**CAUTION**

**Proper Start Up Procedures MUST be Followed!**

1. Trim the corners of the end of the aluminum before feeding it into the machine intake. Cut approximately a 45-degree angle for about 3 inches on each side.
2. Coil Carriage or de-coiler must be aligned with the machine.
3. Coil must be feeding straight into the machine.
4. Slowly start the coil feeding into the machine (Do Not Start the Machine in Run Mode)
5. Bump the JOG button until the coils through the end of the machine.
6. Once your material is through the OSHA guard or the guillotine you can push the run button and you are ready to run.