

Call for consumer information

Customers from outside the U.S.

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Call for consumer information

Customers from the U.S. / Canada

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IMPORTANT: Read before using!

Operating and safety instructions

NOTICE

All instructions, warranties and other collateral documents are subject to change at the sole discretion of STEPCRAFT, Inc. For up-to date product literature, visit www.stepcraft-systems.com for customers from Europe or www.stepcraft.us for customers from US / Canada and click on the service & support tab for this product.

Age recommendation: For advanced handcrafters ages 14 and above. This is not a toy.

SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE.

Should you encounter any doubts or require any further information, please do not hesitate to contact us before commissioning of the power tool. Our contact details can be found on the front page of this manual.

General safety warnings

Personal safety

CAUTION	Stay alert, watch what you are doing and use common sense when operating a drag knife. Do not use a drag knife when you are tired and / or under the influence of drugs, alcohol or medication. A moment of inattention while operating the drag knife may result in serious personal injury.
NOTICE	All persons who operate the drag knife must have read and fully understood all relevant operating instructions. Misunderstandings may result in personal injury.

Tool use and care

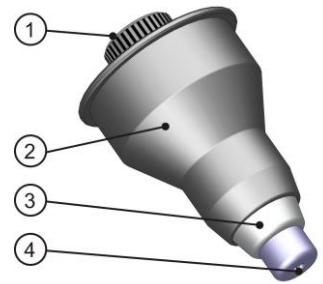
CAUTION	Store idle drag knives out of the reach of children and do not allow persons unfamiliar with the drag knife or these instructions to operate the drag knife. Drag knives are dangerous in the hands of untrained users.
NOTICE	Keep cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control by the machine.
CAUTION	Do not alter or misuse the tool. Any alteration or modification is a misuse and may result in serious personal injury.
CAUTION	Use narrow pliers in order to change the drag knife. Extract it downwards with the help of the pliers. Do not pull at it with bare fingers because this leads to danger of cuts.
NOTICE	This is not a handheld tool. The drag knife is designed to be system-guided and must be operated in a CNC router or 3D desktop system. Operation of the drag knife handheld may result in serious personal injury.
CAUTION	When using the drag knife, always have the workpiece securely clamped. Never attempt to hold the workpiece with your hands while using the drag knife.

Additional safety warnings

CAUTION	Depending on the application field of the machine (private or commercial), you need to observe the applicable occupational safety and health, safety and accident prevention and environmental regulations, too.
CAUTION	Use clamps or another practical way and secure way to support and attach the workpiece to the machine table. Holding the workpiece with your hands leaves it unstable and may lead to loss of control.

Parts and functions of the drag knife

1. With the help of the **depth adjustment screw (1)** you can set the cutting depth. Turning it clockwise increases the cutting depth, turning it counterclockwise diminishes the cutting depth. The scale enables an exact setting (1 scale line = 0,01 mm).
2. The upper part of the **main housing (2)** has a diameter of 43 mm. This is where the drag knife is being inserted into the tool holder.
3. The **cutter holder (3)** is spring mounted. This suspension levels irregularities of the workpiece and provides the required pressure. The entire range of spring amounts to 10 mm. For most materials we recommend a spring preload (= immersion depth) of approx. 2-5 mm.
4. The **drag knife (4)** is being inserted from the bottom into the double ball bearing bushing. It is being held by a magnet. In order to change the drag knife, unscrew it with the help of part 1 as far as possible, then pull it using pliers.



How to use the drag knife on the machine

1. Insert a drag knife (4) into the drag knife holder (3).
2. Set the depth adjustment screw (1) to protrude far enough to cut your material. Set it in a way that it only scratches and not cuts through a possible carrier foil.
3. Insert the drag knife into the Euro neck holder of your Stepcraft machine, as shown in the picture.
4. Upload your work file into the machine control software.
5. After the reference run, drive the drag knife back to the workpiece's zero (xy-position).
6. Lower the z-axis until the drag knife (4) touches the workpiece.
7. Zeroize this position of the z-axis.
8. Set the infeed (immersion depth) of your machine control software adequately (recommendation 2-5 mm).
9. Start cutting.
10. Should you notice during operation that the drag knife is cutting too much or too less, you can readjust it with the help of the depth adjustment screw (1).

