

## OPERATING PROCEDURES

### WARNING :

- NEVER OPERATE MACHINE WITHOUT COVERS SECURED.
- NEVER INSERT ANYTHING IN EXIT CHUTE (Front) & ONLY MATERIAL TO CUT IN INLET (Back).

**SET-UP:** Place the machine on a bench with the material to be cut level with the inlet. Secure AC-500 to the bench with hardware provided. Ensure the discharge area is free of obstruction. Further setup and operational videos are on our website, [www.AutoCutterUSA.com](http://www.AutoCutterUSA.com)

### KEYS / DEFINITIONS

HOME is the Display Menu (May or may not have values entered).  
“SLOWLY FLASHING” of a value occurs until “ENTER” is pressed.  
QTY – Select to ENTER a value of a QUANTITY in the Batch.  
LEN – Select to ENTER a value of a LENGTH in the Batch.  
IN/CM – Select to TOGGLE the Unit of Measure from the Default in INCHES to Metric in CM.  
PROGRAM / RECALL – Save a batch program entered, **OR** Recalled a previously saved program.  
ENTER – Save a value.  
CLEAR – Return the value to ZERO or RETURNS to the Home screen.  
START – Begin Batch Run (Qty & Length) entered or Actuate knife when Qty & LEN at ZERO.  
STOP – Pauses Batch Run in progress.  
TEST – Runs ONE piece of Batch Length programmed.  
MODE – Select in conjunction with another key required for specific action:  
+LEN = Calibration, +Program/Recall = Save Batch Values,  
+STOP = Reverse Motor Action, +“2” = Toggle Speed FAST/SLOW

**POWER-UP:** Plug the cord into machine & outlet. Turn on by switching I/O to ON position (I)

**LOAD MATERIAL:** BEFORE or AFTER PROGRAMMING BATCH  
**BEFORE Pressing “START”**

- Press & hold down the lever, inserting the material from the back to the front, by threading it completely thru to the exit in the front.
- Press “START” to begin Batch Run.
- Press “STOP” at any time to PAUSE batch and “START” to RESUME.

### PROGRAMMING A BATCH – DIRECT ENTRY MODE

**DO NOT USE ANYTHING BUT FINGERTIP PRESSURE ON KEYS**

**ENTER QUANTITY:** Press “QTY” (“0000” slowly flashes). Select a value, Press “ENTER”.  
*[Quantity entered appears as 0000 of ####](#)*

**ENTER LENGTH:** Press “LEN” (“0000.0” slowly flashes). Select a value, Press “ENTER”.  
ie: “2.0” press the number “2” & “0” then “ENTER”.  
*[Length entered will appear as 0002.0](#)*

**UNITS OF MEASURE:** Units are default in inches “IN”.  
Press “IN/CM” to toggle from inches to centimeter units.

**SELECT SPEED:** Default feed rate is 30'/minute “FAST”. To change the speed to 15'/min, “SLOW”, press and hold the “MODE” key and the number 2.  
Press & release the number “2” will toggle SPEED.

## PROGRAMMING A BATCH – DIRECT ENTRY MODE - CON'T

### LENGTH CALIBRATION : (OPTIONAL)

This process, AUTOMATICALLY, calculates the correction needed to the overall length. The difference between the programmed length from the actual length can occur due to; set-up, material properties, and environmental conditions. Length calibration allows for a customized calculation of your application.

Press “MODE” & HOLD DOWN while pressing “LEN” - Release

Display Screen:

**LENGTH CALIBRATION**  
**LEN: 0000.0 (slowly flashes) IN**

- Load material to calibrate.
- Select the number value of the length desired.
- Press “ENTER”; The machine will feed & cut ONE piece.
- Accurately measure the cut length of the piece it just fed out.
- Enter the length value **MEASURED** to the nearest 0.1” / 0.1cm  
**“0000.0” (slowly flashes)**
- Press “ENTER”; the machine is ready to cut the Calibrated Length.

**TEST LENGTH :** (OPTIONAL) Press “TEST” to run **ONE** piece of programmed length.

Press “START” to begin Batch Run.  
End of Batch Run – Display Screen:  
**“END OF BATCH RUN”**

### SAVING & RECALL PROGRAM BATCH

This option allows up to 12 Batch Configurations saved for future recall.

### SAVING A PROGRAMMED BATCH : (OPTIONAL)

- After Entering the Quantity, Length, Unit of Measure, Speed, & Calibration.
- Press “MODE” & HOLD DOWN while pressing “PROGRAM / RECALL”- Release.
- The available batch number defaults to the first FREE memory slot with “Batch #” & “FREE” status, slowly flashing.
- To Save the Program Number available, “FREE”, Press “ENTER”.
- To select a different Program Number, Select the number between 1 – 12, & “ENTER”, **OR** Press “PROGRAM / RECALL” again to Scroll.
- Press “ENTER” to Save **OR** “CLEAR” to Exit the memory saving mode.
- **The last used saved program at powering down will reappear when powered back on.**

### RECALL PROGRAM BATCH : (From Previously Saved)

- Press the “PROGRAM / RECALL” key.
- Press the program number between 1 & 12, **OR** scroll thru the programs by Pressing & Releasing the “PROGRAM / RECALL” key until you find the program needed.
- Press the “ENTER” to Save **OR** the “CLEAR” to Exit.

**For further instructions on Saving, Recalling, Deleting & Overwriting a Program Batch, please visit our website; [AutoCutterUSA.com](http://AutoCutterUSA.com)**

## ERROR MESSAGE SCREEN / SOLUTION

To Clear ERROR Message Press ANY KEY

ERROR MESSAGE	POSSIBLE CAUSE	POSSIBLE SOLUTION
<b>KEY STUCK</b> (when powered up)	Key pressed when Powered On	Check for Pressed key(s)
<b>BLADE NOT HOME</b> (when powered up)	Knife Blade too Tight Knife Return Spring Weak or Came Loose	- Adjust Blade (Loosen/Tighten) - Replace or Reattach Spring
<b>FEED FAILURE</b>	Material jammed- No Feeding Flat Material too Wide for Unit Material Slipping Drive Rollers Material Slipping w/ Rubber Rollers Material Not Falling Away/Out of Exit Chute Motor not Turning	- Clear Feed System of Material <b>MODE + STOP = REVERSE</b> - Flat .375/AC250 & .500/AC500 - Clean Knurling w/ Fine Steel Brush - Rubber Rollers Worn-Replace - Clear Area for Material to Freely Fall Away - Material Jammed Around Drive Roller
<b>CUT FAILURE</b> <b>CORRECT BEFORE</b> <b>RESUMING</b>	Knife jammed or obstructed preventing returning to "HOME" position	- Clear knife of Obstruction - Adjust Blade

**WARRANTY / SERVICE:** *ONE YEAR WARRANTY:* This warranty is for the original purchaser and is Non-Transferable. Auto Cutter USA, LLC warrants the Model AC-250 & Model AC-500 to have no defects in material & workmanship under normal use for ONE year from the date of purchase. Keep the original receipt for proof of purchase to attain warranty provisions. Within one year from the date of purchase, Auto Cutter USA, LLC repairs or replaces on its own accord any product or parts found to be defective. If the AC-250 or AC-500 needs service within the warranty period; please contact Auto Cutter USA, LLC, 417-285-3684 or [info@autocutterusa.com](mailto:info@autocutterusa.com) to receive the (*Return Merchandise Authorization*). Send to; 13477 Lawrence 1045, Stotts City, MO 65756. This warranty does not cover shipping, handling, duties, taxes, or brokerage fees. This warranty does not cover; damages or losses caused by shipping. Nor by accidents, misuse, neglect, abuse, personal injury, environmental exposure, repair by anyone other than Auto Cutter USA, LLC, or use on a voltage other than 110v, or use for anything other than the original purpose. The *One Year Warranty* excludes consumable parts: knife blade, rubber feed rollers, & overlay.

**SERVICE REPAIR:** Auto Cutter USA, LLC services all AC-250 & AC-500 cutting machines. Please contact Auto Cutter USA, LLC (417-285-3684) for Return Merchandise Authorization & return to:

Auto Cutter USA  
Service / Warranty Dept  
13477 Lawrence 1045  
Stotts City, MO 65756

Cost is Service Charge + Parts. For owners repairing their units, please call or email [info@autocutterusa.com](mailto:info@autocutterusa.com) for standard replacement parts. Owners are responsible for all freight costs (including damage, loss, & insurance).

**REPAIR:** Call or email for RMA (*Return Merchandise Authorization*). The authorization number must accompany any repair. Include an explanation of the problem and the proof of purchase if under warranty. If proof of purchase is not verified for warranty, the repair is a service, and the customer is liable for all costs.

FOR CUSTOMER CARE & INSTRUCTIONAL VIDEOS

VISIT [www.AutoCutterUSA.com](http://www.AutoCutterUSA.com)  
417-285-3684

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**AMERICAN MADE \* AMERICAN PROUD**

Auto Cutter USA, LLC

## TWO-SPEED PROGRAMMABLE AUTOMATIC CUTTING MACHINE



AC-250: WIRE Size 12 to 40 Awg, FLEXIBLE TUBING to 3/8" OD  
AC-500: WIRE Size 8 to 16 Awg, FLEXIBLE TUBING to 1/2" OD

Automatically Measure & Cut-to-Length; Wire, Tubing,  
Heat-Shrink, Cable & Much More.

- Operator Controlled Two-Speed (15'/min & 30'/min)
- Rubber or Steel Feed Rollers.
- Save & Recall up to 12 Program Batches.
- Computerized Calibration.
- Programmable in 0.1" / 0.1 cm Increments.
- Intuitive Operation – 20 Touch Key Selection.
- Self Adjusts for ALL Material - No Tool/Die Changes.
- No Pre-Feeder Required.
- Easily Portable / Bench-Top Secure.
- 110v - No Air Required.

[www.AutoCutterUSA.com](http://www.AutoCutterUSA.com)