting speed	400mm/s			
Maximum cutting length	20000mm			
Maximum cutting thickness	1mm			
Knife pressure	0-800g(digital adjustment) Shows up to 255 on LCD based on Grade. See scale to get conversion. Example: 255 on LCD = 800 Grams down force			
Mechanism precision	0.05mm			
Repeatable precision	<+/-0.1mm			
Type of tool	Carbide blade			
Type of plot pen	All types Diameter 11.4mm plotter pen			
Plotting instruction	Compatible DM/PL, HP/GL			
Interface	USB1.0			
Power source	AC110/220v±10% 50Hz			
Power consumption	<100VA		<120VA	
Operating environment	Temperature:+5 ° -+45 ° , humidity 30%-70%			
External size	1045×375×380mm	1292×375×451mm	1472×375×451mm	1593×375×451mm
Transporting weight	25kg	36kg	41kg	45kg

5. Troubleshooting

5.1 Question: Will the characters below 1CM be deformed?

Answer: when cutting small characters, please set offset in the software, for example, in

“Wen Tai” sign software:

- (1). Click “plotting output” once, a plotting output picture will pop up.
- (2). Click “set” once, a picture of setting plotter will pop up.
- (3). Click “compensation setting,” a dialog box will pop up.
- (4). Select “sharp-angle compensation,” adjust the value to required level.

The compensation ranges within 0.1-0.7. Usually it is set it to 0.25. In addition, the plotting speed of the cutter should be set below 20.

5.2 Question: Why there is an additional stroke after finishing cutting?

Answer: 1. Check if the tip of cutter is flexible when it is up and down.

2. Change the Master software if there are some deviant letters.

3. Check if there are any problems in the files you are ready to output.

5.3 Question: why does a zigzag happen to the image being cut?

Answer: The PROCUT motor features high power and speed. The cutting speed needs to be adjusted according to the size of the character. Generally, to cut small glossy characters with a high precision requirement, the speed shall not exceed 40. In most cases, the speed at the shift 50-60 is favorable. To cut large quantities of bigger characters within shortest time, the speed can be 70, 180. But since the step distance of motor is so long, evident zigzags occur. Therefore, you should set the speed to specific sizes of characters, and the relationship between speed and size of characters please refer to following table:

Size of font (mm)	SPEED (mm)
<10	10-20
10-30	30
30-50	40-50
50-500	60
>500	70-80

5.4 Question: Why does the paper (vinyl) deviate when it runs by a large margin?

Answer: the paper feed bracket containing paper roll should be completely parallel to paperweight wheel. For big roll of materials, loosen it prior to cutting to prevent excessive obstruction when plotting or cutting. For the machines with four paperweight wheels, when plotting large images or characters back and forth, use two paperweight wheels at the sides instead of the four simultaneously. Unequal abrasion of the two wheels

also may result in deviation of the paper; in worse case replacing wheels is needed.

5.5 Question: Why does lock-up happen in plotting output?

Answer: (1). Exterior 220 V input voltage is too low (150V), the plotter will restart thus lock-up happens.

(2). When disturbance of exterior 220 V input voltage is too high, lock-up may happen. To resolve this you can use purified regulated power source.

5.6 Question: Why does the machine tingle when it is touched?

Answer: the machine might be improperly grounded, make sure central line of the power source grounded.

5.7 Question: Why does the job rough, with sharp-angle raised when plotting?

Answer: (1). The protruding length of knife tip is too long, please adjust it as required. (2). The knife needs to be replaced.

5.8 Question: Why does the plotter first scratch a line before plotting?

Answer: A job was exited illegally, and cutting instructions are still existing in the memory of plotter. To resolve the problem, turn off the machine and turn it on again.

5.9 Question: No LCD display, or a black row of blocks are displayed?

Answer: (1). In case of no display, check whether the power is working.

(2). If black blocks are displayed, check if voltage is at required level. If troubles remain after the above operation, please contact maintenance center.

5.10 Question: Why can't some characters close in strokes when it is plotting?

Answer: Because the knife of the plotter is eccentric knife with a eccentric value, to resolve it, set "closing compensation" in the software. For example: in "Wen Tai" software:

(1). Click "plotting output" once, a plotting output picture will pop up.

(2). Click "set" once, a picture of setting plotter will pop up.

(3). Click "compensation setting" a dialog box will pop up.

(4). Select closing compensation, adjust the value to required level, generally the value is set to be 0.5.

5.11 Question: Why is the machine missing some part of letter when cutting?

Answer: (1). Check the machine if it has enough pressure.

(2). Reinstall the software.

(3). Check the head of the knife.

(4). If the problem still exists, please contact with repair center.

5.12 Question: Why is the machine in low-speed state after start-up?

Answer: Because paper sensor fails to detect the fore end of paper. When feeding paper make fore end of paper cover hole of paper sensor, then perform another automatic paper testing.

5.13 Question: Why do some nicks deep, while some shallow when cutting?

Answer: PROCUT uses a durable, soft PVC material as knife strip cushion to protect the knife. But long periods of use may produce a trace, therefore roughing the stripe cushion. This can cause some nicks become deep, while are shallow. To resolve this replace the strip cushion. Or, if problem is not severe, adjust knife as described in section 3.2.B, increasing knife pressure (some 120 -150)。

5.14 Question: Why can't the plotter run when it is outputting?

Answer: (1). Check whether the plotter is properly connected with computer. If PROCUT is connected with COM1 or COM2 of your computer, check whether the set ports are conformed to those connected。

(2). Check whether the plotter is in online state, namely whether the LCD displays “ON LINE”。

(3). Check whether the encryption card of software is properly. If not please turn off the power and reinstall it. Check driving program of the plotter is for PROCUT series。

5.15 Question: Why can't the instant glue be taken off?

Answer: (1). Perform a trial run prior output, adjust press to appropriate level.

(2). Check whether the knife is worn, or whether the knife tip is broken. For new knives, the nick is thin in the vinyl, while for old ones the nick is thick and impressive. To resolve the problem, replace the knife。

5.16 Question: What is important when cutting big characters?

Answer: (1). When cutting big characters, the system automatically knows how to setup the page. You can cut a big character in several pages, but it is notable that the setting of output width should be conformed to the width of the vinyl. In addition, when cutting big characters you should widen pages or set seaming distance

(2). When cutting large and long characters, check the alignment of the vinyl and the cutting head。

5.17 Question: How do we maintain the plotter?

Answer: PROCUT series plotter all use quality oil from Japan. No further oil is needed even after extended period of time. After operation everyday, dust the machine with soft brush. The glue remaining in engine base can be cleaned with alcohol. If frequently operated in dusty environment, after two years have maintenance technicians clean the dust in machine. If plotting precision degrades, the maintenance of running parts is desirable (repairing and replacing the worn parts).

5.18 Question: Why is the plotter sometimes out of control?

Answer: During transportation or use, the signal line is might be improperly connected. Open the machine and properly plug all lines. If the problem still persists, please contact maintenance center.

5.19 Question: Why does the plotter stop?

Answer: Because it encounters vibration for an extended time, or it has been used for a long period, or it is affected by temperature, causing so dielectric displacement to happen to the servo driving board, resulting in a stop. Please contact local agent or customer maintenance center.

If you need help, visit our TECHNICAL FORUM at www.CutterPros.com we have help documents in that area that can help you get your cutter to communicate with your computer in less than 5 minutes in many cases. They are downloadable and/or viewable online!

Need Vinyl?

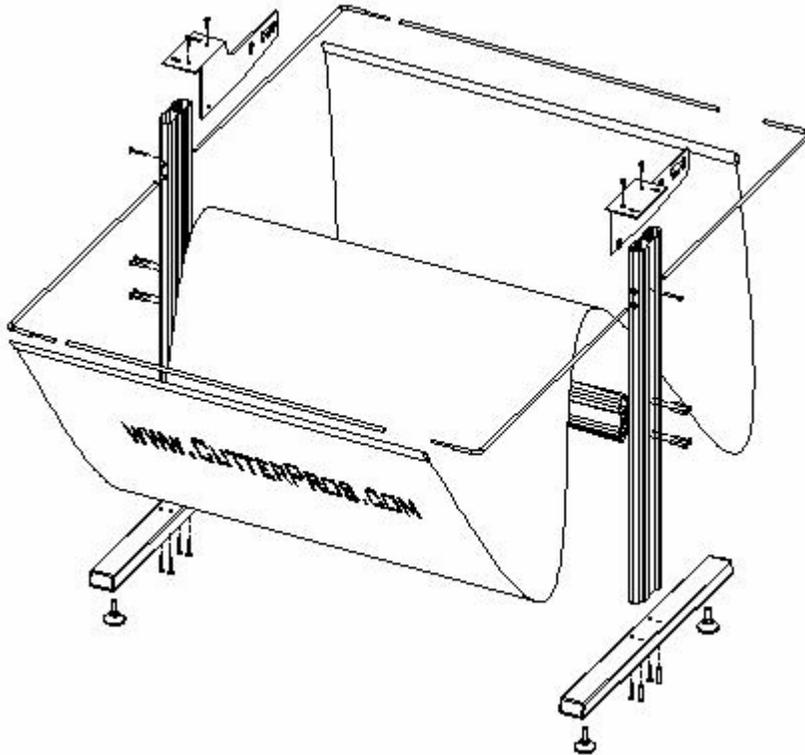
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- 1, Vertical Floor Stand and Installation Sketch Map (if yours is equipped with a optional basket you will also install it as follows below)



Assemble the stand according to the illustration. When stand is assembled, place the cutter on the stand, aligning screw holes, locking with the screws. Insert the struts of basket into the corresponding holes of stand, through cloth, then adjust the length of the basket to the correct size.

DOWN FORCE:

There are different levels of down force which will be displayed on the LCD. When display at 255 on the LCD, it is equal to the greatest down force of 800grams.

Details as following:

255.....	800g
245.....	785g
235.....	775g
225.....	765g
215.....	750g
205.....	735g
195.....	720g
185.....	700g
175.....	685g
165.....	665g
155.....	650g
145.....	635g
135.....	620g
125.....	600g
115.....	550g
105.....	500g
95.....	430g
85.....	370g
75.....	300g
65.....	X
56.....	X
47.....	X
38.....	X
29.....	X
20.....	X

Note: "X" means that the down force is not high enough.

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