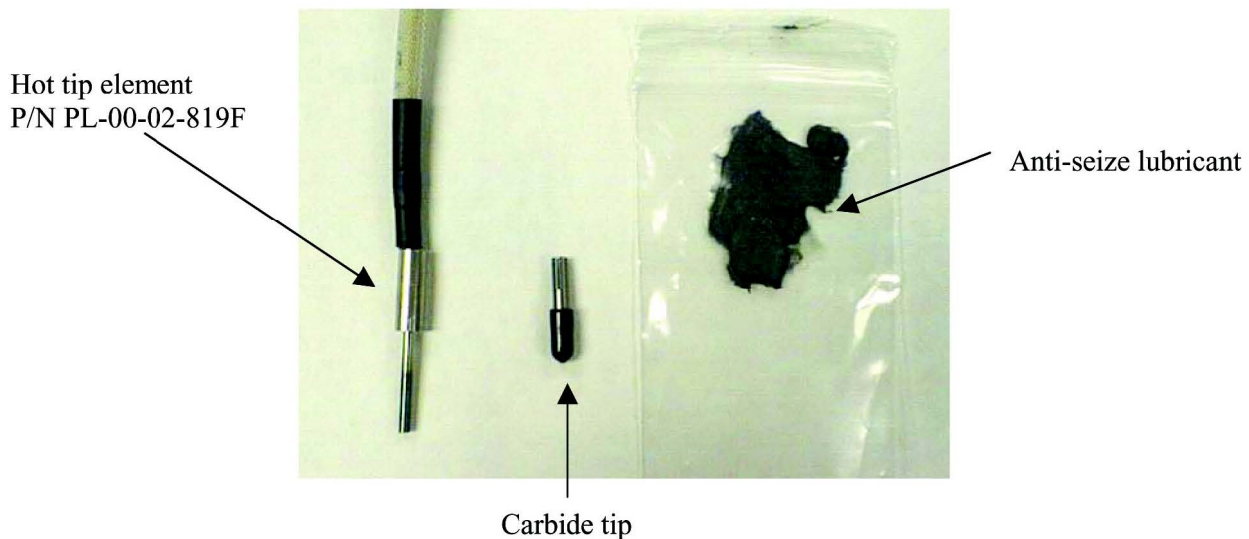


Hot Tip Element Replacement Procedure

Step 1- Remove element, tip and anti-seize lubricant from shipping bag.



Step 2- Using needle nosed pliers, carefully squeeze the notched end of the carbide tip together until it fits snugly onto the shaft of the element.

DO NOT SQUEEZE THE TIP WHILE IT IS ON THE ELEMENT, AS THIS WILL DESTROY THE ELEMENT!!!

Step 3- Remove the tip from the element and open the bag of anti-seize. Insert the end of the element into the bag and apply a SMALL amount of anti-seize to approximately $\frac{3}{4}$ " of the element.

Step 4- Insert element into tip until it bottoms out.

Step 5- Install assembly into the hot tip holder.

Step 6- Install assembly into machine.

Step 7- Adjust the height of the element as outlined in the Hot Tip height adjustment procedure.



Hot Tip Height Adjustment Procedure

The Hot Tip element supplied with your Allen I Tech Cutter has been preset at the factory prior to shipping. The following procedure explains how to set the height after changing the replaceable element should it become necessary.

Step 1- Insert Hot Tip adapter with element installed into the tool holder of the I Tech Cutter. Proper orientation of the tip is shown to the right. Press down until the shoulder of the white Teflon comes into contact with the black tool holder and tighten the brass thumbscrew.

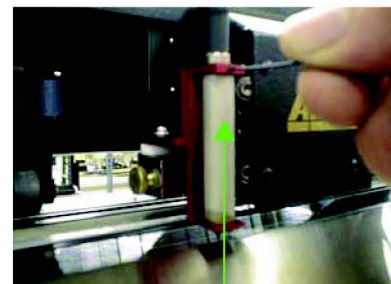


Tip cuts on this surface

Step 2- Insert connector into receptacle in the cutting head cover. Press into place holding the area shown at right. Be sure all gold pins are aligned with connector before pushing into place. **DO NOT PULL OR PUSH ON THE WIRES OR MESH COVERING OF ELEMENT, AS IRREPARABLE DAMAGE TO ELEMENT WILL RESULT.**

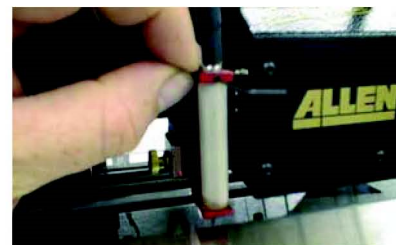


Step 3- Loosen set screw with the Allen wrench supplied in your accessory kit. Allow the tip to come into contact with the stainless steel platen. Use the Allen wrench to hold the red adapter at its lowest position, with the tip still in contact with the stainless steel. Note the amount of element showing above the red adapter.



Note amount showing above red

Step 4- Using your thumb and forefinger, hold the element down to the stainless steel, and raise the red adapter up by HALF the distance of the exposed element in the previous step. Tighten set screw while holding both pieces in position.



Raise red adapter by $\frac{1}{2}$ the distance shown in step 3

Hot Tip Controller Instructions

Your Allen I-Cutter controller has been factory set to cut most materials, and has been thoroughly cut-tested using reflective materials. The sample of material included with your I-Cutter was cut on your machine during the final testing procedure.

It may become necessary to adjust the heat setting when cutting different types of material, but it is suggested that only the cut speed and force be adjusted to achieve satisfactory cutting prior to adjusting the heat setting.

The sample of material received with your I Cutter was cut at the factory default setting for heat, with only the speed and force being adjusted to achieve the results seen.

A good starting point for speed is 20, with a force setting of 30 for heavy reflectives such as 3M Diamond Grade material. Use the factory default heat setting to start.

If it should become necessary to adjust the heat setting, the instructions below will guide you through the process.

If you need further technical assistance, please contact Allen Datagraph Technical support at 603-893-1983.

Digital Display

Displays current heat setting or menu item
(Temperature shown is not typical cut temperature. Shown for photographic purposes only.)

Indicator Light

Illuminates when heat is being applied to tip



SET Button

Press and hold to adjust heat settings using up and down keys

Infinity Key

NOT USED

Up & Down Keys

Press to adjust heat setting while holding SET key

To adjust heat setting or to turn heat on when heat is set to OFF:

1) Press and hold SET key. 2) Adjust heat setting using up or down keys. 3) Release keys when desired setting is reached. 4) Allow tip to heat up before performing test cut or proceeding with cutting operation.

To Turn heat OFF: 1) Press and hold SET key.

2) Press and hold down key until OFF is displayed.

3) Release SET key.