

Thank you for your choice of our manual Paper Cutting Machine series. We will provide good quality and reliable after-sale service on the basis of original products.

Our research and development engineers combined advantages of products at home and abroad, and finally developed new model machines with new advantages. It owns high technology, precise construction designation, and elegant appearance with the security control part and improved cutting precision to get high work efficiency. It can be broadly used in printing shop and official usage. It is the most ideal cutting equipment which well complies with official automatic system.



Warning: this kind machine is allowed to cut printed paper or books or soft leathers only. It is forbidden to cut any metal sheets or other hard objects do harm to the machine quality.



Forbid children to operate the machine



Keep hand from underneath the blade



Do not extract or transport the blade without protection



Do not cut hard or splintery materials



Must use socket with ground wire connected

Note: Please read this manual carefully first in order to realize and use this kind machine. It will help you improve the work efficiency, bring into play the function of machine, prolong service life of the machine.

# Safety Cations

**According to relevant standards, to avoid accident and accidental injury, only professional operators are allowed to use this machine (children or non-professional operators are forbidden to operate) to use or maintain these machines, please pay high attention to safety cautions below:**



## Settlement position

The weight of this machine is about 75-95kgs. Please put it in balance in a clean place.



## Power

Please connect with the power source correctly in accordance with the specification. the power source should be steady AC220V.50HZ. 2KW, and the machine will run irregularly if the voltage is too high or too low or too low. We suggest you use alternating current (AC) power source with steady voltage to improve your working efficiency.



## Ground connection

For safety, you should use electric supply socket with ground wire connected.



## Overloading with appliance

Don't connect too many electric equipment at the socket. It is dangerous and easy to cause fire or electric shock.



## Maintenance

Before you clean or maintain the machines, you must cut the electric source and pull out the electric supply socket.



## Keep dry

Prevent water or other liquid flow into inner machine.



Children or non-professional person must not operate this machine.

Do not reach beneath the blade.

Do not reach cut.

Do not cut hard material or material which may splinter.



Must use socket with ground wire connected



Air safety switch, non-professional persons are not allowed to open. It is much dangerous.



Under normal usage, please add right amount lubricating oil to transmission parts and screw mandrel to ensure the machine running properly.



Emergency stop which is used in emergent situation. It should be pressed after dealing with emergency. Then press the RESET button to get into functional



Test to running the machine with one piece 80gsm paper. If the paper can't be cut completely, please fine adjust the spin blade depth (adjustable depth range about 5mm)

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# Chapter I Safety caution

## 1. Open the box and check

When you open the package of the machine, firstly you should check the machine and relevant accessories. Please contact the seller or company if there is any damage or shortage.

● Main unit one set	● Machine chassis one set
● Specification one piece	● Tooling one set
● Rubber under chassis four pieces	● Certificate one piece
● Stick one piece	● Power plug one piece
● Maintenance warrant one piece	

## 2. Machine installation

- ◆ Open the wooden crate ,take out the machine casing and discharge the fixed screws on the base plate of the main machine;
- ◆ The machine casing needs to be assembled completely, and the screws should be fixed firmly.;



- ◆ The main unit should be installed on the machine casing correctly.

- ◆ Fix the door of the cabinet;
- ◆ Check all parts of the machine, and clean them;
- ◆ Turn on the power and test running.



### 3. Environmental conditions

- ◆ The machine should be placed in clean working environment, keep away from direct sunlight and wind.
- ◆ Temperature of operating environment :10-30℃, should not exceed 32 ℃;
- ◆ Humidity level of the operating environment: 50-80%
- ◆ Working power source of cutting line:DC3V.

### 4. Special suggestions



Remember only one professional operator is allowed to operate the machine;



When you cut ,you should operate buttons by both of your hands; Please don't disassemble infrared safety covering



When you put your hands or other things into the cutting area, you must cut the power firstly;



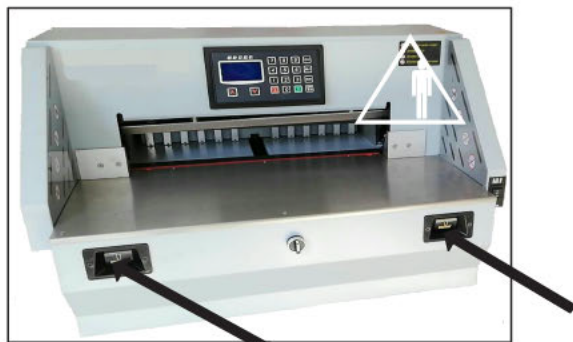
When you change blades,you should strictly abide the blade changing instruction;



You are not allowed to re-equip the construction and circuit of the machine by yourself.

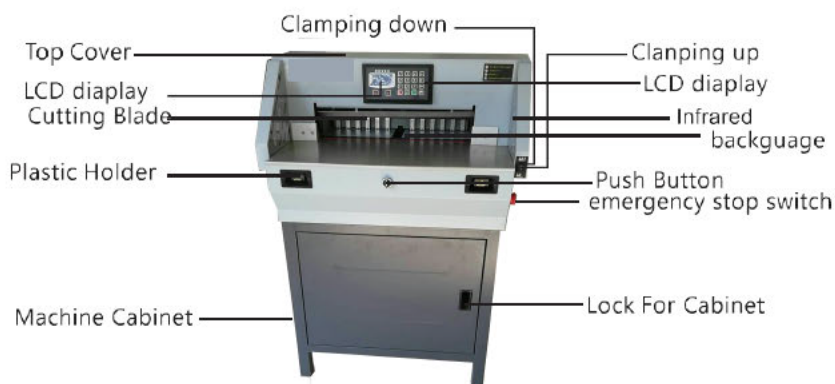
### 5. Operating figure

Turn on the power, open air switch and rotate the emergency stop to make machine get into power-on state. Then press RESET button, the paper pusher starts running. Proper operation like this: Stand in the front of the machine press the buttons with your hands shown in the picture.



## Chapter II Brief instruction of the paper cutting machine

### 1. Parts description

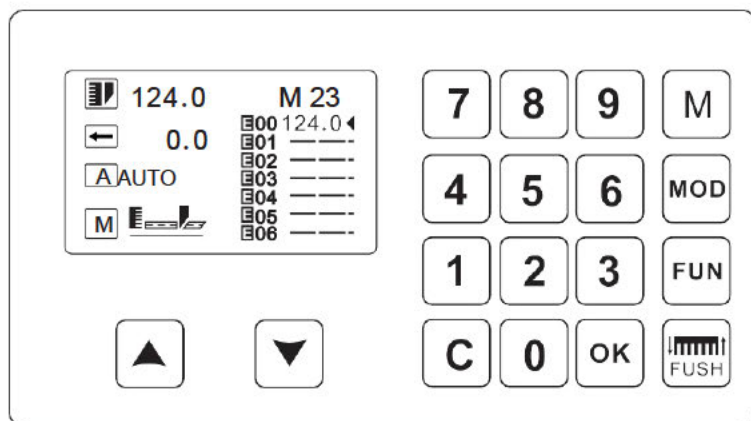


### 2. Principal technical parameter

Specification \ Model	AE460R	AE490R
Max.Cutting Size ( mm )	460	490
Min.Cutting Size ( mm )	40	40
Cutting thickness Size	60	80
Paper -clamping mode	Automatic	Automatic
Paper-pressing mode	Program-control	Program-control
Display mode	LCD	LCD
Safety Protection	Infrared	Infrared
Power	1230W/220V/50HZ	1280KW/220V/50HZ
Machine Measurement	935*620*1235mm	935*740*1235mm
Net weight	130KG	150KG

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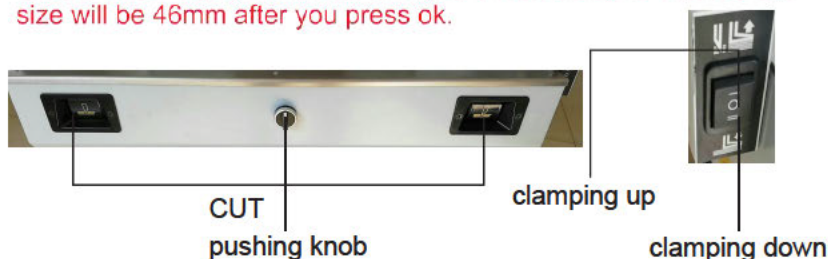
- Confirm entering , saving and backgauge moving
- Out storage data
- Eject mode and reet
- Modify and clear data**
- Mode for switching
- Forward&Back/Select key
- Number key
- Function key

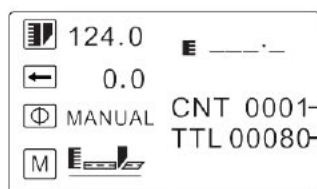
+ Getting into screen of fine adjustment for cutting blade

Press M key and dosplay stored data,and getting into automatic mode. Press M key without losing,you can modify and select groups in M area form1-100 with entering number in M area or switching steps up and down until the cursor shines.

Press MOD button to switch among manual,automatic and divide mode. You can enter manual mode with pressing any number if curretnt mode is automatic or divide.Press C to get into modify mode .Then press ok to save data and exit.

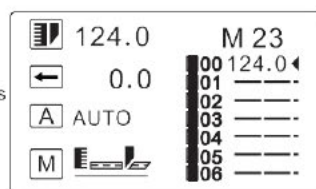
**Note:** Every time you enter data,you must add 0 more digits at the end to get accurate data.For example,you want to cut 460mm, you should enter 4600,then press ok.If you enter 0460,the finished cut size will be 46mm after you press ok.



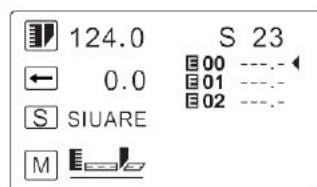


Manual state

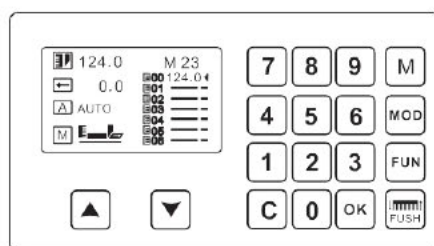
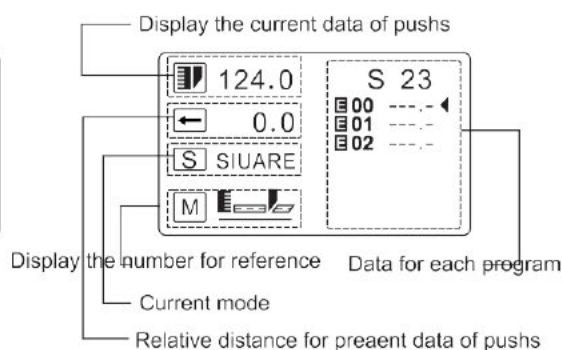
Count the times  
of cutting  
General cuts



Automatic state



Divide state

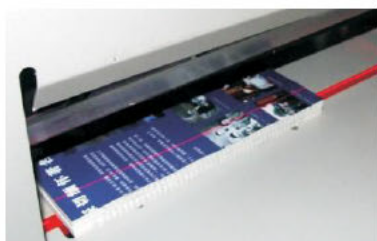


## Chapter III Basic operation

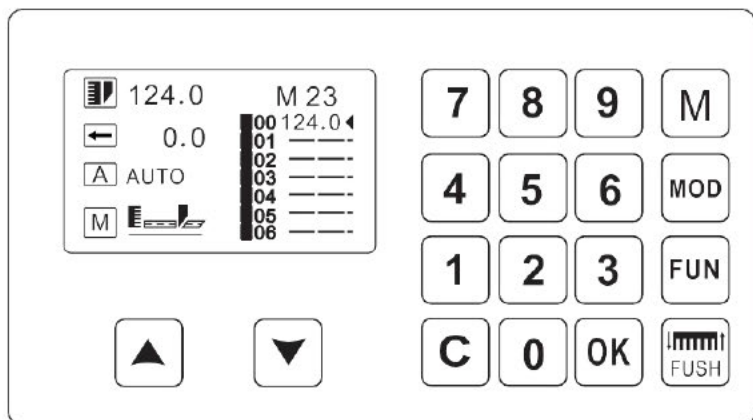
### 1. Basic operation

#### ◆Start the machine

Before operating the machine, please review contents described before carefully, then remove the things on the machine and clean the machine. Insert the power plug into AC220V.50HZ/60HZ.4KW socket.







Turn the protective switch to ON position. Digital display screen or crystal display shines, indicative line lights. The machine can be operated after background is calibrated automatically.




1) There are three pushing modes in programming paper guillotine. Now we take 285mm for example to push paper.

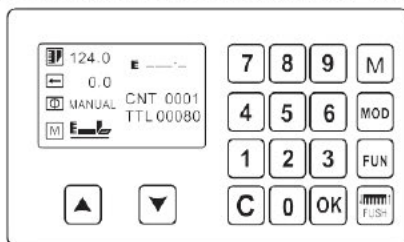
◆ Manual mode

Manual mode is with priority. As long as rotating the knob  with hand, the mode will be switched into manual state and display  whatever mode it is in before. When in divide and automatic mode state, only press **MOD** to switch into manual mode  automatically.






◆ Rotate the knob clockwise. Backgauge will move in the direction shown by the arrow . Backgauge move 0.1mm each rotation. It moves quicker and quicker if keeping pressing the knob







◆ Rotate the knob anticlockwise. Backgauge will move in the direction shown by the arrow . Backgauge move 0.1mm each rotation. It moves quicker and quicker if you keep pressing the knob

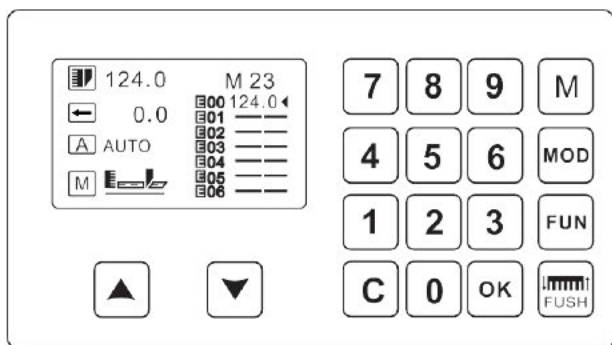
◆ Assuming present backgauge is in 300mm position, it moves 0.1mm each rotation until getting the position of 285mm. The crystal display screen shows:



◆ Automatic mode

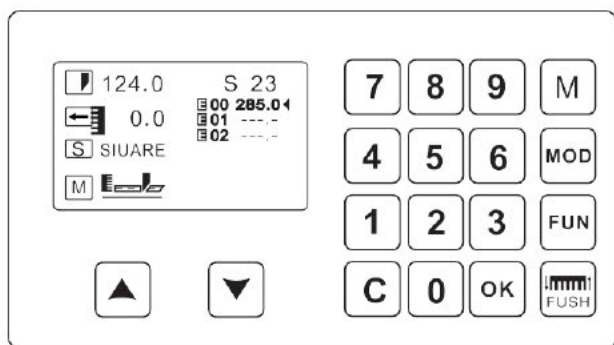
Press **MOD** to get into automatic mode  and LCD displays seven blank data (there are 100 groups, 7 groups each blank.) Press **M** without losing, enter number until the cursor shines. Select group by switching  . For example, press **M** without losing, then enter 23 until cursor shines. Press **M** or **OK** to select this group data, or switch  or  to get M23. If there is only dotted line there, press **C** to enter data. And set cutting size 285mm, press **M** or **OK** to save, then set next designate data.

The rest can be done in the same manner. After finishing setting, change key to select 285.0 and press **OK** to make paper pusher move to M1 285mm position automatically. Select , display  . That means the backgauge won't push paper or books after cutting. Press  once time and display  . That means the backgauge will push paper or books automatically after cutting.









### ◆Divide mode

- 1) Press **MOD** to get into **S** divide mode. Press **C** button to clear and set overall size 285mm. Press **C** to clear and set divide size 50mm. Then press ENTER to make backgauge move to overall size 285mm position.

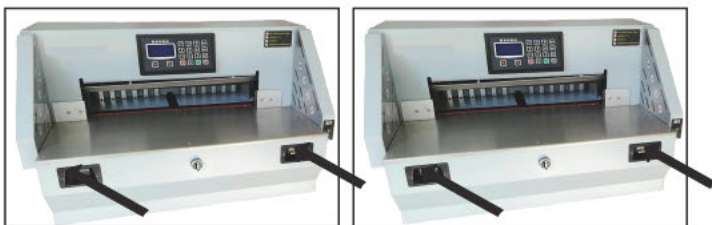


- 2) Put the books or paper right to cut, then make the books or paper lean to the left;



3) Start to cut after the size is confirmed. then pressing two CUT buttons at the same time. After that, the paper presser and blade come down, if you find the paper is not straight, Please stop pressing two CUT buttons, and press  +  +  to make paper presser and blade return. After you confirmed the paper put right, then press two CUT button to finish cutting completely. Start to cut after the size is entered. Press two CUT button at the same time. After that, the paper presser and blade come down. If you find the paper is Unparallel, stop pressing two CUT button, and press  +  +  to make paper presser and blade return. After you confirmed the paper is put right, then press two CUT button to finish cutting completely.

Press  +  Pressing before cutting



- 4) Different result are in different modes. a) In the manual mode state, press pushing after finishing cutting, backgauge will push paper or books automatically. b) In the automatic mode state, If you do not set pushing automatically after cutting, backgauge will push automatically. If you do not set pushing automatically after cutting, backgauge also will push paper or set pushing automatically after cutting. backgauge also will push b) Put the books or paper right to cut, then make the books or paper lean to the left; paper or books automatically and get into next data after finishing cutting if you press the pushing button. c) in the dividew mode state after first cutting backgauge will push second divide size. The rest will be done in the same manner until the paper is cut completely.
- 5) Repeat above operation if cutting should be continued.
- 6) If the last paper can't be cut completely, please adjust it following the method of blade adjustment.



## 2. Basic adjustment

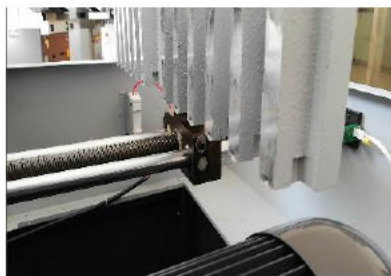
### ◆Dimension adjustment

Cut the electricity power

Unload the back cover plate and check whether there is any other matter on the guiding rod;



Pull out the front covering strip, and check stepping motor, to see whether the synchronous pulley and synchronous belt are fixed normally;



Adjust the support chip on the screw, and you can move it back and forth until dimension, then lock the retaining screw firmly,

## ◆Cutting blade adjustment

Cut the electricity power;

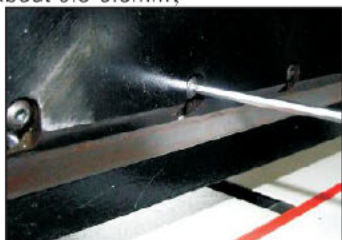
First of all, fine adjust the cutter blade depth(adjust depth range about 2-3 mm) or exchange the cutting side of stick.



Disassemble retaining screws on both sides of the upper cover, and then take the upper cover away;



Loosen seven M6 fasten screws on the blade which is on blade carrier, and adjust the screws on blade on blade carrier, until the blade cuts into the shim about 0.3-0.5mm;



Tighten screws on blade carrier, Put on the up cover, then fix up;

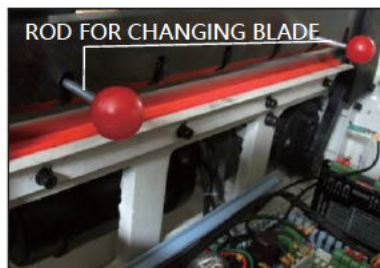
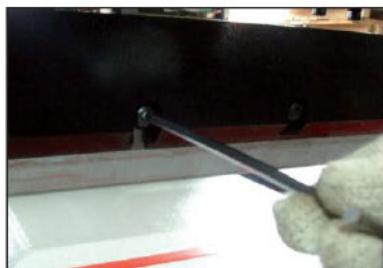
Choose one piece of paper to have a try. If it cannot be cut completely, you can readjust according to processes above.



## ◆blade adjustment(Be careful to operate)

Open the upper cover;

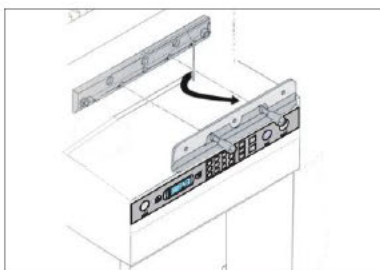
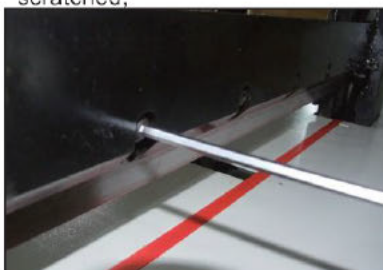
Loosen the fasten screws on the blade carrier,revolve the two screwstems clockwise,and then fix up firmly;



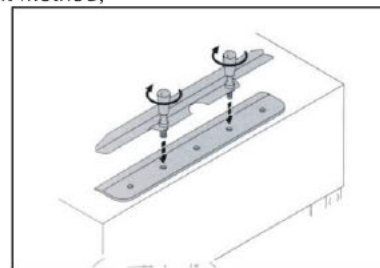
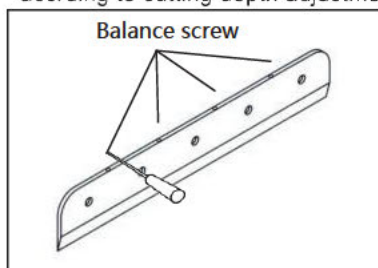
Take away other fasten screws on the blade carrier;

Revolve the two screw stems anticlockwise 180 , then take out the blade.

Please wear gloves or use cotton cloth to wrap the blade to avoid being scratched;



When you install the blade,you should screw up the screwstems,insatall the blade on the blade carrier and use screw strip to fasten and fix up, then adjust accrding to cutting depth adjustment method;





Blade sharpening needs to be done in a professional factory to ensure the quality.

Note: Dull blade can't cut paper correctly, Blade also will become dull if it always cuts thick paper or pasteboard, If cutting quality and accuracy can't meet required standard, the blade needs to be changed. Your work will go smoothly if you always have one replacement standly. When you need to change blade, you must operate according to the steps of blade change instruction.

Note: To avoid any injury, you must be the more careful when you change the blade.

### ◆ Cutting stick adjustment

One knife shim can be used for 8 times;

When slash on the shim is too deep, you should adjust or change knife strip;

Knife shim can be took out by screw which should be assembled onto the cutting desk flatly when it needs to be set back; Knife shim should lean to the left side;

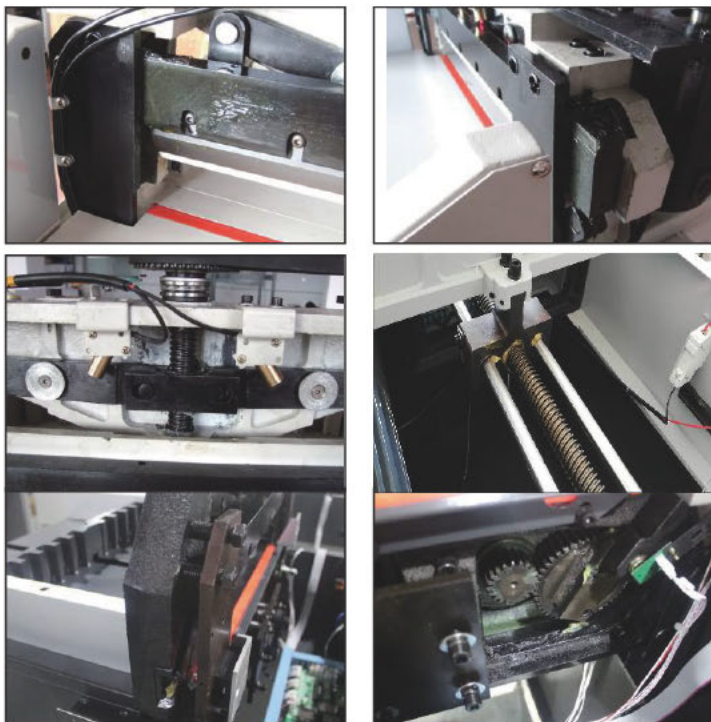


Note: When knife shim is being changed, the blade itself also needs to be adjusted. If the blade cuts too deep, the knife will be damaged easily, and the blade also will abrade rapidly.

## IV、 Lubrication and maintenance

### 1. Lubrication

The machine should be lubricated every one month. Check and clean, tight accessory parts and add lubricated oil to transmission parts. Be careful to add oil in case of dropping in the electric circuit boards and electric component.

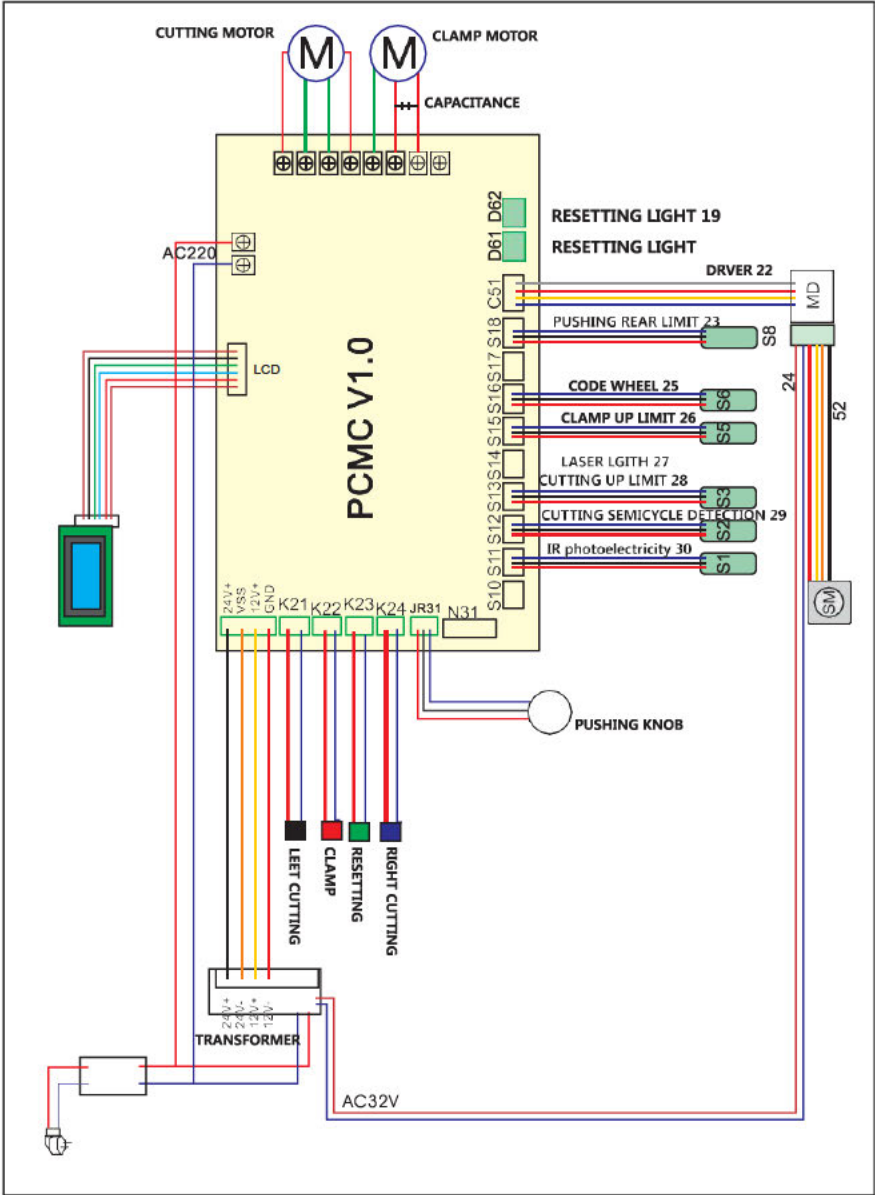


### 2. Maintenance

- 1) When the machine is working, other objects are forbidden to put on the machine. Because the blade cuts hard objects it will be damaged. There should be on staple pin in the book, which will damage the blade when cutting.

After everyday work, you should wipe the machine, remove junk, wax the blade and cut the power.

3.Paper cutter circuit diagram



## Chapter V common error and elimination

Error	Phenomena	Solution
Paper cutting is not even or the cutting size is not accurate	The cutting paper is unparallel and has large deviation	Remove the backgauge position offset and loosen the fastening screw to adjust the angle of pushing board.
The blade can not reset or works up and down continuously	All the button is invalid and can not control the blade	1. The sensor's position moves or was damaged. 2. The main board has been damaged
The window can't display or display wrong or can't	Power buttons are invalid	Check display board, main board of the electrical equipment, and circuit parts
Digital-controlled circuit damaged	Paper-pushing part can't work	1. Check stepping motor, driver 2. Check whether the circuit of main board is damaged
Alarm for displaying E-1	The button is invalid and cutting action stops	1. Check the flash 2. Check the control panel
Alarm for displaying E-2	Cut normally, but blade can't return to the original position.	1. Check limit sensor on the blade shelf 2. Check the control panel
Alarm for displaying E-4	Press shelf return abnormal	1. Check limit sensor on the press shelf 2. Check the mainboard
Alarm for displaying E-5	Pressing is abnormal	1. Check pressing motor code-wheel sensor 2. Check the mainboard
Alarm for displaying E-6	Cut normally, but paper pusher pusher can't limit and adjust	1. Check pressing motor backward calibration sensor 2. Check the mainboard

E-1 Photo-electric protection

E-2 error for cutter motor code-wheel sensor

E-4 error for pressing upper limit sensor

E-5 error for pressing motor code-wheel sensor

E-6 error for reset sensor

## Repair warranty

1. The guarantee period of paper-cutting machine is one year. You should register in maintenance station within one month after you buy the machine, in order to establish maintenance file;
2. Maintenance service scope :
  - ① Supply the service of installation ,adjustment,operation,training, periodic maintenance, elimination of error in normal operation and repair.
  - ② Supply to change parts damaged in moral operation,maintain motor and circuit for one year:knife shim and blade belong to expendable supplies,so they are excluded form the maintenance scope.
3. Maintenance should be undertake by the local sales agency.

4. We won't undertake the maintenance and accessories diversion fees caused by conditions below:

- ① Damage caused by accident, wrong operation or intent disassembling.
- ② Repaired by stations not authorized by our company, or use dependable materials and accessories not required by our company.
- ③ The customer doesn't register in the maintenance station within one month after he buys the machine.
- ④ The machine is damaged because of oil lack, oil in or water inflow.

# User file

Name\_\_\_\_\_ Tel\_\_\_\_\_

Address\_\_\_\_\_

Company\_\_\_\_\_

P.C \_\_\_\_\_ Date\_\_\_\_\_

Distributor\_\_\_\_\_

Model\_\_\_\_\_ Serial No\_\_\_\_\_