

# CUTTER

## INDUSTRIES

### Pneumatic Auto Cutter IV User Guide



#### For Wire and Hard Tubing

Wire 10 to 18 AWG

Tubing to 1/2" OD (Heat Shrink to 3/8" OD)

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# CUTTER

## INDUSTRIES

### User Guide for the Pneumatic Auto Cutter IV

**FAILURE TO USE CLEAN DRY AIR WILL VOID WARRANTY**

#### SET UP

##### Secure the Cutter to the Bench

Insert two 1/4"-20 set screws into the bottom of the base plate (front & back center) for permanent or semi-permanent attachment to the workbench.

**NOTE:** When the automatic cutter is plugged into a 120v power source, it is always on. If left plugged into a 120v power source, the machine goes into Sleep Mode after 30 minutes of inactivity and the LED will go out. To resume, press any key. The memory will be retained.

##### Calibrate Cut Length

Some materials or sizes may cut longer or shorter than the programmed length due to their different compression between the feed rollers. The variance will always repeat within 1%.

- Run a test piece (programmed to desired length) to determine length variance.
- Reprogram for longer or shorter length compensating for the length variance.

The default length mode always comes on in U.S. Mode (inches).

The default decimal point always comes on the 00.0 position.

##### Load (Insert) Material

For material over 0.2" diameter, remove the inlet feed guide. (Use needle nose pliers)

- Press down on the tension arm located on the rear left side of the machine.
- Insert material through the inlet hole just forward from the tension arm.

ALWAYS insert material until it is visible at the exit side of the machine.

#### OPERATION

##### Program a Batch Run

1. Set Length Mode (English/Metric)
  - To change to metric (cm), press the English/Metric switch through the small hole in the lower left of the face plate. This is best done with a paper clip, pencil, etc.
  - In English (U.S.) mode, length advances in 0.2 inch increments.
  - In Metric mode, red light appears, length advances by 0.5 cm.
2. Set the Decimal Point
  - To shift the decimal point to the right (000.) Hold **Length** & press **Run**
  - To shift the decimal point to the left (00.0.) Hold **Length** & press **Run**
3. Set the Batch Quantity
  - Press the buttons marked **Set Right**, **Set Center**, or **Set Left** to set desired quantity.
  - Each time you press one of these buttons, the display advances from 0 through 9.
4. Set the Batch Length
  - Hold the **Length** button while pressing the **Set Right**, **Set Center**, or **Set Left** buttons.
  - Each time you press one of these buttons, the display advances from 0 through 9.

##### Start a Batch Run

- Press **Run**.  
(The display will show the remaining quantity to cut.)

##### Pause a Batch Run

- Press **Run**. The batch run will pause.  
(The display will NOT blink.)

##### Resume a Batch Run

- Press **Run** to resume.

##### End of Batch Run

- Operation stops automatically.  
(LED will display "0" blink quickly.)

##### Repeat Batch Run

- Press **Run** to clear the display and reset.
- Press **Run** again to start another batch with the same settings.

## Run New Batch

- Press **Run** to clear the settings & reset.
- Change quantity as needed.
- Change length as needed.
- Press **Run** to start the new batch.

## If Feed is Interrupted or Material is Jammed

- Display will blink slowly.
- Resolve the cause of the interruption.
- Press **Run** to clear the pause.
- Press **Run** to resume.

## INTERNAL ACCESS (after one-year warranty expires)

**ALWAYS DISCONNECT** the machine from the power source before removing panels or covers.

- Remove the side panels by removing the two screws at the base.
- Remove the back panel by removing the two screws at the base and sliding the panel down.
- *Removing the front top cover should not be needed*, but if necessary, remove the two screws at the base and one on top. Move aside carefully to protect electronics and wire harness.
- Replace the front top cover, the back panel and the side panels, keeping the wire harness clear of the motor fan and air cylinder.

## Changing the Knife Blade

- Remove the clip from the link holding the knife blade to the cylinder rod.
- Using a 7/16" Allen wrench, loosen the set screw on the top side of the knife base.
- Using a 1/8" Allen wrench, remove the shoulder screw from the knife base at the top of the knife blade.
- Remove and replace the knife blade, keeping the nylon washers in their original position.
- Tighten the shoulder screw through the new knife blade and knife base into the aluminum upright.
- Reset the knife blade tension. (see instructions below)

## Reset Knife Blade Tension

- Using a 7/16" Allen wrench, loosen set screw on the top side of the knife base.
- Adjust the shoulder screw so the knife freely returns to its neutral position from the vertical position but is a bit slow to do so from the fully actuated position.
- Using a 7/16" Allen wrench, tighten the set screw on the top side of the knife base.

## TROUBLESHOOTING

### Material is not being cut cleanly or completely

- The knife blade may be dull or damaged.
- The shoulder bolt holding the knife blade to the knife base may be too loose.
- Foreign material on or in the cylinder rod may be preventing a full stroke.

### Material is not feeding properly

- Flattened width may not exceed 0.500".
- Feed systems with knurled rollers have 3 lbs. minimum pull (1 lb. for soft tubing).
- Feed systems with rubber rollers (magnetic wire) have approximately 1/2 lb. pull.
- Drive roller knurling may be filled with foreign material.
  - Steel roller knurling may need to be cleaned with a fine steel brush.
  - Rubber rollers may need to be roughed with 36 grit sand paper.
- Knife blade may not be returning far enough and is blocking the exiting material.
  - Knife blade is held too tight to the knife base by the shoulder bolt.
  - Knife blade pivot points may need lubrication (CRC #05359 or equivalent).
  - The cylinder may be weakened or loose from the base.
- Motor doesn't turn or feed.
  - Fan interference has stopped the motor.
  - Material is jammed around the drive roller.
- Tension arm roller may not be holding material against motor drive roller.
- Tension arm roller may not be turning freely on its shoulder bolt shaft.
- Tension arm spring may be too weak to hold processing material.
- End of spool material may have been left between drive roller and knife blade.
- The inlet feed guide must be in place when cutting material less than 1/4" diameter.



## One-Year Warranty

Cutter Industries warrants the Automatic Cutter to be free of defects in materials or workmanship for one year from the date of purchase. During this warranty period, the unit will be repaired or replaced, at Cutter Industries option, after the unit has been returned to Cutter Industries for examination. All freight costs for return of items are to be paid by the customer. Cutter Industries shall not be liable for the air control valve, knife blade, rubber feed rollers, physical damage or for direct or indirect damage or personal injury which may result from improper use and any end user alterations.

This warranty shall become null and void if the unit has been repaired by others, has been damaged by the addition or alteration of the unit, has been used with components or accessories other than those supplied by Cutter Industries, or if the unit has been misused or damaged in any way. Damage that is deemed to be caused by the owner can be repaired at the owner's expense. All other warranties, expressed or implied, of merchantability and all other warranties which extend beyond the description of the unit on the face hereof shall terminate upon any change of ownership. Cutter Industries shall not be liable for any consequential damages except to the extent required by law.

## Service

If your Automatic Cutter needs service, it must be shipped to Cutter Industries at the address below. If your unit is less than five (5) years old, service charges start at \$125. If your unit is more than five (5) years old, service charges start at \$225. Estimates of repair costs will be provided upon request. Customer is responsible for all shipping costs. For owners doing their own service, please call us for standard replacement parts. To make payment for service or parts, please call us directly.

## Returns

Please call our office before shipping your cutter to us. Please make sure you enclose an explanation of the problem you are experiencing, your return address, phone number, email address and contact person with the returned machine. If dated proof of purchase cannot be verified, the machine will be processed as a return for service. All packages should be insured by the owner. Cutter Industries is not responsible for any shipping damage. When possible, returns should be made in the original packaging. Customer is responsible for all shipping costs. Please see our website for detailed information and instructions if your automatic cutter needs service.



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