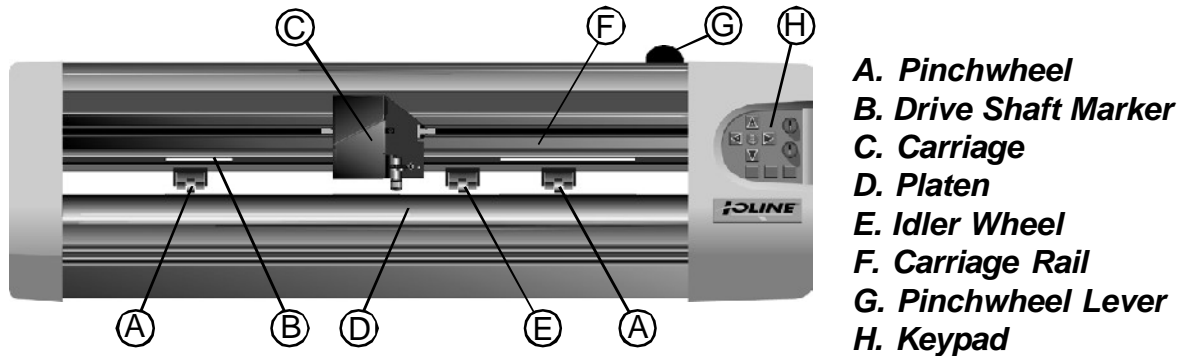


This quick start guide shows how to assemble and setup the Ioline 100 cutter. Consult the user guide on the CD-ROM for more detailed information about installation and operation. The user guide may be printed from the provided Adobe® Acrobat® viewer if necessary.

Caution: *The cutter is heavy and could cause an injury if it falls. A minimum of two people are required to safely unpack the machine and attach it to the cradle. One person should hold the machine while the screws holding it to the cradle are inserted.*



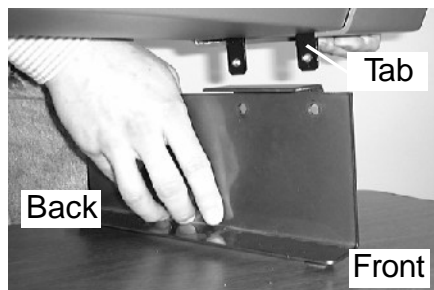
Step 1 **Unpack**



Remove the machine, cradle parts, and accessory kit from the box. Check the packing list. Always lift the cutter with two people, one person at each end. Save all of the packing materials.

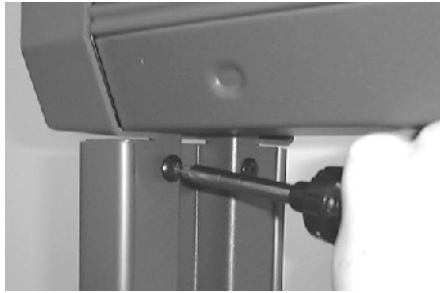
Tools Required for Assembly:
Phillips screw driver

Step 2 **Attach the Cutter to the Cradle**



Place Machine on the Cradle

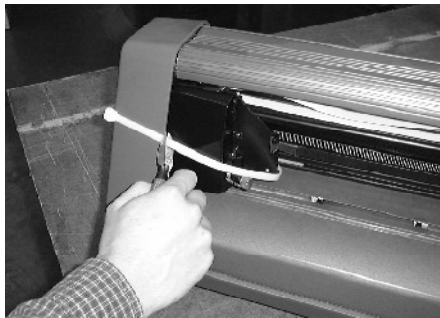
One person should hold the machine while the other person positions the cutter. Slide the tabs on the bottom of the machine outside the top of both cradle feet. The longer portion of the foot should extend from the back of the machine. Make sure that the holes line up with the threaded holes in the tabs. Place the metal material roll axle in the notches on cradle brackets.



Insert the Screws

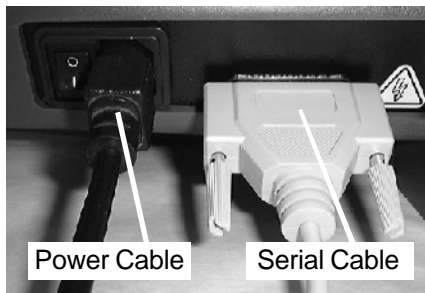
One person should hold the machine while the other person inserts the screws to secure the cutter to the cradle feet. Insert four 3/8 in. Phillips head screws through the cradle feet and into tabs on the machine. Tighten the screws.

Step 3 *Finish Installation*



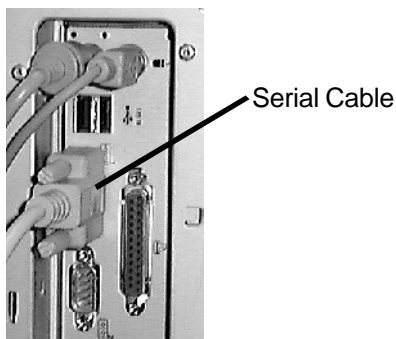
Finish Assembly

Cut the plastic strap that holds the carriage in shipping position. Remove all packing foam from around the carriage. Assembly is complete.



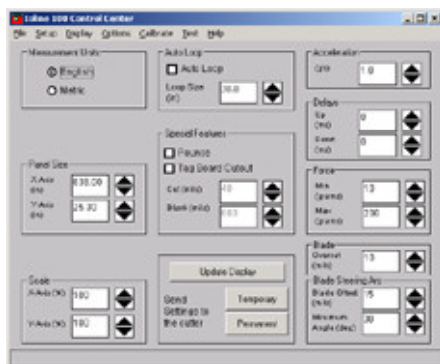
Connect the Machine Cables

Make sure that the power is off ("O" symbol on the switch) to the cutter. Connect the supplied serial cable (25 pin end) and the power cord to the panel on the back of the right side of the cutter. Lock the cable to the machine with the thumb screws. Plug the machine power cable into a wall socket or surge protector.



Connect the Computer Cable

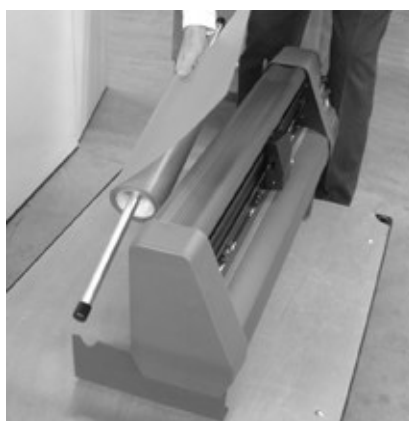
Make sure that power is off to the computer. Connect the 9 pin end of the serial cable to one of the serial ports on the back of the computer. Tighten the thumbscrews. Make sure that the computer is plugged in and working properly. See the *Installation* chapter of the user guide for more information. **Note:** Some computers have 25 pin serial connectors. An adapter is required for this type of connection.



Install the Software

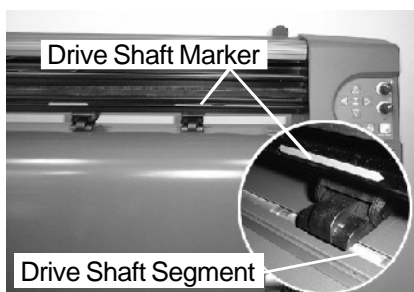
Install the Ioline Control Center and the 101 software onto the computer. Select all of the software from the list of options in the Setup program on the CD-ROM. The Setup program also allows installation of the electronic User Guides and the necessary viewer.

Step 4 Prepare to Cut



Load the Material Roll

Place a roll of material onto the metal material roll axle. With the pinchwheels up, thread the material through the machine.



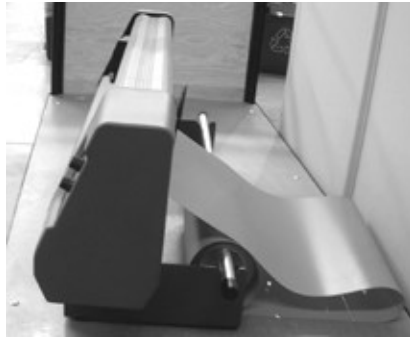
Position the Pinchwheels Over the Drive Shaft

Move the material and pinchwheels from side to side to find a position where the outermost drive wheels are on the material, about 1" from each edge, and over a drive shaft segment. Use the drive shaft markers (illustration) to determine where to place the wheels. The long drive shaft segment on the right side of the machine allows many pinchwheel positions for most material widths. Evenly space the inner idler wheel over a drive shaft segment. Make sure there is a minimum of an inch between the edge of the roll and the cradle foot after the pinchwheels are in the correct position.



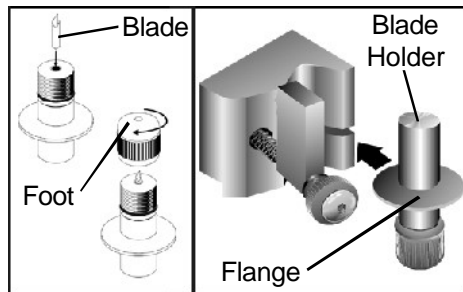
Square the Material

Turn on the cutter. Press the down arrow key and watch the right edge of the material as it moves under the pinch wheels. If the edge does not stay straight, lift the pinchwheels off the drive shaft with the lever then realign the material. Repeat this process until the material moves straight through the machine.



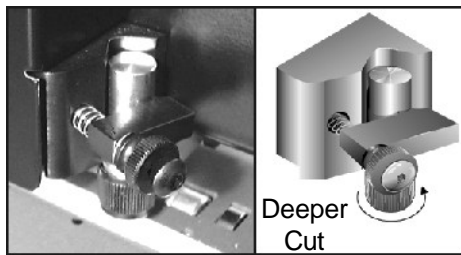
Position the Material

Do not let the material become suddenly tight between the machine and the material roll. Manually unroll a few feet of material from the roll to create a slack loop behind the machine. Use the arrow keys on the keypad to move material through the machine to re-check alignment. Move the front material edge two inches in front of the blade and the carriage an inch from the right edge.



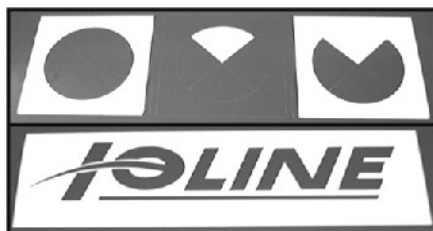
Insert a Blade, Load the Holder in the Jaw

Unscrew the *Foot* from the blade holder. Insert a *Blade* into the hole in the *Blade Holder* making sure it is fully seated. Replace the *Foot* and adjust it so that the blade tip is barely inside the foot with no blade exposed. Loosen the thumb screw on the carriage jaw and insert the *Blade Holder*. The *Flange* will fit in a slot in the jaw. Rotate the clamp down onto the *Flange* and tighten the thumb screw until the *Blade Holder* is held securely.



Adjust the Blade Exposure and Force

Turn the force knob on the keypad clockwise to maximum. Press the **Test Cut** key. There should be little or no scoring of the material. Turn the foot 1/8 turn clockwise (from the bottom). Press the **Test Cut** key. Weed the test cut pattern and examine cut quality. Continue adding blade exposure and pressing **Test Cut** until the pattern weeds easily and the blade leaves a clear scoring on the backing. Reduce the force in small increments and perform more test cuts until the test cut pattern does not weed well. Set the force to the previous position. Press and hold the **Test Cut** key for 3 seconds. The machine will cut a large test pattern as a final check. Move the carriage and material to a starting position for the first file. Press the **Set Origin** key on the keypad. The light on the keypad will turn green.



The machine is ready to cut. Refer to the User Guide and the design software documentation for more information about optimizing cutter performance.