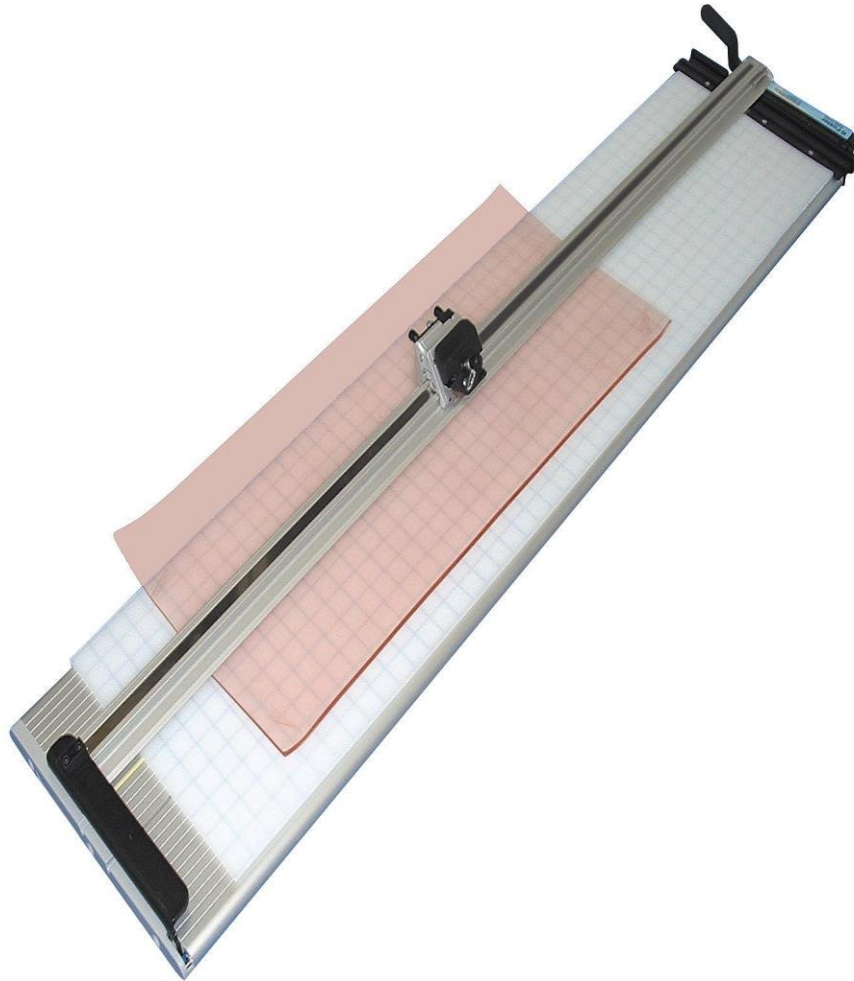




FLEXO CUTTER Instruction Manual



THE WORLD'S FINEST CUTTING MACHINES

FOSTER KEENCUT

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Flexo Cutter User Instructions

Thank you for choosing the Flexo Cutter made by Keencut. Every effort has been made to bring you a superbly built product with the promise of many years of good service. In order to obtain maximum benefit from your machine please read these instructions carefully. For advice and assistance or replacement parts please contact Foster Keencut at 800-523-4855 or 215-442-1700, Fax 215-442-1313 or e-mail: information@fosterkeencut.com.

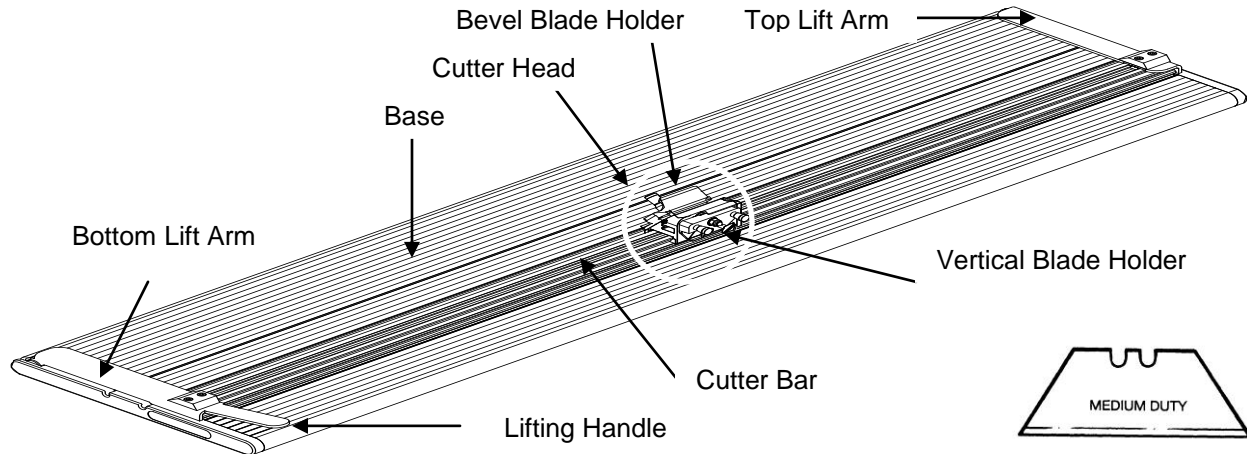
<u>Flexo Cutter</u>	<u>Cutting Mat</u>	<u>Mat Size</u>
#60808	#60840	16" x 12"
#60808	#60848	32" x 12"
#60812	#60852	50" x 12"
#60816	#60856	64" x 12"
#60820	#60860	86" x 12"

<u>Blades</u>	
#69108	Medium Duty Blades
#69120	XR Utility Blades
#69130	Ceramic Blades
#69134	Teflon Coated Blades
#69119	Heavy Duty 080 Blades

- Included in your order is one each of the following:
- Self-healing cutting mat
 - Grid sheet
 - Ceramic coated utility blade
 - Ceramic/Teflon utility blade

Please try these samples and call your favorite Foster dealer for replacement and pricing on these items.

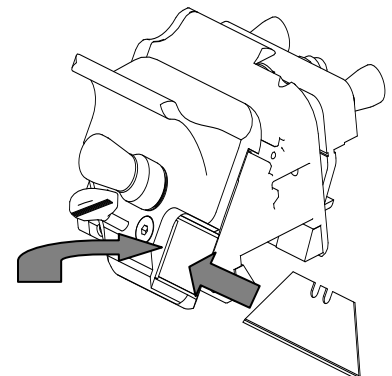
KNOW YOUR FLEXO CUTTER



INSERTING THE BLADE

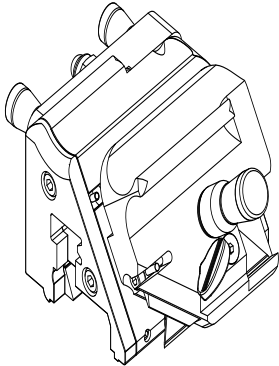
Insert the blade into the back of the Bevel Blade Holder and push it as far forward as it will go (onto the Blade Stop), turn the wingbolt clockwise to clamp the blade. The Vertical Blade Holder works in the same way except it does not have a Blade Stop, blade depth control on the vertical cutter is not so critical.

NOTE: The set screw on the Bevel Blade Holder must be removed to hold the Teflon Coated Blade and XR utility blades.



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BLADE DEPTH ADJUSTMENT



The Bevel Blade Depth Adjuster is situated in the front of the bevel Blade Holder and can be adjusted using the 2.5mm Allen key provided with the machine. By having the least amount of blade protruding the Flexo will not only cut easier but produce a smoother and more accurate cut.

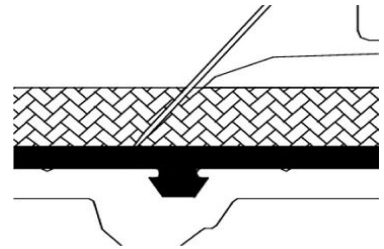
There is no Blade Depth Stop on the vertical cutter, just set the blade depth by eye so that it protrudes through the thickest material normally cut. As the blade is cutting vertically the pressure on each side of the blade is relatively even, when bevel cutting it is not and can result in the blade bending if it is extended too far.

CUTTING MAT

The self healing cutting mat supplied with each cutter provides a rigid cutting surface. This stabilizes the flexo as it is cut. Do not cut into the silicone strip imbedded into the aluminum base. There is too much flexibility in the silicone and you will be unable to achieve a straight cut.

CUTTING FLEXO

When cutting flexo use the Cutting Mat supplied on the base of cutter to collect the top of the blade. Ensure you have the blade set to the correct depth to prevent cutting the Mat too deeply. Use the grid underneath the cutting mat as a visual reference. It is not for measuring.



Here are some helpful hints for achieving the best results.

1. To eliminate entry and exit burrs, push the blade into the flexo, through the base, to start your cut.
2. If you cut with the base side up place the foam protector sheet (used for shipping between each flexo plate), on the base board, to protect the emulsion side from scratching.
3. To stabilize the plate for ultra-fine trimming, try starting your cut 1" in from the edge. Come back and complete the cut from the edge.
4. To obtain smooth clean edges and avoid fracturing (especially on thicker flexo plates), we recommend multiple passes and frequent blade changes.

USE ON A FLAT SURFACE

It is important that the table surface the cutter is mounted on is relatively flat. If not the base and cutter bar may not clamp the material correctly allowing it to move while being cut.

Flexo Cutter User Instructions

CLEANING

Your Flexo Cutter is a precision made machine and will give many years of accurate and reliable service if you follow these few simple steps. Keep all liquids (including tea and coffee) away from the machine – spillages spoil the machines performance and the Flexo cut upon it. Dust/vacuum daily, for stubborn stains use detergent/water mix firstly applied to a cloth. Cover the machine overnight with a plastic or fabric sheet.

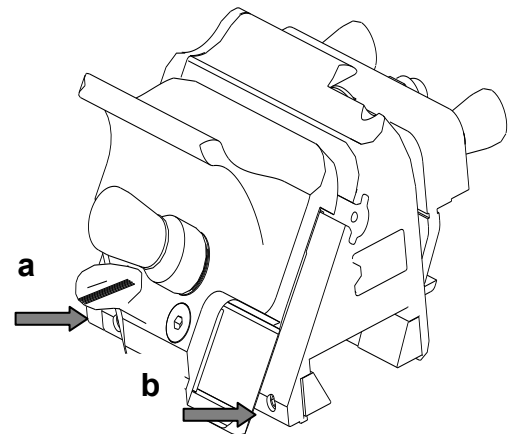
In the event of heavy soiling solvent cleaners can be used but:-

- Apply the solvent to a cloth and not directly to the machine.
- Read and comply with the solvents safety instructions.
- Do not allow the solvent to come into contact with any printed or plastic parts of the machine.

ADJUSTING THE CUTTER HEAD BEARINGS

As the bearings settle into position you may wish to adjust them to eliminate side play from the sliding head as follows:

1. Place the 2mm hexagon wrench in the front bearing adjustment screw (**a**) and turn clockwise by small increments ($1/16^{\text{th}}$ of a turn) sliding the head each time to check for free running.
2. When the head slides less easily turn the adjustment screw back counter-clockwise by one small increment or two to restore free running.
3. Repeat steps 2 & 3 on the back bearing adjustment (**b**) first rotating the bevel blade holder to gain access to the head of the adjustment screw.



NOTE: It is not necessary to remove the head for cleaning and once the bearings are adjusted to your preference you may never have to do it again.

LUBRICATION

Lubrication of the cutter bar should not be necessary if the cutter is kept clean. However, should you wish to, use silicone lubricant preferably applied with a sponge pad or spray applied to a cloth first. Follow the health instructions of the spray cans.

DO NOT USE OIL, GREASE OR MULTI-PURPOSE PENETRATING OIL ON THE CUTTER BAR