

AutoPRO™

User Manual

Automated Drywall Corner Trim System

Safety Guidelines

This manual contains information that is very important to know and understand. This information is provided for SAFETY and to PREVENT EQUIPMENT PROBLEMS. To help recognize this information, observe the following symbols.

⚠ DANGER

Indicates an imminently hazardous situation which, if not avoided, WILL RESULT in death or serious injury.

⚠ WARNING

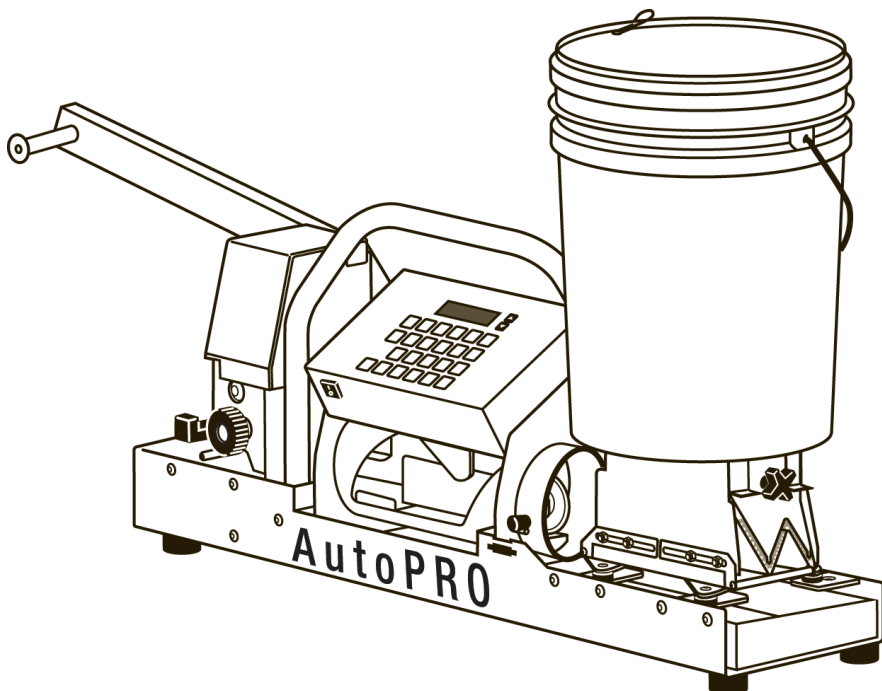
Indicates a potentially hazardous situation, which if not avoided, COULD RESULT in death or serious injury.

⚠ CAUTION

Indicates a potentially hazardous situation! If not avoided, MAY RESULT in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

Indicates important information, that if not followed, may cause damage to machine.



Safety Guidelines

General Safety and Warnings for AutoPRO machine operation

Read manual carefully. Be thoroughly familiar with the controls and the proper use of the machine.

Follow all local electrical and safety codes, as well as the U.S.A., National Electrical Codes (NEC) and Occupational Safety and Health Act (OSHA). Only persons well acquainted with these rules should be allowed to use the machine.

Wear safety glasses and approved hearing protection when operating the machine.

Operate machine on dry, level surface. DO NOT lay machine on side.

Turn off machine when not in use.

WARNING

Do not operate machine if it is wet.

WARNING

Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to this manual.

WARNING

Keep all panels and covers securely in place.

WARNING

All visitors (especially children) should be kept at a safe distance from the machine.

WARNING

DO NOT use setting-type compounds in AutoPRO as they will damage the machine.

CAUTION

Structus recommends ready-mix All-Purpose joint compound **ONLY** for use in the AUTOPRO machine when running corners.

WARNING

DO NOT modify this machine with non-Structus products, as modification could affect performance, safety or durability. In addition, damage or performance problems resulting from modification may not be covered under warranty. AUTOPRO is engineered to be used with the LevellinePRO roll product **ONLY**.

CAUTION

AutoPRO is engineered to be used with the LevellinePRO roll product **ONLY**.

WARNING

DO NOT store the AutoPRO machine in temperatures below 32° F.

WARNING

Do not use a grounding adapter with this machine!

DANGER

Improper use of grounding plug can result in a possible risk of electric shock!

DANGER

All wiring and electrical connections should be performed by a qualified electrician. Installation must be in accordance with local codes and national electrical codes.

WARNING

Motors, electrical equipment and controls can cause electrical arcs that will ignite a flammable gas or vapor. Never operate or repair in or near a flammable gas or vapor. Never store flammable liquids or gases in the vicinity of the compressor.

WARNING

Do not wear loose fitting clothing while operating machine. Keep hands and loose fitting clothing away from moving parts.

WARNING

Do Not attempt to move AutoPRO with Hopper Assembly in place. To move or transport AutoPRO, remove Hopper Assembly.

FCC statement:

Note: This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

Changes or modifications not expressly approved by Structus Building Technologies, Inc. could void the user's authority to operate the equipment.

Industry Canada notice:

This device complies with Industry Canada licence-exempt RSS standard(s). Operation is subject to the following two conditions: (1) this device may not cause interference, and (2) this device must accept any interference, including interference that may cause undesired operation of the device.

Le présent appareil est conforme aux CNR d'Industrie Canada applicables aux appareils radio exempts de licence. L'exploitation est autorisée aux deux conditions suivantes : (1) l'appareil ne doit pas produire de brouillage, et (2) l'utilisateur de l'appareil doit accepter tout brouillage radioélectrique subi, même si le brouillage est susceptible d'en compromettre le fonctionnement.

FOREWORD

Welcome to the growing number of drywall contractors who are using the AutoPRO Automated Drywall Corner Trim System. We are proud of the innovative engineering and quality construction of each AutoPRO machine that we build.

This instruction manual explains the operation of the AutoPRO system. Please read it thoroughly and follow the instructions carefully.

All information and specifications in this manual are current at the time of printing. However, because of our commitment to continual product improvement, we reserve the right to make changes at any time without notice.

For questions and further information, please contact us:

1-888-662-6281

www.levelline.com

For additional downloadable copies of this manual, visit www.levelline.com or call 1-888-662-6281.

IMPORTANT INFORMATION BEFORE USING AutoPRO

Recommended Compounds

Structus recommends ready-mix All-Purpose joint compound thinned with water **ONLY** for use in the AutoPRO machine when running corners.

Modification of AutoPRO

DO NOT modify this machine with non-Structus products, as modification could affect performance, safety or durability. In addition, damage or performance problems resulting from modification may not be covered under warranty. AutoPRO is engineered to be used with the LevellinePRO roll product **ONLY**.

Using Roll Product in the Machine

AutoPRO is engineered to be used with the LevellinePRO roll product **ONLY**.

Moving AutoPRO

If the AutoPRO hopper is full of joint compound, Structus recommends removing the hopper assembly before maneuvering the AutoPRO machine.

Storing AutoPRO

DO NOT store the AutoPRO machine in temperatures below 32° F.

Do NOT operate machine if it is wet.

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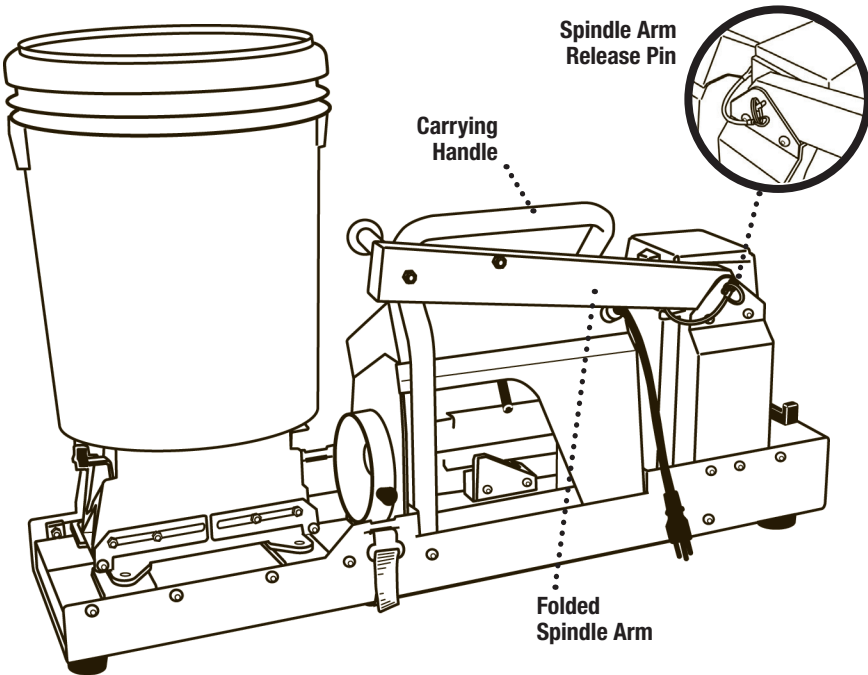
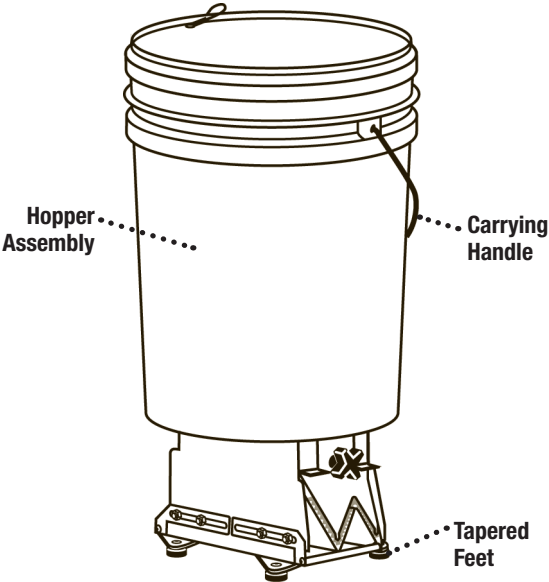
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Primary machine components

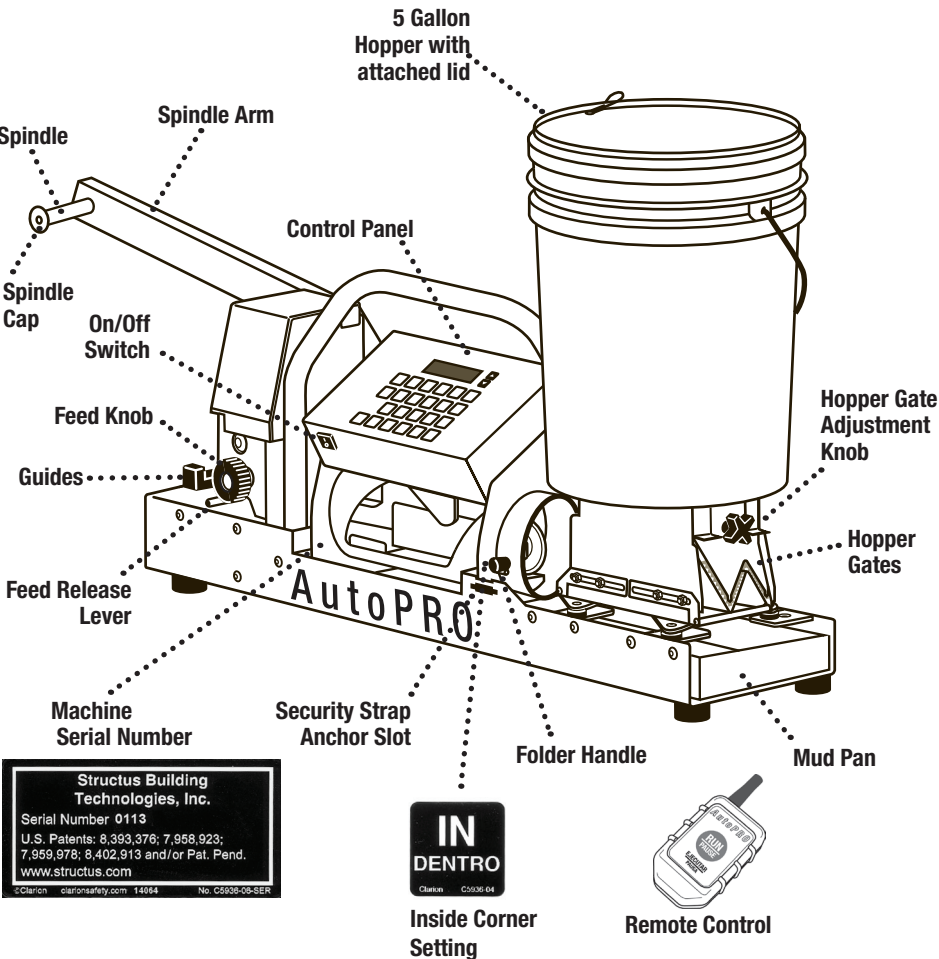
⚠ WARNING

Do Not attempt to move AutoPRO with Hopper Assembly in place.

To move or transport AutoPRO, remove Hopper Assembly.



OPERATION OF MACHINE - Machine components



Model: AutoPRO 21000
FCC ID: 2ACWZ21000
IC: 12255A-21000

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) this device may not cause harmful interference, and (2) this device must accept any interference received including interference that may cause undesired operation. Made in USA

PELIGRO

Las partes móviles pueden aplastar y cortar.
No opere sin el protector.



DANGER

Moving parts can crush and cut.
Do not operate with guard removed.

McQuay-Norris Safety Systems, LLC

www.mcquay-norris.com

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Revised No. 0012101007

PELIGRO

Voltaje peligroso.
NO abrir. No contiene partes que el usuario pueda dar mantenimiento.
Solo el personal autorizado puede darle mantenimiento.
NO rociar agua en la caja de control.



DANGER

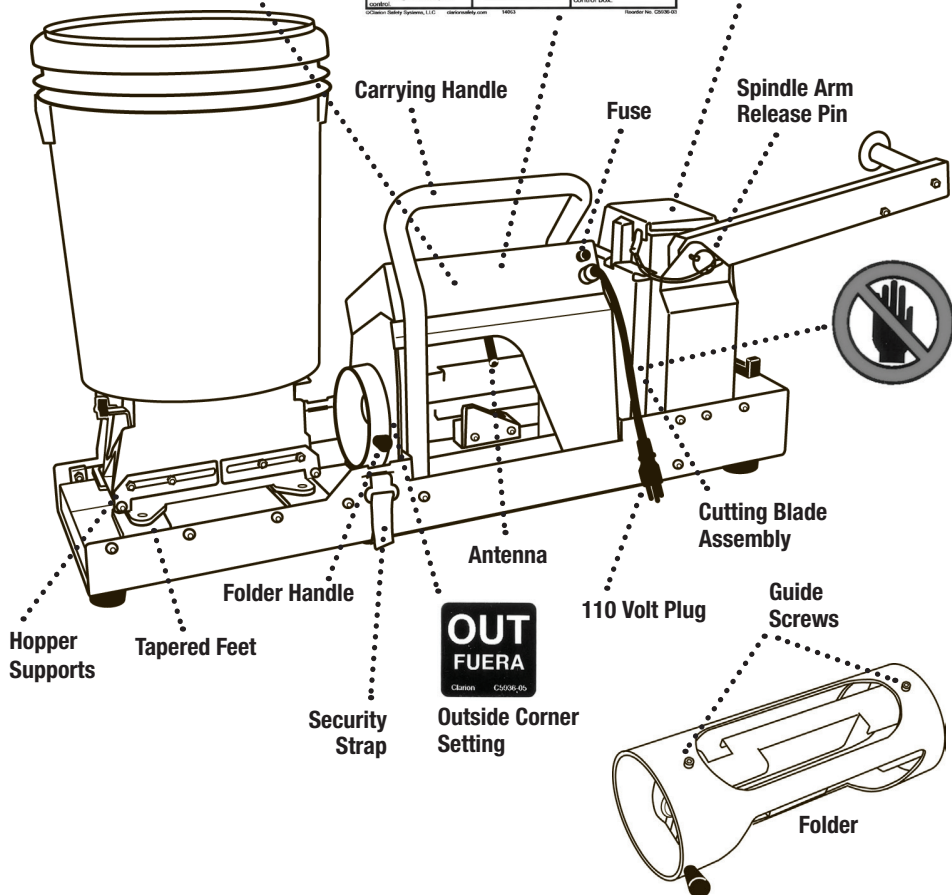
Hazardous voltage.
Do NOT open. No user serviceable parts inside.
Service is to be performed only by authorized personnel.
Do NOT spray water on the control box.

McQuay-Norris Safety Systems, LLC

www.mcquay-norris.com

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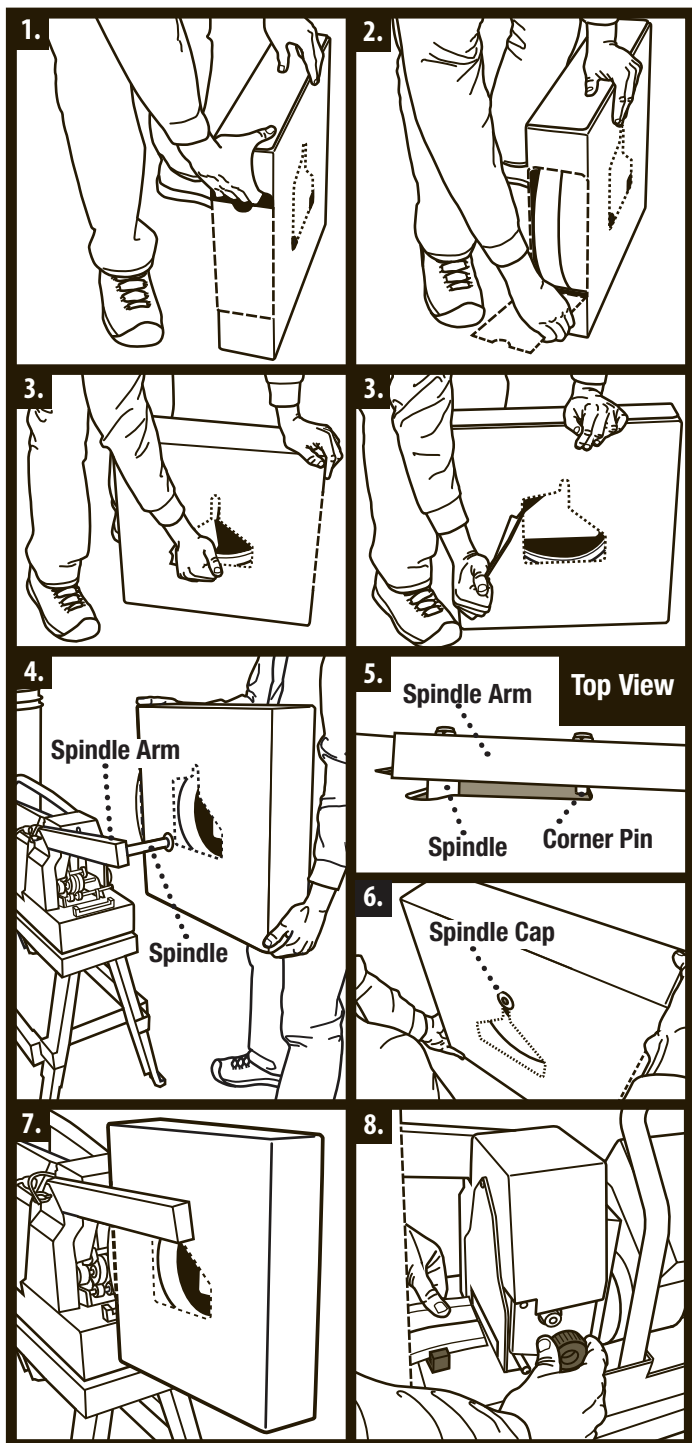
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**OUT
FUERA**

Classen C4006/06

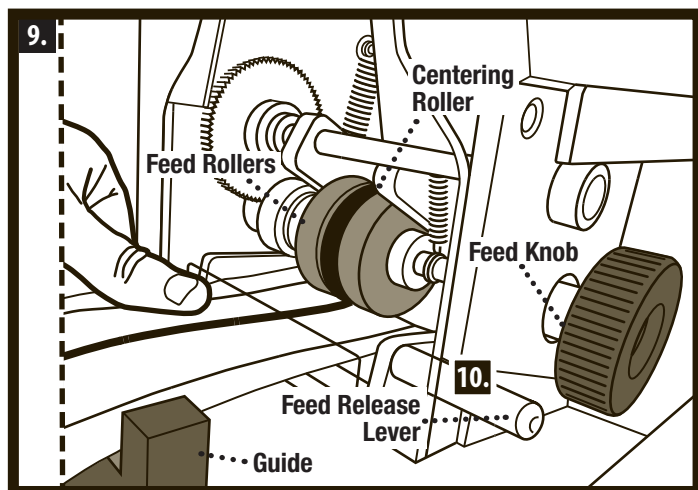
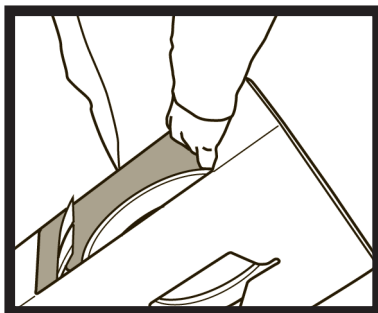
Outside Corner
Setting



To load LevellinePro into the AutoPro machine:

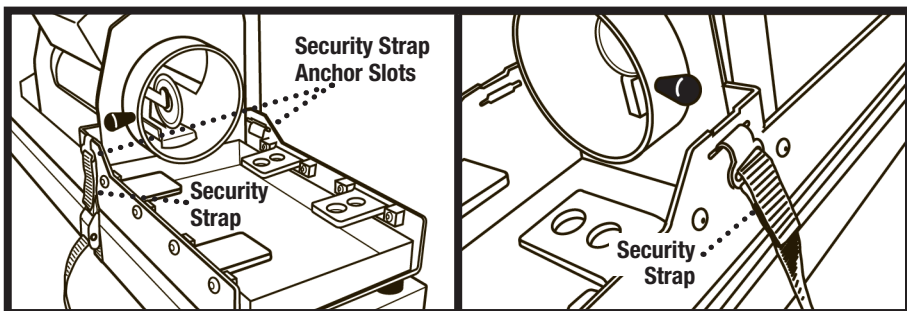
1. Push in perforated section above finger hole.
2. Tear out perforated large end panel and remove.
3. Using finger holes, remove perforated panels on both sides of the box.
4. Lift box with perforated end panel facing machine, and mount over spindle.
5. Box should fit snugly against spindle arm, resting on the spindle and corner pin (as shown in #7).
6. On opposite box side, make sure box sits on spindle and is secured in place by spindle cap.
8. Pull end of LevellinePro out of box between guides.
9. Feed LevellinePro through open slot into feed rollers using the feed knob. Make sure center groove in product lines up with centering roller. Turn feed knob until product stops against inside cutter blade.
10. To remove or adjust position of LevellinePro, push down on feed release lever.

**Carrying the
LevellinePRO
Box**



Mounting and securing the AutoPRO

WARNING - A fully loaded AutoPRO weighs over 150 lbs - DO NOT operate or load the AutoPRO with product or joint compound without securing it firmly to a stable bench, cart or platform with the supplied strap. Make sure the bench, cart, or platform is rated for this load.



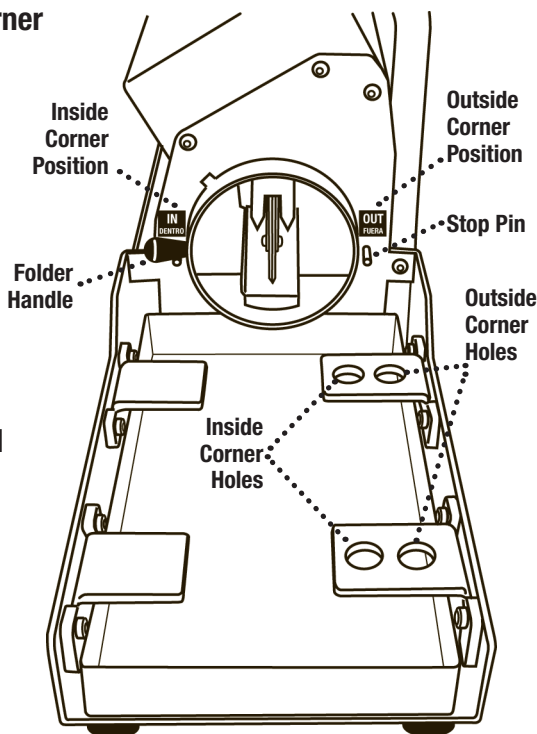
Setting for outside or inside corner

For an outside corner:

1. Rotate the folder handle away from you until the folder handle rests against the stop pin in the OUT position.
2. Locate the hopper with the tapered feet in the far set of locating holes.

For an inside corner:

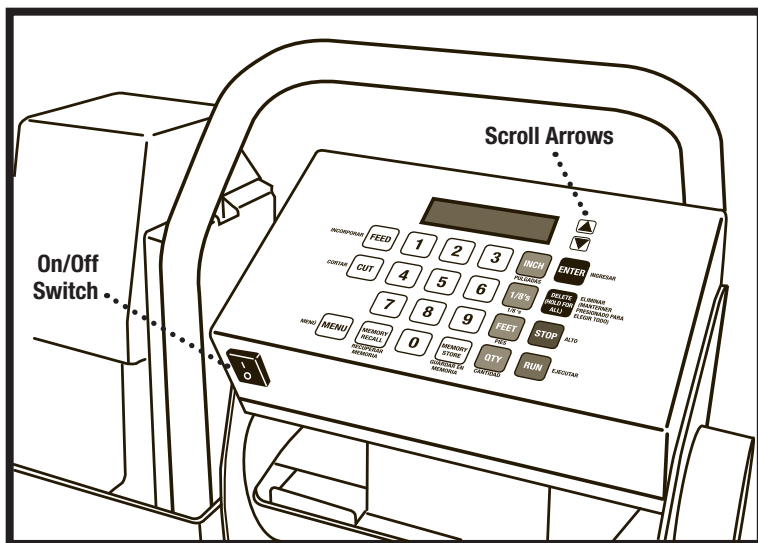
1. Rotate the folder handle toward you until the folder handle rests against the stop pin in the IN position.
2. Locate the hopper with the tapered feet in the near set of locating holes.



Language

To set the language of the display to English or Spanish:

1. Press MENU and select "2 - English/Español".
2. Select language.



CALIBRATION

The AutoPRO is calibrated at the factory but may require periodic calibration.

To calibrate the AutoPRO:

1. Make certain the product is loaded properly and the product box is touching the end of the AutoPRO.
2. Remove the hopper (calibration may be performed with hopper in place if it is empty, clean, and in the “outside corner” position).
3. Set the folder to “outside corner” position.
4. Press MENU and select “1- Calibration”.
5. Press RUN to begin calibration. The AutoPRO will run one short corner.
6. Pull the short corner out of the AutoPRO and discard.
7. Press RUN to dispense the calibration corner.
8. Measure the corner with a tape measure to the nearest 1/16th inch.
9. Enter the measurement, using the 1/8's button for 1/16ths, and press ENTER.

For example, if the calibration corner measures 120 12/16 inches, enter:

a. “120””IN”

b. “12””1/8's”

c. Press ENTER to calibrate.

10. Press MENU to exit. The AutoPRO is now calibrated. (Confirm calibration by measuring next output corner.)

Remote setup

The remote supplied with the AutoPRO is already setup at the factory - follow these steps to setup an additional remote.

1. Press MENU and select "2 - Learn Remotes".
2. Press the remote button while the 10-second timer counts down.
3. After 10 seconds the screen will change to the "Test Remotes" screen.
4. While in the "Test Remotes" screen verify that the OFF changes to ON when the remote button is pressed.
5. Press MENU to exit.



ENTERING DATA

Entering corner measurements and quantities:

Note: Minimum corner length is 28".

1. Begin by entering numeric length and the unit of measure.

For example, two corners measuring 6 feet, 3 5/8 inches would be entered as:

"6" "FT"

"3" "IN"

"5" "1/8's"

"2" "QTY" (NOTE: if quantity step is skipped, the quantity defaults to 1)

2. Check the display on the AutoPRO to be sure that it displays the corner data correctly. If you make a mistake at any time while entering measurements and quantities, you can override the data by re-entering it correctly.
3. Press ENTER to store this line in the list and advance to the next corner entry line.
4. Continue entering corners in this manner until you have entered all the corners that you would like to run in one batch.

Viewing data

1. Press the "^" scroll arrow (up) to scroll upwards in the list.
2. Press the "v" scroll arrow (down) to scroll downward in the list.

Editing data

1. To edit an entry, use the scroll arrows until the asterisk “*” is next to the line you want to edit.
2. Retype the measurement that you need to change (FT, IN, 1/8's, or QTY).
3. When you are done editing, press ENTER so that the AutoPRO keeps your changes.

Deleting data

Deleting all data:

1. To delete all of your entered corner data in the current list, press and hold DELETE HOLD FOR ALL.
2. Press ENTER to confirm that you want to delete all.

Deleting one line:

1. Scroll through the lines of data until the entry you need to delete is on the third line of the display.
2. Press DELETE.

Storing/recalling data

The AutoPRO can store lists of corners in Memory Store so that they can easily be recalled. The AutoPRO can store up to ten lists at a time.

1. Enter your measurements, one after the other, as described above, until your list is complete.
2. Press MEMORY STORE and a corresponding memory number (i.e. “MEMORY 1”).
3. When you are ready to reuse the list, simply press MEMORY RECALL and the corresponding memory button.
4. If a Memory button is full of data and you wish to override the data with new information, enter your new measurements and quantities, press MEMORY STORE and a corresponding memory number. This will override the previous list.

RUNNING CORNERS

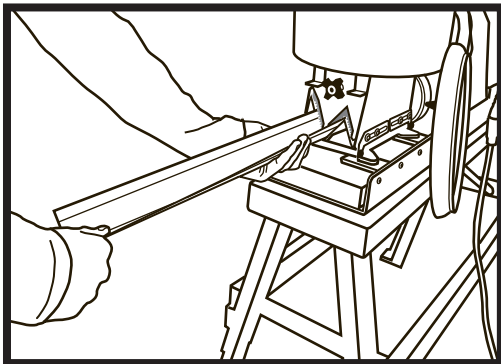
Enter “run mode”:

1. Make certain the product is loaded properly and the product box is touching the end of the AutoPRO.
2. Make certain the folder and hopper are both set for the desired corner (inside or outside).

3. Press RUN or the remote button to enter “run mode” and dispense the first corner on the list.
4. To pause the corner output, press STOP or the remote button during output - press RUN or the remote button to resume.
5. Press RUN or the remote button to dispense the next corner on the list.

Pulling corners out of the AutoPRO

1. Support the corner as it comes out of the AutoPRO. Wait to pull out the product until you hear the AutoPRO cut the corner - if you pull the corner before the cutter fires, it may cause length errors.
2. After the AutoPRO cuts the corner, be certain to pull the corner from the AutoPRO smoothly and at a consistent speed to ensure optimal joint compound coverage on the corner. Pulling the corner out too rapidly may result in gaps in joint compound coverage.



Exit “run mode”

1. Press STOP to exit “run mode” in order to edit the corner data, edit the list, recall a stored list, etc.

End of roll

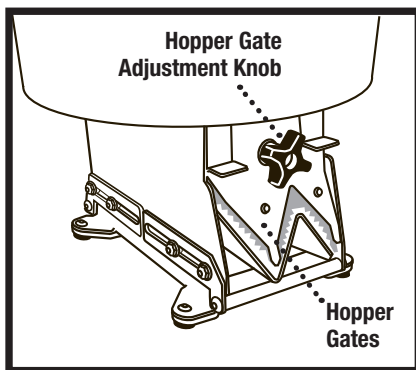
In the event that the end of a roll is reached while dispensing a corner the AutoPRO will stop dispensing and not cut.

1. Remove the current corner from the AutoPRO. **DO NOT PRESS CUT BEFORE REMOVING THE CORNER** - pressing cut before removing the corner may cause a small piece of product to remain in the cutter which may jam the AutoPRO.
2. Press CUT to reset the AutoPRO.
3. Load a new roll of product, making certain that the product stops against the cutter blade (to ensure proper corner length).
4. Press RUN to repeat the corner or press ENTER to skip to the next corner.

Adjusting hopper gates

Adjust the hopper gates to reduce leakage while ensuring sufficient coverage. If the gates are too tight the product may jam in the AutoPRO.

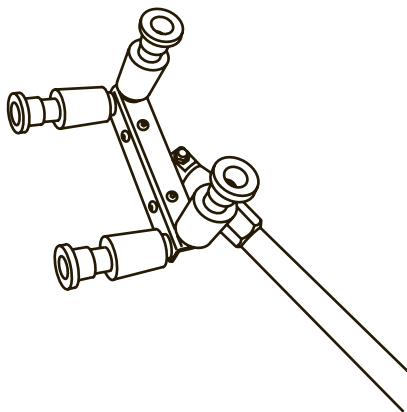
1. Adjust gate by loosening knob and sliding the gate up or down. Tighten the knob once the gate is in position.
2. As the viscosity of your joint compound may vary from bucket to bucket, you may need to adjust the hopper gates periodically to get the desired coverage.
3. If you are getting coverage inconsistency, check your joint compound thickness and add water as needed.



INSTALLATION TIPS

Use a roller tool for best results.

Use a roller to achieve the best installation results, prevent high-siding, achieve an even taper on both sides of the corner and get a straight corner edge.

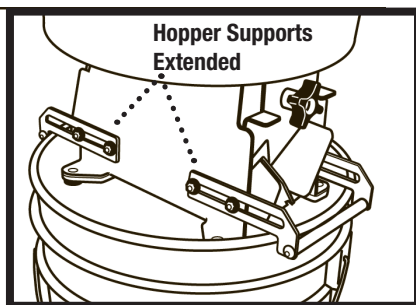


To use: install mudded side of LevellinePRO to corner. Place a roller over corner and roll with consistent, smooth pressure.

USING STAND-ALONE HOPPER

The AutoPRO hopper can be used separately from the AutoPRO machine to apply joint compound to other corner products.

1. Remove the hopper from the machine.
2. Extend both hopper supports.
3. Place the hopper on to a 5-gallon



bucket, making certain the hopper supports are fully extended and hooked over the edge of the bucket.

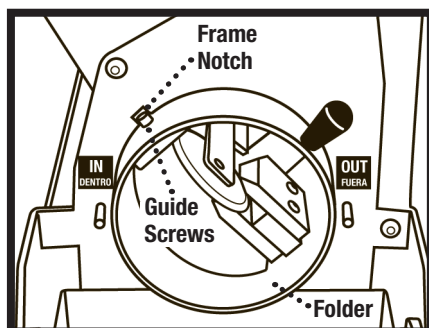
4. Push the corner through the inlet gate of the hopper.

CLEANING AND STORING

Cleaning the AutoPRO

WARNING - DO NOT IMMERSE OR SPRAY-DOWN THE AUTOPRO CUTTER, ELECTRONICS, OR WIRING.

1. Unplug the AutoPRO before cleaning.
2. Wipe down the AutoPRO with a damp sponge, removing joint compound from all surfaces.
3. If necessary, remove and rinse off the mud pan. Don't forget to replace the mud pan when finished.
4. If necessary, remove and rinse off the folder by rotating the folder until the screws line up with the notch in the frame. Don't forget to replace the folder when finished.



Storing the hopper

To reduce the amount of cleaning each day the hopper can be stored overnight, with or without joint compound.

1. Place lid on top of hopper.
2. Place hopper in to a clean 5-gallon bucket filled with 5" of water.

TROUBLESHOOTING

Issue: display is blank.

Check the following:

1. The AutoPRO is unplugged.

Solution: plug the AutoPRO in to 110 volt grounded outlet.

2. The AutoPRO is turned off.

Solution: turn on the AutoPRO machine.

3. The AutoPRO fuse is blown.

Solution: replace the fuse with a 5x20 mm, 6.3A, 250V, slow-blow fuse.

4. The cooling fan is running but the display is blank.

Solution: The AutoPRO has power but the display may be defective - call Customer Service at 1-888-662-6281.

Issue: unable to edit data.

Check the following:

1. AutoPRO is in “run mode”.

Solution: press stop to exit “run mode”.

Issue: display reads “FEED ERROR”

Check the following:

1. The product is not loaded correctly.

Solution: Make certain the product is loaded correctly and the center groove in the product lines up with the centering roller.

2. The product is jammed in the AutoPRO.

Solution: inspect the cutter, folder, and hopper for product jam.

Solution: make certain the folder and hopper are in the proper setting (both set for inside or outside corner).

Solution: make certain the hopper is positioned correctly, with the inlet facing the folder exit.

3. The hopper gates are too tight.

Solution: open the hopper gates slightly.

4. The joint compound has hardened or is too thick.

Solution: Make certain the joint compound is not hardened in the hopper or gates and/or replace the joint compound with a thinner mixture.

Issue: display reads “BLADE ERROR”.

Check the following:

1. Cutter blade is up. The cutter blade must be down before a measured corner will run - this is to make certain the product is starting at the blade so the proper length can be measured.

Solution: press FEED as necessary to advance the current corner until it clears the hopper then press CUT to lower the cutter blade.

Issue: display reads “END OF ROLL”.

Check the following:

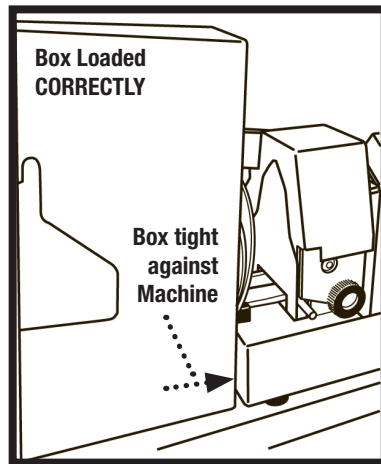
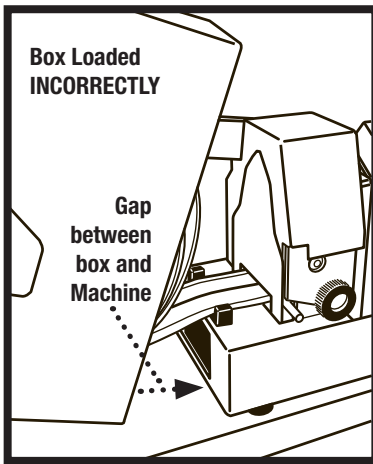
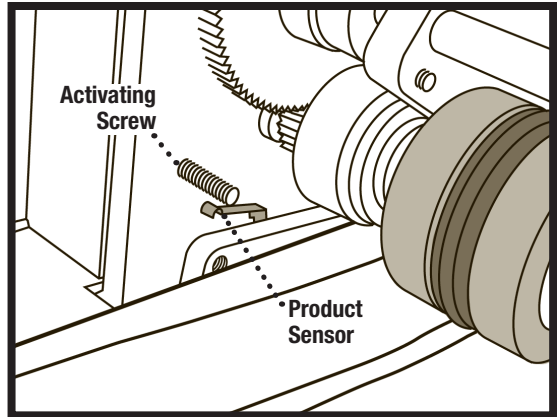
1. Box is empty.

Solution: see “End of roll” in the “RUNNING CORNERS” section.

2. Product sensor is out of adjustment.

Solution: make certain the lever of the product sensor does not contact the activating screw when product is loaded.

Make certain the lever of the product sensor does not contact the activating screw when product is loaded.



Issue: display reads “PRODUCT ERROR”.

Check the following:

1. Box is loaded incorrectly.

Solution: make certain the box is loaded correctly on the spindle arm and the box is tight against the rear of the machine.

Issue: outside corner is greater than 90°.

Check the following:

1. Folder blocks are worn.

Solution: the folder blocks are symmetric and can be swapped side-to-side to extend the life. Replace the folder blocks if both sides of the folder blocks are worn.

Issue: Inconsistent joint compound coverage.

Check the following:

1. Hopper is low/empty.

Solution: add joint compound to hopper.

2. Joint compound is too thick.

Solution: add water to the joint compound.

AutoPRO SPECIFICATIONS:

Dimensions:

Width: 9" (12" with hopper)

Length: 36" (56" with product loaded)

Height: 16" (26" with hopper)

Weight:

Dry weight: 43 lbs.

Full weight: 160 lbs.

LevellinePRO box weight: 17 lbs.

Power: 110 volt

Fuse: 5x20 mm, 6.3A, 250V, slow-blow

The leader in high-performance drywall corner solutions.



1-888-662-6281

info@structus.com

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visit www.levelline.com or call 1-888-662-6281.

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