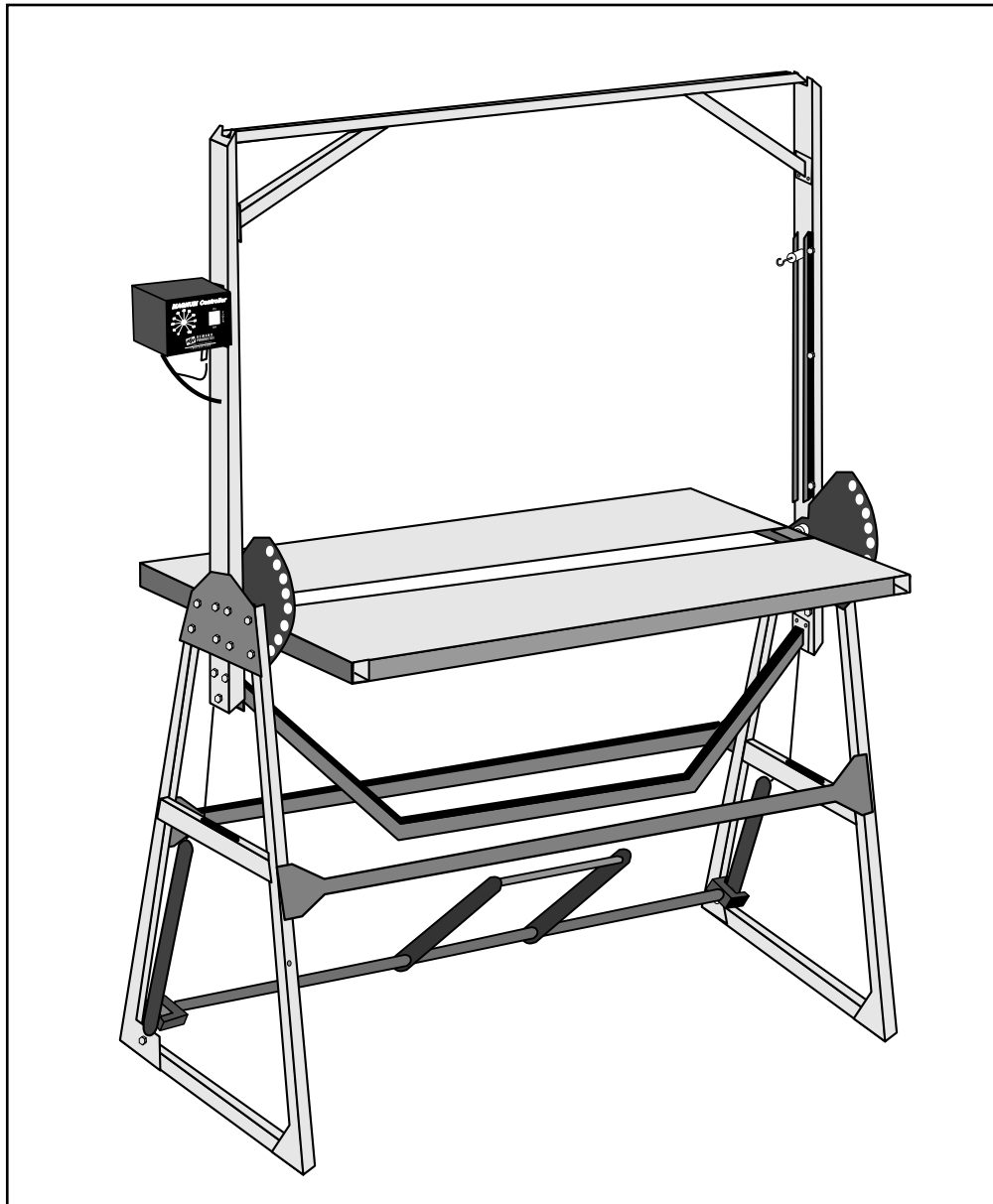


# STYRO-CUT 15™

## ASSEMBLY INSTRUCTIONS

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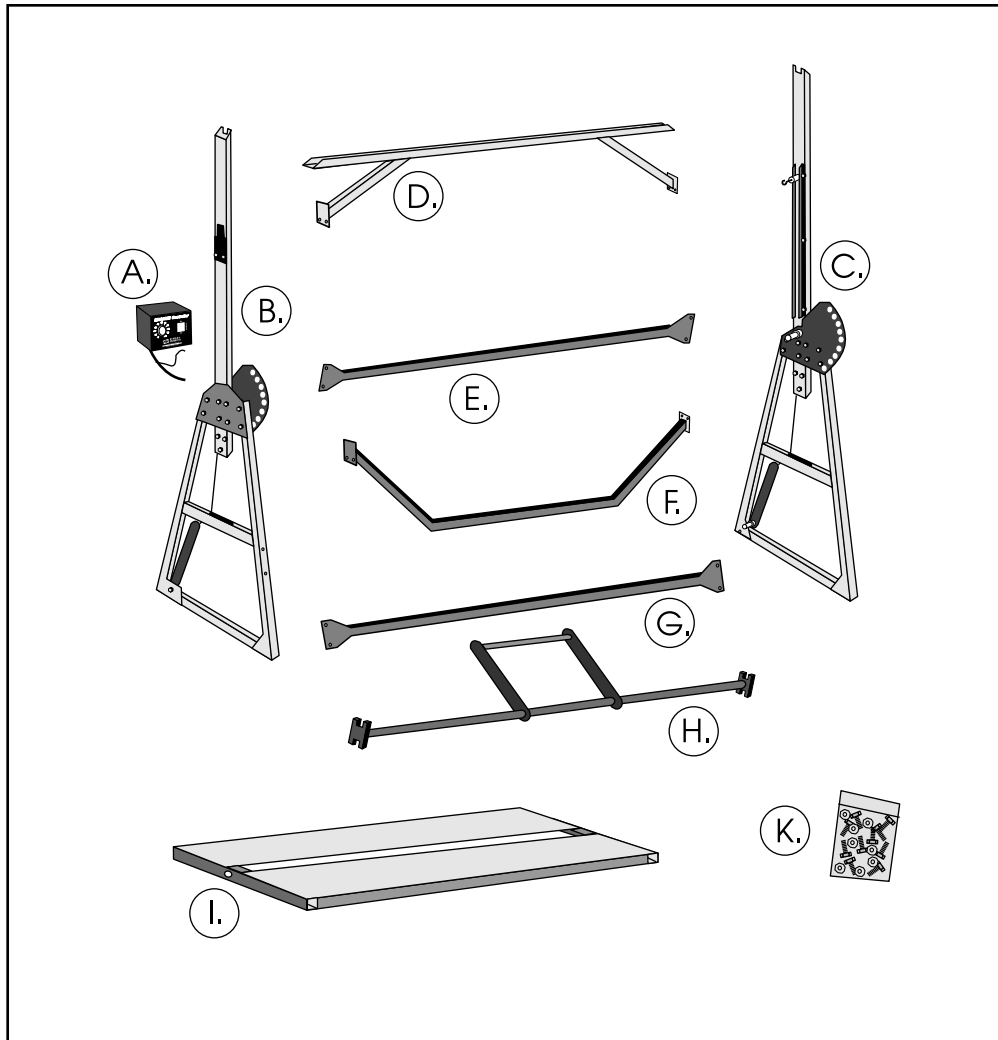
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**1-800-325-7540**

# STYRO-CUT 15™

## ASSEMBLY INSTRUCTIONS

### Parts List



A. Controller  
B. Left Upright  
C. Right Upright  
D. Top Brace  
E. Rear Bottom Brace

F. Bottom Brace  
G. Front Bottom Brace  
H. Foot Pedal assembly  
I. Table  
K. Bag of Bolts & Nuts



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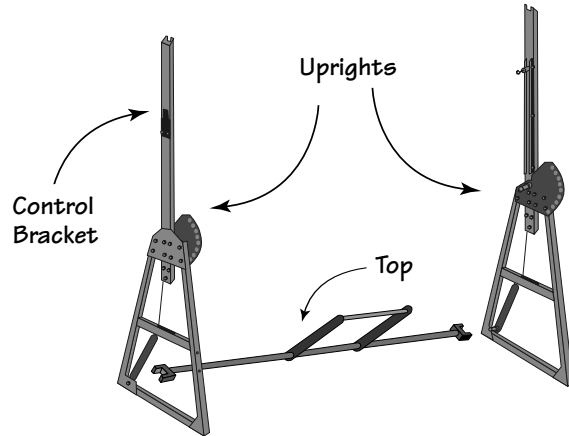
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## ASSEMBLY INSTRUCTIONS

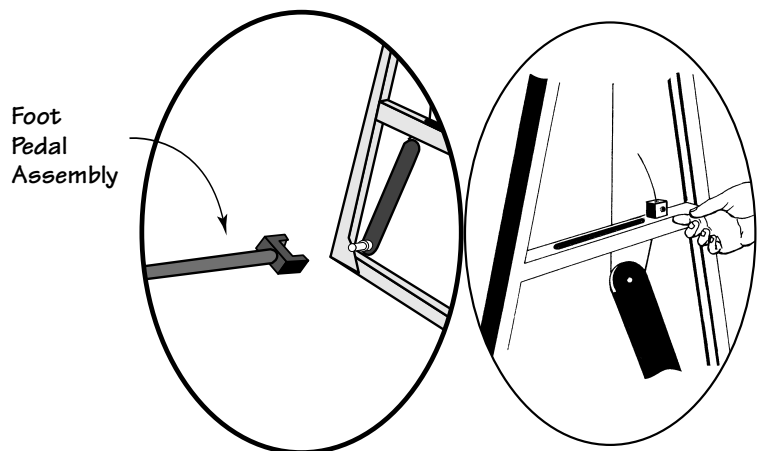
1.

Raise both uprights to a vertical position. (The left upright will have the control bracket attached.) Set the foot pedal assembly between the two uprights. The decal that indicates the top should face up.



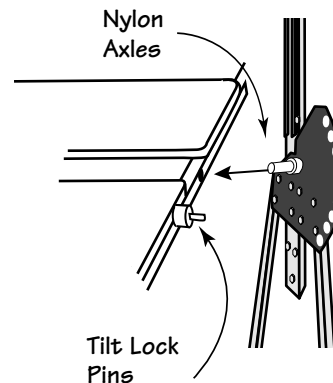
2.

Slip the foot pedal assembly onto the axle of the left vertical upright. Once the foot pedal has been connected to the uprights they should stand by themselves. This will also set the foot pedal in the proper operating position. (Note: The steel travel cable on the vertical uprights have been preadjusted at the factory. These cables should only be adjusted as necessary.)



3.

Mount the table onto the two nylon axles located on each upright. Be sure the lever is facing in front. As you mount the table it may be necessary to use the lever to disengage the tilt lock pins so the table will fit between the tilt lock plates.



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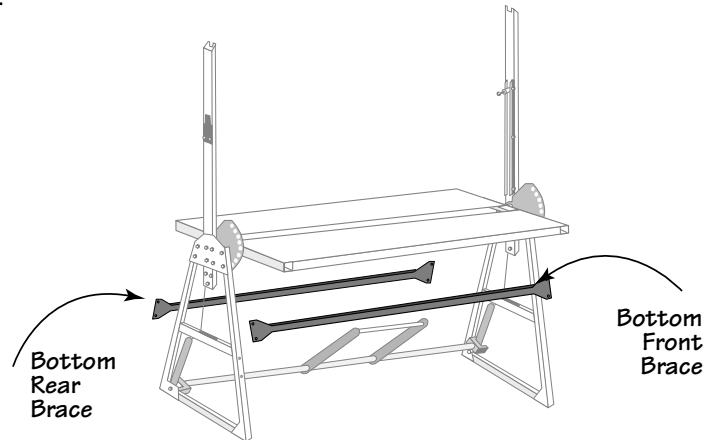
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## ASSEMBLY INSTRUCTIONS

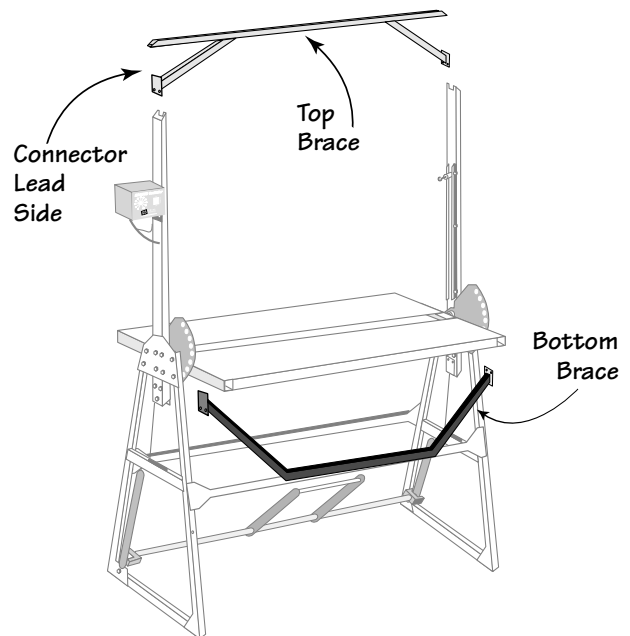
4.

Secure the bottom front and rear braces using the 1/4-20 bolts and nuts provided. Finger tighten only until later.



5.

Secure top brace in place making sure wire harness connector lead is to the left side. (This connector will plug into the control box also mounted on the left upright.)



6.

Secure the bottom brace using the 1/4-20 nuts and bolts provided.



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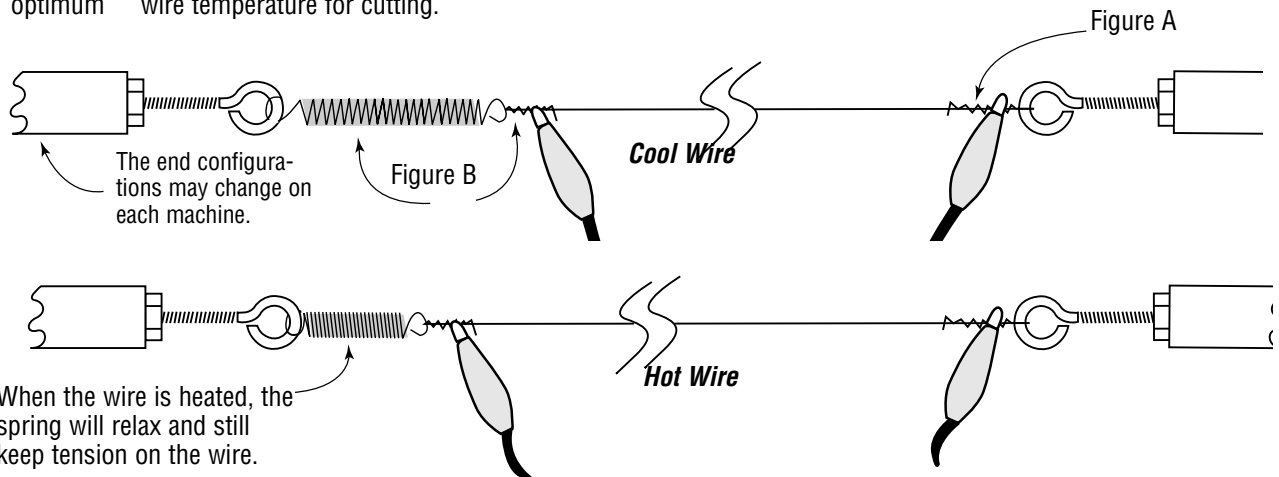
# STYTO-CUT 15™

## ASSEMBLY INSTRUCTIONS

### Hot Wire Basics

*Whether you are using Ni-Chrome or Inconel wire, the basics are pretty much the same —*

1. To attach the tension spring and wire start on one side and connect the wire with a tight wrap knot to the attachment point.  
See figure A.
2. Attach the tension spring to the other side and loop the wire through the open end of the spring. Pull the wire tight until the spring is about 2 times its normal length. Then secure the wire with a tight wrap knot. See figure B.
3. Connect the alligator clips to the wire knots on each side. Do not attach the clips to anything other than the wire knot.
4. With the controller set at "0", turn the controller on and slowly dial up the heat control until the wire begins to glow orange. Then quickly turn the controller down until the wire becomes gray. The first stage of gray color is normally the optimum wire temperature for cutting.



### Safety Tips

Note: Wire expands when hot. If the spring is too tight the wire may break restricting operation of mechanism. If too loose, the cut will be sloppy. Readjustment of tension may be necessary from time to time.

**Power Controller** – Use nothing longer than a 50 foot 12/3 grounded extension cord. Set the temperature dial on the controller to zero (0). Turn on the controller and adjust the dial until the wire glows orange. Immediately back off the controller until the wire just begins to turn from orange to gray. This is the optimum cutting temperature of the wire. Anything hotter will cause premature wire failure or anything cooler will require too much feed pressure on the wire causing premature failure. If the wire is too hot, the cut may not be as accurate as you would like. A wire that is too hot will melt the foam too quickly at the beginning of the cut and less quickly as the wire cools off resulting in an inaccurate cut.

- Use only the recommended wire.
- Do not use this equipment in wet or damp conditions.
- Use only grounded receptacles.



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