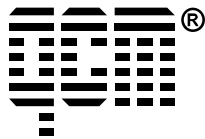


QCM AUTOMATIC CUTTER USER'S MANUAL

FOR **QCM-8800A**



QUALITY COMMERCIAL MACHINES CORPORATION

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INTRODUCTION

Congratulations on your selection of a QCM automatic cutter. We are certain you will be pleased with the purchase of this fine machine. Please read this manual carefully before putting the machine into operation. Keep this manual handy for future reference. It is considered a permanent part of the machine and should remain with the machine if resold.

PRODUCT DESCRIPTION



Figure 1

- Blade assembly cover
- Blade
- IR grating safety sensors
- ① Left control panel
- ② Main body
- ③ Stand
- ④ Adjustable feet

- ⑤ Back gauge
- ⑥ Double rail
- ⑦ Main operating panel
- ⑧ Handle mounting holes
- ⑨ Blade adjustment screw
- ⑩ Power circuit breaker
- ⑪ Right control panel

MAIN FEATURES

- Cast solid steel blade carrier frame.
- Integrated automatic paper clamp and cutting blade drive.
- Dual (standard and metric) digital controlled linear back gauge.
- Digital back gauge position control and display with 0.01" (0.1 mm) resolutions.
- Dual side gauges.
- Light guided cutting line indicator.
- Detachable stand.

SAFETY FEATURES

- Two-hand operation.
- Blade automatic return.
- Clamp automatic return.
- Infrared (IR) grating safety sensors on front table.
- Emergency stop.
- Power breaker switch.

SAFETY PRECAUTIONS

When operating this machine the following safety precautions must be observed.

- This machine is designed for single person operation only. No more than one person is allowed to operate the machine at a time.
- Under no circumstances should children be allowed to operate the machine. Keep the machine out of the reach of children.
- Never place fingers beneath the blade edge inside the cutting area.
- Do not remove or install the blade without hand protection.
- Do not transport or leave the blade unprotected without proper packaging.
- Do not try to cut any metal, wood, or other brittle materials that may cause machine and bodily injury.

INSTALLATION

1. Open the shipping container box, release the fasteners beneath the main machine body ②. Installed the four handles into the handle mounting holes ⑧ securely, carefully take out the machine. Put the machine on a steady flat surface. You need four people to lift the machine.
2. Check to make sure that there is no visible signs of damages on the machine.

3. Assemble the machine stand ③. Make sure all the fasteners are tight and secured. Level the adjustable feet ④.
4. Mount the machine on the stand ③.
5. Make sure that there are no debris on the machine.
6. Place the machine in a clean and safe environment with temperature: 55 - 85 F and humidity: 50 - 80%.

OPERATION

1. Connect the power cord to a 110V, 60 Hz, 15 amp dedicated power source, turn on the power circuit breaker ⑩, and turn the E-Stop on the control panel clockwise to switch on the main power. Make sure that the main power indicator on the left control panel ① is on.

NOTE: Press and hold the "IN/CM " key for 3 second to switch the unit between standard and metric as needed.

⑦ Main operating panel

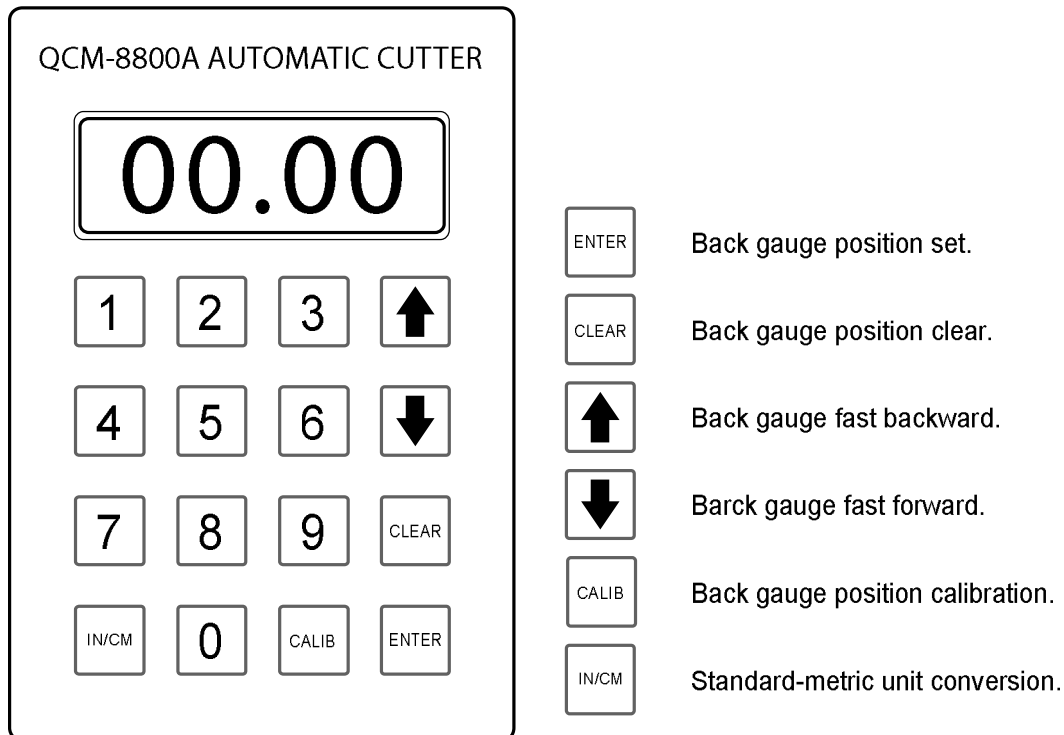


Figure 2

2. Enter the 4-digit desired back gauge position on the main operating panel ⑦, press the "ENTER" key to set the position.
3. Position the paper stack so that it flushes with the back gauge and the left side gauge.

Caution: Never place fingers beneath the blade edge inside the cutting area!

① Control panel

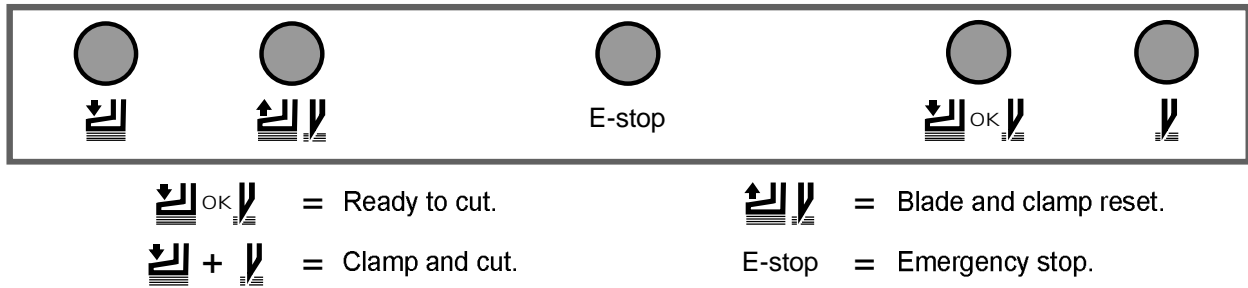


Figure 3

4. Press the button on the control panel ① to turn on the light guided cutting line indicator.
5. Verify that the desired cutting position matches the guided cutting line. If not, get back to steps 2, 3 and 4 to re-adjust the position of the back gauge and the paper stack.
6. Press the and the buttons simultaneously to complete the cut.
7. Press the “Back gauge fast forward” key on the main operating panel ⑦ to eject the paper stack and complete the operation.

MAINTENANCE

This machine may only be used for cutting paper or similar materials. Do not use it to cut any hard substances or material that may splinter. Hard materials such as paper clips and staples will damage the cutting blade.

Turn off the main power by pressing the “E-stop” button on the control panel ① and the power circuit breaker ⑩ when not in use.

Every three months, turn off the main power switch, turn off the circuit breaker, unplug the power cord, and open the cover, check, clean, lubricate and oil the motion parts of the blade assembly. For long-time storage, coat the blade and the blade carrier with anti-rust lubricant.

This machine must not be placed outdoors. Do not operate the machine in the vicinity of flammable liquids or gasses.

It is strongly suggested to keep a spare blade kit (QCM-9550B) available in case the blade needs to be sent for sharpening.

Blade Removal and Installation

The blade can be sharpened or replaced. It may only be sharpened by qualified workshops.

Caution: Even a dull blade is a very dangerous item. Extra care must be taken in handling the blade to prevent personnel injury or blade-edge damage in the process of removal and reinstallation.

Do not handle the blade without hand protection.

Do not transport or leave the blade exposed without proper packaging.

Read all the instructions below carefully before proceeding.

The following instructions are intended for qualified technicians only. *Quality Commercial Machines Corporation assumes no responsibility for any accident or injury incurred while attempting to repair any QCM*

1. Turn off the main power switch, turn off the circuit breaker, unplug the power cord, and remove the blade assembly cover.
3. Remove the two blade screws on the blade carrier that have notches beneath. Install and fasten the two blade grips to places instead.
4. Remove the rest of the blade screws. Hold both blade grips, release the grips half-turn, lower down the blade, and carefully take the blade out of the machine.
5. Loosen the blade height adjustment setscrews on top of the blade carrier.
6. Mount the grips on a new blade. Place the blade onto the carrier and fasten the blade with the grips.
7. Fasten the blade with the screws, remove the grips and fasten the rest of the two screws.
8. Fasten the blade height adjustment setscrews on the top of the blade carrier.
9. Each time, after the replacement of a blade, make sure to rotate or replace the cutting stick.

Cutting Stick Removal and Installation

Each cutting stick can be used eight times (rotated four times, flipped, and rotated four more times.)

1. Pry out the cutting stick with a small flathead screwdriver, rotate the cutting stick to an unused surface, and mount the cutting stick back.
2. Make sure that the stick is leveled and fully against the stop to its left.
3. Turn the blade adjustment screw ⑨ all the way to the left.
4. Mount the blade assembly cover back.

Once the cutting stick has been rotated, follow the operating procedure to cut a piece of paper. If it does not make a clean cut, it may be necessary to adjust the blade height by turning the blade adjustment screw ⑨. Adjust the blade adjustment screw ⑨ a quarter turn to the right each time, and try again till the paper is cut through entirely.

TROUBLESHOOTING GUIDE

PROBLEM ...	CAUSE ...	SOLUTION ...
Main power indicator is off.	No power source.	Check the power cord. Check the power circuit breaker. Check the key lock switch.
Does not cut straight or accurate.	Back gauge is off alignment.	Release the back gauge fastener. Adjust the back gauge perpendicular to the side gauge with a wedge.
Power is on but no actions.	Loose connectors on the control circuit board.	Check all the connectors on the control circuit board.
Blade does not go back to the up position fully or keeps moving up and down.	Blade limit sensor or the control board malfunction.	Check the sensor and the control circuit board.
Blade cuts slowly and powerlessly.	Motor capacitor malfunction.	Replace the capacitor.

SYSTEM ERROR CODE LIST

ERROR CODE ...	CAUSE ...	SOLUTION ...
"E-1" error with alarm and will not cut.	IR grating sensor blocked or malfunction.	Check the IR grating sensor and the control circuit board.
"E-2" error with alarm and blade does not go back.	Blade limit sensor or the control board malfunction.	Check the sensor and the control circuit board.
"E-3" error with alarm and blade can not be adjusted.	Blade height adjustment malfunction.	Check blade carrier upper limit sensor. Check the control circuit board.
"E-4" error with alarm and blade does not go all the way back.	Blade limit sensor or the control board malfunction.	Check blade carrier lower limit sensor. Check the control circuit board.
"E-6" error with alarm and back gauge will not calibrate.	Back gauge limit sensor malfunction.	Check back gauge limit sensor. Check the control circuit board.

TECHNICAL SPECIFICATIONS

Model Number:	QCM-8800A
Cutting Width:	18.0"
Cutting Height:	2.0"
Accuracy:	Better than 0.01"
Base Size:	40" x 35"
Unit Weight:	640 lbs
Dimensions:	38" x 44" x 50"
Shipping Weight:	750 lbs
Motor:	1.5 hp
Power Supply:	110V, 60 Hz (15 amp dedicated line required.)