



Gerber® 2500 Surface Installation Instructions

1. Remove existing cutting surface and thoroughly remove all traces of adhesive using 3M® adhesive remover, clean out and remove all residue from all vacuum holes in table top, move cut gantry to one end of the table, remove the cutter head, notcher, etc., repair any dents or depressions in the table top.



2. Roll out vacuum transfer mesh onto table top, leave a small gap down the center of the table and stop about 3" short of the ends of the table, tape the mesh at one end of the table and stretch out any wrinkles before taping it at the opposite end of the table.



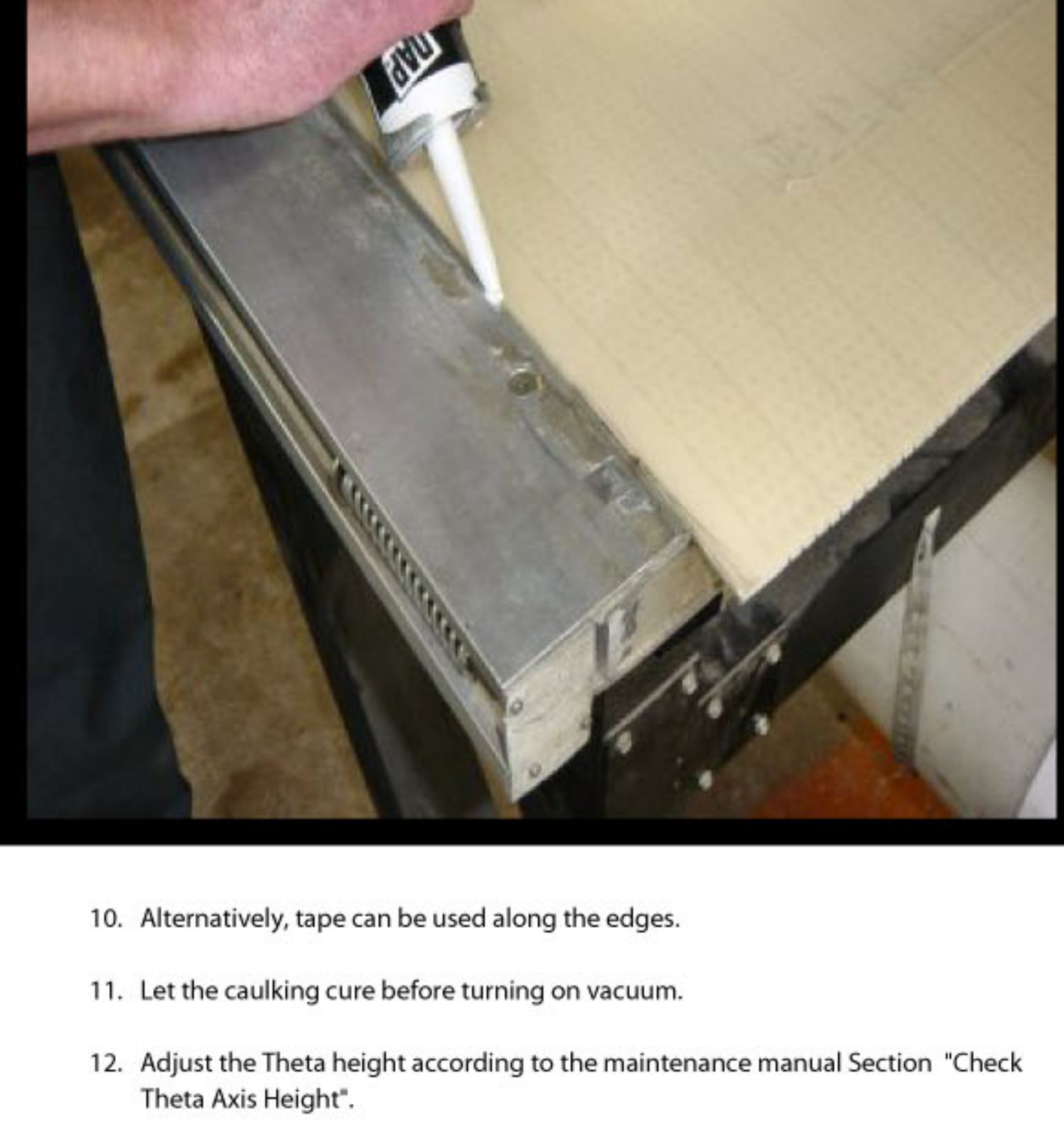
3. Set roll of cutting surface at opposite end of table from cut gantry, align edge of surface to end of table, gently unroll surface taking care not to wrinkle or create overlaps in the vacuum transfer mesh.



4. Feed cutting surface under cut gantry.
5. If the surface does not lay flat, clamp surface to one end of table, stretch surface from opposite end of table to remove any wrinkles.
6. Should the surface have several wrinkles that will not lay flat, let surface sit for several hours or overnight before proceeding to the next step.
7. Trim any excess surface length from end of table.
8. Run a bead of caulking underneath the surface at the ends of the table.



9. Run a bead of caulking along the length of the surface where it joins the extrusion, the caulking provides the vacuum seal.



10. Alternatively, tape can be used along the edges.
11. Let the caulking cure before turning on vacuum.
12. Adjust the Theta height according to the maintenance manual Section "Check Theta Axis Height".
13. Align the cutter head angle according to the maintenance manual Section "Align Cutter Angle".
14. Use reasonable cutter tool air pressures, typically 15-32 psi.
15. Install a new cutter blade.
16. Open vacuum ports as required.

NOTE: The theta height adjustment and the cutter air pressure are the most critical factors for successful cutting and for extended surface life. Setting the theta too low or setting the air pressure too high may cause excessive surface wear.

Maintenance: If after an extended use of the cutting surface a decrease in vacuum is noticed, roll up the cut surface and blow out the vacuum transfer mesh and vacuum holes in the cut table. Excess fabric threads in the cutting surface can be removed with a ShurForm® file.

For installation help, please call 828-327-8442